



HISTEEL

L S A W

LONGITUDINAL
SUB-MERGED
ARC
WELDED STEEL PIPE

HISTEEL CO., LTD.

60 years

Industrial experiences with trust and technical advance

HISTEEL CO., LTD. started with the establishment of HANIL IRON & STEEL CO., LTD. in 1957. HANIL started to produce ERW pipe in 1977 after take-over of the first pipe manufacturer in Korea. The pipe division was later-on separated from HANIL and incorporated as HISTEEL to strengthen the competitiveness by intensively focusing on the pipe business. Since then, HISTEEL has been making steady progress through continuing investment, development of new products and expansion of production range.

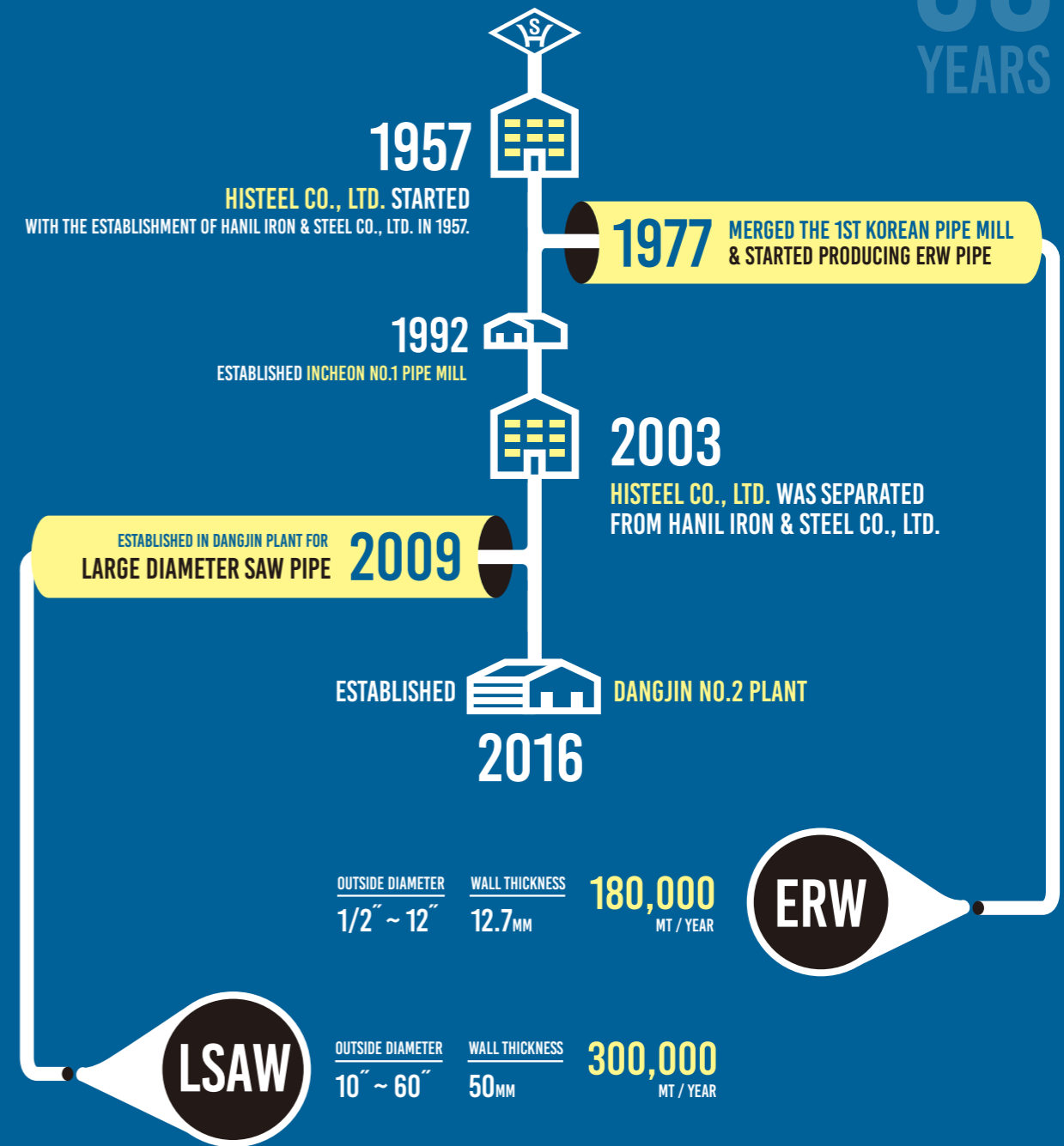
In 2009 HISTEEL established in Dangjin a Large-Diameter, Heavy-Wall Pipe mill with an annual capacity of 240,000MT to serve rising demand for energy pipes worldwide. HISTEEL's state-of-the-art facility holds a dominant position in product quality in the market, especially by having introduced the first Full Length Cold Expansion facility in Korea. This has set a milestone in the quality level of Korean Large-Diameter Heavy-Wall Thickness Pipe.

