

# Lance Pipe



QUALITY PRODUCTS WITH THE DEPENDABILITY YOU DESERVE



## LANCE PIPE/PIPE SIZES

Pipe Size Chart				
Pipe Sizes	Outside Diameter	Quick Connect	Threaded One End	Threaded & Coupled
1/8"	.405"	NO	YES	YES
1/4"	.540"	YES	YES	YES
3/8"	.675"	YES	YES	YES
1/2"	.840"	YES	YES	YES
3/4"	1.05"	YES	YES	YES
1"	1.315"	NO	YES	YES
1 1/4"	1.660"	NO	YES	YES
1 1/2"	1.900"	NO	YES	YES

### Oxylance offers both Calorized and Bare Lance Pipe.

- Our bare Lance Pipe inventory comes in many diameters, wall thicknesses, lengths and end finishes.
- End finishes for bare lance pipe are Plain End, Threaded and Quick Connect. We carry a wide variety of raw goods that can be processed to your specific requirements.
- All of our Lance Pipe is cleaned for oxygen service in our cleaning operation to ensure safe and reliable use.

- Uses for Lance Pipe
  - » Scrap Processing
  - » Opening Tap Holes
  - » Injecting additives into the melt
  - » Blowing oxygen into the melt for foamy slag operations



- Threaded lances are only available in pipe sizes. Tubing cannot be threaded.

## LANCE PIPE/TUBE SIZES

- Oxylance follows strict quality control measures to insure consistent and reliable products. For added value, lance ends are de-burred where necessary to ensure clean, dimple free ends. De-burring lance pipe increases holder grommet life and reduces potential safety hazards.

Tube Size Chart

Tube Sizes	Outside Diameter	Plain End	Quick Connect
3/16"	.187"	YES	NO
1/4"	.250"	YES	NO
5/16"	.312"	YES	NO
3/8"	.375"	YES	YES
1/2"	.500"	YES	YES
5/8"	.625"	YES	YES
3/4"	.750"	YES	YES
.922"	.922"	YES	YES
1 1/4"	1.250"	YES	YES
1 1/2"	1.500"	YES	YES







## LANCE PIPE MANUFACTURING PROCESS



- The pipe goes through the end finishing and is inspected for open seams or other discontinuities and rebundled to the size bundles required by our customers. Pipe shown is de-burred plain end.



- Quick Connect Lance Pipe, allows the operator to join two lances together and reduces waste of unused lance.





# Oxylance

Lance Pipe

## LANCE PIPE MANUFACTURING PROCESS



- Lance Pipe after threading and inspection. Customers can order threaded Lance Pipe threaded on one end or threaded and coupled.



- Oxygen cleaning is required for all material used for oxygen service. Oxylance has a specialized cleaning process that insures that the lance pipe is free of all mill and process lubricants and metal shavings.





## CALORIZED LANCE PIPE

- Calorized lance pipe is made up of 5 layers. At the core is a high quality mild steel pipe. In the calorization process the lance pipe is heated to 1000 c (1830 f) in a mixture of aluminum powder. When the pipe and aluminum reaches 1000 c the aluminum will fuse to the lance pipe and forms a permanent layer of aluminum iron alloy. The Calorized pipe is then coated inside and out with a layer of refractory material which resists heat and slows the melting speed of the lance pipe. Where bare lance pipe burns at 1300 to 1500 c (2400 to 2800 f) the Calorized pipe burns 2050 c (3750 f).
- Calorized lance pipe is used for melting and refining steel by both injecting oxygen and injecting other elements such as Carbon or Lime into the melt.

### USES FOR CALORIZED PIPE

Cutting scrap steel

Refining steel during the melt

Injection of Carbon, Lime Powder, and other additives for adjusting grades of carbon steel or specialty steels

Removing slag inside oxygen convertors.

