

Method of hot pilger rolling of pipes involves rolling a sleeve onto a mandrel using rollers to form a pipe, with the rear end of the sleeve left unrolled to form a pilger head, followed by the preliminary release of the mandrel from the sleeve-pipe, rolling out the Pilgrim head on the free section of the mandrel, and subsequently completely removing the mandrel from the pipe. The section of the pipe, ranging in length from one to three of its outer diameters and adjacent to the pilger head, is rolled with a wall thickness increased by 10–15% compared to the wall thickness of the main part of the pipe by increasing the roll spread and the feed rate by 15–20% higher than the feed rate during rolling of the main part of the pipe. Then, the mandrel is preliminarily released from the pipe sleeve, and the thickened section of the pipe is re-rolled by reducing the roll gap until the wall thickness is uniform, followed by rolling of the pilger head and the final release of the mandrel from the pipe.