At the No.2 Plant in Dangjin, HISTEEL has developed the world's first Small-Diameter Heavy-Wall LSAW Pipe mill starting at 10" by using our own 40 years of accumulated experience. HISTEEL's unique JCO-Press enables LSAW pipe manufacture under the diameter of 14", which was before considered to be impossible.

This JCO facility produces Small-Diameter Heavy-Wall LSAW pipes from diameters 10" to 24" with an exceptionally heavy wall thickness up to 50mm. This enables broader and reliable LSAW solutions made from plates as an alternative to commonly used expensive seamless pipes. Small-Diameter Heavy-Wall LSAW Pipe can be used in applications such as Process-Piping for a super high pressure plant and offshore construction, as well as Line Pipe for oil & gas transportation, and special structural applications. Excellent wall-thickness and surface tolerances of plate materials processed on our modern JCO-Press assure extraordinary dimensional tolerances as a modern alternative old-fashioned seamless technology.

The driving forces of HISTEEL as a globally recognized pipe manufacturing company are loyalty, integrity, which has built trust and satisfaction for our customers. HISTEEL staffs are constantly motivated to offer customer-oriented solutions. HISTEEL is proud to be known as a trusted partner aiming to satisfy customers from all over the world since over half a century.

60 YEARS



QUALITY & SAFETY

ISO 9001:2008
API Q1

ISO 14001
ISO/TS 29001

OHSAS 18001
QMS 3183

CAPACITY

Thanks to its modern high-output three-roll-bending machine and full-body cold-expander HISTEEL has sufficient technical ability to supply large volume projects with hundreds kilometers of pipes to sophisticated customer specifications.

HISTEEL's JCO line provides new solutions that complement the technical limitation of ERW pipe and substitute seamless pipe. HISTEEL is able to manufacture Large-Diameter Square Pipe for mechanical applications, hollow-sections as well as seismic columns for high-rise buildings.

LINE & CAPACITY

ROLL BENDING

240,000 MT/YEAR

JCO

60,000 MT/YEAR

TOTAL
ANNUAL CAPACITY

MAX. **300,000** MT

ROUND PIPE

OUT DIAMETER

10" ~ 60"
(276.4mm ~ 1524mm)

WALL THICKNESS

6.35mm ~ 50mm

LENGTH

6m ~ 12.2m
(20ft ~ 40ft)

LARGE DIAMETER SQUARE PIPE

OUT DIAMETER

300 × 300mm ~ 1000 × 1000mm

WALL THICKNESS

9mm ~ 50mm

LENGTH

6m ~ 12.2m



APPLICATIONS

LINE PIPE

API 5L
EN 10208-1, 2
GOST ISO 3183



OFFSHORE STRUCTURALS

API 2B
EN 10219
EN 10225
DNV-OS-B101



PROCESS PIPING

ASTM A134 ASTM A691
ASTM A139 EN 10217-1,2
ASTM A671 KS D 3583
ASTM A672



PILING PIPES

ASTM A252
EN 10029
KS F 4602
KS F 4605



STRUCTURAL TUBULARS

ASTM A500
EN 10219
EN 10210
EN 10225
KS D 3566



MECHANICAL TUBING

EN 10296



PRODUCTION RANGE

HISTEEL’s various sizes of production from 10" to 60" in outer diameter ensures supply of a broad range of products. HISTEEL’s unique 10" Small-Diameter SAW Pipe and Large-Diameter Square Pipe provide unprecedented solutions to the industry.

