

公司简介

Company profile

万鑫公司始建于1982年，位于河北省霸州市，交通便利，距离天津港口70公里，北京机场90公里。专业从事设计开发和制造直缝焊管设备、高精度纵剪生产线、螺旋焊管设备、高频焊管H型钢设备、冷弯型钢设备、热镀锌生产线以及轧辊。首创具有国际先进水平的成套焊管机组及关键工艺技术，从成立至今，公司始终秉持“以精良的技术、高质量的产品、完善的服务奉献客户”的企业方针，逐步发展壮大。公司于2004年通过ISO9001:2000质量管理体系认证。

公司目前分为设计研发和加工制造两大体系，设计研发方面，设六大部门，设计人员中教授级高工、高级工程师和工程师以上职称的技术人才，包括多名螺旋焊管、直缝焊管及纵剪机组的知名专家。生产加工方面，公司于1992年开始自行加工生产，现下设两个生产制造厂，占地224000平方米，拥有丰富的生产加工经验，均始终秉承“质量至上”的生产理念，大小加工设备三百余台，年生产能力超过亿元，是国内客户坚实可靠的生产基地。可承担“交钥匙”工程，产品执行API、BS、ASTM、JIS及GB标准。

公司各类产品具有很好的适用性和良好的经济合理性，深受广大国内外用户的一致好评。产品辐射国内近二十个省市，已成为国内知名企业日照钢铁集团、京华创新集团、天津友发钢管集团、江苏国强镀锌实业有限公司、四川华新钢铁结构有限责任公司、云南三正集团等公司设备的定点生产基地，并出口到亚洲、非洲、东欧、南美等国家。

BaZhou WanXin Industrial and Trading Co., Ltd is found in 1992, and located at BaZhou city Hebei Province, has convenient transportation, which is 90KM to Beijing and 70KM to Tianjin Port. WanXin is a high and new-technology enterprise specialized in design, development and manufacture of ERW welded pipe equipment, high precision slitting & cross-cutting equipment, HF welding H-beam steel equipment, spiral welded pipe equipment, cold forming equipment, hot-galvanized pipe making machine and rollers. Also is the pioneer that has the key processing technology and the international advanced whole set of welded pipe mill. WanXin always adhere to the enterprise policy "contribute to the society with excellent techniques, high quality products and perfect service". Hold the import-export power, passing ISO9001:2000 Quality Management System Certificate of Conformity on 2004.

WanXin has Design Research and Manufacture systems, R&D has six departments, its staff are engineers or above, and some of them are the experts of the well-known spiral welded pipe, straight seam welded pipe and slitting/crosscutting in China. Manufacturing since 1992, now WanXin occupies two factories, covering 224000M², has abundance experiences on manufacturing and processing, adhere to manufacture policy "the quality is the top", has over 100 million production capacity for one year, it is the firm base of production for customers. WanXin is able to undertake turn-key projects and the products meet with API, BS, ASTM, JIS and GB standards.

The WanXin products have excellent suitability and good economic reasonability, are very popular at home and abroad. WanXin customers is covering nearly twenty provinces or cities in China and also become the named production base of famous group- Rizhao Steel Group, JingHua Innovation Group, Tianjin Youfa Steel pipe Group, Jiangsu Guoqiang zinc-plating industrial Co., Sichuan Huaqi, Yunnan Sanzheng Group etc, and also has exported to Asia, Africa, Eastern Europe, South America and so on.



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直缝焊管机组简介

ERW pipe mill

直缝焊管机组是将纵剪钢板后展成一定宽度的钢板，然后进入成型机，利用轧辊将钢板卷成开口管，利用高频电流加热钢板边缘并挤压成焊缝，用挤压辊挤压成圆管。直缝焊管机组又称ERW机组。我公司生产的全自动FFX高频直缝焊管生产线，及多功能250方至500方直缝方矩焊管机组属业内全自动及大型方矩焊管设备制造技术的前列！

The High frequency straight seam welded pipe mill is used to level the fixed strip after slitting line, and entry it to forming machine, bend to open pipe by roller, melt the strip edges through the High frequency current, squeeze and weld the pipe to be closed by the squeeze roll. The high frequency pipe mill is also called ERW pipe mill. Our products technology of full-automatic FFX HFW production line and multifunction 250mm-500mm directly formed square pipe line are among the highest in the industry.

