



**MANUFACTURER  
OF HELICAL  
SUBMERGED ARC  
WELDED** *steel pipes*

[www.hatboru.ro](http://www.hatboru.ro)

**2025**



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# Contents

▶	<u>About Us</u>	1
▶	<u>Areas of use</u>	2
▶	<u>Factory and Production Range</u>	3
▶	<u>Coating</u>	4
▶	<u>Lining</u>	5
▶	<u>Quality Control</u>	6

▶	<u>Certificates</u>	9
▶	<u>Mechanical Laboratory tests</u>	12
▶	<u>Weight Table</u>	14
▶	<u>Production Interval Table</u>	15
▶	<u>Location</u>	17
▶	<u>Contact</u>	18

# ABOUT US

Hatboru Romania SA, is the newest project of its kind in the field of production in Romania, as result of a joint-venture investment made by Hatboru company from Turkey and Romanian entrepreneurs. The factory is located in Giurgiu, produces helical submerged arc welded steel pipes, which could be anti-corrosion coated, externally and also internally, ensuring the technical characteristics that increase the pipe life duration.

[office@hatboru.com](mailto:office@hatboru.com)

The new Hatboru Romania SA production unit, has over 150 employees and will facilitate customers access to products that incorporate hi-technology and heavy equipment usage. The big and supple production capacity of the factory will help Romania to become a significant player on the energetic infrastructure market in the region. With the production development of Hatboru Romania SA, the range of suppliers and partners increased, from the raw materials procurement to special transportation of helical welded pipes; storage, production, maintenance, delivery, outsourcing operations.

1



## *The pipes produced by Hatboru Romania could be used for:*

- ▶ Water supply
- ▶ Sewerage
- ▶ Irrigations
- ▶ Hydro power plants
- ▶ Heating, high temperature water transmission
- ▶ Gas distribution lines, storage application
- ▶ Oil pipelines
- ▶ Liquid hydrocarbons transmission
- ▶ Petroleum products
- ▶ Foundation piles, roads and bridges constructions
- ▶ Industrial pipe network





## *Factory in Romania*

32.000 m<sup>2</sup> - Open area

23.000 m<sup>2</sup> - Well equiped closed area:

- Production line for SSAW pipe - 1
- Coating & Lining Lines - 2

50.000 - Metric ton annual production capacity

## *Production Range*

External diameter: from 406,4 mm up to 2540 mm

Wall thickness: from 4 mm up to 25 mm

Pipe length: from 8 m up to 28 m

## **COATING**

- ▶ Polyethylene
- ▶ Polypropylene
- ▶ Polyurethane
- ▶ Solvent Free & Coal-Tar Epoxy
- ▶ Fusion Bonded Epoxy





## *LINING*

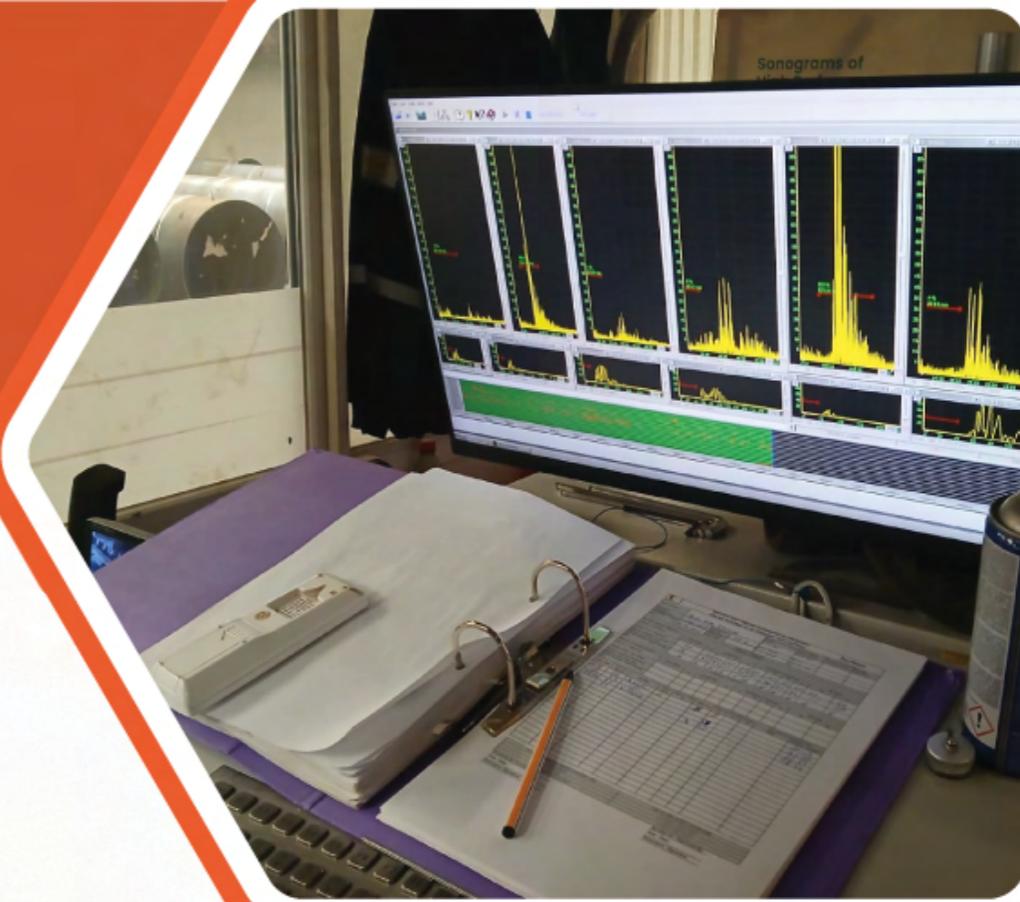
- ▶ Epoxy  
(Solvent Free & Coal-Tar Enmel)
- ▶ Flow Coat Epoxy
- ▶ Fusion Bonded Epoxy

