

DIN EN ISO 13680:2020-11 (E)

Petroleum and natural gas industries - Corrosion-resistant alloy seamless tubular products for use as casing, tubing, coupling stock and accessory material - Technical delivery conditions (ISO 13680:2020); English version EN ISO 13680:2020, only on CD-ROM

Contents		Page
Foreword		vii
Introduction		viii
1 Scope		1
2 Normative references		2
3 Terms, definitions, abbreviated terms and symbols		4
3.1 Terms and definitions		4
3.2 Abbreviated terms		6
3.3 Symbols		7
4 General		8
4.1 Dual normative references		8
4.2 Units of measurement		8
5 Information supplied by the purchaser		8
6 Manufacturing process		11
6.1 Melting practices		11
6.2 Product manufacturing process		11
6.3 Pipe end sizing		11
6.4 Straightening		11
6.5 Process requiring validation		12
6.6 Traceability		12
6.7 Manufacturing procedure qualification test		12
6.8 Process for update of alloys and/or grades		12
7 Material requirements		13
7.1 Chemical composition		13
7.2 Tensile properties		13
7.3 Hardness properties		13
7.4 Charpy V-notch test properties — General requirements		13
7.4.1 Evaluation of test results		13
7.4.2 Critical thickness		14
7.4.3 Specimen size, orientation and hierarchy		14
7.4.4 Alternative size impact test specimens		14
7.4.5 Sub-size test specimens		14
7.4.6 Test temperature		14
7.5 Charpy V-notch — Absorbed energy requirements for coupling stock and accessory material — All grades		14
7.5.1 General		14
7.5.2 Requirements for all grades		15
7.6 Charpy V-notch — Absorbed energy requirements for pipe — All grades		15
7.7 Flattening requirements		16
7.8 Charpy V-notch test properties at low temperature for group 2		17
7.8.1 General		17
7.8.2 Evaluation of test results		17
7.8.3 Selection of test specimens		17
7.8.4 Test temperature		17
7.8.5 Absorbed energy requirements		17

7.9	Corrosion properties	17
7.9.1	General	17
7.9.2	Pitting corrosion properties for group 2	18
7.10	Microstructure properties	18
7.10.1	Group 1	18
7.10.2	Group 2	18
7.10.3	Groups 3 and 4	18
7.11	Surface condition	18
7.12	Defects	19
7.12.1	Pipe	19
7.12.2	Coupling stock and accessory material	19
7.12.3	Process control plan	19
8	Dimensions, masses and tolerances	19
8.1	Outside diameter, wall thickness and mass	19
8.2	Length	20
8.3	Tolerances	20
8.3.1	Tolerance on outside diameter, wall thickness and mass	20
8.3.2	Inside diameter, <i>d</i>	20
8.3.3	Straightness	20
8.3.4	Drift requirements	20
8.4	Product ends	20
9	Inspection and testing	21
9.1	Test equipment	21
9.2	Type and frequency of tests	21
9.3	Testing of chemical composition	21
9.3.1	Chemical analysis	21
9.3.2	Test method	21
9.3.3	Chromium depletion test — Groups 2, 3 and 4	21
9.4	Testing of mechanical characteristics	22
9.4.1	Test lot	22
9.4.2	Selection and preparation of samples and test pieces	22
9.5	Tensile test	22
9.5.1	Orientation and size of test pieces	22
9.5.2	Test method	22
9.5.3	Invalidation of test	22
9.5.4	Retest	22
9.6	Hardness test	23
9.6.1	Test pieces	23
9.6.2	Test method	23
9.6.3	Invalidation of tests	24
9.6.4	Periodic checks of hardness-testing machines	24
9.6.5	Verification of hardness-testing machines and indenters	24
9.6.6	Retests	25
9.7	Impact or flattening test	26
9.7.1	Test pieces	26
9.7.2	Frequency of testing	26
9.7.3	Impact test method	26
9.7.4	Flattening test method	27
9.7.5	Impact test retest	27
9.7.6	Flattening test retest	27
9.7.7	Invalidation of tests	28
9.8	Impact test at low temperature for group 2	28
9.9	Pitting corrosion test for group 2	28
9.10	Microstructural examination	29
9.10.1	Test pieces	29
9.10.2	Test method	29
9.10.3	Retest	30

9.11	Dimensional testing.....	30
9.11.1	General.....	30
9.11.2	Outside diameter.....	30
9.11.3	Wall thickness at end of products.....	30
9.11.4	Wall thickness of product body.....	30
9.12	Drift test.....	31
9.12.1	Non-upset and external upset pipe.....	31
9.12.2	Internal upset pipe.....	31
9.12.3	Drift mandrel coating.....	31
9.13	Length.....	31
9.14	Straightness.....	31
9.15	Mass determination.....	31
9.16	Visual inspection.....	31
9.16.1	General.....	31
9.16.2	Pipe body, coupling stock and accessory material.....	32
9.16.3	Pipe ends.....	32
9.16.4	Disposition.....	32
9.17	Non-destructive examination.....	32
9.17.1	General.....	32
9.17.2	NDE personnel.....	33
9.17.3	Products.....	33
9.17.4	Pup joints.....	33
9.17.5	Untested ends.....	33
9.17.6	Upset ends.....	33
9.17.7	Reference standards.....	34
9.17.8	NDE system capability records.....	34
9.17.9	All product group 1.....	35
9.17.10	Full-body NDE of product — Groups 2, 3 and 4.....	35
9.17.11	Pipe, coupling stock and accessory material requiring further evaluation.....	35
9.17.12	Evaluation of indications (prove-up).....	35
9.17.13	Disposition of pipe containing defects.....	36
9.17.14	Disposition of coupling stock and accessory material containing defects.....	37
9.18	Positive material identification.....	37
10	Surface treatment.....	38
10.1	Group 1.....	38
10.2	Groups 2, 3 and 4.....	38
11	Marking.....	39
11.1	General.....	39
11.2	Colour-code identification.....	39
11.3	Marking content and sequence.....	39
11.4	Marking informative for couplings, pup joints and accessories after threading.....	40
12	Surface protection — Group 1.....	40
13	Documents.....	41
13.1	Electronic media.....	41
13.2	Retention of records.....	41
13.3	Test certificates.....	41
14	Handling, packaging and storage.....	42
14.1	General.....	42
14.2	Handling.....	42
14.3	Packaging.....	42
14.3.1	General.....	42
14.3.2	Identification.....	42
14.4	Storage.....	43

Annex A (normative) Tables in SI units44
Annex B (normative) Figures in SI (USC) units68
Annex C (normative) Tables in USC units.....73
Annex D (normative) Purchaser inspection97
Annex E (normative) Cleanliness requirements98
Annex F (normative) Coupling blanks and accessory material from bar..... 100
Annex G (normative) Product specification level 2 (PSL-2)..... 115
Annex H (normative) Standardized manufacturing procedure qualification test..... 117
Annex I (informative) Photographic examples of microstructures, groups 2, 3 and 4..... 121
Bibliography 125