直缝焊管机组工艺流程 Technical Process:

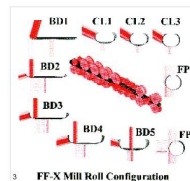


直缝焊管机组选型表 ERW PIPE MILL Model List:

序号 Item#	型号 Model	产品规格(毫米) Pipe sizes(mm)	成型速度(米/分) Forming speed (m/min)	适用板厚(毫米) Thickness(mm)	场用重量 (吨) Coil weight (t)	装机容量 (千瓦) Installed capacity(KW)	钢卷占地 面积(平方米) Floor area(m ²)
1	ERW32	Φ10-Φ32	70-100	1.0-3.0	2	~400	3.5×60
2	ERW50	Φ20-Φ50	60-100	1.5-3.0	2.5	~450	4×70
3	ERW78	Φ42-Φ76	30-90	1.0-3.75	3	~600	4.5×80
4	ERW89	Φ48-Φ89	50-80	2.0-4.0	3.5	~800	5×85
5	ERW114	Φ25-Φ114	30-60	3-8	5	~1100	8×100
6	ERW165	Φ60-Φ165	30-50	3-10	10	~1600	10×120
7	ERW219	Φ114-Φ219	20-40	4-10	15	~1800	15×150
8	ERW325	Φ165-Φ325	10-30	4-14	20	~3000	18×200
9	ERW355	Φ165-Φ355	8-25	4-14	20	~3500	20×220
10	ERW426	Φ219-Φ426	8-20	4-16	30	~4000	20×240
11	ERW508	Φ219-Φ508	8-20	4-16	30	~4500	21×260
12	ERW610	Φ219-Φ610	8-20	4-20	30	~5000	24×280
13	ERW630	Φ273-Φ630	6-20	6-22	30	~5500	24×300
14	ERW660	Φ273-Φ660	6-20	6-22	30	~6000	24×300

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1. FFX219-630mm成型机
2. FFX219-630mm定径机
3. FFX机组辊型
4. GZH Φ140 排辊成型生产线
5. Φ50 成型定径机
6. Φ114 成型定径机



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前准备段 Preparation section

开卷机 Uncoiler

开卷机是焊管生产线前准备段的重要设备，主要用于支撑带钢，并把带钢卷展开，为生产线提供原料。开卷机在焊管生产中根据带钢宽度和上料小车、直头机配合使用，将带钢引出后喂入矫平机进行矫平。开卷机包括双锥开卷机、双工位开卷机、箱式开卷机等。

Uncoiler is the important equipment of preparation in welding pipe production line, mainly used for holding steel strip and unfolding coils, supplying raw material for the production line. Uncoiler also need to be used in concert with coil loading car and end straightener in welded tube production, guiding the steel strip into the leveling machine to carry on flattening. The uncoiler includes double mandrel type, uncoiler double workstation, and box type.



双锥开卷机
double cone uncoiler



双工位开卷机
Double workstation uncoiler



箱式开卷机
Cage style uncoiler



开卷直头机
uncoiler and end straightener

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夹送矫平机 Pinching and leveling machine

夹送矫平机是用来把开卷机输送出来的带钢头尾矫平，为剪切对焊提供方便。该机主要用于较厚带钢的矫平。

Pinching and leveling machine is to level the ends of the steel strip after uncoiler, provide the convenience for the shear end/welder. This machine is mainly used in thicker strip flattening.



剪切对焊机 Shear end/welder

剪切对焊机用于剪切带钢头尾的不规则部分，并将前后带钢的尾部头部焊接起来，从而保证生产的连续性。

Shear end/welder is to cut off the irregular ends of steel strip and weld the ends of the front and next strips, ensure the continuity of production.



