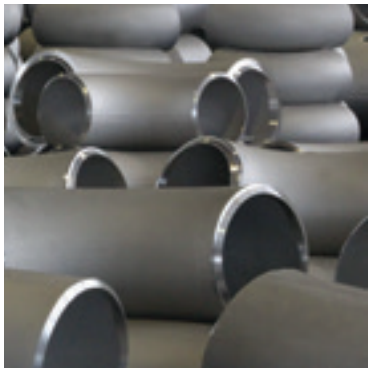
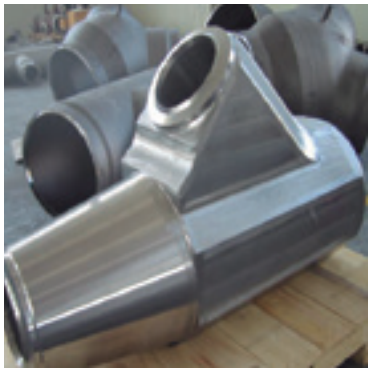
TUBACEX GROUP

BUTT WELDING FITTINGS & SPECIAL COMPONENTS

CARBON ALLOYS, STAINLESS STEEL AND HIGH NICKEL ALLOYS

TUBACEX:
Fittings and special components

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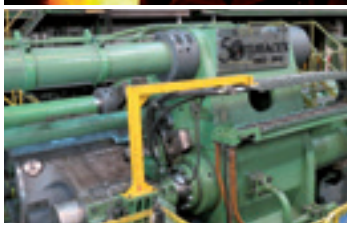
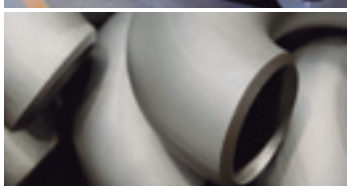
The Tubacex Group
A Global Leader in Seamless Stainless Steel and High Nickel Alloy Fittings and Special Components

The Tubacex Group has become one of the world's leading Seamless Stainless Steel and Nickel Alloy tubular solutions providers.
Founded in 1963, Tubacex brings the experience of a world leader combined with important R&D effort, which is required to meet the future needs of the industry.
The Tubacex Group, which exports to over 100 countries worldwide, has a share of around 15% of the world market for Seamless Stainless Steel tubular solutions, with a total workforce of around 2,400 employees. The headquarters are in Llodio, 25 Km (15 miles) from the Port of Bilbao, in northern Spain.
The Tubacex Group's integrated production process includes a steel making plant, several extrusion and cold finishing mills, trepanning facilities, fitting and special components producers and an extensive network of service centers which provide a wide range of added value operations to the Group's portfolio.

Tubacex: a global integrated group at your service





SOLUTIONS	BUSINESS UNIT
Stainless Steel and High Nickel alloy bars and billets	ACERALAVA TUBACEX GROUP
Seamless Pipe and Tubes up to 8" (extrusion, piercing, cold finishing)	TTI TUBACEX GROUP
	SCHOELLER BLECKMANN TUBACEX GROUP
	SALEM TUBE TUBACEX GROUP
	TUBACEX INDIA TUBACEX GROUP
Seamless Pipe up to 72"	IBF TUBACEX GROUP
Fittings and special connections from ½" to 72"	TTA TUBACEX GROUP
	AWAJI STAINLESS TUBACEX GROUP
Stock, Service and Trading Value-added operations	TSS TUBACEX GROUP

Fittings and special components are manufactured in IBF (Italy), Tubacex Taylor Accesorios (Spain) and Tubacex Awaji (Thailand).

These manufacturing units are part of a fully integrated value chain:

The Group's steel plant, Acerálava, in Spain, provides a customized list of steels and is able to offer exceptions to the standard. Tubacex's metallurgical engineers are devoted to the development of sophisticated steels capable of operating in the demanding environments of the future.

The Seamless Pipes&Tubes Manufacturing Division constitutes the leading worldwide producer of Seamless Stainless Steel tubes & pipes and supplies hollow bars to the Group's fitting producers.

