Chrome Running Guidelines

These guidelines ensure maximum performance when running chrome pipes - high Cr alloyed (with a chrome content greater than 9%) and Ni based alloys -, which possess higher thread galling characteristics than standard carbon grade pipes.

When running chrome pipes, follow all procedures in the TenarisHydrl Running Manual, using the Chrome Running Guidelines as a complement.

Procedures

PRE-RUNNING

1. Drift using a non-metallic drift mandrel.

2. Avoid excessive or vigorous cleaning.

3. After cleaning contamination, debris and foreign particles are unacceptable. For Group 2 connections apply a thin, even coat of moly coat spray to any shiny areas of the pin metal seal.

4. Apply a thin, even coat of running compound (the thread form outline should be clearly visible) to both the pin and box using a mustache brush (yard or rack preparation).

5. Reinstall clean thread protectors.

RUNNING

1. Check for traveling block and rotary hole alignment. If misalignment is excessive, an adjustment must be made. Most chrome connection make-up problems (i.e. galling and high shoulder) are caused by poor alignment.

2. The use of a weight compensator is highly recommended to facilitate hand make-up.

3. The use of pick-up/lay-down equipment with a traveling basket coated with rubber or with another soft material is recommended. Metal to metal contact is not acceptable. Nylon slings are recommended.

4. Before stabbing, ensure that the running compound is properly applied. If necessary, spread it in order to obtain a thin and even layer on both the pin and box connections. Any shiny area found on Group 2 connections should be sprayed lightly with moly coat spray.

5. It is highly recommended to make up the connections by hand using a strap wrench and a steady pulling motion. Only after a connection is hand-tight should the power tongs be engaged to apply the final make-up torque. Do not jerk on the connection.

6. When full automatic power tong is used, the connections must be made up at low rpm (10 rpm max, 5 rpm recommended) in the first threads to prevent galling.

6.1. In the initial stages, monitor make-up and rotation speed for possible irregularities, making adjustments as necessary.

6.2. Pay attention to any instant indication of high torque developed, it is a sign of possible misalignment. Rotation should be stopped, thread alignment verified and rotation restarted. If misalignment is detected, it must be corrected prior to continuing rotation.

PULLING

1. It is highly recommended to use weight compensator to avoid thread damage.

2. It is highly recommended to use power tongs in low gear only to break out connections. Then continue to walk joint out by hand using a strap wrench.

3. It is recommended to apply stabbing guide

4. Extreme care should be exercised when lifting the pin out of the box. Lift joint slowly and steadily in order to avoid bumps.

5. Clean, dry and inspect pin connection.

6. Apply storage/running compound and install dry, clean pin protectors.

NOTE: GROUP 2 REFERS TO WEDGE SERIES 500™, MACII™, SLX™, PH4™, PH6™ AND CS®.