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活套 (储料仓) Accumulator (material storing device)

活套 (储料仓) 用于存储带钢，保证机组连续生产，分为笼式活套和卧式螺旋活套。

Accumulator (material storing device) is used to store steel strip, ensure that the mill line can produce continuously. This device is divided into cage accumulator and horizontal spiral accumulator.



箱式活套 Cage type accumulator



卧式螺旋活套
Horizontal accumulator

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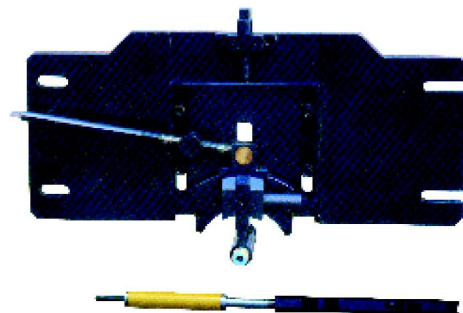
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内毛刺清除装置 Inner deburring equipment

内毛刺清除装置是由刀杆、调整装置、液压站组成。其中刀杆部分主要是由刀具架、轴承座、连杆等部分组成。刀具架放置有环形刀、液压支架、刀具微调装置。一种刀杆可适应钢管内径较大范围的使用。

Pipes inner deburring equipment consists of toolbar, adjusting device, and hydraulic unit. Of them, the toolbar is mainly composed of toolframe, impeller frame, connecting rod and so on. The toolframe is equipped with knife ring, hydraulic support, knives vernier device. One toolframe can adapt to a large range of pipe inner diameters.



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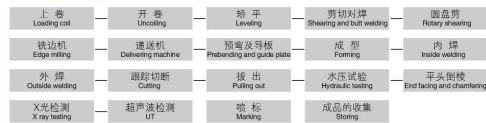
螺旋焊管机组简介

SSAW pipe mill

螺旋焊管机组是将钢卷通过机组设备打开、矫平，然后以一定的角度送入成型机，利用三辊成型原理，辅以一定的角度，形成连续的圆管，然后将连续的螺旋状焊缝用埋弧焊机焊接。

Spiral welded pipe making machine is used to uncoil and level the steel coil, and send the strip to forming machine by certain angle, then bend the pipe by certain angle based on three-roller forming principle, at last weld the spiral welding seam by the submerged arc welder. It is also called SSAW pipe mill.

螺旋焊管生产工艺流程 Technical process:



螺旋焊管机组选型表 SSAW PIPE MILL Model List:

序号 Item#	型号 Model	产品规格(毫米) Pipe sizes(mm)	卷板宽度(毫米) Plate width(mm)	适用板厚(毫米) Thickness(mm)	适用卷重 (吨) Coil weight (MT)	装机容量(千瓦) Installed capacity(KW)	机轴占地 Floor area(m ²)
1	LH-400	Φ219-Φ426	400-750	5-10	10	180	18×180
2	LH-500	Φ219-Φ529	400-800	5-11	15	200	18×180
3	LH-600	Φ219-Φ630	450-1050	6-12.7	20	240	21×180
4	LH-700	Φ219-Φ720	500-1250	5-14	20	260	21×180
5	LH-800	Φ219-Φ820	500-1300	6-18	30	380	24×180
6	LH-1000	Φ219-Φ1020	500-1300	6-20	30	390	24×180
7	LH-1400	Φ325-Φ1420	500-1560	6-22	30	400	26×180
8	LH-1600	Φ426-Φ1620	500-1560	6-25.4	40	510	30×180
9	LH-1800	Φ508-Φ1820	1100-1600	8-25.4	40	510	30×180
10	LH-2000	Φ508-Φ2020	1200-2000	8-25.4	40	530	30×180
11	LH-2400	Φ508-Φ2400	1200-2000	8-25.4	40	530	30×180
12	LH-3000	Φ508-Φ3000	1200-2000	8-25.4	40	530	30×180

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后桥
Rear Axle



螺旋焊管机组
SSAW pipe mill



螺旋焊管平头机
End facing and leveling machine



输送机
Delivering unit

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纵剪机组简介

Slitting line

纵剪机组是将卷板打开、矫平，然后利用圆盘剪将钢板分切成所需的窄条，用卷取机将窄条卷收，再将卷成盘的窄条打包。

Slitting line is used to uncoil and level the coil plate, slit the steel plate by rotary shearing unit, then recoil the plate by recoiler, at last pack the coil.

