



Special tailor made pipes and mechanical products



www.cenainterpipes.it





Cena Interpipes is an Italian private Company, located in Brescia (Italy), specialized in the mechanical machinings of deep drilling, coring, boring, honing and turning, with a strong orientation to Customers requirements and their high qualitative Standards we achieve by means of the exact coordination among the steps of the whole cycle of production - including the drawings of ad-hoc equipment and tools, the supply of the base material, the heat treatment, the mechanical machining, the not destructive testings and the final inspection. All our products are delivered with all the technical necessary/required documentation.

The flexibility of our structure, together with very skilled personnel and technologically advanced machineries and equipment, make **Cena Interpipes** the ideal partner for the manufacturing of pipes and tubular components in compliance with the required specifications.

Our main excellence products are:

- special tailor made pipes that for dimensional parameters (diameter, thickness, length), materials, quantity or delivery times are not easily available from the conventional production ways;
- heavy and thin wall seamless pipes;
- special tailor made hole finishings on medium and great size mechanical components and hydraulic cylinders;

in any types of material with **very tight dimensional tolerances with lengths till 22 m, outside diameters till 1600 mm and weights till 30 ton** starting from seamless pipes or forged items.

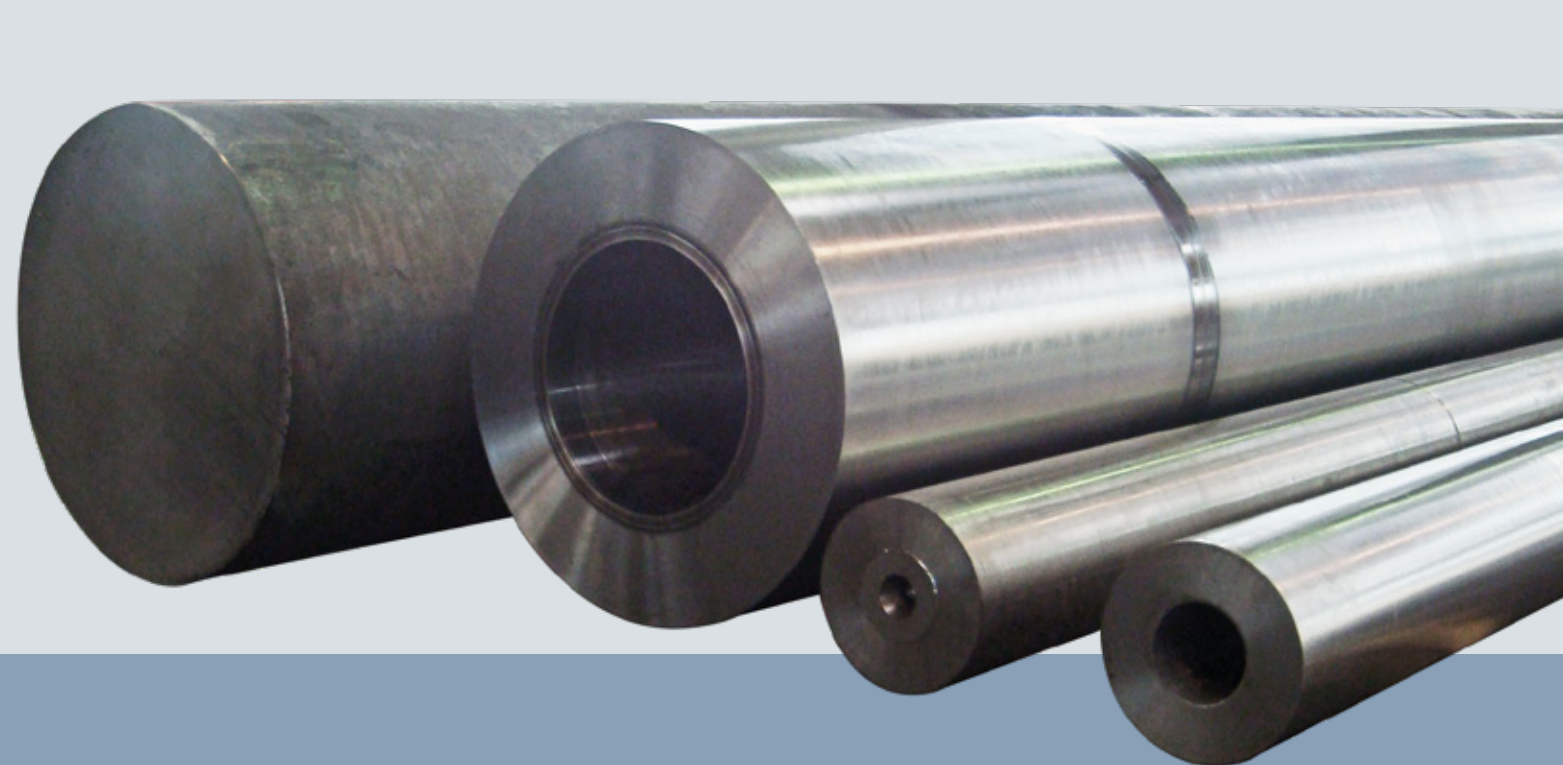
The use of chlorine free, chlorine derivatives free and active sulphur free oil allows the mechanical machinings on a vast range of materials (carbon steel, alloy steel, inox, duplex, super duplex, super alloys, hastelloy, brass, copper, etc.) with no influence on the characteristics of the final product.

