Global Leader of

**Anti-corrosion steel pipe**

Anti-corrosion steel pipe is processed through the preservation process, which can effectively prevent or slow down the process in the transport and use of chemical or electrochemical corrosion reaction of steel pipe.

- Internal and External Anti-corrosion pipe Standard
- Type of anti-corrosion steel pipe
- Anti-corrosion surface treatment process of spiral pipe
- Anti rust process
- Pipeline anti corrosion technology
- Oil pipeline anti-rust varnish
- Anti rust coating for oil pipelines
- Anti-corrosion surface treatment process of spiral pipe
- The difference between the anti-corrosion pipes and insulation pipes
- Anticorrosion performance of galvanized mild steel pipe

Internal and External **Anti-corrosion pipe** services:

Anti-corrosion steel pipe in the country is mainly used for petroleum, chemical, gas, heat, sewage treatment, water, bridges, steel pipes and other engineering fields. anti-corrosion steel pipe is divided into the following categories.

Typically the metal surface will be accompanied by dust oxide corrosion layer of oil contaminants salt or old paint.

Spiral steel pipe in the actual construction, long-term contact with liquid, air, soil and other media, so it need to add a layer of protection for products on corrode the metal surface to prevent corrosion and prolong the life spiral.
The 3PE Coating Steel Pipe enjoys good impact resistance, abrasive resistance, shock resistance, acid resistance, high quality and long service life.

Our 3PE coating steel pipe can be used in transferring natural gas, crude oil and refined oil product over long distance. Our 3 PE coating steel pipe can be also used in urban fuel gas piping system, storage tanks and groove piping system, protecting pipe in electricity and communication industries and water piping systems.

3PE preservation:
PE anti-corrosion pipe three-tier structure:
the first layer of epoxy powder (FBE> 100um), the second adhesive (AD) 170-250um, the third layer of polyethylene (PE) 2.5-3.7mm.

2PE preservation:
PE pipe anti-corrosion two-story structure,
the first layer adhesive (AD), the second layer of polyethylene (PE), two kinds of integration.

3PE Coating Steel Pipe
Coating Material : Epoxy Powder, Adhesion, Polyethylene Or Polypropylene, Cement Inside 
Standard: API 5L (PSL1, PSL2); GB/T 9711.1; 
Grade: Gr. B, X42, X46, X52, X60, X65, X70, X80; Q235B; Gr. C; 
Seam: SAW, SSAW; HSAW

Outside Diameter: 219-2020 MM 
Wall Thickness: 5-25MM 
Length: 4/6/12/18/21 meters 
End: Plain or Beveled 
Surface; Bare or Black Painted or Anti-corrosion, such as 3LPE;

Inspection: Hydraulic Testing, Eddy Current, Infrared Test; 
The third party, SGS, BV, can be accepted.

Certificate: Certificate: API 5L, API 5CT. ISO 9001; CE and so on.
The coating has the advantages of simple operation, no pollution, coating resistance and bending resistance, high temperature and other characteristics, has been applied widely overseas.

**Single-layer anti-corrosion epoxy powder pipe**

**Melting guitar epoxy powder coating**

It is nearly 30 years ago to develop a new type of coating, using electrostatic spray coating of epoxy powder coating, the first film. The coating is coated with easy to operate, pollution-free, coating and anti-bending performance impact, and of high temperature, in foreign countries has been widely used.

Coating Material: Epoxy Powder, Adhesion, Polyethylene Or Polypropylene, Cement Inside

Standard: API 5L (PSL1, PSL2); GB/T 9711.1;
Grade: Gr. B, X42, X46, X52, X60, X65, X70, X80; Q235B; Gr. C;
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Outside Diameter: 219-2020 MM
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End: Plain or Beveled
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Inspection: Hydraulic Testing, Eddy Current, Infrared Test;
The third party, SGS, BV, can be accepted.

Certificate: Certificate: API 5L, API 5CT, ISO 9001; CE and so on.
High-density polyethylene jacket pipe is widely used in oil pipelines, gas pipelines, urban heating pipes, water pipes, electricity and other corrosion engineering, product quality and service by the users of a good level.