纵剪机组工艺流程 Technical process:



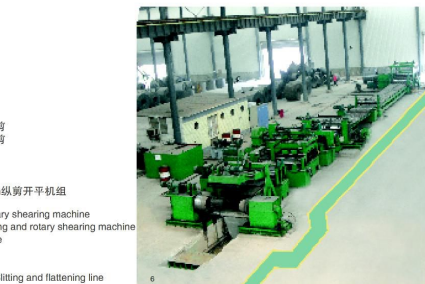
纵剪机组选型表 Slitting line model list:

序号 Item#	型号 Model	适用板厚 Thickness(mm)	适用卷重(吨) Coil weight(MT)	卷板宽度 Plate width(mm)	剪切速度 Cutting speed (m/min)	机轴占地 Floor area (m ²)
1	ZJ400	0.8-4.0	5	400	30-100	10×3
2	ZJ600	0.5-5.0	7	400-600	20-100	17×4
3	ZJ800	1.0-8.0	10	500-800	20-80	30×6
4	ZJ900	1.0-8.0	10	600-900	15-70	30×7
5	ZJ1200	3-12	15	900-1200	20-60	30×9
6	ZJ1250	0.3-2	5	900-1200	50-100	32×9
7	ZJ1500	4-10	20	900-1550	20-60	32×10
8	ZJ1600	4-12.7	25	900-1600	20-60	32×10
9	ZJ1800	5-14	30	1000-1800	15-60	32×12
10	ZJ2000	6-14	30	1200-2000	15-60	35×13
11	ZJ2200	6-20	40	1200-2200	12.5-25	39×15



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1. 开卷机及液压剪
2. 液压剪及圆盘剪
3. 卷取机
4. 圆盘剪
5. 纵剪机组
6. ZJ2200x16mm纵剪开平机组

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钢管热镀锌机组简介

Hot galvanizing pipe mill

钢管热镀锌生产线是将成品黑管经过表面处理自动镀锌，在钢管内外表面镀一层耐腐蚀、表面光滑镀锌层的生产设备。生产线主要设备包括烘干机、加热炉、镀锌机、钢管引出机、引上机构、引上辊道、平移机构、蒸汽和空气组合内吹机、（或导杆内吹机）放平机构、冷却水槽、喷淋辊道、打字辊道、蓝带机、电器部分等。万鑫公司生产的热镀锌生产线规格介于1/2寸至10寸。

Hot galvanizing line is used to produce corrosion resistance and smooth layer on the surface of raw pipes after cleaning. The main equipments include: drying oven, heating furnace, galvanizing machine, drawing machine, drawing upward unit, pulling out roller, moving device, internal blowing with steam and air combination, (or guide rod internal blowing) laying flat device, cooling tank, spraying conveyor, mark conveyor, blue ring machine, electrical device and so on. WanXin company can produce hot galvanizing pipe mill spec is between 1/2 inch to 10 inches.