PRECISION MECHANICAL MACHININGS

- Deep drilling
- Coring
- Boring
- Honing
- Turning
- Mechanical machining as per drawing

PRODUCTS

- Bored pipes
- Forged pipes
- Heavy and thin wall thickness pipes
- Honed pipes
- Buckle arrestors
- Special tailor made pipes
- Tubular items as per drawing
- Taper joints
- Drilled / hollow bars
- Drilled column for presses
- Drilled shafts
- Cylinder bodies as per drawing
- Risers



Deep drilling

On items of every dimension starting from I.D. 30 mm and length up to 22 m.

Deep drilling of:

- Column for presses
- Drilled / hollow bars
- Naval shafts
- Spindle shafts
- Tail shafts
- Turbine shafts

Coring

Manufacture of ad-hoc equipment, in compliance with Customer requirements for the optimization of the recovery of the cored material and the reduction of the cutting scrap.

Coring of:

- Special forged items
- Special tailor made pipes
- Solid bars



Boring

Boring up to I.D. 1.200 mm and length up to 22 m in only one way.

Boring of:

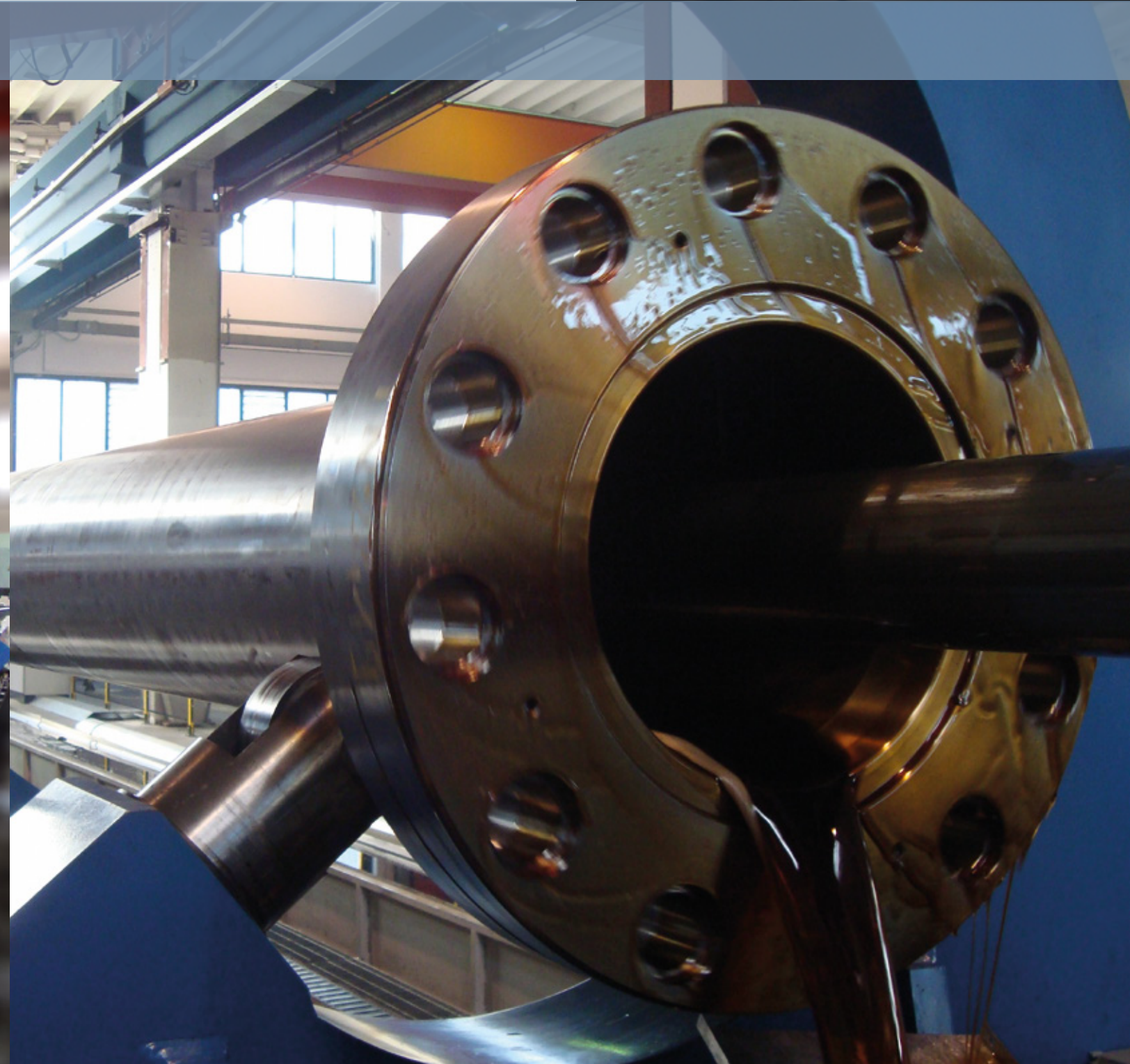
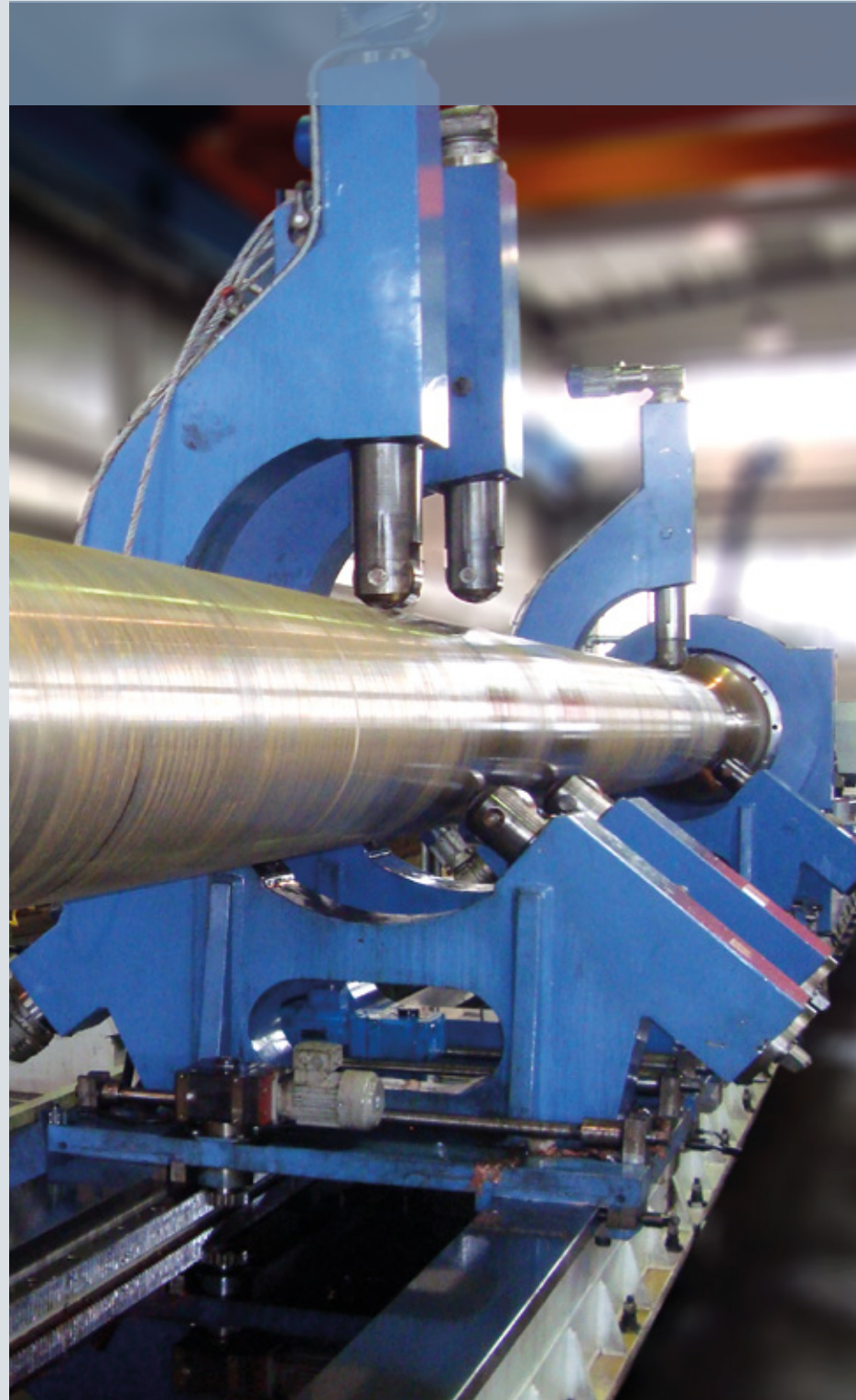
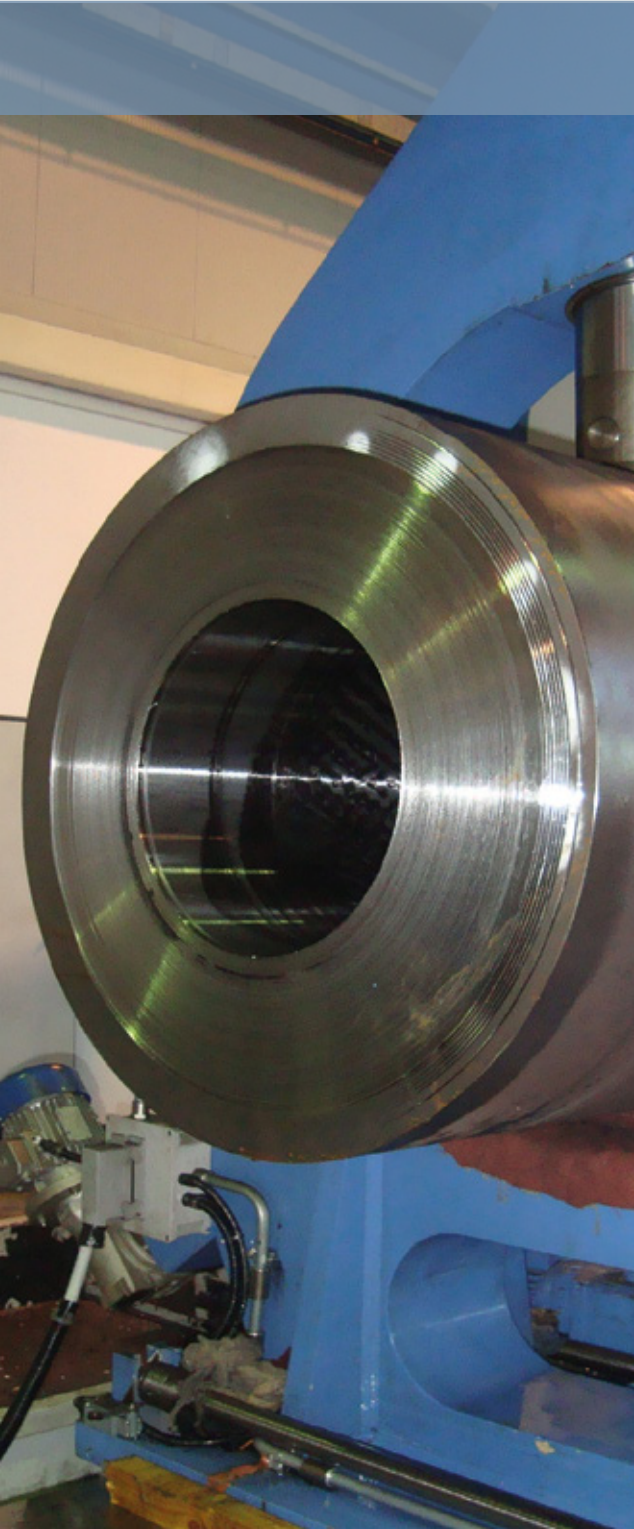
- Drilled / hollow bars
- Risers
- Shafts and special forged items
- Special and tailor made pipes
- Special cylinder bodies