# QUALITY CONTROL

Quality Control is following-up the production flow, from the material reception, pipe forming, till the shipment stage.

During the manufacturing, all the inspection steps are documented, DT and NDT reporting treated as a must.

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As non-destructive testing, surfacing/  
sub-surfacing and volumetric checking,  
the used methods are:

- ▶ Visual and dimensional control
- ▶ Mechanized & manual Ultrasonic testing
- ▶ Mechanized X-Ray on welds
- ▶ Dye Penetrant Inspection
- ▶ Magnetic Particle Inspection
- ▶ Hydrostatic testing
- ▶ DFT / Coating thickness measurement check

[office@hatboru.com](mailto:office@hatboru.com)





*From a QMS perspectives,  
Hatboru Romania has  
obtained and maintains  
the following ISO's  
certifications:*

- ▶ ISO 9001  
- Quality management systems
- ▶ ISO 14001  
- Environmental management systems
- ▶ ISO 45001  
- Occupational health and safety  
management system



# Certificates

*Considering the pipe forming, welding and surfaces treatments as the main areas covered, we have certified the Romanian workshop for various manufacturing international norms and standards:*

EN ISO 3834-2

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EN 1090-1 / 2

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EN ISO 3183: 2019

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2014/68/EU 2014/68

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EN 10217 – 1 / 5: 2019

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# Certificates

EN 10219-1: 2006

EN 10224:2003 + A1:2006

EN ISO 21809-1: 2018

DIN 30670: 2012

UNI 9099

AWWA C210

EN 10301: 2003

# Mechanical Laboratory tests

The Destructive testing is close following the manufacturing process in terms of either the mechanical & chemical coils properties or welding and coating testing. Therefore, the underneath listed methods are aligned to the ISO/IEC 17025 requirements:

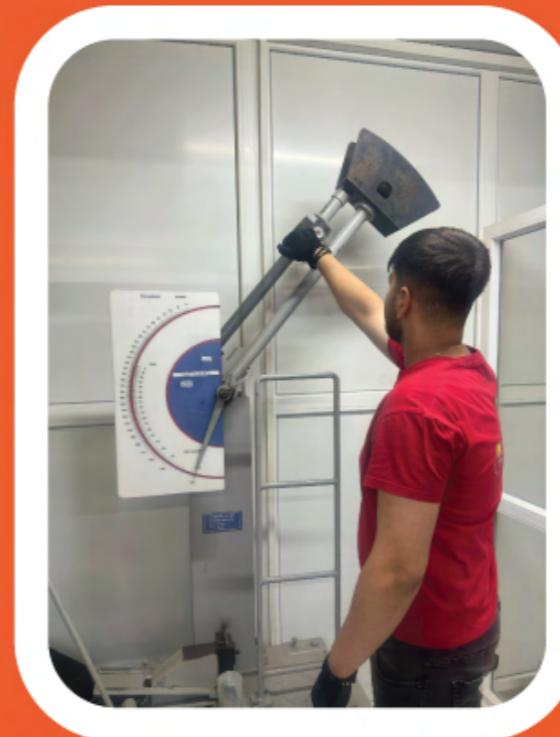
1. Tensile Test



2. Guided  
Bending Test



3. Charpy  
Impact Test



4. Hardness Test

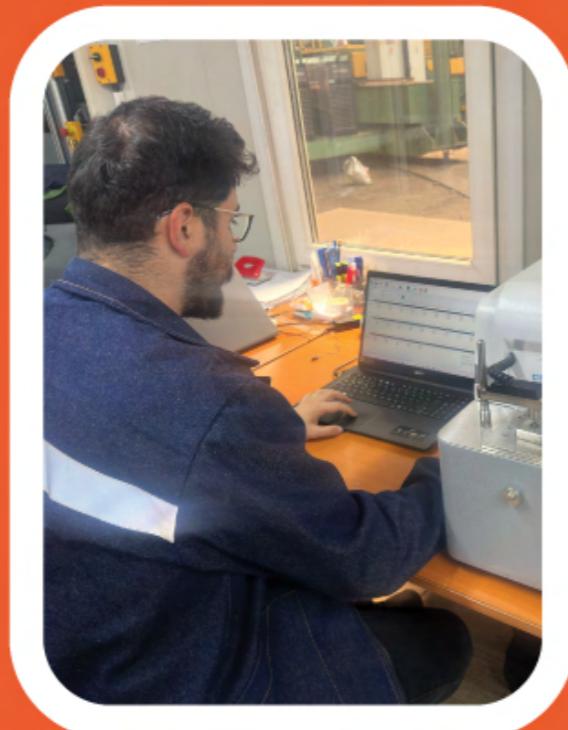


# Mechanical Laboratory tests

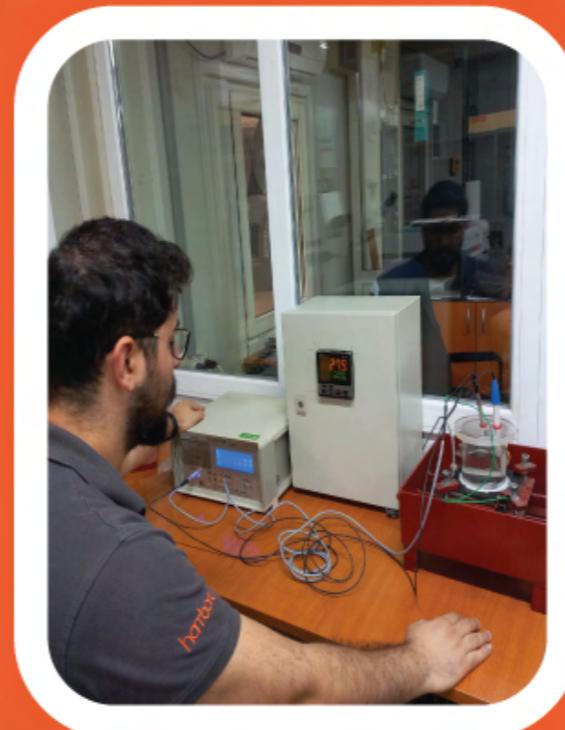
5. Macrographic Examination



6. Chemical Analysis



7. Cathodic disbondment testing



8. Viscosity testing

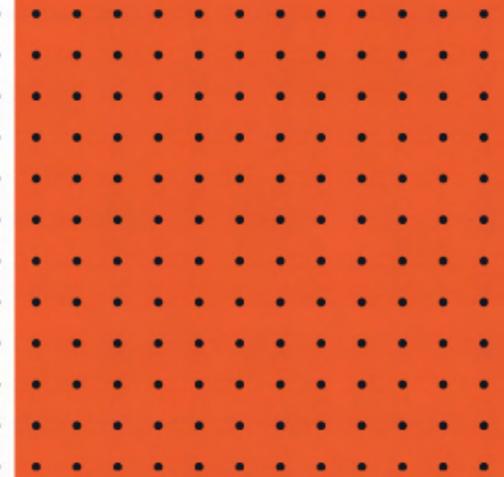


### WEIGHT TABLE

OD $\phi$		Wall Thickness (mm)																					
		4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25
mm	Inch	Weight (kg/m)																					
406.40	16.00	39.69	49.49	59.24	68.94	78.60	88.20	97.75	107.26	116.71	126.12	135.47	144.78	154.04	163.24	172.40	181.51	190.57	199.58	208.54			
457.20	18.00	44.70	55.76	66.76	77.71	88.62	99.47	110.28	121.04	131.74	142.40	153.01	163.57	174.08	184.54	194.95	205.31	215.63	225.89	236.10			
508.00	20.00	49.71	62.02	74.28	86.48	98.64	110.75	122.81	134.82	146.78	158.69	170.55	182.36	194.12	205.84	217.50	229.12	240.68	252.20	263.66	275.08	286.45	297.77
558.80	22.00	54.73	68.28	81.79	95.25	108.66	122.02	135.33	148.60	161.81	174.97	188.09	201.15	214.17	227.13	240.05	252.92	265.74	278.51	291.22	303.90	316.52	329.09
609.60	24.00		74.55	89.31	104.02	118.68	133.30	147.86	162.38	176.84	191.26	205.62	219.94	234.21	248.43	262.60	276.72	290.79	304.81	318.78	332.71	346.58	360.41
660.40	26.00		80.81	96.83	112.79	128.71	144.57	160.39	176.16	191.87	207.54	223.16	238.73	254.25	269.73	285.15	300.52	315.85	331.12	346.34	361.52	376.65	391.72
711.20	28.00		87.07	104.34	121.56	138.73	155.85	172.92	189.94	206.91	223.83	240.70	257.52	274.30	291.02	307.70	324.32	340.90	357.43	373.90	390.33	406.71	423.04
762.00	30.00		93.34	111.86	130.33	148.75	167.12	185.44	203.72	221.94	240.11	258.24	276.32	294.34	312.32	330.25	348.13	365.95	383.73	401.46	419.15	436.78	454.36
812.80	32.00		99.60	119.37	139.10	158.77	178.40	197.97	217.50	236.97	256.40	275.78	295.11	314.39	333.62	352.80	371.93	391.01	410.04	429.02	447.96	466.84	485.68
863.60	34.00		105.87	126.89	147.87	168.79	189.67	210.50	231.28	252.01	272.69	293.32	313.90	334.43	354.91	375.34	395.73	416.06	436.35	456.58	476.77	496.91	517.00
914.40	36.00			134.41	156.64	178.81	200.94	223.03	245.06	267.04	288.97	310.85	332.69	354.47	376.21	397.89	419.53	441.12	462.66	484.14	505.58	526.97	548.32
965.20	38.00			141.92	165.40	188.84	212.22	235.55	258.84	282.07	305.26	328.39	351.48	374.52	397.50	420.44	443.33	466.17	488.96	511.70	534.40	557.04	579.63