ROLL BENDING LINE

OD		WALL THICKNESS (mm)																		
mm	Inch	6	7	9	10	14	16	18	20	22	24	26	28	30	32	34	36	38	40	45
457.2	18																			
508.0	20																			
558.8	22																			
609.6	24																			
660.4	26																			
711.2	28																			
762.0	30																			
812.8	32																			
863.6	34																			
914.4	36																			
965.2	38																			
1,016.0	40																			
1,066.8	42																			
1,177.6	44																			
1,168.4	46																			
1,219.2	48																			
1,270.0	50																			
1,320.8	52																			
1,371.6	54																			
1,422.4	56																			
1,473.2	58																			
1,524.0	60																			

JCO LINE ROUND PIPE

OD		WALL THICKNESS (mm)																			
mm	Inch	6	7	9	10	14	16	18	20	22	24	26	28	30	32	34	36	38	40	45	50
273.0	10																				
323.8	12																				
355.6	14																				
406.4	16																				
457.2	18																				
508.0	20																				
558.8	22																				
609.6	24																				

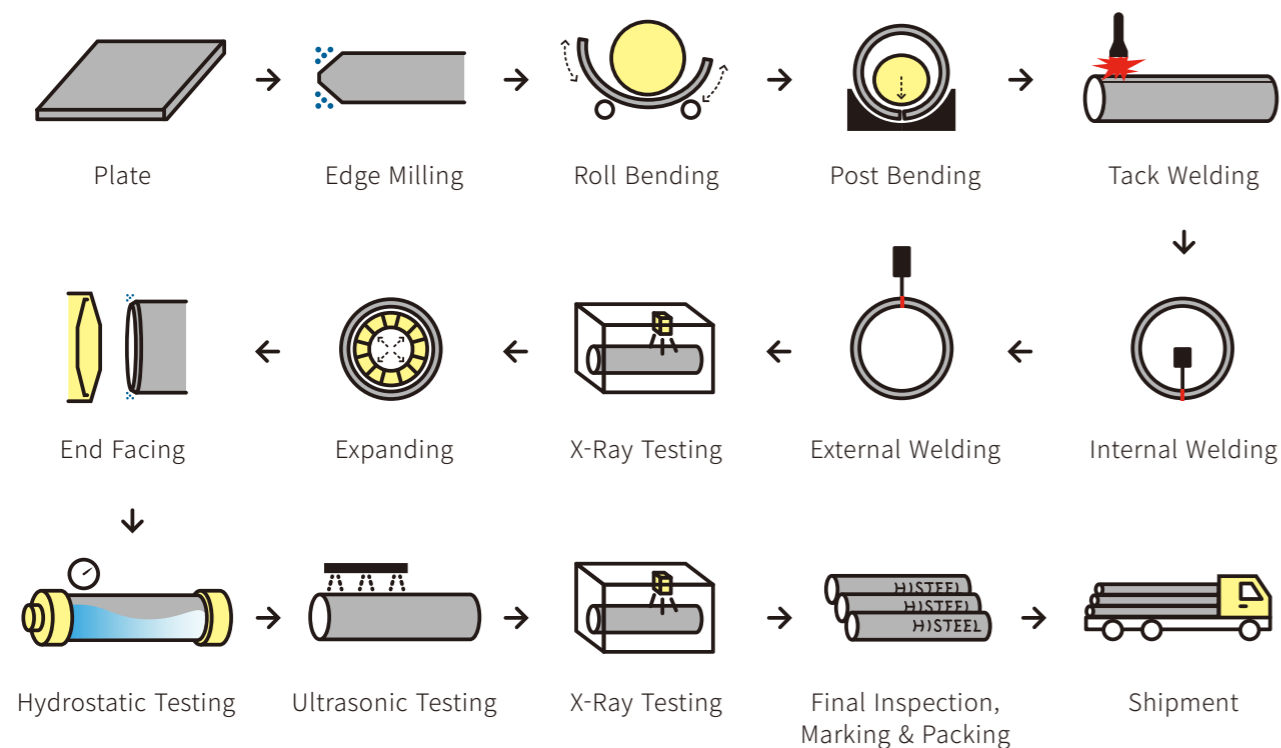
JCO LINE LARGE-DIAMETER SQUARE PIPE

OD	WALL THICKNESS (mm)											
SQ (mm)	9	12	16	19	22	25	28	32	36	38	40	45
300 X 300												
350 X 350												
400 X 400												
450 X 450												
500 X 500												
550 X 550												
600 X 600												
650 X 650												
700 X 700												
750 X 750												
800 X 800												
850 X 850												
900 X 900												
950 X 950												
1000 X 1000												

