

METHOD AND DEVICE FOR MANUFACTURING SMALL-DIAMETER METAL TUBES

BACKGROUND OF THE INVENTION

5 FIELD OF THE INVENTION

[0001] The present invention relates to a method and device for manufacturing metal tubes, small-diameter welded tubes having an outside diameter less than 20 mm, in particular, with high efficiency.

DESCRIPTION OF THE BACKGROUND ART

10 [0002] The roll forming method has been typically adopted as a method for manufacturing welded metal tubes. For example, under such a method, metal bands are fed to 10 or more roll forming stands arranged in a tandem fashion, and the metal bands are continuously formed into a cylindrical shape (see e.g. patent document 1). Subsequently, both edge parts of the cylindrically formed metal bands are butted and
15 welded, thereby manufacturing metal tubes.

[0003] However, the roll forming method, as mentioned above, involves a problem that a manufacturing line consists of a plurality of roll forming stands (i.e. multistage stands), which requires increased workload due to roll exchange and dimension adjustment by workers when changing the diameter of the metal tubes. Furthermore,
20 a lengthy downtime of the manufacturing line due to roll exchange leads to lower production efficiency of the welded metal tubes.

[0004] When manufacturing small-diameter metal tubes each having an outside diameter of 20 mm or less, the roll forming method involves problems that the metal bands have defects in formation such as meandering and twisting, which results in
25 significantly lower production efficiency of welded metal tubes.

[0005] When small-diameter metal tubes each having an outside diameter of 20 mm or less are manufactured, it is preferable that the number of forming stands is reduced as much as possible in order to improve work efficiency and productivity, and it is more preferable that such metal tubes are manufactured through a single stand.

30 [0006] As another method for manufacturing welded metal tubes other than the roll forming method, the die draw forming has been adopted. Under such a method, metal bands are fed to a forming die, and thereafter the metal bands are drawn from the forming die, thereby continuously forming the metal bands into a cylindrical shape (see e.g. patent document 2). In the method, one forming die is sufficient for forming
35 metal bands into a cylindrical shape. In other words, one forming stand is sufficient.

[0007] However, under the die draw forming method, significant friction is generated between the forming die and the metal band when the band is fed to and drawn from the forming die. For reducing such friction, greasing the surface of the metal band has been suggested (see patent document 2).

40 [0008] However, if the metal band has defects caused in the metal band manufacturing process, even with its surface greased, the metal band with metal powders coming off the defects is fed to the forming die, which results in accumulation of metal powders in the forming die. Such accumulation of metal powders, unless the inside of the forming die is frequently maintained, leads to surface defects on the metal

tubes. In such a case, the surface defects must be treated with surface polishing after manufacturing the metal tubes. In other words, the die draw forming method results in lower productivity and higher production cost.

[0009] Not only in the roll forming method but also in the die draw forming method, laser welding have been adopted as a method to butt and weld the edge parts of the metal bands cylindrically formed. Laser welding is preferred in view of productivity and workability of welded metal tubes.

[0010] (Prior Art Documents)
(Patent Documents)

Patent Document 1: Japanese Patent Application Publication No. H6-134525

Patent Document 2: Japanese Patent Application Publication No. H8-267150

[0011] (Problems to be Solved)

As mentioned above, a problem of the roll forming method has been not only that increased workload due to roll exchange and dimension adjustment are required but also that tiny adjustment errors made in the roll forming stands when manufacturing small-diameter metal tubes, in particular, are likely to cause problems such as meandering and twisting of the metal bands during butting of the edge parts of the metal bands.

[0012] Furthermore, another problem of the die draw forming method has been that a large amount of grease is used to reduce friction between the metal band and the forming die, and therefore degreasing of the metal band is required after it is formed into a cylindrical shape for laser welding.

SUMMARY OF THE INVENTION

[0013] The present invention is proposed for solving the above problems. Specifically, the object of the present invention is to provide a method and device for manufacturing small-diameter metal tubes in which only one stage of a roll clearly larger in outside diameter than a metal tube to be manufactured, i.e., a single stand of a roll having large diameter is used, and in which a metal band is formed into a cylindrical shape with high accuracy without greasing, and thereafter, the edge parts of the metal band are butted and welded each other.

