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 cooling 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;
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.

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 1-3, 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.