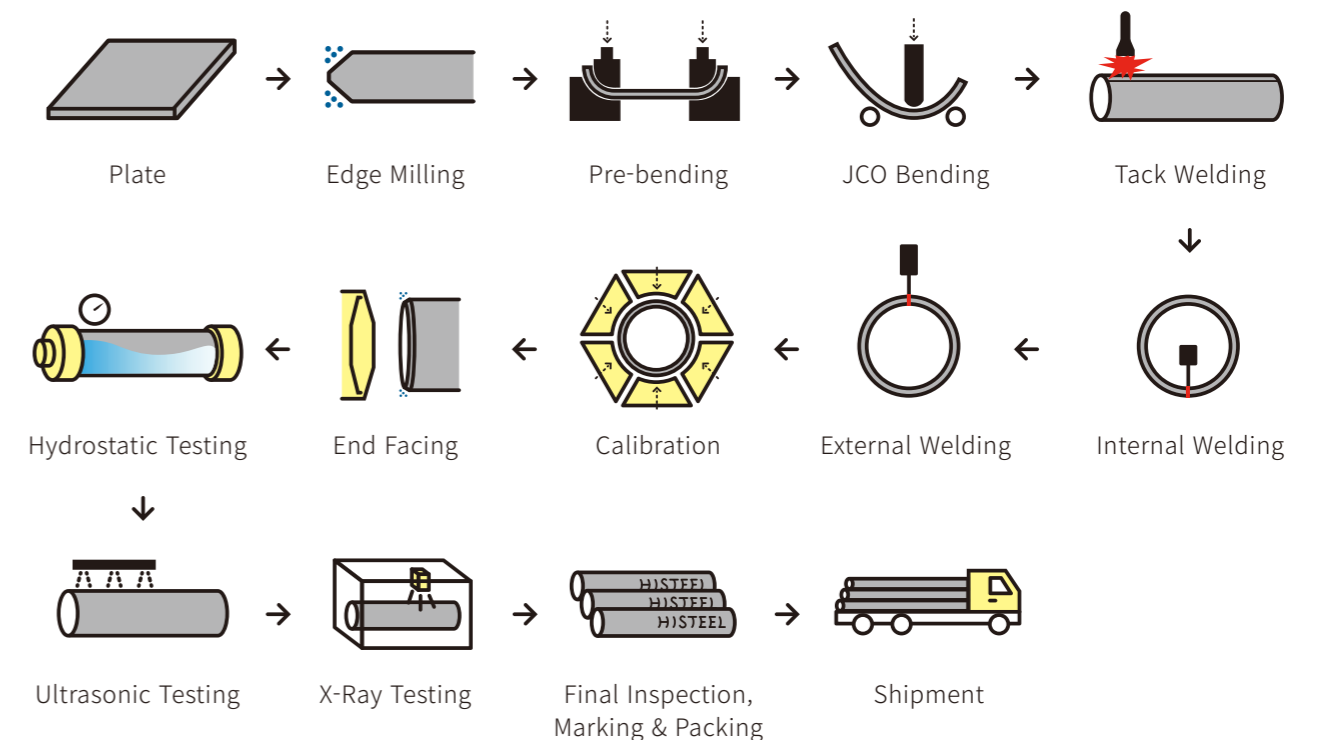
MANUFACTURING PROCESS

HISTEEL's shop layout is designed with a modern conveyor system which connects each process, making the work-flow highly efficient for mass production. Every manufacturing process is monitored by ERP system enabling traceability and reliability. HISTEEL is certified to ISO 9001, ISO 14001 and OHSAS 18001 helping ensure the excellent product quality to our clients.