[0014] (Means for Solving Problems)

In order to achieve the above object, the method for manufacturing small-diameter metal tubes by using a roll stand according to the present invention is characterized by comprising: feeding a metal band to the roll stand so that the metal band is formed into a cylindrical shape, the roll stand having a pair of large-diameter side rolls and a bottom roll arranged in a three-sided roll system, the pair of large-diameter side rolls each having an outside diameter ratio, ϕ_2/ϕ_1 , of 10 or more defined as an outside diameter ϕ_2 thereof relative to an outside diameter ϕ_1 of the metal tube to be manufactured, the pair of large-diameter side rolls including at least a first large-diameter side roll and a second large-diameter side roll arranged so as to face the first large-diameter side roll, the bottom roll being offset-positioned on an entrance side with respect to a line connecting between a rotation axis of the first large-diameter side roll and a rotation axis of the second large-diameter side roll; and thereafter, welding edge parts of the metal band.

[0015] It is preferable that the outside diameter ratio, ϕ_2/ϕ_1 , is 25 or more. As will

be described later, for improvement of the forms of the abutting edge parts in welding, it is also preferable that the metal band is fed to an edge bending roll to bend its edge parts in advance before the metal band is fed to the large-diameter side roll.

5 [0016] It is preferable that the stand for roll having large diameter used in the present invention has two large-diameter side rolls and one bottom roll arranged therein on the basis of a three-sided roll system (see FIG. 8 (A)). As will be described later, FIG. 8 (A) is a cross-sectional view showing the structure of such a three-sided roll system having a bottom roll placed therein. A pair of large-diameter side rolls are arranged side by side in such a fashion that their rotation axes are parallel to each other and that their outer peripheries face each other. Then, the bottom roll is arranged in such a fashion that its outer periphery is positioned in the vicinity of a facing portion at which the outer peripheries of the two large-diameter side rolls face each other. In the above facing portion, the edge parts of the metal band are butted each other during the process of forming a metal tube. The rotation axis of the bottom roll is substantially perpendicular to those of the two large-diameter side rolls. It is preferable that the bottom roll is offset-positioned on the upstream side in the moving direction of the metal band (that is, on the entrance side of the manufacturing line) with respect to a line connecting between the rotation axes of a pair of large-diameter side rolls (see FIG. 10). As will be described later, FIG. 10 is a top view showing a more preferable installation position of the bottom roll used in the large-diameter side roll based on the three-sided roll system according to the present invention. The offset-layout of the bottom roll on the upstream side in the moving direction of the metal band allows further reduction of strain caused in the process of forming metal tubes.

20 [0017] The three-sided roll system may be changed into a four-sided roll system by adding a fin roll (see FIG. 11). The fin roll is placed in the above facing portion in such a fashion that its outer periphery faces the outer periphery of the bottom roll, and that its rotation axis is parallel to the rotation axis of the bottom roll. The layout of the fin roll allows a position at which the edge parts of the metal band are butted each other to be maintained with high accuracy.

30 [0018] Furthermore, a fin roll may be placed above the squeeze roll immediately before the edge parts of the metal band are welded at the position of the squeeze roll. The fin roll can prohibit an abutting position of the edge parts of the metal band from twisting at the position of the fin roll (see FIG. 13). It is preferable that the fin roll used here has a fin and a concave face having a curvature larger in radius than the metal tube to be manufactured, because the fin enables accurate positioning of the abutting part preferable for subsequent welding, and the concave face enables correction of the forms of the abutting edge parts of the metal band by pressing the edge parts, which results in the obtainment of small-diameter metal tubes with excellent forming accuracy.