钢管热镀锌生产工艺流程 Process flow:

原料 (黑管) Raw material (black pipe)	脱脂 Degreasing	酸洗 Acid treatment	漂洗 Water cleaning	浸溶剂 Applying immersion
烘干 Drying	热镀锌 Zinc hot-dipping	外吹 External blowing	内吹 Internal blowing	空冷 Air cooling
水冷 Water cooling	钝化 Passivation	烘干 Drying	打字 Marking	检查 Inspection
打包 Packaging	成品 Finished products			

钢管热镀锌机组列表 Hot galvanizing pipe mill Model List:

序号 Item No.	产品规格 Product spec.	生产方式 Production mode	壁厚 Thickness (mm)	管长 Pipe length (m)	生产速度 Production speed (m/min)	内吹形式 Internal blowing form	设备占地 Equipment area (m²)	厂区面积 Plant area (m²)
1	1/2-2	双线生产 Double work-line	1.8-3.25	6	34-36	蒸汽 Steam	3×30	18×110
2	1/2-4	双单线生产 Single and double work-line	1.8-3.75	6-8	12-30	蒸汽 Steam	3×30	18×110
3	3-8	单线生产 Single work-line	3.75-5.0	6-8	12-30	导杆 Guide rod	3×30	18×110
4	6-10	单线生产 Single work-line	5.0-7.5	6	8-12	导杆 Guide rod	3×30	18×110

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热镀锌生产线
Galvanized pipe production line



热镀锌生产线
G.I. pipe mill (galvanized iron pipe mill)



镀锌机构
Galvanized unit



镀锌钢管
Galvanized pipes

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冷弯型钢机组简介

Cold forming steel mill

冷弯型钢机组是将一定宽度的卷板打开、矫平，然后进入成型机，利用轧辊将钢板在冷态弯曲成所需的形状。

冷弯型钢机组根据产品不同，大致分为方管机组、钢板桩机组和其他机组。

方管机组主要生产方管和矩形管，采用连续成型工艺，配备高频焊机，可实现一套轧辊生产规格范围内所有规格的产品。我公司可生产规格200至500方的连续成型方机组。

钢板桩机组为专门生产钢板桩的机组，采用连续成型工艺。

其他机组可以通过更换轧辊生产槽钢、C型钢等多种型钢。

Cold forming steel mill is used to open and level certain width rolled plates and then enter the plate into the forming machine, and bend the plates in cold state to the required shape by rollers.

According to the different products, cold forming steel mill is grouped into square pipe mill, steel sheet pile unit, and other units.

Square pipe mill mainly products square and rectangular pipes, using "directly forms to square" technology, equipped with high-frequency induction welder, it can realize one set roller producing all specifications of square and rectangular pipes. Our company can produce square pipe mill the spec. is from square 200mm to 500mm.

Steel sheet pile unit is specified unit in manufacturing steel sheet piles by taking use of continuous bit by bit flexible forming technology.

Other units can product U-steel, C-shape steel and many other shape steels by changing rollers.

冷弯型钢机组工艺流程 Technical process:

上卷 Loading coil	开卷 Uncoiling	矫平 Leveling	剪切对焊 Shear and welder	成型机 Forming machine
焊接 Welding	水冷 Water cooling	定尺 Sizing	定尺切断 Cutting by fixed length	成品收集 Storing

冷弯型钢机组列表 Model list:

序号 Item No.	型号 Model	产品规格(毫米) Product Spec (mm)	适用壁厚 (毫米) Thickness (mm)	适用重量 (吨) Coil Weight (MT)	成型速度(米/分) Forming Speed (m/min)	装机容量(KW) Installed Capacity	占地(m²) Floor Area
1	LW-200	20×20~50×50	1-3	5	20-80	~700	18×100
2	LW-400	50×50~100×100	2-8	5	20-80	~900	18×100
3	LW-600	60×60~150×150	2-10	10	20-60	~1700	21×100
4	LW-800	80×80~200×200	2.5-12.7	15	20-40	~1800	21×130
5	LW-1050	100×100~250×250	3-14	20	15-30	~2800	21×150
6	LW-1250	120×120~300×300	3-16	30	10-25	~3600	21×160
7	LW-1400	150×150~350×350	4-18	30	8-20	~3800	24×210
8	LW-1600	200×200~400×400	4-20	30	8-20	~4100	24×240
9	LW-2000	250×250~500×500	4-22	40	8-20	~4500	24×260

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ZF150~500° 冷弯型钢生产线
ZF150~500° Cold forming steel mill