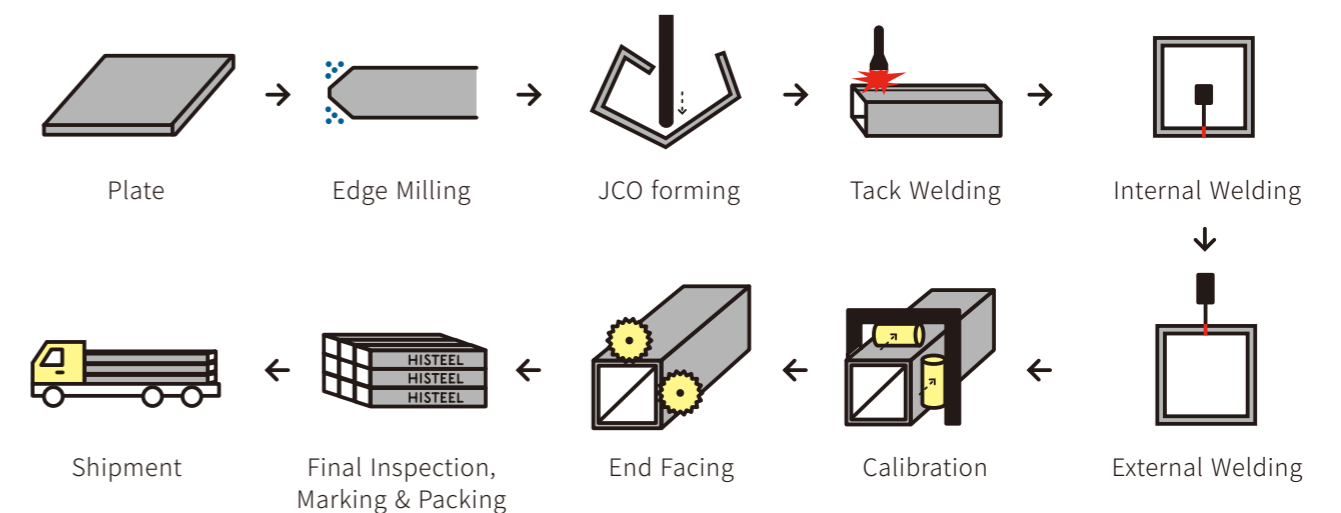
ROLL BENDING LINE



JCO LINE ROUND PIPE



JCO LINE LARGE-DIAMETER SQUARE PIPE



ROLL BENDING LINE

HISTEEL’s heavy duty 3-Roll-Bending machine enables to achieve high level of productivity within our scope of diameter and wall-thickness. HISTEEL’s Full-Body Cold-Expander is able to calibrate the pipes to perfect straightness and roundness over and above customer strict requirements.



1
EDGE MILLING
MACHINE

W.T. Max. 43mm

2
ROLL BENDING
MACHINE

3 Roll Type

O.D. 18" ~ 60"
(406.4mm ~ 1,524mm)