40 [0019] (Advantageous Effects of the Invention)

According to the present invention, by using large-diameter side rolls whose outside diameter is clearly larger than an outside diameter of a metal tube to be manufactured, metal bands can be formed into a cylindrical shape through a single stand, and small-diameter metal tubes each having excellent surface property can be manufactured in a highly efficient fashion. Further, by forming metal bands into a cylindrical shape through a single stand, the total number of stands required for manufacturing metal tubes can be drastically reduced, and the workload required for

roll exchange and dimension adjustment by workers can be reduced as well. Still further, by appropriate use of fin rolls, small-diameter metal tubes can be stably manufactured.

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BRIEF DESCRIPTION OF THE DRAWINGS

[0020] For more thorough understanding of the present invention and advantages thereof, the following descriptions should be read in conjunction with the accompanying drawings, in which:

10 FIG. 1 is a perspective view (A) showing the outline structure of large-diameter side roll and the spatial relationship between the large-diameter side roll and a welding machine configured to weld abutting part of edges, which are used in the present invention, and is also an enlarged view (B) showing groove part of the large-diameter side roll.

15 FIG. 2 is a view showing a relation between outside diameter ratio, ϕ_2/ϕ_1 , and equivalent plastic strain caused in the edge parts of a metal band.

FIG. 3 is a schematic view of a manufacturing line used for manufacturing small-diameter metal tubes according to the present invention.

FIG. 4 is a cross-sectional view showing the outline structure of edge bending roll.

20 FIG. 5 is a cross-sectional view showing the outline structure of large-diameter side roll.

FIG. 6 is a view showing the state where the edge parts of a metal band is bent by using two large-diameter side rolls.

25 FIG. 7 is a view showing the state where a problem stems from a part of a metal band under transformation between two large-diameter side rolls.

FIG. 8 is a cross-sectional view (A) showing the structure of a large-diameter side roll based on three-sided roll system having a bottom roll placed therein, and is also an enlarged view (B) showing the spatial relationship between the two large-diameter side rolls and the bottom roll.

30 FIG. 9 is a top view showing an installation position of the bottom roll used in the large-diameter side roll based on three-sided roll system according to the present invention.

35 FIG. 10 is a top view showing a more preferable installation position of the bottom roll used in the large-diameter side roll based on three-sided roll system according to the present invention.

FIG. 11 is a cross-sectional view showing the structure of the large-diameter side roll based on four-sided roll system obtained by arranging a first fin roll in the three-sided roll system according to the present invention.

40 FIG. 12 is an explanatory view showing the state of a metal band when one stage of fin roll is placed.

FIG. 13 is an explanatory view showing the state of a metal band when two stages of fin rolls are placed.

FIG. 14 is an explanatory view showing the form of the edge parts in the abutting part of a large-diameter metal tube.

45 FIG. 15 is an explanatory view showing the form of the edge parts in the abutting part of a small-diameter metal tube.

FIG. 16 is a view showing a preferable form of a second fin roll placed immediately in front of the squeeze roll.

DESCRIPTION OF EMBODIMENTS OF THE INVENTION

5 [0021] In general, under the roll forming method, metal tubes are formed gradually by means of multistage forming through 10 or more roll forming stands arranged in a tandem fashion. Therefore, in order to alter the diameter of the metal tube to be manufactured, all the rolls placed in the forming stands are required to be replaced with rolls corresponding to the altered outside diameter of the metal tube to be
10 manufactured. Furthermore, a considerable amount of labor and time required for roll exchange leads to lower productivity.

[0022] Therefore, the present invention provides a means to form metal bands into a cylindrical shape gradually through a single stand and reduce strain on metal bands caused in roll forming. A detailed description will be provided hereinafter.

15 [0023] FIG. 1 is given to describe the large-diameter side rolls used in the present invention. The large-diameter side rolls (42, 44) in the present invention (see FIG. 1 (A)) are designed so that the ratio, ϕ_2/ϕ_1 , of the outside diameter ϕ_2 of the forming roll relative to the outside diameter ϕ_1 of the metal tube to be manufactured is considerably large, that is, the outside diameter ratio, ϕ_2/ϕ_1 , is 10 or more, and preferably 25 or
20 more.

[0024] The large-diameter side rolls (42, 44) designed to have a great outside diameter ratio, ϕ_2/ϕ_1 , can be regarded as being a forming die used in the die draw forming method. In other words, the present invention can form a metal band (100) into a cylindrical shape not through a multistage stands but through a single stand.
25 However, the present invention does not need grease used in the die draw forming method.