High Density Polyethylene (HDPE) Jacketed System is designed for piping systems above or below ground suitable for inside or outside applications. High quality polyurethane foam insulation combined with a durable watertight jacket supplied in 20’ or 40’ lengths, means an economical, high-quality system.

High density polyethylene jacket corrosion structure: the outer surface of pipe wrapped in high-density polyethylene material, with a high mechanical strength and excellent corrosion resistance, can protect the steel in the transportation, installation and use of the process to avoid external factors the damage. Manufacture of stent should be added antioxidants, UV stabilizers and carbon black, etc. Polyethylene jacket tube easy to aging, such as open storage tarpaulin and other items appropriate to cover, dumps should stay away from high heat and fire, anti-corrosion steel pipe made after the ban exposure, sudden cold, or polyethylene jacket tube easy to crack, the impact product performance and service life.

Calculated as follows:
OD ≤ 400mm, the upper and lower deviation, and = 0.1 × of the nominal wall thickness of +0.2
Diameter ≥ 400mm, the upper and lower deviation = 0.15 × the sum of the nominal wall thickness of +0.2

3PE Coating Steel Pipe
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Standard: API 5L (PSL1, PSL2); GB/T 9711.1;
Grade: Gr. B, X42, X46, X52, X60, X65, X70, X80; Q235B; Gr. C;
Seam: SAW, SSAW; HSAW

Inspection: Hydraulic Testing, Eddy Current, Infrared Test;
The third party, SGS, BV, can be accepted.

Certificate: Certificate: API 5L, API 5CT. ISO 9001; CE and so on.

Resistant to chemical corrosion, resistance to cathodic disbandment resistance, mechanical damage to properties.
Three-layer PE/PP coating is characterized by excellent corrosion-proof performance, insulatibity, relatively long service life and mechanical damage resistance.

It is widely used in coating for all kinds of major pipeline engineering.

**3PP preservation:**

PP three-tier structure of anti-corrosion pipeline: the first layer of epoxy powder (FBE50 – 100um), the second adhesive (AD) 250 – 400um, the third layer of polypropylene (PP) 1.4 – 4.0mm. Three of the integration, and steel pipe with a good solid coating, Coating temperature up to 110 degrees.

Diameter of Φ159 – Φ1220

**2PP preservation:**

PP anti-corrosion pipe two-story structure: the first layer adhesive (AD), the second layer of polypropylene (PP), two kinds of integration, three layers thick with the same PP.
Cement mortar lining can ensure a safe and abundant water supply for your water customers for many years to come.

Cement will also extend pipe life by inhibiting the corrosion of ferrous materials and preventing future rust and tube regulation build up.

Water pipe or pipe through the centrifuge tube wall spraying machine in the formation of 8 – 16 mm of cement coating, a major role in the protection of water quality. Imperial produces quality linings per AWWA standard C-205, API practice 10E, or per your Custom-specified mix.

A durable, cost-effective, time proven choice for protecting steel pipe interiors for over a Century. Appropriate for above or below-ground applications in potable and reclaimed water systems.

Diameter range is Φ325 – Φ2220

Inspection: Hydraulic Testing, Eddy Current, Infrared Test;
The thired party, SGS, BV, can be accepted.

Certificate: Certificate: API 5L, API 5CT, ISO 9001; CE and so on.

Resistant to chemical corrosion, resistance to cathodic disbondment resistance, mechanical damage to properties.
When the corrosion of steel in more types of media, such as acids, alkalis, salts, oxidants and water vapor, etc., the coating must be chemically inert, acid salt corrosion, the coating should be compact structure, water permeability, adhesion, tough fullness. Such cases for IPN8710 corrosion.

Water supply pipes within the wider variety of corrosive media, there is acid, alkali, salt, oxidizing and water vapor, etc., coatings must be chemically inert, acid and alkali salt corrosion, the coating should be compact and water permeability, strong adhesion, tenacity fullness.

IPN8710 primer: from polyurethane polyethylene, modified epoxy resin, non-toxic anti-rust pigment, filler, additives such as composition, room temperature curing to form interpenetrating networks, film structure, dense, acid, alkali, salt, rust-proof performance, strong adhesion.

