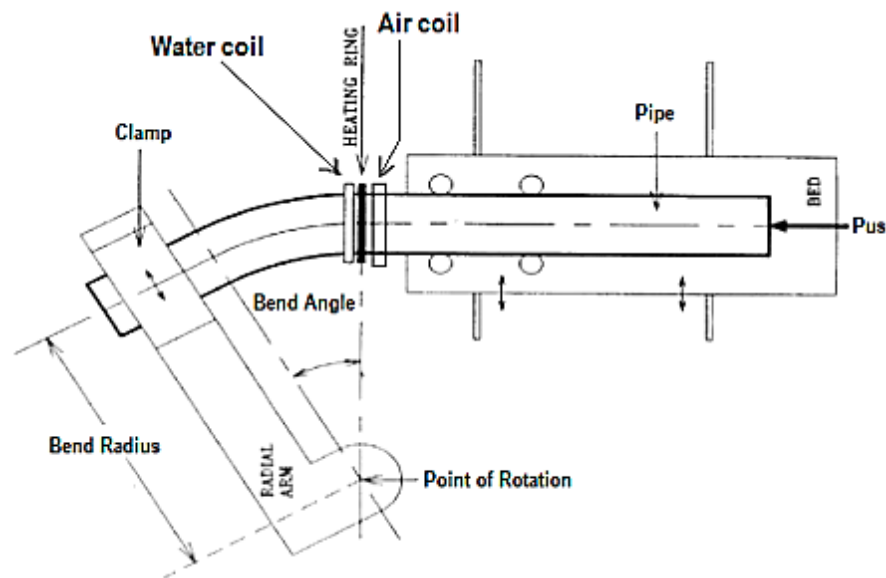


## Process Flow Chart Forming of Hot Induction Bends



The pre-inspected pipe to be kept on the pipe carriage and clamped



The induction coil and cooling coils to be mounted around the pipe



The radius of bend is fixed by adjusting the radius arm and front clamp





The pipe is now heated by induction to the temp of 815 - 1100 C.



Bending of the pipe to be started slowly and carried out at speed of 10 - 40 mm/min.



The bending operation is stopped at the specified angle of bend and predetermined arc length



Keep the bends on inspection platform for measurement of dimension & tolerances.



## Materials for induction bends

- Carbon Steel (Seamless/Weld Seam)
- Alloy Steel
- Stainless Steel
- High Chrome Steel
- High Nickel High Chrome Steel
- Inconel
- Monel
- Copper Alloy Titanium

## Applicable Standards / Specifications

- API 5L -LV
- MSS SP-75
- ASME B31.3
- ASME B16.49
- ASME B16.9
- PFI ES-24
- ISO 15590-1
- DNV OSF 101