[0025] The method for manufacturing metal tubes according to the present invention is suitable for manufacturing small-diameter metal tubes having an outside diameter less than 20 mm. This is because the method requires large-diameter side rolls having
30 a considerably large outside diameter ratio corresponding to the outside diameter of the metal tube to be manufactured. This means that the required diameter of large-diameter side rolls would be realistic if manufacturing small-diameter metal tubes each having an outside diameter less than 20 mm, but too large diameter of large-diameter side rolls would be required if manufacturing metal tubes each having
35 an outside diameter more than 20 mm, which would be unrealistic and disadvantageous for increase in cost.

[0026] A preferable relationship of the outside diameter ratio, ϕ_2/ϕ_1 , between the outside diameter ϕ_1 of the metal tube to be manufactured and the outside diameter ϕ_2 of the forming rolls will be described here. The use of side rolls having a great
40 outside diameter ratio, ϕ_2/ϕ_1 , allows a gradual roll forming of metal bands, more specifically, allows roll forming while reducing strain caused in roll forming.

[0027] FIG. 2 shows a relation between the outside diameter ratio, ϕ_2/ϕ_1 , and equivalent plastic strain caused in the edge parts of the metal band (see FIG. 2). By setting the outside diameter ratio, ϕ_2/ϕ_1 , at 10 or more, metal bands can be formed into
45 a cylindrical shape while much less strain occurring 0.25-mm inside the edge parts of the metal band being maintained (see FIG. 2). Further, by setting the outside diameter

ratio, ϕ_2/ϕ_1 , at 10 or more, the edge parts of the metal band can be bent while a good cross-sectional shape thereof being maintained, and the edge parts of the metal band can be formed without warpage. Still further, equivalent plastic strain caused in the lateral parts of the metal band (see FIG. 2) becomes constant at a low level when the outside diameter ratio, ϕ_2/ϕ_1 , is set at approximately 25.

[0028] Therefore, it is preferable that the outside diameter ratio, ϕ_2/ϕ_1 , is set at 25 or more. Although there is no particular need to set an upper limit on the outside diameter ratio, the upper limit at approximately 80 would be practical. Such an upper limit is considered on the basis of the saturation of reducing effect of strain caused in the edge parts of metal bands at the outside diameter ratio, ϕ_2/ϕ_1 , of around 80 as well as on the roll cost.

[0029] It is preferable that the metal band (100) is fed to edge bending rolls before it is formed into a cylindrical shape by the large-diameter side rolls (42, 44) on the single stand. Accordingly, bending can be provided preliminarily to the edge parts of the metal band (100), which enables the subsequent smooth bending of the edge parts by the rolls having large diameter.

[0030] FIG. 3 is given to describe the manufacturing method according to the present invention. FIG. 3 is a schematic view showing the outline of a practical manufacturing line used for manufacturing small-diameter metal tubes according to the present invention.

[0031] The metal band (100) is fed to an edge bending roll stand (30) while the metal band (100) being pressed against by a plate presser (10) with both edges thereof aligned by a guide (20). The metal band (100) has both edges bent by edge bending rolls (32, 34) according to the lateral ends R of the edge bending rolls before the band is formed into a cylindrical shape by large-diameter side rolls (42, 44) on a large-diameter side roll stand (40). Subsequently, a fin roll (80) enhances accuracy of the abutting position of the edge parts of the metal band (100) before the band is fed to a squeeze roll stand (50) for welding the abutting part by a welding machine (120). Through such processes, the metal band (100) is made into a metal tube (70). Reference numeral 60 indicates drawing equipment.

[0032] As shown in FIG. 4, the edge bending roll stand (30) consists of a pair of rolls arranged in a vertical direction, of which: the first edge bending roll (32) has a concave portion with lateral ends R; and the second edge bending roll (34) has a convex portion with lateral ends R.