A worldwide Service Center Network (Tubacex Service Solutions) offers highly competitive distribution and a wide range of additional services to our customers.

Tubacex brings the experience of a world leader in the manufacture of Stainless Steel Tubular Solutions.

The Tubacex Group

Worldwide presence
Through our sales offices

Competitiveness
Thanks to our lean manufacturing process

Service
Cooperation with our customers

Flexibility
In the chemical composition of materials & deliveries

Reliability
Of a fully integrated company

Customers are the main drivers of the Tubacex Group's activities and efforts. The organization and investments are continuously being adapted to meet the increasing requirements that companies face every day in highly demanding activities in the Oil&Gas, Petrochemical, Chemical and Power Generation industries, among others. These new challenges are driving Tubacex to implement the most advanced verification equipment and inspection procedures to assure product quality and excellent service, backed by a fully integrated company with a worldwide presence.

OIL AND GAS EXPLORATION AND PRODUCTION

New challenging corrosive environments and applications are driving the Tubacex product portfolio of corrosion resistant alloys in both onshore and offshore E&P, focusing particularly on:
• Oil Country Tubular Goods (OCTG) • Umbilical tubes and a wide range of seamless stainless and high nickel alloys for subsea applications (risers, flowlines, manifolds…)
• Tubes for platforms (piping systems, separators…)

REFINING, PETROCHEMICAL AND CHEMICAL INDUSTRIES

Tubacex offers an extensive portfolio of grades and sizes to fulfill design expectations in relation to various areas and equipment in the Petrochemical and Chemical industry, particularly:
• Regas Facilities • Refineries • Heat exchangers • Reactors • Furnaces, Heaters and Re-heaters • Other processing industries.

FERTILIZER PRODUCTION

Fertilizer production materials need to withstand severe corrosion conditions. Tubacex supplies pipes, tubes & fittings for the equipment involved in the production of Urea, Ammonia, Nitric acid, Sulfuric acid, Phosphoric acid and Melamine.

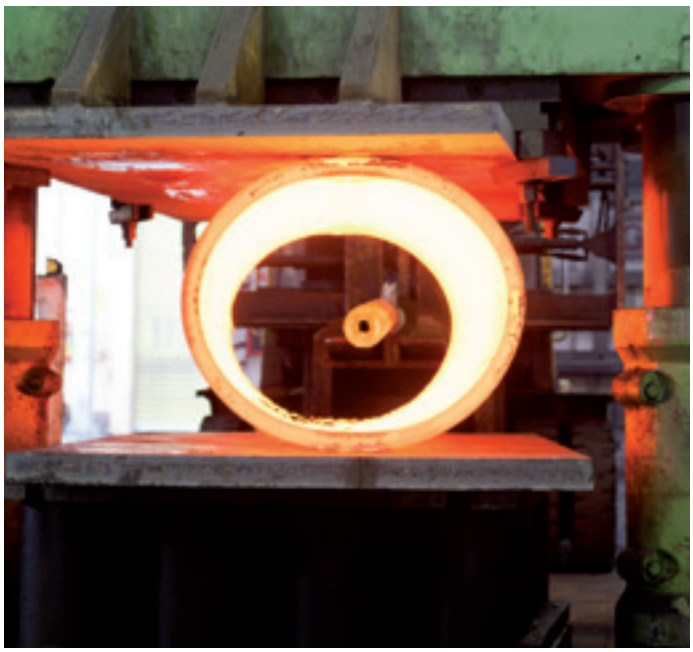
POWER GENERATION

Tubacex's manufacturing range covers the main stainless steel heat resistant grades used in boiler equipment for:
• Critical equipment • Ultra Super Critical (USC) equipment • Industrial power plants • Nuclear power plants.

STOCK FOR DISTRIBUTION AND OTHER INDUSTRIES

Tubacex's manufacturing range covers the main Seamless Stainless steel portfolio for distributors worldwide:
• Pipes and Tubes in accordance with all relevant standards • Hollow Bars for metalworking industry through Tubacex Service Solutions • Instrumentation and hydraulic tubing for a wide range of high value-added industries, including automotive and aerospace • Round Bars.