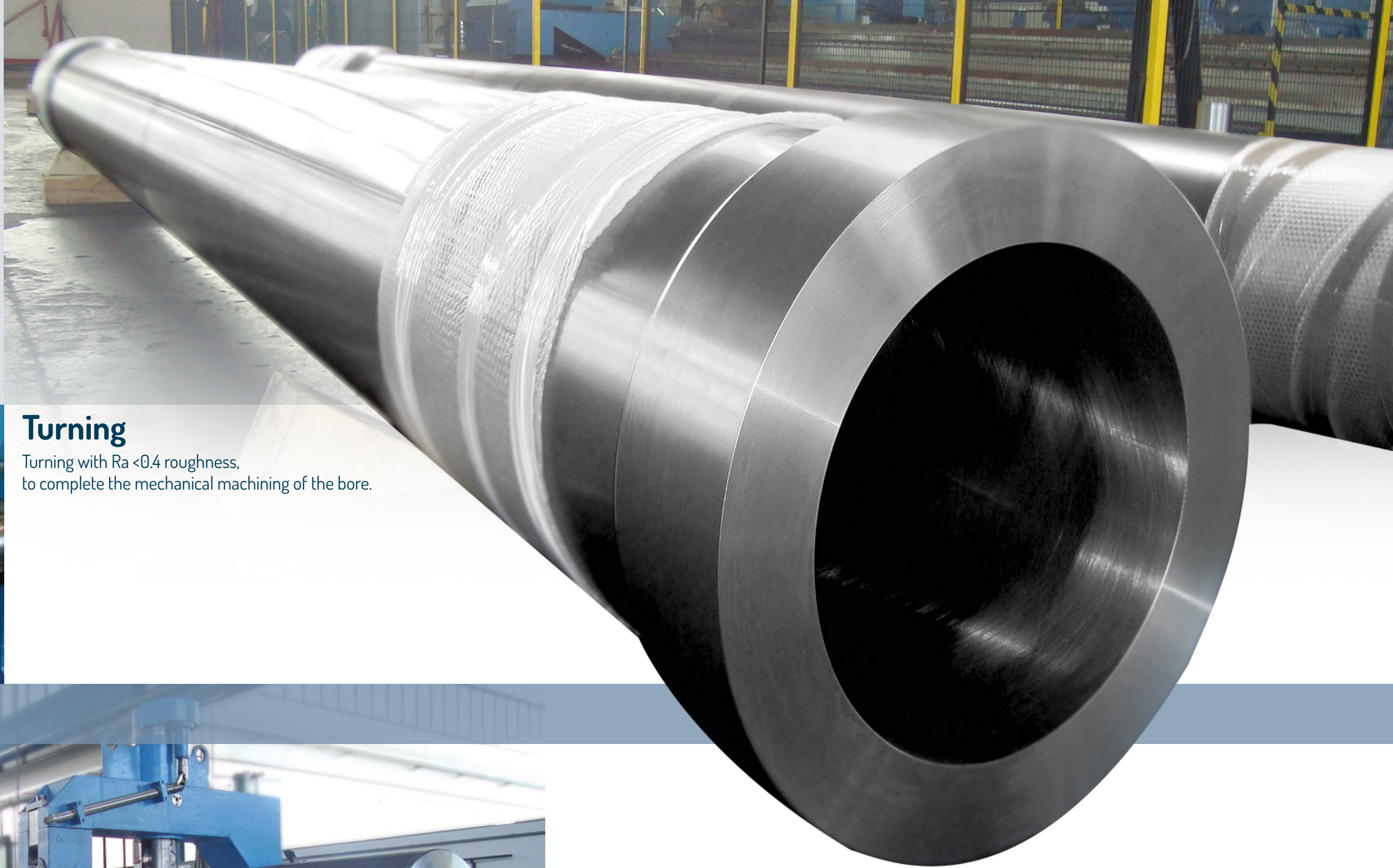
Honing

Honing of the inside surface up to I.D. 1.200 mm, H7 tolerances and < Ra 0.2 roughness.

Honing of:

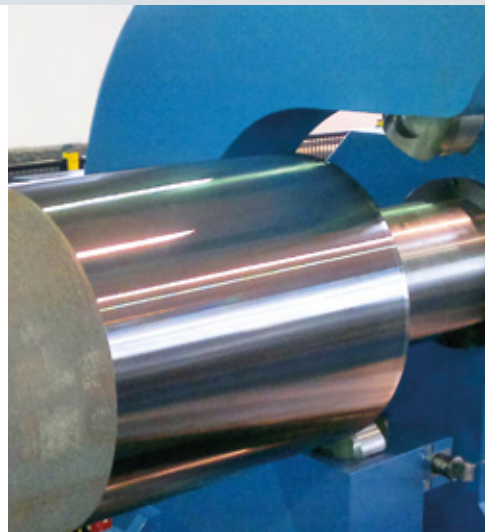
- Cylinder pipes
- Naval shafts
- Recovery of pre-existent bores
- Risers
- Special cylinder bodies as per drawing





Turning

Turning with $Ra < 0.4$ roughness, to complete the mechanical machining of the bore.