[0033] The metal band (100) is fed to the edge bending roll stand (30), and both edge parts of the metal band (100) are bent according to the lateral ends R of the edge bending rolls. Furthermore, the metal band (100) is fed to the large-diameter side roll stand (40) (see FIGS. 1 and 5), and is formed into a cylindrical shape.

[0034] After having passed through the edge bending rolls, the metal band (100) is formed into a cylindrical shape under a pressing force provided inwardly from a pair of large-diameter side rolls (42, 44) in a lateral direction (see FIG. 6). A gap is formed between the first and second large-diameter side rolls (42, 44) (see P in FIG. 7). When the metal band (100) receives the pressing force of the large-diameter side rolls (42, 44), the metal band (100) can partly escape into the above gap P, which results in occurrence of defects in a cylindrical shape (see FIG. 7).

[0035] It is preferable that the so-called "supporting member" is placed in the gap P formed between the first and second large-diameter side rolls (42, 44) to prevent the

metal band (100) from partly escaping into the gap P.

[0036] FIG. 8 is given to describe the “supporting member” mentioned above. The first and second large-diameter side rolls (42, 44) are cut at either one of both end parts in an axial direction so that said either one is inclined by approximately 30 degree with respect to a direction from the outermost part to the inner part in a radial direction. More specifically, the first and second large-diameter side rolls (42, 44) on a bottom-surface side of metal band (i.e. in a lower side of FIG. 8) are cut in such a fashion that they are inclined by approximately 30 degree with respect to a direction from the outermost part to the inner part in a radial direction as shown in FIG. 8. A bottom roll (90) is placed between the inclined parts of the large-diameter side rolls (42, 44) (see FIG. 8 (A)) so as to serve as the “supporting member.” It is preferable that a three-sided roll system is adopted by placing the bottom roll (90) in the large-diameter side roll stand (40).

[0037] FIGS. 9 and 10 are given to describe the layout of the bottom roll (90). If the bottom roll (90) is arranged in such a fashion that its center line O' coincides with the line O substantially perpendicular to rotation axes of the first and second large-diameter side rolls (42, 44) (hereinafter referred to as “perpendicular line O”) (see FIG. 9), there is a probability that defects would occur when the metal band (100) is formed into a cylindrical shape. It is assumedly because the metal band (100) is subjected to excessive strain caused by the constraints of the entire circumference of the band in a circumferential direction thereof, when the perpendicular line O coincides with the center line O' of the bottom roll (90).

[0038] When the perpendicular line O of the large-diameter side rolls (42, 44) coincides with the center line O' of the bottom roll (90), there is a probability that, as mentioned above, before the metal band (100) having been fed to the large-diameter side rolls (42, 44) is supported by the bottom roll (90), the bottom of the metal band (100) slips downward and is folded. Subsequently, the folded bottom of the metal band (100) is supported and lifted by the bottom roll (90) thereby being refolded or folded back. It is assumed, therefore, that excessive strain would occur on the metal band (100), which leads to defects.

[0039] In the present invention, therefore, the bottom roll is offset-positioned on a side (i.e. on an upstream side of the manufacturing line) opposite to a moving direction (i.e. a moving direction X of the manufacturing line) of the metal band (100) with respect to the perpendicular line O of the large-diameter side rolls (42, 44) (see Q in FIG. 10). Accordingly, the entire circumference of the metal band (100) is not restrained as a whole, an escape route is generated, unnecessary deformation due to folding and folding back is diminished, and strain is significantly reduced. Therefore, the formed metal band (100) is drastically improved in shape and quality.

[0040] The edge parts of the metal band (100) cylindrically formed are butted and welded thereby manufacturing a metal tube. As shown in FIG. 3, under the state where the metal band (100) cylindrically formed is held on the squeeze roll stand (50), its edge parts are butted and welded by the welding machine (120). Laser welding is preferred in view of productivity and workability of welded metal tubes.

[0041] Laser welding is not the only method for welding. Other examples of possible methods are arc welding, such as tungsten inert gas (TIG) welding and plasma welding, high-frequency welding, and the like.