W.T. Max. 43mm

Length 20ft ~ 40ft

3
WELDING
MACHINE

Welding Type SAW

Internal 3-Pole

External 5-Pole

4
FULL BODY
COLD EXPANDING
MACHINE

W.T. Max. 43mm

Length 20ft ~ 40ft

Procedure
Pre Washing > Expanding
> Post Washing

5
HYDROSTATIC
TESTER

Pressure
Max. 350 bar

Test Duration
Max. 20 sec

6
ULTRASONIC
TESTER

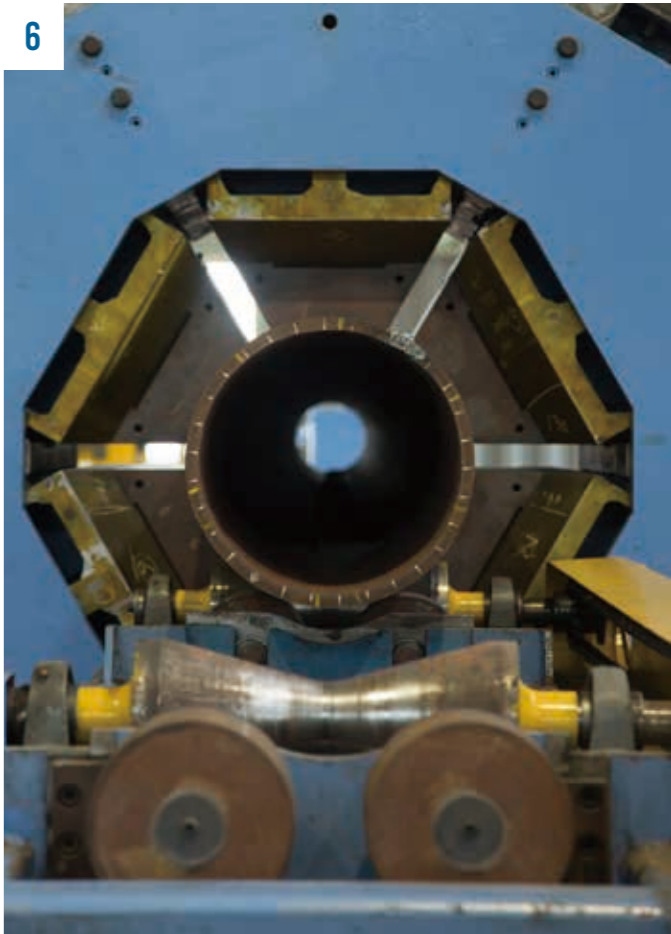
Number of Probe
22 channel Laser Auto Seam Tracking Type

7
X-RAY (2 SETS)

X-Ray Image Intensifier System
Real Time TV Screen Type

JCO LINE

HISTEEL’s JCO press line is specially geared to produce the smallest LSAW pipes in the world starting at 10". This Small-Diameter Heavy-Wall LSAW Pipe serves in subsea line-pipe, process-piping and offshore structural applications as a perfect alternative to seamless pipe with much better dimensional tolerances.



1
EDGE MILLING
MACHINE

W.T. Max. 50mm

2
PRE-BENDING
MACHINE

W.T. Max. 50mm

Length 20ft ~ 40ft

Simultaneous Bending on
both Edges

3
JCO PRESS
MACHINE

W.T. Max. 50mm

Length 20ft ~ 40ft

4
WELDING
MACHINE

Welding Type SAW

5
LONG-SEAM MILLING
MACHINE

W.T. Max. 50mm

Length 20ft ~ 40ft

Top Position Milling Type

6
CALIBRATION
MACHINE

W.T. Max. 50mm
6 Independent Calibrating Jaws

ADDITIONAL SERVICES

HISTEEL has access to quality-proven long-term service providers to satisfy additional customer specification requirements such as post weld heat treatment (PWHT), anti-corrosion coatings for environment protection and rust prevention. HIC/SSC testings are done in-house own laboratories using current modern state-of-the-art equipment monitored by certified bodies.

SOUR SERVICE



HYDROGEN INDUCED CRACKING(HIC) TEST

Test Method NACE TM0284

Solution

Solution A (Strong Acid)
Solution B (Weak Acid)

Capability

Vessel : 10 liter X 6ea
20 specimens / vessel

SULFIDE STRESS CORROSION CRACKING(SSCC) TEST

Test Method NACE TM0177, ASTM G39

Test Type Four Point Bend Test

Solution

Solution A (Strong Acid)
Solution B (Weak Acid)

Capability

Vessel : 10 liter X 6ea
20 specimens / vessel

POST WELD HEAT TREATMENT



Stress Relieved 590°C ~ 680°C
ASTM A671, A672, A691 CL22

Normalizing 900°C ~ 950°C
ASTM A671, A672, A691 CL32

* Hold time : 1inch / hour

COATING



3Layer PE Coating
DIN 30670, ISO 21809-1, CSA Z245-21

FBE / Dual FBE Coating
ISO 10080, CSA Z245-20, AS 3862, AWWA C213

Liquid Epoxy Lining

High Build Epoxy Coating

Zinc Rich Primer Coating

HISTORY

After its establishment in 1957, HISTEEL merged the first Korean pipe mill in 1977 and has produced steel pipe products with the pride of being the 1st Korean pipe manufacturer. HISTEEL has grown in the past 60 years, on the base of loyalty and trust. HISTEEL endeavors to continuously grow to become a plus 100-year company.