1016.00	40.00			149.44	174.17	198.86	223.49	248.08	272.62	297.10	321.54	345.93	370.27	394.56	418.80	442.99	467.13	491.23	515.27	539.26	563.21	587.11	610.95
1066.80	42.00			156.96	182.94	208.88	234.77	260.61	286.40	312.14	337.83	363.47	389.06	414.60	440.10	465.54	490.94	516.28	541.58	566.82	592.02	617.17	642.27
1168.40	46.00			171.99	200.48	228.92	257.32	285.66	313.96	342.20	370.40	398.55	426.64	454.69	482.69	510.64	538.54	566.39	594.19	621.94	649.65	677.30	704.91
1219.20	48.00			179.51	209.25	238.95	268.59	298.19	327.74	357.23	386.68	416.08	445.43	474.73	503.99	533.19	562.34	591.45	620.50	649.50	678.46	707.37	736.22
1320.80	52.00				226.79	258.99	291.14	323.24	355.30	387.30	419.25	451.16	483.02	514.82	546.58	578.29	609.95	641.55	673.11	704.62	736.09	767.50	798.86
1422.40	56.00				244.33	279.03	313.69	348.30	382.86	417.37	451.83	486.24	520.60	554.91	589.17	623.39	657.55	691.66	725.73	759.75	793.71	827.63	861.50
1524.00	60.00				261.86	299.08	336.24	373.35	410.42	447.43	484.40	521.31	558.18	595.00	631.76	668.48	705.15	741.77	778.34	814.87	851.34	887.76	924.13
1625.60	64.00						358.79	398.41	437.98	477.50	516.97	556.39	595.76	635.08	674.36	713.58	752.76	791.88	830.96	869.99	908.96	947.89	986.77
1727.20	68.00						381.34	423.46	465.54	507.56	549.54	591.47	633.34	675.17	716.95	758.68	800.36	841.99	883.57	925.11	966.59	1,008.02	1,049.41
1828.80	72.00							448.52	493.10	537.63	582.11	626.54	670.92	715.26	759.54	803.78	847.96	892.10	936.19	980.23	1,024.21	1,068.15	1,112.04
1930.40	76.00							473.57	520.66	567.69	614.68	661.62	708.51	755.35	802.14	848.88	895.57	942.21	988.80	1,035.35	1,081.84	1,128.28	1,174.68
2032.00	80.00							498.63	548.22	597.76	647.25	696.69	746.09	795.43	844.73	893.97	943.17	992.32	1,041.42	1,090.47	1,139.46	1,188.41	1,237.32
2133.60	84.00							523.68	575.78	627.82	679.82	731.77	783.67	835.52	887.32	939.07	990.77	1,042.43	1,094.03	1,145.59	1,197.09	1,248.55	1,299.95
2235.20	88.00							548.73	603.34	657.89	712.39	766.85	821.25	875.61	929.91	984.17	1,038.38	1,092.54	1,146.65	1,200.71	1,254.72	1,308.68	1,362.59
2336.80	92.00							573.79	630.90	687.95	744.96	801.92	858.83	915.69	972.51	1,029.27	1,085.98	1,142.65	1,199.26	1,255.83	1,312.34	1,368.81	1,425.22
2438.40	96.00								718.02	777.53	837.00	896.42	955.78	1,015.10	1,074.37	1,133.59	1,192.75	1,251.87	1,310.95	1,369.97	1,428.94	1,487.86	
2540.00	100.00								748.09	810.11	872.08	934.00	995.87	1,057.69	1,119.47	1,181.19	1,242.86	1,304.49	1,366.07	1,427.59	1,489.07	1,550.50	