[0042] Not only in laser welding but also in other welding methods, it is preferable

that, when the edge parts of the metal band (100) are butted and welded, the abutting position is determined with high accuracy and the abutting part extends in a straight fashion along the moving direction X of the manufacturing line. In order to enhance the positioning accuracy of the abutting position in the present invention, it is preferable that roll forming is carried out by the large-diameter side roll stand (40) based on a four-sided roll system including a first fin roll (80) on a side of the abutting part in addition to the bottom roll (90) (see FIG. 11).

[0043] Even when roll forming of metal tube is carried out by installing a fin roll (80) on the large-diameter side rolls (42, 44) on a top-surface side of metal band (i.e. immediately above the large-diameter side rolls (42, 44) in FIG. 11) (see FIG. 11), there is a probability that the metal band (100) would twist in a circumferential direction before the band is conveyed to the squeeze roll stand (50) after having been formed at the large-diameter side rolls (42, 44), which results in defects of welding (see e.g. FIG. 12). This is probably due to deviation in a centering position of the metal band (100) when it is fed to the manufacturing line, or deviation of the centers of the large-diameter side rolls and the squeeze roll. However, manual correction of such deviations is difficult and unrealistic due to increase in cost.

[0044] In the present invention, therefore, not only the first fin roll (80) is placed at the large-diameter side rolls (42, 44) on a top-surface side of the metal band, as shown in FIG. 11, but also a second fin roll (82) is placed immediately in front of a position where the band (100) is fed to the squeeze roll stand (50) on a side opposite to a side of the metal band (100) with respect to the squeeze roll (i.e. above the squeeze roll), as shown in FIG. 3.

[0045] In other words, such concurrent use of the two fin rolls (80, 82) ensures that the abutting position of the edge parts is accurately determined at two points along the moving direction X of the manufacturing line, and the abutting part extends in a straight fashion, thereby enabling stable and continuous welding.

[0046] Furthermore, in continuous roll forming of the metal band (100), the metal band receives non-uniform strain to each part in a biased fashion, depending on various factors. Therefore, the edge parts of the metal band (100) are likely to have unstable forms due to level differences in the abutting position of the edge parts. Even if there are no such level differences, there is a probability that the abutting of the edge parts would be poor as shown in FIG. 15, which results in difficulties in subsequent welding.

[0047] The smaller the diameter of the metal tube to be manufactured is, the more remarkable the above-mentioned phenomenon becomes. As shown in FIG. 14, if the diameter of the metal tube to be manufactured is relatively large (see FIG. 14 (A)), the abutting part of the edge parts (110a, 110b) has an I-shape (see FIG. 14 (B)) and can be butted and welded without problem. However, if the diameter of the metal tube to be manufactured is small (see FIG. 15 (A)), the abutting position of the edge parts (110c, 110d) is in a V-shape as shown in FIG. 15 (B), which leads to defective welding.

[0048] In the present invention, therefore, a second fin roll (82) is placed immediately in front of a position where the steel band is fed to the squeeze roll stand (50) on a side opposite to a side of the metal band (100) with respect to the squeeze roll (i.e. above the squeeze roll) (see FIG. 16). The second fin roll (82) has a fin (82a) and a pressing face (88) having a curvature larger in radius than the metal tube to be manufactured. The fin enables an accurate positioning of the abutting part preferable for the subsequent welding by using the second fin roll (82), and the concave face enables

correction of the forms of the abutting position of the edge parts by pressing the edge parts of the metal band (100).

[0049] (Examples)

Example 1: A case of manufacturing metal tubes each having an outside diameter of 6.5 mm (ϕ_1) from raw material of 0.5 mm thick ferritic stainless steel bands each having a composition of 18Cr-1Mo-Ti-low C, N will be described below.