IPN8710 finish: from epoxy, rubber and resin-modified, non-toxic anti-rust pigment, filler, additives etc.. Excellent chemical resistance, non-toxic, anti-microbial erosion.

Uses: IPN8710 primer for water supply pipeline wall corrosion grounding coating;
Diameter range is Φ325 – Φ2220

IPN8710 finish for water supply pipeline wall corrosion finish.
Internal and External Anti-corrosion steel pipe Standard

钢内内外防腐生产线
Internal and External Anti-corrosion Steel Pipe Production Line

防腐生产线主要是对各类钢内内外表面进行防腐涂层加工。我们公司拥有φ920、φ2020，3PP/3PE/FBE外防腐生产线二台套，年生产能力250万平方米，内防腐生产线二台套，年生产能力300万平方米。

Anticorrosion production line mainly provides coating for all types of steel tubes. Two sets of machine unit for φ920 and φ2020 3PP/3PE/FBE external anticorrosion can provide yearly 2,500,000 sq. meters capacity. The other two sets of machine unit for internal anticorrosion have annual production capacity 3,000,000 sq. meters.

SY/T0315-2005《钢质管道单层熔结环氧粉末外涂层技术规范》环氧粉末外涂层厚度
SY/T0315-2005 ‘Technological standard of FBE external fusion bonded epoxy coating for steel pipeline’. The external coating thickness of FBE:

<table>
<thead>
<tr>
<th>Coating grade</th>
<th>Min. thickness (µm)</th>
<th>Reference thickness(µm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>普普通通General grade</td>
<td>360</td>
<td>360-400</td>
</tr>
<tr>
<td>加强级Reinforcement grade</td>
<td>460</td>
<td>460-500</td>
</tr>
</tbody>
</table>

Q/CHCS538-2002《埋地钢质管道双层熔结环氧粉末外涂层技术标准》
Q/CHCS538-2002 “Technological standard of FBE external double fusion bonded epoxy coating for buried steel pipeline”

<table>
<thead>
<tr>
<th>Coating grade</th>
<th>Min. thickness (µm)</th>
<th>Thickness of bottom</th>
<th>Thickness of surface</th>
</tr>
</thead>
<tbody>
<tr>
<td>普通级 General grade</td>
<td>≥250 µm</td>
<td>≥260 µm</td>
<td>≥370 µm</td>
</tr>
<tr>
<td>加强级 Reinforcement grade</td>
<td>≥800 µm</td>
<td>≥300 µm</td>
<td>≥500 µm</td>
</tr>
</tbody>
</table>

如果业主对涂层厚度有特殊要求，则按供需双方商定的厚度要求，但底层与面层的厚度比宜控制在1:2~1:1.5之间。

If the owner proposes a specific requirement about the coating thickness, it can be carried out according to the thickness requirement recommended by the powder manufacturer, but the thickness of bottom to that of surface should be between 1:2 and 1:1.5.

CAN/CSA-Z245.20-02《加拿大钢质管外壁环氧粉末涂层技术标准》
CAN/CSA-Z245.20-02 ‘Canadian technological standard of FBE external coating for steel pipeline’

涂层的公称厚度和最大厚度应由买方确定，最小厚度应为300µm。
The nominal thickness and maximum thickness of coating should be determined by purchaser, the minimum thickness should be 300µm.

钢管内防腐主要质量指标

Fourteenth: Main quality index of internal coating of steel pipe

<table>
<thead>
<tr>
<th>Coating grade</th>
<th>Min. thickness (µm)</th>
<th>Dry-t hin thickness</th>
</tr>
</thead>
<tbody>
<tr>
<td>普通级 General grade</td>
<td>≥206</td>
<td></td>
</tr>
<tr>
<td>加强级 Reinforcement grade</td>
<td>≥250</td>
<td></td>
</tr>
<tr>
<td>特别加强级 Special reinforcement grade</td>
<td>≥300</td>
<td></td>
</tr>
</tbody>
</table>

注：焊接处的防腐层厚度，不得低于管体防锈层规定厚度的80%。

Note: the coating thickness on weld seam should be not less than 80% of coating thickness on pipe body.
Anti-corrosion steel pipe is processed through the preservation process, which can effectively prevent or slow down the process in the transport and use of chemical or electrochemical corrosion reaction of steel pipe.