Fittings and Special Components portfolio



The Tubacex range includes the design and manufacture of butt welding fittings, tube bends, elbows, tees, reducers and caps (both seamless and welded), complementing the wide offer of tubular solutions by IBF and TTA companies. Furthermore, IBF offers a wide range of special parts (manifolds, laterals, special reducers…)

- Located in San Nicolò, Italy, the IBF fittings division manufactures fittings and special components in a range that goes from ½" to 72" NPS for a wide range of end users (Oil and Gas, Power Gen, Chemical, Petrochemical and Nuclear markets). Specialized in special and large scale pieces, cold drawn dimensions are mainly sourced from its participated company CFF.
- Located in Artziniega, Spain, Tubacex Taylor Accesorios (TTA) manufactures fittings (elbows, return bends and reducers, both concentric as eccentric) mainly for the petrochemical industry, perfectly complementing the portfolio of the rest of the Group and particularly the seamless tubes for furnace applications, heaters and re-heaters. TTA size range goes from 1 ½" up to 12" NPS, in short and long radius as well as special radii.
- Located in Amphur Muang-Samutprakarn, Thailand, Awaji Stainless manufactures stainless fittings (seamless and welded) in austenitic grades from 1/2" to 12" in both ASTM and JIS standards.

The Tubacex Group´s fitting and special components extensive production program is suitable for all kinds of projects. The range offered is one of the widest in the industry:

MANUFACTURING RANGE - FITTINGS AND COMPONENTS	
Seamless	from 1/2" to 44"
Welded	from 1/2" to 72"

Hot drawing, bending and cold drawing processes
Any thickness

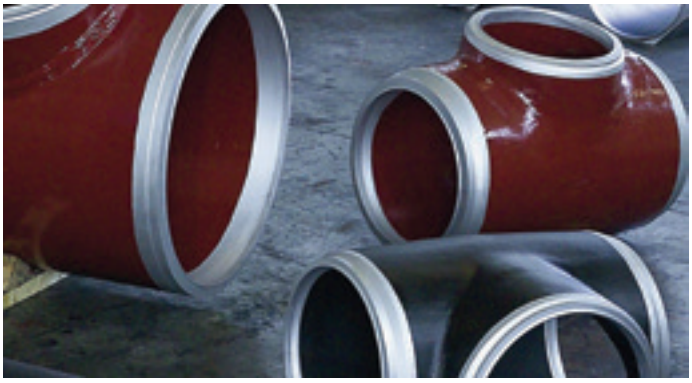
Materials covered include a wide range of grades, from carbon steel to titanium, focusing on Stainless Steel and High Nickel Alloys - as described for trepanned pipes. The Tubacex Group maintains a high stock level in finished and semi-finished products, as well as base materials, to provide full flexibility and an extremely competitive lead time.

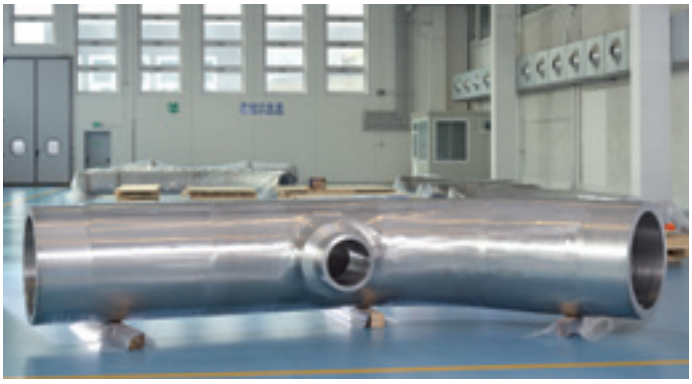
Product portfolio

- The Tubacex Group's Fittings program covers all kind of fittings (Butt welding fittings & elbows, tees, reducers, caps) from standard to special products, manufactured by hot drawing, bending or cold drawing.