[0050] The manufacturing line is shown in FIG. 3. The edge bending rolls are shown in FIG. 4. The large-diameter side rolls (42, 44) are shown in FIGS. 5 and 7 ($\phi_2 = 300$ mm, outside diameter ratio, $\phi_2/\phi_1 = 46$). The bottom roll had an outside diameter of 62 mm, and offset Q of the large-diameter side rolls was 0 mm, 12 mm, 14 mm, 15 mm, 16 mm, 18 mm, and 20 mm on the upstream side of the manufacturing line with respect to the center line. The first fin roll (80) was placed at the large-diameter side rolls (42, 44) on a top-surface side of the metal band (i.e. above the large-diameter side rolls (42, 44)) without placing a second fin roll (82) at a position immediately in front of the squeeze roll stand (50).

[0051] Plate leading of the above raw material was performed at a line velocity of 4 m/min, and the raw material was subjected to fiber laser welding with a power output of approximately 900 W and a beam diameter of 0.6 mm on the squeeze roll to manufacture metal tubes. No grease was used. The result was that, when the offset Q was 0 mm, the obtained metal tubes had outer surface defects, and their roundness was poor. When the offset Q was set at other values, the obtained metal tubes had no outer surface defects at any offset value, and their roundness was good.

[0052]

Example 2: A case of manufacturing metal tubes each having an outside diameter of 3.7 mm (ϕ_1) from raw material of 0.3 mm thick ferritic stainless steel bands each having a composition of 16.5Cr-Ti-low C, N will be described below.

[0053] The manufacturing line is shown in FIG. 3. The edge bending rolls had a diameter ϕ of 100 mm. The large-diameter side rolls (42, 44) had an outside diameter ϕ_2 of 100 mm or 300 mm, with an outside diameter ratio, ϕ_2/ϕ_1 , of 27 or 81, respectively. The bottom roll had an outside diameter of 62 mm, and its offset Q was 0 mm, 10 mm, 12 mm, 14 mm, 15 mm, 16 mm, 18 mm, and 20 mm on the upstream side in the moving direction of the metal band (100) with respect to the perpendicular line O connecting the large-diameter side rolls (42, 44). The metal tubes were manufactured under the conditions of the line velocity of 4 m/min, fiber laser output of approximately 500 W, and a beam diameter of 0.6 mm. No grease was used.

[0054] The first fin roll (80) was placed above the large-diameter side rolls (42, 44), and a second fin roll (82) was not placed at the position immediately in front of the squeeze roll stand (50). As a result, when the offset Q was 0 mm, the obtained metal tubes had outer surface defects, and their roundness was poor irrespective of whether the outside diameter ratio, ϕ_2/ϕ_1 , was 27 or 81. When the offset Q was set at any other values, the obtained metal tubes had no outer surface defects, and their roundness was good at any offset value.

[0055]

Example 3: A case of manufacturing metal tubes each having an outside diameter of 6.5 mm (ϕ_1) from raw material of 0.3 mm thick ferritic stainless steel bands each having a composition of 16.5Cr-Ti-low C, N will be described below.

[0056] The manufacturing line, the edge bending rolls, the large-diameter side rolls

(42, 44), and the bottom roll were the same as those used in example 1. In other words, the outside diameter ratio, ϕ_2/ϕ_1 , was 46.

[0057] In example 3, the offset Q of the bottom roll was 0 mm, 5 mm, 7 mm, 10 mm, 12 mm, 15 mm, 18 mm, and 20 mm on the upstream side in the moving direction of the metal band (100) with respect to the perpendicular line O connecting the large-diameter side rolls (42, 44). In all the cases, the first fin roll (80) was placed above the large-diameter side rolls (42, 44), and a second fin roll (82) was placed at a position immediately in front of the squeeze roll stand (50) on a side opposite to a side of the metal band (100) (i.e. above the squeeze roll) with respect to the squeeze roll. Two types of the second fin roll (82) having a pressing face with a curvature radius of 5 or 10 mm placed at the upper side position immediately in front of the squeeze roll stand (50) were used. Thus, 16 types of metal tubes were manufactured. No grease was used.

[0058] Plate leading of the steel band made from the above raw material was performed at the line velocity of 10 m/min, and the steel band was subjected to fiber laser welding with a power output at approximately 1500 W and a beam diameter of 0.6 mm.