## PRODUCTION INTERVAL TABLE

<b>OD <math>\phi</math></b>		<b>Wall Thickness (mm)</b>																					
		4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25
mm	Inch																						
406.40	16.00																						
457.20	18.00																						
508.00	20.00																						
558.80	22.00																						
609.60	24.00																						
660.40	26.00																						
711.20	28.00																						
762.00	30.00																						
812.80	32.00																						
863.60	34.00																						
914.40	36.00																						
965.20	38.00																						
1016.00	40.00																						
1066.80	42.00																						
1168.40	46.00																						
1219.20	48.00																						
1320.80	52.00																						



## PRODUCTION INTERVAL TABLE

<i>OD</i> $\phi$		<i>Wall Thickness (mm)</i>																					
		4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25
mm	Inch																						
1422.40	56.00					1	2	3	4	1	2	3	4	1	2	3	4	1	2	3	4	1	2
1524.00	60.00					1	2	3	4	1	2	3	4	1	2	3	4	1	2	3	4	1	2
1625.60	64.00					1	2	3	4	1	2	3	4	1	2	3	4	1	2	3	4	1	2
1727.20	68.00					1	2	3	4	1	2	3	4	1	2	3	4	1	2	3	4	1	2
1828.80	72.00					1	2	3	4	1	2	3	4	1	2	3	4	1	2	3	4	1	2
1930.40	76.00					1	2	3	4	1	2	3	4	1	2	3	4	1	2	3	4	1	2
2032.00	80.00					1	2	3	4	1	2	3	4	1	2	3	4	1	2	3	4	1	2
2133.60	84.00					1	2	3	4	1	2	3	4	1	2	3	4	1	2	3	4	1	2
2235.20	88.00					1	2	3	4	1	2	3	4	1	2	3	4	1	2	3	4	1	2
2336.80	92.00					1	2	3	4	1	2	3	4	1	2	3	4	1	2	3	4	1	2
2438.40	96.00					1	2	3	4	1	2	3	4	1	2	3	4	1	2	3	4	1	2
2540.00	100.00					1	2	3	4	1	2	3	4	1	2	3	4	1	2	3	4	1	2

1	S235, GrB, St37, L245
2	S275, St44, X42, X46, L290, L320
3	S355, St52, X52, X56, L360, L390
4	S450, X60, X65, L415, L450



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# LOCATION

## Hatboru Romania SA

Hatboru Romania S.A. is located within the Free Trade Zone of Giurgiu, a city in southern Romania, just 65 km from the capital, Bucharest. The region lies on the Wallachian Plain, featuring a flat landscape interspersed with small rivers.

The southern edge of Giurgiu County is bordered by the Danube River, which also marks the national frontier with Bulgaria. Giurgiu is directly connected to Bucharest via National Road DN5 (approx. 1-hour drive), and to Bulgaria through the Friendship Bridge over the Danube, linking it to the city of Ruse.

Together, Giurgiu and Ruse form one of the main hubs of the Giurgiu–Ruse Euroregion, offering strategic access to cross-border trade and transportation corridors.

[www.hatboru.ro](http://www.hatboru.ro)







# CONTACT US

## Phone

+40766 229 793

## Email

office@hatboru.com

## Website

www.hatboru.ro

## Location

Romania, Giurgiu, Free Zone

## Linkedin

Hatboru Romania

## Facebook

Hatboru Romania





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