LW750 冷弯生产线
LW750 Cold Forming Mill



220° 冷弯型钢主机
220° Cold Forming Machine



高速公路护栏板生产线
High-speed guardrail production line

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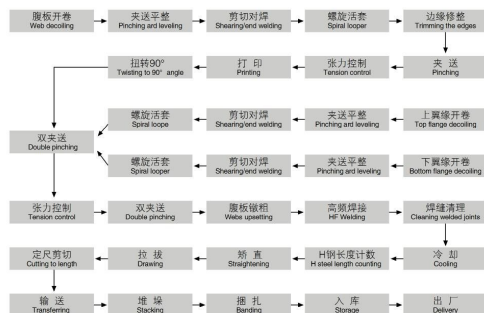
高频焊接轻型H型钢生产线简介

High frequency welding light h-beam product line

高频焊接轻型H型钢生产线特点 The features of HPFW light H-beam production:

- 1、速度快、效率高； Fast speed, high efficiency;
- 2、热影响区小、变形小； Small heat affected zone, little deformation;
- 3、不同材料可以焊接组合； Different kinds of materials can be welded together;
- 4、可以实现微张力控制状态； It can realize the micro-tension control state;
- 5、产品精度高； High product precision;
- 6、截面性能高； High section performance;
- 7、可以按照用户指定标准生产非标产品； We can manufacture non-standard product according to users' designated specs.
- 8、适用于轻钢结构。 This product line applies to light steel structure.

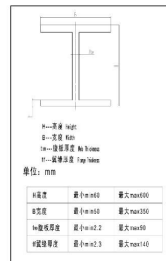
生产工艺流程 Production technical process:



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高频焊接H型钢生产线
HPFW light H-beam production line



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电脑飞锯

Computer flying saw

电脑飞锯是焊管、冷弯生产线的关键设备，可在管材高速运动状态下实现高精度自动跟踪并锯切到一定长度。

Computer flying saw is main equipment of welded pipe and cold forming production line. It can achieve high precision automatic tracking and cutting then by fixed length.



铣切锯
Milling saw



电脑飞锯
Computer flying saw

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矫直机

Straightening machine

矫直机，是高频直缝焊管生产主要设备之一，其功能是消除钢管焊接后的应力，矫正纵向弯曲，消除钢管的椭圆度，一般采用六辊或者七辊矫直形式即上四辊下二或者上三下四。我公司能够生产Φ32mm-Φ219mm各种型号矫直机。

本设备采用立柱框架式结构，由上横梁、下底座、立柱、压下辊轮箱、上下辊座、矫直辊、传动电机、减速机、传动轴、矫直辊微调装置等组成。

Straightening machine is one of the main machines for ERW pipe mill, which mainly eliminates stress after welding, corrects bending and clears pipe ovality. The machine adopts 6 rollers or 7 rollers (with 4 up 2 down or 3 up 4 down). WanXin can product various models from Φ32mm to Φ219mm.

The machine adopts column frame structure, consists of upper beam, lower base, stand column, press worm-gear case, upper and lower roller base, straightening roller, motor, reducer case, drive shaft and vernier device of straightening roll etc.



矫直机
Straightening machine

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管端平头倒棱机

Pipe end facing and chamfering machine

管端平头倒棱机主要用于对钢管管端进行铣削并去掉加工棱角。配备仿形倒棱刀，加工的坡口均匀美观。我公司也可以生产直径达Φ3000mm螺旋钢管机配套平头倒棱机。

Pipe end facing and chamfering machine is mainly used for milling the pipe ends and chamfering the edge of inside and outside. Set with shape copying chamfering knife, the treated groove is even and aesthetic. Our company can also produce SSAW mill chamfering machine.