- In addition to fittings, special components such as laterals, manifolds, tees, stress joints, weldolets are manufactured at IBF fittings and special parts division, with a clear trend to a more particularized design.

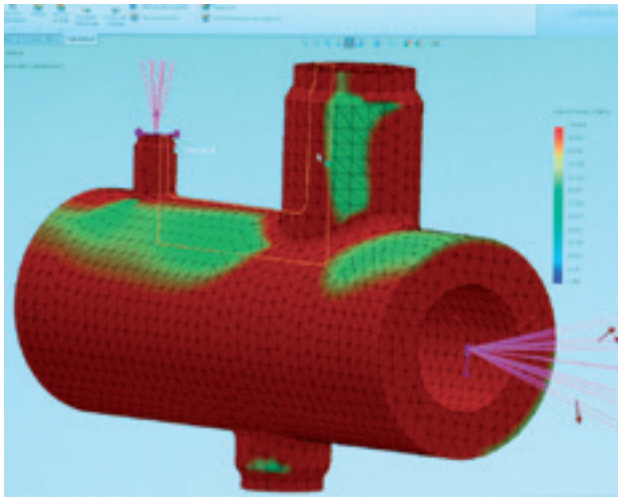
FITTINGS	SPECIAL COMPONENTS
Butt Welding fittings & elbows	Special components
Tees	Manifolds
Reducers	Laterals
Caps	3D / 5D Bends / Stress Joints

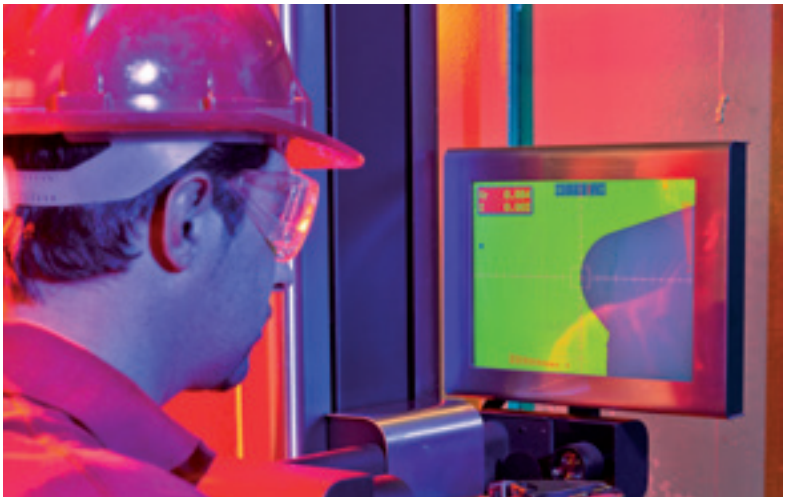




- In order to satisfy the growing market demand for specific customized solutions, the Tubacex Group has made its production routes more flexible, being able to provide different manufacturing options per product. Specific designs are defined and calculated by the engineering department.

- The IBF technical department designs the products in compliance with all applicable Standards/Codes (ASTM, ASME, API, EN, UNI, BS, DIN, NORSOK, GOST, etc.) to satisfy all customers' technical requirements by means of the best design software. The technical department also supports production, designing heavy tools (e.g. dies) to be used during the manufacturing process.