Mechanical machining as per drawing

- Cylinder bodies
- Shafts
- Special mechanical components according to Customer drawing
- Taper joints

PRODUCTS

- Bored pipes
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- Heavy and thin wall thickness pipes
- Honed pipes
- Buckle arrestors
- Special tailor made pipes
- Tubular items as per drawing
- Taper joints
- Drilled / hollow bars
- Drilled column for presses
- Drilled shafts
- Cylinder bodies as per drawing
- Risers



Risers

Risers starting from single forged items, one way internal mechanical machining. If required, special shaping of the internal surface.

Drilled / hollow bars

Single and serial production with high efficiency of the machining and of the surface yield.

Drilled shafts

Deep drilling in only one way for all the lengths up to 22 m.

Combined cycle of drilling and honing to guarantee the most restrictive parameters.

Warranty of the best straightness along all the item.

Drilled column for presses

Lightening or passage holes on big size columns for presses, even with very thin extra materials, guaranteeing the perfect axially.



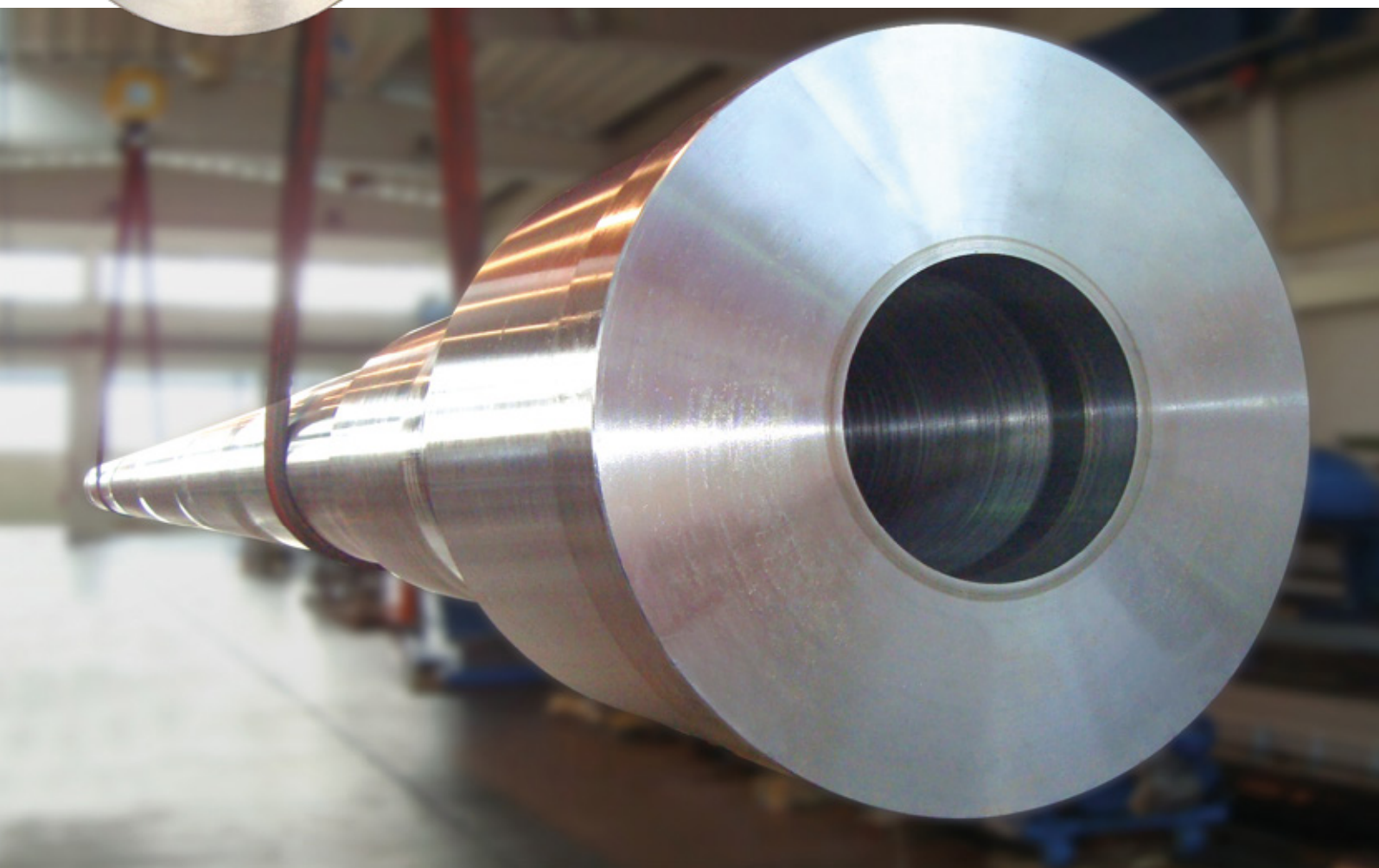
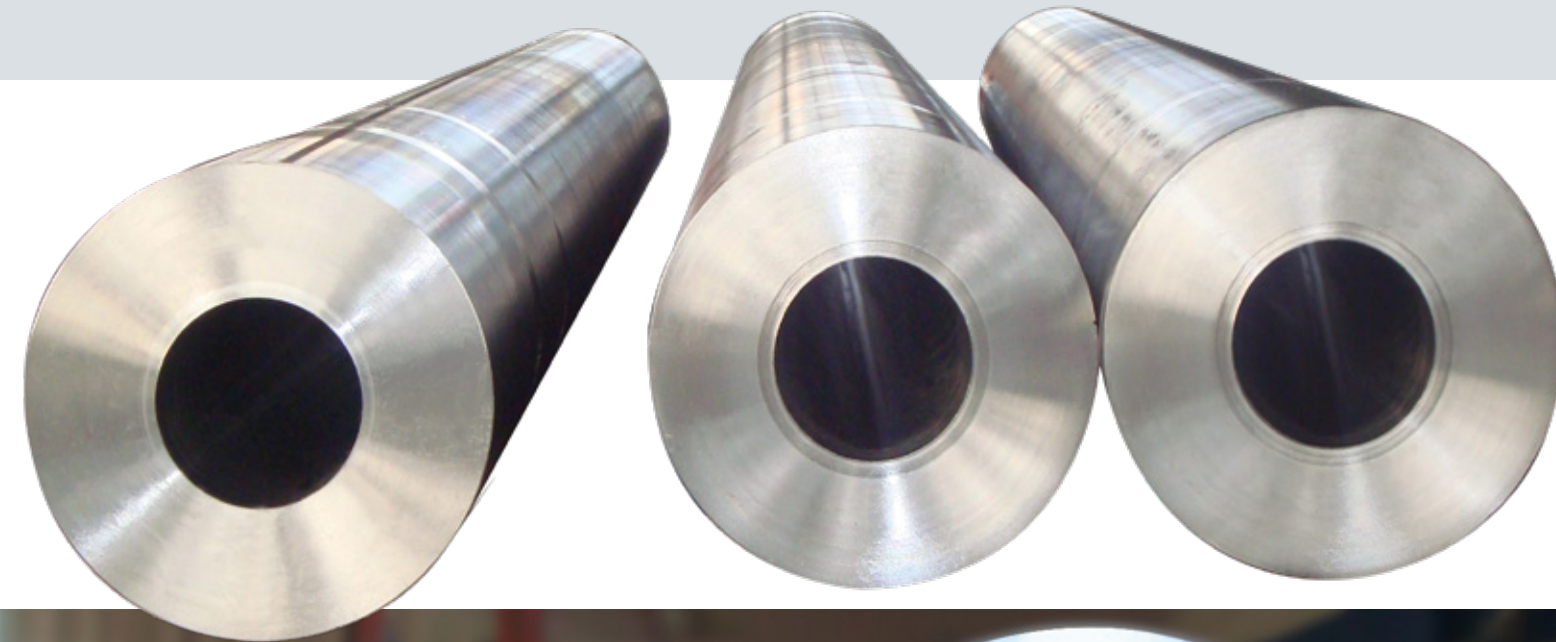
Heavy and thin wall thickness pipes

