

A method of pipe rolling on Pilger rolling mills includes deformation on a mandrel of a heated hollow shell in a template with a cross-section, which decreases in a circle, of steel, welded and polished rolls, coating the surface of roll templates with an anti-sticking compound before installing them in the stand, in addition, in case of sticking metal in problem areas of the rolls during rolling a mill is stopped, the problem areas of the roll with stuck metal are polished followed by coating the fillers with anti-sticking compound with a central angle  $\theta = 100-120^\circ$  from the beginning of the working area of the template and on the top of the template in the areas of transition from the head to the polishing area, and from the polishing area to the longitudinal section, while the band width of application of anti-sticking compound makes  $\alpha = 50-100$  mm.