		DIN / EN			ASTM			JIS		
		NORM CODE	STEEL GRADE	STANDARD	STEEL GRADE UNS	STEEL GRADE	STANDARD	STEEL GRADE	%Ni	%Cr
STAINLESS & HIGH NICEKL STEEL	AUSTENITICS	1.4301	X5 CrNi 18 10	DIN 17458 EN10253-4	S30400	WP 304	ASTM A403	SUS 304	8-11	18-20
		...	...	...	S30409	WP 304H	ASTM A403		8-11	18-20
		1.4306	X2CrNi 19 11	DIN 17458 EN10253-4	S30403	WP 304L	ASTM A403	SUS 304L	8-13	18-20
		1.4828	X15CrNiSi 20 12	SEW 470					11-13	19-21
		1.4541	X6CrNiTi 18 10	DIN 17458 EN10253-4	S32100	WP 321	ASTM A403		9-13	17-20
		1.4878	X12CrNiTi 18 9	SEW 470	S32109	WP 321H	ASTM A403			
		1.4550	X6CrNiNb 18 10	DIN 17458 EN10253-4	S34700	WP 347	ASTM A403		9-13	17-20
					S34709	WP 347H	ASTM A403			
		1.4401	X5 CrNiMo 17 12 2	DIN 17458 EN 10253-4	S31600	WP 316	ASTM A403	SUS 316	10-14	16-18 (16,5-18,5)
		1.4404	X2CrNiMo 17 13 2	DIN 17458 EN10253-4	S31603	WP 316L	ASTM A403	SUS 316L	11-16	16-18 (16,5-18,5)
		1.4435	X2CrNiMo 18 14 3							16-18 (17-18,5)
		1.4571	X6CrNiMoTi 17 12 2		S31635	WP316Ti	ASTM A213		10,5-13,5 (10-14)	16,5-18,5 (16-18)
		1.4941	X6CrNiTiB1810	DIN 17459 EN 10216-5					9-12	17-19
		1.4910	X3CrNiMoBN17-13-3	DIN 17459 EN 10216-5		WP 316LBN	ASTM A 403		10-14	16-18
		1.4580	X6CrNiMoNb17-12-2	DIN 17458		WP 316HNb			10,5-13,5	16,5-18,5
		1.4833	X7 CrNi 23 14	SEW 470	S30908	WP 309	ASTM A403		12-15	22,24
		1.4845	X12 CrNiSi 25 21		S31008	WP 310S			19-22	24-26
		1.4841	X15 CrNiSi 25 20		S31400	WP 314				
		1.4438	X2CrNiMo 18 15 4	EN 10253-4	S31703	WP 317L			11,0-14,0	18-20
					S31700	WP 317				
		1.4547	X1CrNiMoCuN20-18-7	EN 10253-4	S31254	"6Mo" SUPER AUSTENITIC	ASTM A403		17,5-18,5	19,5-20,5
		1.4466	X1 Cr Ni Mo N 25 22 2	EN 10216-5 EN10297-2	S31050	TP310 MoLN	ASTM A213		22	25
		1.4335	X1 Cr Ni 25 21	EN 10216-5 EN10297-2	S31002	TP310L NAG	ASTM A312		21	25
	NICKEL ALLOYS	1.4539	X1NiCrMoCuN25-20-5	SEW 400 Vd TÜV 421 EN 10253-4	N08904	WP 904 L	ASTM A403		24-26	19-21
		1.4876	X10NiCrAlTi 32 20	SEW 470 Vd TÜV 412	N08800	WPNIC	ASTM B366		30-34	19-23
		1.4958	X5NiCrAlTi 31-20	DIN 17459 EN 10216-5	N08810	WPNIC10			30-32,5	19-22
		1.4959	X8NiCrAlTi 32-21						30-34	
		1.4876H	X10NiCrAlTi 32 20 H	Vd TÜV 434	N08811	WPNIC11				19-23
		1.4563	X1NiCrMoCu31-27-4	SEW 400	N08028	"Alloy 28"	ASTM B668		30-32	26-28
		2.4660	NiCr20CuMo		N08020	WP20CB "Alloy 20"	ASTM B366		32-38	19-21
		2.4858	NiCr 22Mo 9Nb	Vd TÜV 432/2	N08825	WPNICMC			38-46	19,5-23,5
		2.4366	NiCu30Mn		N 04400	WPNC	ASTM B 366		> 63,0	
		2.4663	NiCr23Co12Mo	DIN 17744 EN 10302	N 06617		ASTM B 366		> 44,5	20,0-24,0
		2.4856	NiCr22Mo9Nb	DIN 17744 EN 10302	N 06625	WPNCMC	ASTM B 366		> 58,0	20,0-23,0
	AUSTENITIC-FERRITIC	1.4410	X2CrNiMoN25-7-4	EN 10253-4	S32750	"Superduplex"	ASTM A 815		6,0-8,0	24,0-26,0
		1.4501	X2CrNiMoCuWN25-7-4	EN 10253-4	S32760	Duplex 25Cr				
		1.4462	X2CrNiMoN 22 5 3	SEW 400 EN 10253-4 Vd TÜV 418	S31803	Duplex 22Cr			4,5-6,5	21,0-23,0
					S32205					22,0-23,0
	ALLOY STEEL					WPB	ASTM A234		< 0,40	< 0,40
						WP1			_	_
		1.7338	10CrMo5-5	E10253-2		WP11			_	1,00-1,50
		1.7335	13CrMo4-5	E10253-2 DIN17175 DIN17176		WP12			_	0,80-1,25
		1.7380	10CrMo9-10			WP22			_	1,90-2,60
		1.7362	X11CrMo5	Vd TÜV 007/2 EN 10253-2		WP5			_	4,0-6,0
		1.7386	X11CrMo9-1	Vd TÜV 109 EN 10253-2		WP9			_	8,0-10,0
		1.4903	X10CrMoVNb9-1	Vd TÜV 511/2 EN 10253-2		WP91			< 0,40	8,0-9,5
		1.4901	X 10 CrWMo VNb 9-2	Vd TÜV 511/2 E10253-2		WP92				8,5-9,5
		1.5415	16Mo3	EN 10253-2	_	_				< 0,30