Manufacture of heavy and thin wall thickness pipes starting from solid or hollow bars.

Forged pipes

Warranty of internal and external machining to achieve the optimal required concentricity.

Optimization of the extra material depending on the foreseen mechanical machinings.



Bored pipes

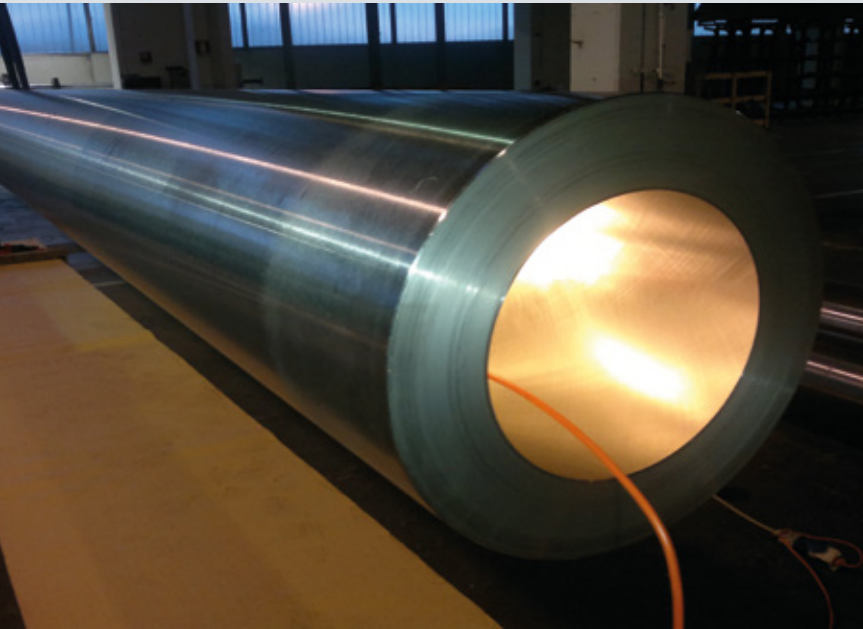
Boring in only one way up to 22 m.

Optimization of the geometrical parameters of standard pipes.

Honed pipes

Total warranty of geometrical and dimensional parameters according to Customer requirements.

Total absence of discontinuity signs in the internal surface.



Cylinder bodies as per drawing

Hydraulic or pneumatic cylinder bodies starting from forged items or pipes.



Buckle arrestors

In seamless execution from pipes or forged items in length till more than 12 m .