Φ21-377mm 直缝焊管平头倒棱机
Φ21-377mm ERW pipe end facing and chamfering machine



Φ219-Φ3000mm 螺旋焊管平头倒棱机
Φ219-Φ3000mm SSAW mill chamfering machine

管端平头倒棱机选型表 Model list:

序号 Item#	型号 Model	产品规格(毫米) Pipe sizes(mm)	钢管长度(米) Pipe Length(M)	装机容量 Installed capacity(KW)	机械占地 Floor area(m²)
1	ERW-PT-100	Φ30-Φ114	6-12	70	4×15
2	ERW-PT-150	Φ40-Φ165	6-12	80	4×15
3	ERW-PT-300	Φ165-Φ325	6-12	60	4×20
4	ERW-PT-500	Φ219-Φ630	8-12	70	5×23
5	SSAW-PT-800	Φ219-Φ820	8-12	90	5×23
6	SSAW-PT-1400	Φ426-Φ1420	8-12	100	5×23
7	SSAW-PT-1800	Φ529-Φ1820	8-12	150	5×23
8	SSAW-PT-2500	Φ820-Φ2500	8-12	160	5×23

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钢管水压机

Hydraulic tester

钢管水压机主要用于对焊管进行压力试验，采用聚脲脂端面密封，配备油、水平衡系统，电脑记录、储存、打印、试验结果，具有保压稳定、安全性高等优点。

Hydraulic tester is mainly used for making pressure test for welded pipes, it adopts Polyurethane end face seal, sets with oil-water balance system, computerized record, store, print and test result etc. It owns steady pressure maintaining and high safety etc. advantages.



Φ21-Φ114mm 水压试验机
Φ21-Φ114mm Four workstation Hydraulic tester



水压机
Hydraulic tester

钢管水压机试验机型表 Model list:

序号 Item#	型号 Model	产品规格(毫米) Pipe sizes(mm)	钢管长度(米) Pipe Length(M)	压力等级(兆帕) Pressure(Mpa)	装机容量 Installed capacity(KW)	机械占地 Floor area(m²)
1	ERW-SY-80	Φ25-Φ85	5-7	≤50	65	5×12
2	ERW-SY-100	Φ30-Φ114	5-7	≤50	65	5×12
3	ERW-SY-150	Φ40-Φ165	5-8	≤50	75	5×12
4	ERW-SY-300	Φ165-Φ325	6-12	≤42	85	4×20
5	ERW-SY-500	Φ219-Φ630	8-12	≤21	65	4×22
6	SSAW-SY-800	Φ219-Φ820	8-12	≤21	85	4×22
7	SSAW-SY-1400	Φ426-Φ1420	8-12	≤21	100	4×22
8	SSAW-SY-1800	Φ529-Φ1820	8-12	≤21	120	4×25
9	SSAW-SY-2500	Φ820-Φ2500	8-12	≤21	160	6×30
10	SSAW-SY-3500	Φ1020-Φ3500	8-12	≤15	160	8×30

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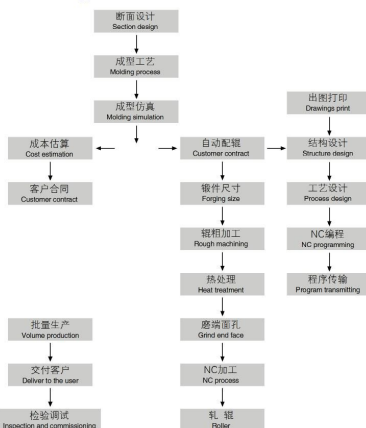
轧辊

Roller

公司设有产品研发部，并拥有各类加工制造设备、数控机床100多套，可设计制造10mm-660mm高频直缝焊管轧辊、各种冷弯型钢生产轧辊，以及相应规格方、矩管轧辊。公司一流的生产设备、雄厚的设计队伍及完善的测控手段，确保了轧辊模具的优质质量。

Setting with R & D department and equipped with various manufacturing facilities and NC machines 100 sets, WanXin can design and produce 10mm-660mm high-frequency welded pipe roller, all kinds of cold-formed steel production line roller, and corresponding square and rectangular roller. Our top-ranking manufacturing equipment, strong design team and perfect measuring control means, ensure the roller moulds being high quality.

轧辊工艺流程 The molding process of roller:



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轧辊
Roller

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