APROXIMATE CHEMICAL COMPOSITION RANGE					
%Mo	%C	%Mn	%Nb	%Ti	%Others
_	< 0,08	< 2,00			
_	0,04-0,10	< 2,00			
_	< 0,035	< 2,00			
	< 0,2				1,5<%Si<2,5
_	0,04-0,10	< 2,00		5(C+N)< Ti <0,7	
				4(C+N)< Ti <0,7	
_	0,04-0,10	< 2,00	10C-1,1		
			8C-1,1		
2,0-3,0 (2,0-2,5)		< 2,00			
2,0-3,0 (2,0-2,5)		< 2,00			
2,0-3,0 (2,5-3,0)	< 0,030				
2,0-2,5 (2,0-3,0)				5(C+N)< Ti <0,7	
_		< 2,00		5C-0,8	%B: 15-50ppm
2,0-3,0	< 0,04	< 2,00			%B: 15-50ppm
2,0-2,5			10C-1,0		
_					
					1,5<%Si<2,5
3,0-4,0	< 0,03				
	< 0,08				
6,0-6,5					0,50 < Cu < 1,00
4,0-5,0					%Cu:1,2-2,0 %N:0,04-0,15
_		< 1,50	Nb<0,1	0,15-0,60	(Al+Ti)<1,0
	0,03-0,08		Nb<0,1		Cu < 0,5 (Al + Ti) < 0,7 Co< 0,5
	0,05-0,1				Cu < 0,5 (Al+Ti)>0,85 (WPNIC11)
	0,06-0,1				(Al+Ti)<0,7 para Ts<700ºC (Al+Ti)>0,85 (WPNIC11)
3,0-4,0	<0,02				Cu: 0,8-1,4
2,0-3,0	< 0,07	< 2,0	8C-1,0		Cu: 3,0-4,0
2,5-3,5	< 0,05	< 1,0		0,6-1,2	Cu:1,5-3,0 Co < 1,0
	0,05-0,15	< 2,0		< 2,5	Cu: 28,0 -34,0
8,0-10,0	< 0,3	< 1,0		< 3,0	Co: 10,0-15,0 Al: 0,8 - 1,5
8,0-10,0	< 0,10	< 0,5	3,15 - 4,15	< 5,0	
3,0-5,0					Cu < 0,50
3,0-4,0		<1,0			Cu: 0,5-1,0 W:0,5-1,0
2,5-3,5		<2,0			N: 0,08 - 0,20
3,0-3,5					N: 0,14 - 0,20
< 0,15	< 0,30	< 1,35	< 0,02		Cu < 0,40
0,44-0,65	< 0,28	0,30-0,90			
0,44-0,65	0,05-0,15	0,30-0,60			
0,44-0,65	0,10-0,17	0,4-0,7			
0,87-1,13	0,05-0,15	0,30-0,60			
0,44-0,65	< 0,15	0,30-0,60			
0,90-1,10	< 0,15	0,30-0,60			
0,85-1,05	0,08-0,12	0,30-0,60	0,06-0,10	<0,01	V: 0,18 - 0,25 N: 0,03-0,06
0,30-0,60	0,07-0,13	0,30-0,60			V: 0,15 - 0,25 N: 0,030-0,070 W: 1,50-2,00
0,25-0,35	0,12-020	0,40-0,90			