Taper joints

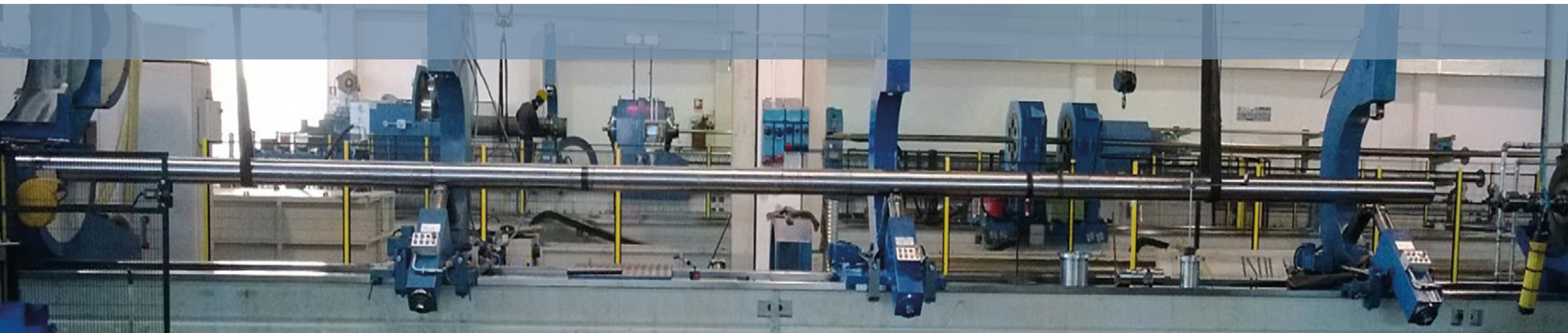
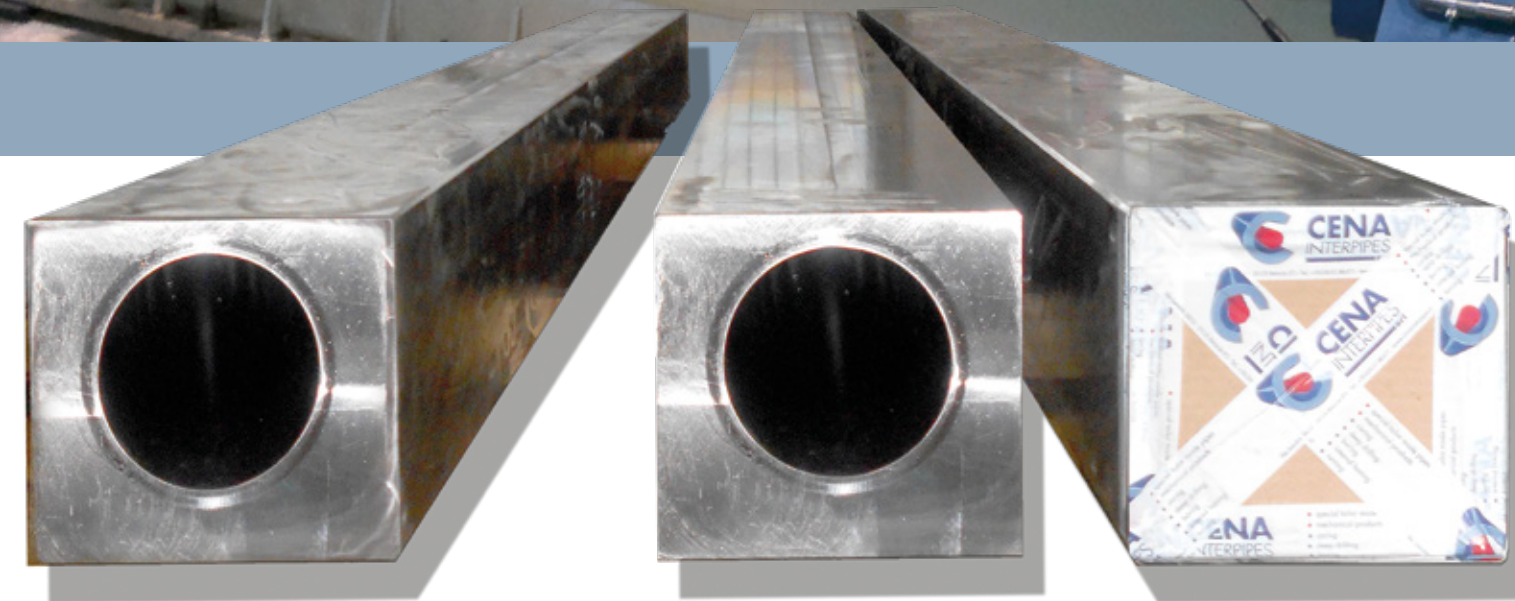
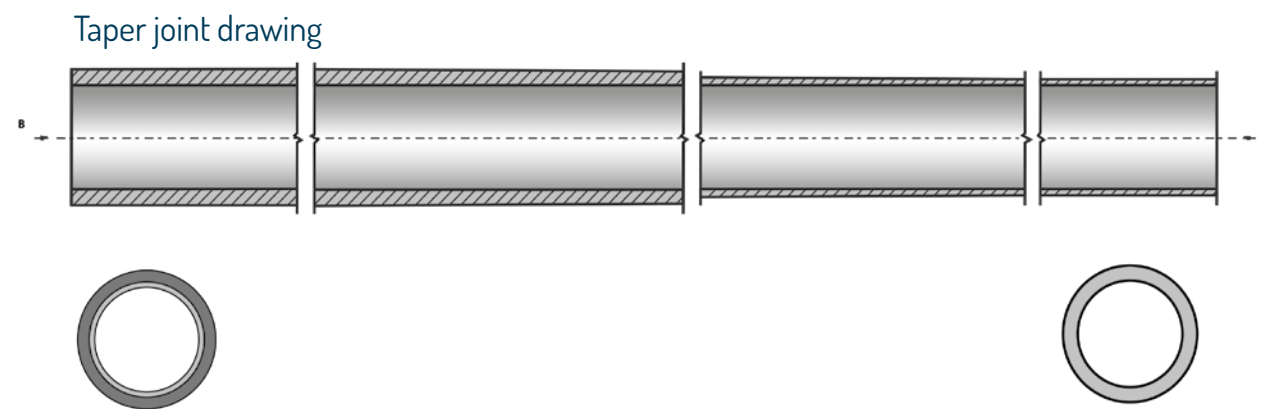
From pipes or forged items for the connection of two lines with different external diameters.

