## Patent Claims

1. A method for producing seamless oilfield pipes having a length of greater than 7 m, in particular up to 200 m, an external diameter of greater than 20 mm but smaller than 200 mm, and a wall thickness of greater than 2.0 mm but smaller than 25 mm, of steel with an increased strength and improved toughness of the material by direct rapid cooling after a heat shaping, in particular after shaping by means of stretch reduction, such that a cooling medium at an increased pressure is applied to the outside surface of the pipe circumferentially for a length of more than 400 times the thickness of the pipe wall within a period of at most 20 sec after the last shaping at a temperature greater than 700°C but below 1050°C in a continuous process, said coolling medium being applied in an amount which produces an equivalent cooling rate of greater than 1°C/sec of the pipe wall over the length of the pipe to a temperature in the range of 500°C to 250°C in rapid cooling, after which the pipe is cooled further in air to room temperature.

2. The method according to Claim 1, wherein the start of rapid cooling of the outside surface of the pipe begins at a temperature below 950°C.

3. The method according to Claim 1 or 2, wherein after the rapid cooling, a targeted reheating of the pipe wall takes place after further cooling of the pipe in air.

4. The method according to any one of Claims 1 to 3, wherein steel with a concentration of the respective alloy elements and accompanying elements and/or contaminating elements in wt%is used for production of a steel pipe:

| | |
|---|---|
| Carbon (C) | 0.03 to 0.5 |
| Silicon (Si) | 0.15 to 0.65 |
| Manganese (Mn) | 0.5 to 2.0 |
| Phosphorus (P) | max. 0.03 |
| Sulfur (S) | max. 0.03 |
| Chromium (Cr) | max. 1.5 |
| Nickel (Ni) | max. 1.0 |
| Copper (Cu) | max. 0.3 |
| Aluminum (Al) | 0.01 to 0.09 |
| Titanium (Ti) | max. 0.05 |
| Molybdenum (Mo) | max. 0.8 |
| Vanadium (V) | 0.02 to 0.2 |
| Tin (Sn) | max. 0.08 |
| Nitrogen (N) | max. 0.04 |
| Niobium (Nb) | max. 0.08 |
| Calcium (Ca) | max. 0.005 |
| Iron (Fe) | remainder. |

5. The method according to Claim 4, wherein the steel contains at least one element in the following amount in wt% for production of a pipe:

| | |
|---|---|
| Carbon (C) | 0.05 up to 0.35 |
| Phosphorus (P) | max. 0.015 |
| Sulfur (S) | max. 0.005 |
| Chromium (Cr) | max. 1.0 |
| Titanium (Ti) | max. 0.02. |

6. A device for producing seamless oilfield pipes having a length of greater than 7 m, in particular up to 200 m, an external diameter of greater than 20 mm but smaller than 200 mm, and a wall thickness of greater than 2.0 mm but smaller than 25 mm, of steel having an increased strength and improved toughness of the material by rapid cooling after shaping, in particular after shaping the pipe by means of stretch production, consisting of a device for applying cooling medium to the surface of a pipe, **characterized in that**, arranged downstream from the last shaping mill in the direction of rolling , a switchable cooling through-zone having a plurality of distributor rings that can be positioned in different positions in the longitudinal direction and are arranged concentrically around the rolled material are provided for a cooling medium, wherein each distributor ring has at least three nozzles directed essentially toward the axis, and wherein each distributor ring or each group of same can be supplied with cooling medium in a throughput-regulated process.

7. The device according to Claim 6, **characterized in that** the nozzles each establish a pyramid-shaped cooling medium stream which widens in the direction of the spray.

8. The device according to Claim 7, **characterized in that** the cooling medium stream has a rectangular cross-sectional shape and the longer axis of the rectangle is directed obliquely toward the axis of the pipe.

9. The device according to Claim 8, **characterized in that** the supply of cooling medium to the cooling through-zone can be switched as a function of the position of the pipe ends in the zone.