Quality, Health & Safety and the Environment

The main goals of the Tubacex Group are to provide customers with the highest quality product, ensuring that all employees work in conditions that are free of health and safety risks and the manufacturing activities do not have an impact on the environment. The result of this commitment is the Certification of the Quality Management Systems in compliance with the leading Standards/Codes and other important approvals by leading customers.

STANDARDS / CODES CERTIFICATION

The Tubacex Group manufactures products in accordance with the main international Standards/Codes (e.g.: ISO, ASME, ASTM, NACE, EN, DIN, API, BS, SIS, GOST, JIS, PED, etc.) and customer requirements (e.g.: SHELL MESC, etc), and all its Quality Management Systems are approved by leading external bodies (e.g.: ASME, Lloyd's Register, TÜV, DNV, BV, etc.).

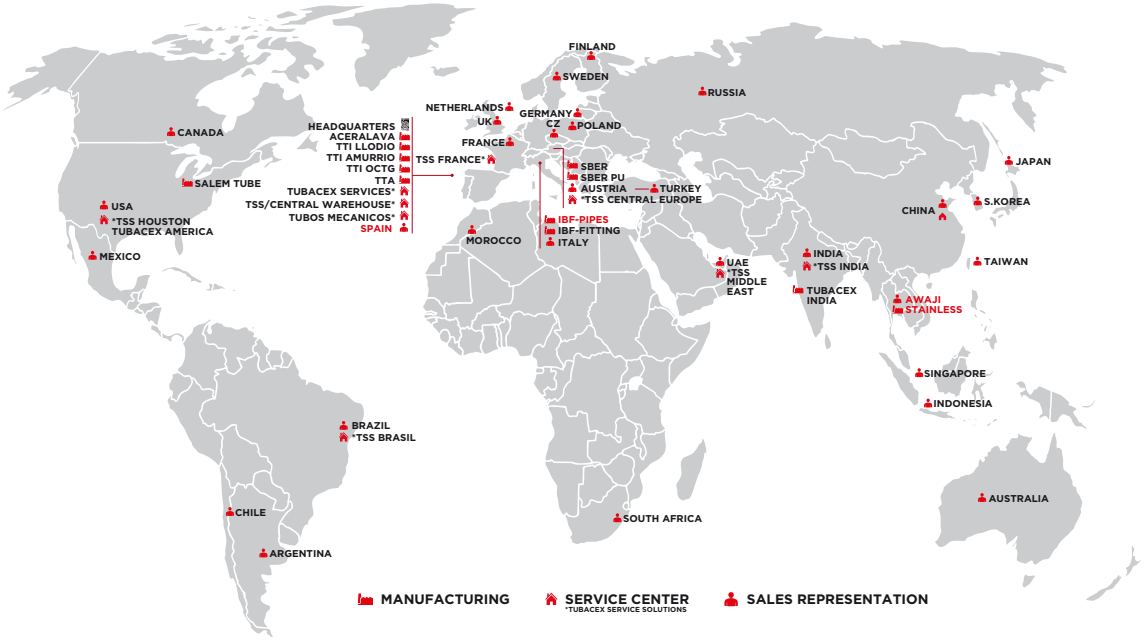
QUALITY MANAGEMENT SYSTEM CERTIFICATES		
Area	Standards & Codes	External Bodies
Quality	ISO 9001	LLOYD'S REGISTER AENOR UDT
	ISO 3834-2	BUREAU VERITAS
	PED 2014/68/EU	TUV NORD / SUD
	AD 2000 MERKBLATT-W0 / TRD 100	TUV NORD / SUD
	ASME III NCA-4000 (NPT Certificate)	ASME
	ASME III NCA-3800 (QSC Certificate)	ASME
	APIQ1	
Health & Safety	OHSAS 18001	ONDOAN / ICIM
Environment	ISO 14001	AENOR / ICIM