1950s	1960s	1970s	1980s	1990s	2000s		2010s
DEC.1957 Established Hanil Iron & Steel Co., Ltd. 	AUG.1965 Founded Korea Steel Association and selected as the 1st Chairman	MAY.1973 Selected as POSCO's 1st distributor JUL.1976 Established Seoul Works  NOV.1976 Established Pohang Coil Center AUG.1977 Installed No.1 pipe line at Seoul Works	DEC.1987 Implemented ERP System JUL.1988 Established Osan Works OCT.1988 Went Public 	JAN.1992 Established Incheon Mills  JAN.1994 Established Incheon Coil Center	MAR.2002 Obtained Japanese Industrial Standard Certifications for Steel Pipes JAN.2003 HISTEEL was strategically separated from Hanil Iron & Steel Co., Ltd.  FEB.2003 Established Incheon No.3 plant	MAR.2003 Established Jiangyin Hanil Steel Co., Ltd. in China  NOV.2005 Awarded the Presidential medal for export contribution OCT.2009 Established Dangjin Plant for LSAW Pipe for Oil & Gas 	DEC.2010 Approved SAW Vendor of Korea Gas Corporation (KOGAS) NOV.2012 Approved SAW Vendor of ADNOC & Takreer (UAE) MAR.2013 Approved SAW vendor of PETRONAS (Malaysia) and KNPC (Kuwait) DEC.2013 Awarded 50 million USD Export Tower DEC.2014 Awarded 70 million USD Export Tower AUG.2016 Installed JCO line specialized in small OD 

LOCATIONS

HISTEEL's manufacturing facilities in Dangjin and Incheon are closely situated to ocean going ports to ideally serve export overseas customers. We are strategically positioned in industrial complexes with well-equipped highway and railway access.

This enables us excellent turn-around times for the logistics of receiving pre-materials from our suppliers as well as dispatching of finished goods to class-A sea-ports.



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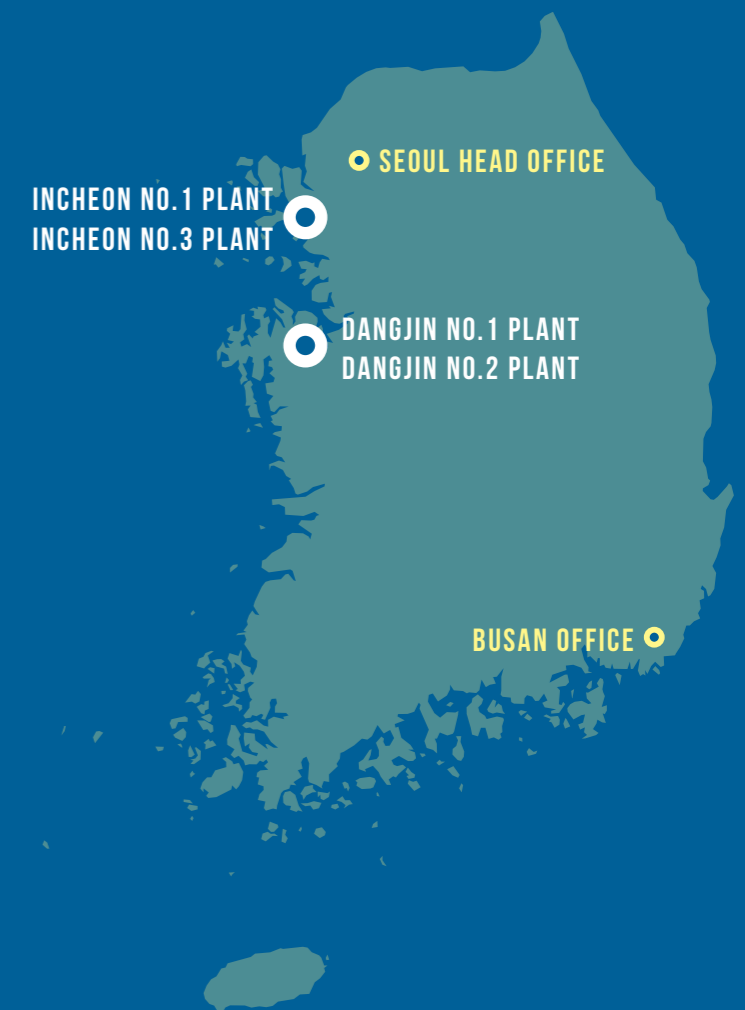


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