2PE/3PE preservation:

2PE/3PE corrosion structure: the surface of the steel and epoxy powder electrostatic spraying adhesive side wound, lateral wound polyethylene coating, combined with the excellent performance of the three, thus significantly improving the overall quality of pipeline corrosion. Resistant to chemical corrosion, resistance to cathodic disbondment resistance, mechanical damage to properties.

### Main quality index of external coating of steel pipe

DIN 30670 "Polyethylene coatings of steel pipes and fittings": The minimum coating thickness should be selected according to the following table:

<table>
<thead>
<tr>
<th>钢管尺寸</th>
<th>Size</th>
<th>最小厚度 Mn. thickness: (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>DN ≤ 100</td>
<td>&lt; 100</td>
<td>1.8 2.5</td>
</tr>
<tr>
<td>&gt;100 ≤ DN ≤ 250</td>
<td>100 &lt; DN ≤ 250</td>
<td>2.0 2.5</td>
</tr>
<tr>
<td>&gt;250 ≤ DN ≤ 500</td>
<td>250 &lt; DN ≤ 500</td>
<td>2.2 3.0</td>
</tr>
<tr>
<td>&gt;500 ≤ DN ≤ 800</td>
<td>500 &lt; DN ≤ 800</td>
<td>2.5 3.5</td>
</tr>
<tr>
<td>DN &gt; 800</td>
<td>DN &gt; 800</td>
<td>3.0 3.5</td>
</tr>
</tbody>
</table>

SY/T0413-2002 "Technical standard of polyethylene coating for buried steel pipeline": The minimum thickness of 3PE/2PE coating:

Note: the coating thickness on weld seam should be not less than 70% of specified value.

<table>
<thead>
<tr>
<th>钢管公称直径</th>
<th>Nominal diameter of steel pipe (DN)</th>
<th>涂层总厚度 PE coating (μm)</th>
<th>胶粘剂厚度 Adhesive (μm)</th>
<th>防腐层最小厚度 (mm) Min. thickness of coating</th>
</tr>
</thead>
<tbody>
<tr>
<td>DN ≤ 100</td>
<td>1.0</td>
<td>1.0 - 2.5</td>
<td>1.6 2.5</td>
<td></td>
</tr>
<tr>
<td>100 ≤ DN ≤ 250</td>
<td>2.0</td>
<td>2.0 - 2.5</td>
<td>2.0 2.5</td>
<td></td>
</tr>
<tr>
<td>250 ≤ DN ≤ 500</td>
<td>2.2</td>
<td>2.2 - 2.9</td>
<td>2.2 2.9</td>
<td></td>
</tr>
<tr>
<td>500 ≤ DN ≤ 800</td>
<td>2.5</td>
<td>2.5 - 3.2</td>
<td>2.5 3.2</td>
<td></td>
</tr>
<tr>
<td>DN &gt; 800</td>
<td>3.0</td>
<td>3.0 - 3.7</td>
<td>3.0 3.7</td>
<td></td>
</tr>
</tbody>
</table>

DIN 30670 "Polyethylene coating of steel pipes and fittings": The minimum thickness of 3PE/2PE coating:

<table>
<thead>
<tr>
<th>钢管公称直径 (DN)</th>
<th>Nominal diameter of steel pipe</th>
<th>防腐层最小厚度 (mm) Min. thickness of coating</th>
</tr>
</thead>
<tbody>
<tr>
<td>DN ≤ 100</td>
<td>1.3</td>
<td></td>
</tr>
<tr>
<td>125 ≤ DN ≤ 250</td>
<td>2.0</td>
<td></td>
</tr>
<tr>
<td>300 ≤ DN ≤ 500</td>
<td>2.2</td>
<td></td>
</tr>
<tr>
<td>DN &gt; 500</td>
<td>2.5</td>
<td></td>
</tr>
</tbody>
</table>
Anti-corrosion surface treatment process of spiral pipe

Anti-corrosion steel pipe in the country is mainly used for petroleum, chemical, gas, heat, sewage treatment, water, bridges, steel pipes and other engineering fields. Anti-corrosion steel pipe is divided into the following categories.