OTHER APPROVED MANUFACTURER CERTIFICATIONS

Norsok M-650
API Spec. Q1 and API 5-CRA
KTA 1401 and AVS D 100 / 50
Achilles Qualif. Certificate
JIS Mark scheme
Lloyd's Register of Shipping (rules for the manufacture, testing and certification of materials) DNV Rules for Classification Part 2
Austenitic Stainless Steel Pipes and Tubes According to En 10216-5 or Equivalent Standards.

Complete list of approvals and certifications is available on request.

Tubacex Around the World



TUBACEX TAYLOR ACCESORIOS
Located in Artziniega, Spain, Tubacex Taylor Accesorios (TTA) manufactures fittings (elbows, return bends and reducers) mainly for the Petrochemical industry. Sizes range from 1 ½'' up to 12'' NPS, in short and long radius as well as in special radii.

IBF
Located in San Nicolò, Italy, the IBF fittings division manufactures elbows, tees, reducers, caps and special components (weldolets, manifolds, laterals, stress joints, etc.) in a manufacturing range from ½" to 72" NPS.

TUBACEX AWAJI
Located in Amphur Muang-Samutprakarn, Thailand, Awaji Stainless manufactures stainless fittings (seamless and welded) in austenitic grades from ½" to 12". The company is able to manufacture in both ASTM and JIS standards - for the demanding Japanese market.

Currently the Tubacex Group exports to over 100 countries worldwide from its manufacturing sites and warehouses. The company has 15 sales offices and an extensive network of agents in diverse countries, giving it a global presence.

FITTING AND SPECIAL COMPONENTS MANUFACTURING

IBF, S.p.a.
BUT WLEDING FITTINGS
SPECIAL COMPONENTS
San Nicolò - Piacenza. ITALY

Tubacex Taylor Accesorios, S.A.U.
BUTT WELDING FITTINGS
Artzeniega. SPAIN

Tubacex Awaji
BUT WLEDING FITTINGS
Amphur Muang-Samutprakarn.
THAILAND

OTHER MANUFACTURING COMPANIES

IBF, S.p.a.
PIPES DIVISION
Vittuone - Milano. ITALY

Acería de Álava, S.A.
STEEL MELTING SHOP
Amurrio. SPAIN

Tubacex Tubos Inoxidables, S.A.
HOT EXTRUSION PLANT
Llodio. SPAIN

COLD FINISHING PLANT
OCTG FINISHING PLANT
Amurrio. SPAIN

Schoeller Bleckmann Edelstahlrohr, GmbH
COLD FINISHING PLANT
HOT EXTRUSION PLANT
SPECIAL TUBE PLANT
Ternitz. AUSTRIA

Salem Tube, Inc.
COLD FINISHING PLANT
Greenville. PA. USA

Tubacex Prakash
COLD FINISHING PLANT
Umbergaon. INDIA

SERVICE & DISTRIBUTION COMPANIES

Tubacex Service Solutions, S.A.
STAINLESS STEEL LONG PRODUCTS DISTRIBUTION
Amurrio. SPAIN

Tubacex America, Inc. / TSS Houston
STAINLESS STEEL LONG PRODUCTS DISTRIBUTION
Houston. UNITED STATES

Metaux Inox Services, S.A.S. / TSS France
STAINLESS STEEL LONG PRODUCTS DISTRIBUTION
Satolas & Bonce. FRANCE

TSS Brasil
STAINLESS STEEL LONG PRODUCTS DISTRIBUTION
Sao Paolo. BRAZIL

TSS Central Europe
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