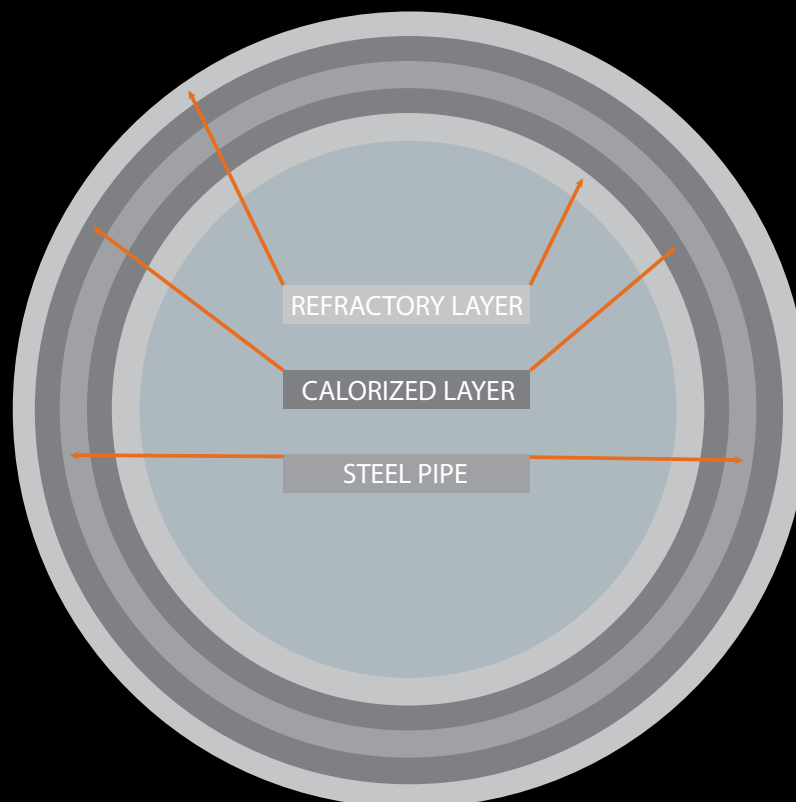
End Finishes; Plain End, Threaded and Coupled and Press on couplings.



## CALORIZED LANCE PIPE SIZES

Calorized Pipe Size Chart						
Pipe Sizes	Outside Diameter	Plain End	Press On Coupling	Threaded & Coupled	Bundle Count	Lengths
3/8"	.675"	YES	YES	YES	200	9' & 18'
1/2"	.840"	YES	YES	YES	200	9' & 18'
3/4"	1.05"	YES	YES	YES	200	9' & 18'
1"	1.315"	YES	YES	YES	100	9' & 18'
1 1/4"	1.660"	YES	YES	YES	100	9' & 18'
1 1/2"	1.900"	NO	YES	YES	50	9' & 18'

- Calorized lance pipe is available in all of the sizes in the chart. Some end finishes and lengths are not stock items and require the material to be ordered. Calorized lance pipe can be ordered in special lengths.





### LANCE PIPE HOLDERS - SIZES .250" TO 1.900"



Lever Action Holders with optional lever handle



PL Holders for .405", .540", .625", .675" & .840"



Oxylance Ball Valve designed specifically for Lancing and oxygen manifolds.



LP Holders for sizes .250", .375", .405", .625", .675", .840", .922" & 1.05"



Apollo ball valves cleaned for oxygen service.



V-05 Deadman valve.



Thermal Shutoff / Anti Slag Safety Device in 1/4", 1/2", 3/4" and 1".





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## OXYLANCE OXYGEN HOSE AND REELS

### HOSE REELS

- Oxylance Hose Reels makes hose handling safer and more efficient.
- There are many advantages to our custom built hose reels.
  - » Safety: Reduces fire hazards caused by oxygen leaks from damaged hoses or lance holders.
  - » Safety: Reduces accidents from trip hazards created by hoses laying in the work area.
  - » Cost: Improves the life of expensive hose reducing replacement cost.
  - » Cost: Reduces maintenance cost to repair damaged hose and lance holders.
  - » Efficiency: Organized workplace is proven to save money by improving efficiency.
  - » OSHA: Assist companies to meet OSHA standards for walking and work area surfaces.



### OXYGEN HOSES

- Oxylance stocks two grades of oxygen hoses.
- 300 psi double wall double braid heavy duty hose. This hose is available in 3/8", 1/2" and 3/4" inside diameter.
- 500 psi mandrel built hose in 3/8" up to 2" available in lengths up to 100 feet.



### FITTINGS

- 3/8", 1/2" and 3/4" hoses are built with brass CGA fittings. 1" up to 2" hose use standard NPT type fittings and can be built with special swivel fittings for easy installation.

### TUNDISH FUSE STARTERS

- Oxylance manufactures Steel Tundish Starter Fuses in a variety of diameters, lengths and wall thicknesses. Fuses are built to the customer's specifications.



- Crimping Machines For Calorized Crimp On Couplings And Quick Connect Lance Pipe.



- For Calorized lance pipe with press on couplings a crimping system is required. We offer two systems for crimping the press on couplings. A hydraulic powered floor model that can be installed in place or a hand held electric unit. Both of these units can also be used with our Quick Connect Bare lance pipe.





**QUALITY PRODUCTS WITH THE DEPENDABILITY YOU DESERVE**

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# Oxylance

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