Typically the metal surface will be accompanied by dust oxide corrosion layer of oil contaminants salt or old paint. Dense oxide layer is an oxide layer formed in the forging steel produced by high temperature, usually attached relatively firmly, but more brittle than the steel itself, and the cathode itself, will accelerate corrosion of metal. It do not remove these substances directly affect paint adhesion of the entire layer.

Spiral steel pipe in the actual construction, long-term contact with liquid, air, soil and other media, so it need to add a layer of protection for products on corrode the metal surface to prevent corrosion and prolong the life spiral.

Spiral steel pipe into the pipe unit, the multi-channel rolling rolls, gradually rolled strip, a gap is formed with a circular opening tube, squeeze rollers to adjust the amount of reduction, so that a gap control in ~ 3mm, and to weld the ends flush.

(1)If the gap is too large, resulting in reduced proximity effect, lack of eddy heat weld together indirectly arising crystal fusion or cracking are not bad.

(2)If the gap is too small, causing the proximity effect increases, excessive heat welding, weld cause burning; or weld extruded to form a pit after rolling, affecting the quality of the weld surface.

After heating the two edges of the tube to the welding temperature, the lower squeeze rollers squeeze the metal grains to form a common mutual penetration, crystallization, forming a solid weld. If spiral pipe extrusion pressure is too small, the crystal is formed on the small number of common weld metal strength decreases, the cracking force; if the pressing force is too large, will make the extruded molten weld metal, not only reduces the weld strength, and will generate a lot of internal and external burrs, and even cause the welding seam defects ride.

Pipeline anti corrosion technology

Ultrasonic detector gas leak detection system is different from the specific design of the sensor to sense that it is limited to a specific gas, but rather to detect sound.

Ultrasonic focusing on industrial leak detection, leak detection and predictive maintenance, products and solutions in steel and non-ferrous metals, tobacco and food and beverage, automotive, chemical and oil and gas, mining and cement, glass manufacturing, electricity and cleaning system, military, paper and printing, rail transport, water treatment, infrastructure, subway fan and large air conditioning systems, port automation, and many other industries are widely used.

Any gas leakage through holes will generate eddy currents, ultrasound will be part of the band, making the ultrasonic detector leak detection system capable of sensing any kind of gas leak. Pipeline anti corrosion
technology with a detection system scan, you can hear the sound from the headphones leak or see changes in
the digital signal.

The closer to the leak, the more obvious. If the site noisy environment, can reduce the reception area and
shadowing hose antagonistic ultrasound. Also the ability to adjust the frequency of the ultrasonic detector leak
detection system also makes the background noise is reduced.

You can check the air pressure systems, test pressure used by telecommunications companies and cable.
Tanks, pipes, and hoses can be detected by the pressure. And a vacuum system, inter-vortex exhaust, diesel
engine fuel intake system, vacuum tanks, marine tanks, watertight doors, material handling systems, pressure
vessels and piping inside and outside the gas-liquid leakage.

Pipeline anti corrosion technology detection method can leak air, gas, steam and liquids pipeline and a variety
of equipment to be checked. If the ultrasonic generator and attached with the use, but also on the refrigerator,
sealed container, air conditioning systems, tires, compressor and various fluids, such as sealed state pipeline
inspection, improving the environment, a powerful tool for saving energy.

**Anticorrosion performance of galvanized mild steel pipe**

Galvanized mild steel pipe is cheap and anticorrosive performance is relatively better related stainless steel
pipes. Galvanized pipe in the design and production of an important form of full use of the standard design,
galvanized mild steel pipe is generally pipe joints, mainly for low domestic water pipes, low cost, good
corrosion resistance, connections are made using British Elbow, tee, short sections to achieve, and generally
do not have the means to connect welding, welding will destroy the zinc coating, welding slag prone plus,
porosity phenomenon and the impact of anti-corrosion effect.