Special tailor made pipes

In every kind of material, also as per Customer specifications.

Tubular items as per drawing

Concentricity between internal and external surfaces is guaranteed by means of mechanical machinings repeated at different diameters.



NOT DESTRUCTIVE TESTINGS

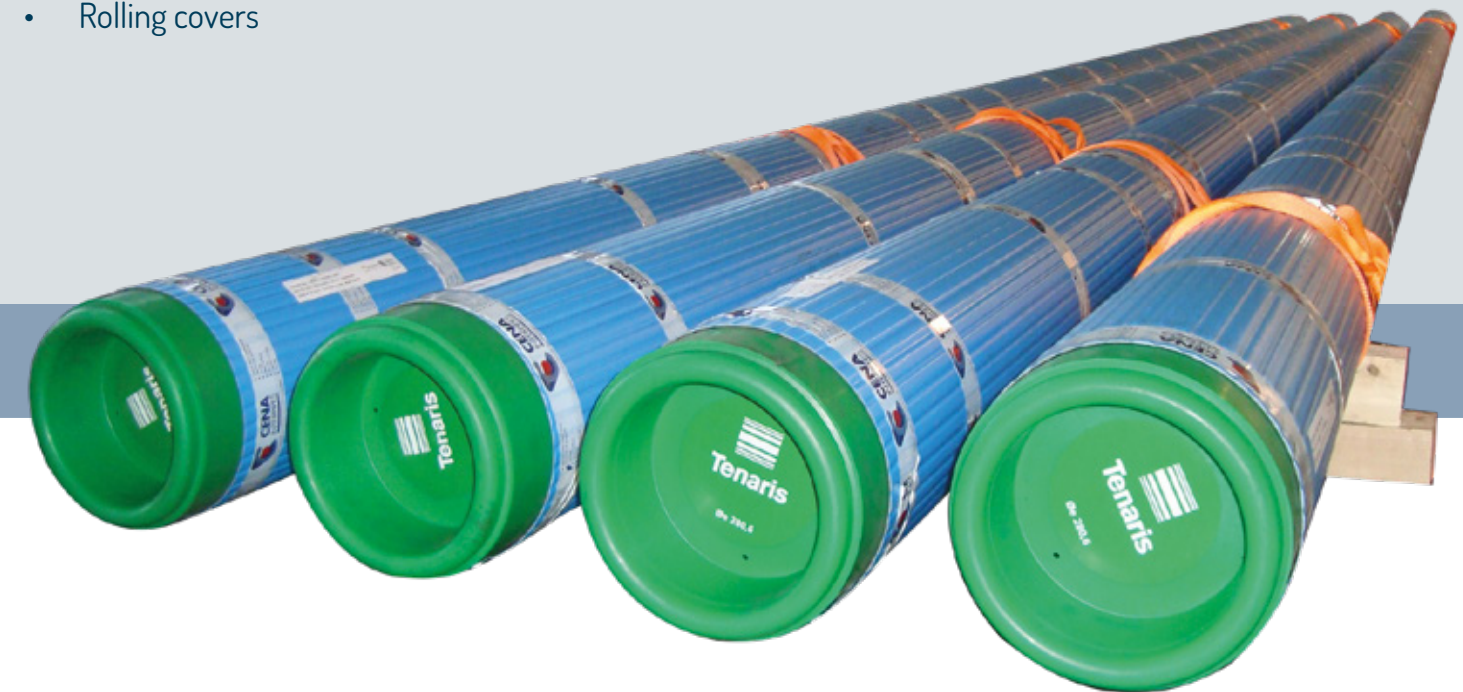
- Dimensional measurements
- Eddy current test
- Geometrical parameters measurements
- Hardness test
- Hydrostatic test
- Magnetic particle test
- Penetrant test
- Residual magnetism test
- Roughness test
- Standard or phased array ultrasonic test
- Visual inspection of the inside surface by means of a camera



PACKAGING

If required, packaging for air and/or sea transport in compliance with Customer requirements:

- Fumigated wooden boxes, ISPM 15 FAO with coupled protection barrier bag and dehydrated salt
- Fumigated wooden boxes, ISPM 15 FAO with VCI protection on the internal walls of the boxes
- Rolling covers



DIMENSIONAL RANGE

Mechanical machinings of special tailor made pipes and products.

- Deep drilling starting from a full piece
- Steel core recovery coring (enucleation)
- Boring with special made bore finishing
- Internal honing
- Turning
- Mechanical machining as per drawing



Ø external	up to 1.600 mm
Ø rotation	up to 2.100 mm
Length	up to 22 m

Tolerances on Ø external	up to f7
Tolerances on Ø internal	up to H7
General Ra	up to 0.2 µm
Straightness	up to 0.1 mm / m

MATERIALS

- Carbon steel
- Low alloy steel
- High alloy steel
- Stainless steel
- Duplex and superduplex
- Super alloys
- Hastelloy
- Bronze, brass, copper alloys

ISO 9001



LIST OF CNC MACHINES

no. 3 DRILLING - CORING - BORING MACHINES

- Gullyver 1600
- Gullyver 800
- ABF Technos

no. 1 HONING MACHINE

- Aladyn 1600

no. 2 LATHES

- WH 700x12000
- L. Pontiggia

no. 1 CUTTING MACHINE 1000x800

no. 1 E2 - 4000 MIG / MAG WELDER

no. 12 TRAVELLING BRIDGE CRANES with floor control

AREAS OF INTEREST

- Moving and lifting
- Offshore & subsea
- Oil & gas
- Petrochemicals
- Plants and machineries
- Power generation





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