[0059] When the offset Q was 0 mm, the obtained metal tubes had outer surface defects, and their roundness was poor under the respective manufacturing conditions mentioned above. When the offset Q was set at any other values, the obtained metal tubes had no outer surface defects, and their roundness was good at any offset value.

[0060]

Example 4: Metal tubes each having an outside diameter of 6.5 mm (ϕ_1) were manufactured from the raw material of 0.5 mm thick ferritic stainless steel bands each having a composition of 16.5Cr-Ti-low C, N plated on both surfaces thereof with aluminum.

[0061] The manufacturing line, the edge bending rolls, the large-diameter side rolls, and the bottom roll were the same as those used in example 1. In other words, the outside diameter ratio, ϕ_2/ϕ_1 , was 46.

[0062] In example 4, the offset Q of the bottom roll was set to 3 mm, 5 mm, 7 mm, 10 mm, and 15 mm on the upstream side of the metal band (100) with respect to the perpendicular line O connecting the large-diameter side rolls (42, 44). The fin roll was placed only above the large-diameter side rolls (42, 44), and no fin roll was placed at a position immediately in front of and above the squeeze roll stand (50).

[0063] Plate leading of the above-mentioned raw material was performed at the line velocity of 2 m/min, and the raw material was subjected to fiber laser welding with a power output of approximately 580 W and a beam diameter of 0.6 mm on the squeeze roll.

[0064] The result was that metal tubes with good roundness and no outer surface defects could be manufactured from the raw material of stainless steel bands with aluminum plating as mentioned above at any offset value.

[0065] (Reference Numerals)

- 10 plate presser
- 20 guide
- 30 edge bending roll stand
- 32 first edge bending roll
- 34 second edge bending roll

	40	large-diameter side roll stand
	42	first large-diameter side roll
	42a	groove part of first large-diameter side roll
	44	second large-diameter side roll
5	44a	groove part of second large-diameter side roll
	50	squeeze roll stand
	60	drawing equipment
	70	metal tube
	70a	large-diameter metal tube
10	70b	small-diameter metal tube
	80	first fin roll
	82	second fin roll
	82a	fin
	88	pressing face
15	90	bottom roll
	100	metal band
	110a	edge part
	110b	edge part
	110c	edge part
20	110d	edge part
	120	welding machine
	O	perpendicular line
	O'	center line of bottom roll
	P	gap between two large-diameter side rolls
25	Q	offset
	X	moving direction of manufacturing line

WHAT IS CLAIMED IS:

1. A method for manufacturing metal tubes by using a roll stand comprising:
feeding a metal band to the roll stand so that the metal band is formed into a
5 cylindrical shape, the roll stand having a pair of large-diameter side rolls and a bottom
roll arranged in a three-sided roll system, the pair of large-diameter side rolls each
having an outside diameter ratio, ϕ_2/ϕ_1 , of 10 or more defined as an outside diameter
 ϕ_2 thereof relative to an outside diameter ϕ_1 of the metal tube to be manufactured, the
pair of large-diameter side rolls including at least a first large-diameter side roll and a
10 second large-diameter side roll arranged so as to face the first large-diameter side roll,
the bottom roll being offset-positioned on an entrance side with respect to a line
connecting between a rotation axis of the first large-diameter side roll and a rotation
axis of the second large-diameter side roll; and
thereafter, welding edge parts of the metal band.
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2. A device for manufacturing metal tubes by using a roll stand comprising:
20 a pair of large-diameter side rolls each having an outside diameter ratio, ϕ_2/ϕ_1 ,
of 10 or more defined as an outside diameter ϕ_2 thereof relative to an outside diameter
 ϕ_1 of a metal tube to be manufactured, the pair of large-diameter side rolls including at
least a first large-diameter side roll and a second large-diameter side roll arranged so as
to face the first large-diameter side roll, the roll stand having the pair of large-diameter
25 side rolls and a bottom roll arranged in a three-sided roll system, the bottom roll being
offset-positioned on an entrance side with respect to a line connecting between a
rotation axis of the first large-diameter side roll and a rotation axis of the second
large-diameter side roll; and
a squeeze roll and a welding machine placed on a downstream side of the
30 large-diameter side roll.