Galvanized mild steel pipe is to use the principle of electrochemical corrosion, cathodic protection and
consumed mainly in the steel and zinc anode contact, carbon steel a cathode, zinc as the anode, thus ensuring
that the steel from corrosion. Generally used for process instrumentation or process water piping is threaded
connections for multi-temperature low-pressure pipeline medium without danger. Galvanized mild steel pipe
are generally after surface treatment on its surface coated with a layer of protective film, with hot dip and
cold-plated to prevent corrosion.

Galvanized mild steel pipe because of high potential than iron, zinc corrosion first, so it protected the iron pipe,
and if not threaded connection, you can also use welding methods, welding room ventilation must be good,
because zinc oxide is toxic to humans with acid electrode J422 can be welded.

**Anti-corrosion surface treatment process of spiral pipe**

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**Anti-rust coating for oil pipelines**

(1) pipe rust rust → brush painting asbestos powder material mixing the clay piece of barbed wire wrapped insulation materials → wiping asbestos cement protective shell corrosion paint brush.

(2) Pipeline brush rust rust → dressing perlite tile galvanized wire → asphalt moisture barrier protection layer → outsourcing galvanized iron brush finish.

(3) pipe rust rust → up brush package superfine wool shell (or rock wool, polyurethane foam cool tile) → (aluminum foil or asphalt shingle) moisture barrier protection layer → galvanized iron finish.

(4) Pipeline brush rust rust → direct injection polyurethane foam aluminum foil in the pipeline → coat protective layer of galvanized iron.

Basic requirements rust layer of oil pipeline: according to the production process, the long-distance transport conditions and open dumps time, oil pipeline rust should have the following properties: good workability, safety and environmental protection, fast drying; paint bright, transparent, non-coding cover logo, do not cover the steel surface rust state; oil pipeline to withstand wind, sun, rain and other environmental conditions affect the rust layer should have good weather resistance; during handling and transport of oil pipeline there is shock, bumps and shocks and other destructive factors, rust layer should have good impact resistance; during shipping, humid Tropics job, rust layer should have good moisture resistance, salt spray resistance; cold in winter regional and summer desert areas, the ambient temperature can reach -30 ~ 60 ℃, rust layer should have good temperature variability.
The difference between the anti-corrosion pipes and insulation pipes

Anticorrosion insulation pipes generally refers to the anti-corrosion pipes and insulation pipes, both of which have strong antiseptic properties, but there are differences in the purposes.

**Anticorrosive pipe**

Anticorrosive pipe is generally use ordinary spiral steel pipe, straight seam steel pipe, seamless steel tube and then through the method of anticorrosion coating, electric protection, such as epoxy anticorrosion technology, and mainly used in pipeline construction, so that you can avoid the soil, air and medium (such as oil, natural gas, etc.) material for pipe corrosion, which can improve the service life of steel pipe and make more safety in pipeline construction.

**Insulation pipe**

Insulation pipe is generally use ordinary spiral steel pipe, straight seam steel pipe, seamless steel pipe heat preservation material on its surface figure, which mainly used in heating pipeline construction.
About Sunny Steel

Sunny Steel provide a wide range of steel products as Steel pipes, Seamless tube and seamless pipes, Alloy pipes, Pipe fittings, Composite steel pipe used in the industry, construction etc.

We are looking forward to get in contact by phone or email and we hope that you enjoy our website.

More than ten years of profound knowledge turn Sunny Steel to your competent partner as trading house for valves, fittings and tubes of stainless steel.

The name Sunny Steel stands for certified quality, because of this all products of our wide range consists to demanding norms and the highest standards.

Sunny Steel also stands for know-how and effective service.

Best solutions for your profit

Our qualified team in our export department in China is always at your disposal and will help you. Profit by the knowledge of Sunny Steel which disposes to a intern data base.

Get in Touch

If you are interested in our products or cooperating with us, even having a comment or a suggestion please contact us now, for more detailed information.

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