

ISO 11960:2020-03 (E)

Petroleum and natural gas industries - Steel pipes for use as casing or tubing for wells

Contents	Page
Foreword	x
Introduction	xi
1 Scope	1
2 Normative references	1
3 Terms, definitions, symbols and abbreviated terms	3
3.1 Terms and definitions	3
3.2 Symbols and abbreviated terms	7
4 Conformance	8
4.1 Dual referencing of normative references	8
4.2 Units of measurement	9
5 Information to be supplied by the purchaser	9
5.1 Grades C90, T95 and C110	9
5.2 Casing	9
5.3 Tubing	11
5.4 Coupling stock, coupling material and accessory material	13
6 Process of manufacture	14
6.1 General	14
6.2 Heat treatment	14
6.2.1 General	14
6.2.2 Grades J55, K55, N80 all types and R95	15
6.2.3 Grades L80 all types, C90, T95 and C110	15
6.3 Straightening	15
6.3.1 Grades H40, J55, K55, N80 all types	15
6.3.2 Grades R95 and P110	15
6.3.3 Grade L80	15
6.3.4 Grades C90, T95 and C110	16
6.3.5 Grade Q125	16
6.4 Traceability	16
6.4.1 General	16
6.4.2 Serialization of Grades C90, T95, C110 and Q125	16
6.5 Processes requiring validation	16
7 Material requirements	17
7.1 Chemical composition	17
7.2 Tensile properties	17
7.2.1 General	17
7.2.2 Elongation	17
7.2.3 Yield strength	17
7.2.4 Statistical tensile testing — Grades C90, T95 and C110	18
7.3 Charpy V-notch test — General requirements	18
7.3.1 Evaluation of test results	18
7.3.2 Critical thickness	18
7.3.3 Specimen size and orientation	18
7.3.4 Hierarchy of test specimens	18
7.3.5 Alternative size impact test specimens	19
7.3.6 Sub-size test specimens	19
7.3.7 Test temperature	19
7.3.8 Statistical impact testing	19
7.3.9 Reference information	19

7.4	Charpy V-notch — Absorbed energy requirements for coupling stock, coupling material, coupling blanks and couplings.....	19
7.4.1	General.....	19
7.4.2	Grade H40	19
7.4.3	Grades J55 and K55 for API threads.....	19
7.4.4	Grades N80 all Types, R95, L80 all Types, C90, T95, P110 and Q125 for API threads	20
7.4.5	Special end-finish.....	20
7.5	Charpy V-notch — Absorbed energy requirements for pipe.....	20
7.5.1	Grades H40, J55 and K55	20
7.5.2	Grades N80 all Types, R95, L80, C90, T95 and P110	20
7.5.3	Grades C110 and Q125	21
7.5.4	Test specimen.....	21
7.5.5	Testing conditions.....	22
7.6	Charpy V-notch — Absorbed energy requirements for accessory material	22
7.6.1	Accessory material — General.....	22
7.6.2	Accessory material for accessories with internal API threads except integral tubing connections.....	22
7.6.3	Accessory material for accessories with internal special end-finish tapered interference-type threads	22
7.6.4	Accessory material for accessories with external threads	22
7.6.5	Accessory material for accessories with either integral tubing connections or internal special end-finish connections that do not have thread interference	22
7.6.6	Critical thickness for accessory material and special end-finish material	22
7.7	Maximum hardness.....	23
7.7.1	Grades L80 all types, C90, T95 and C110	23
7.7.2	Grade Q125 — All products	23
7.8	Hardness variation — Grades C90, T95, C110 and Q125	23
7.9	Process control — Grades C90, T95, C110 and Q125	23
7.10	Hardenability — Minimum percentage martensite for quenched and tempered products	24
7.10.1	Grade L80 Type 1	24
7.10.2	Grades C90 and T95	24
7.10.3	Grade C110	24
7.10.4	All grades except Grades L80, C90, T95 and C110	24
7.11	Grain size — Grades C90, T95 and C110	25
7.12	Surface condition — Grade L80 13Cr	25
7.13	Flattening — Electric-welded pipe	25
7.14	Sulfide stress cracking test — Grades C90, T95 and C110	25
7.14.1	General guidance	25
7.14.2	Test and retest requirements and recommendations	25
7.14.3	Test sample selection and location	26
7.14.4	Test solution	26
7.14.5	Minimum SSC requirements	27
7.14.6	Invalidation of tests	28
7.14.7	Additional testing provisions for ANSI/NACE TM0177-2016 Method D	28
8	Dimensions, masses, tolerances, product ends and defects.....	28
8.1	Labels and sizes.....	28
8.2	Dimensions and masses	28
8.3	Diameter	29
8.3.1	Measurement and design	29
8.3.2	Requirements	29
8.4	Wall thickness	29
8.5	Mass	29
8.6	Length	30
8.7	Casing jointers	30
8.8	Height and trim of electric-weld flash	30
8.8.1	Trimming electric-weld flash	30
8.8.2	Grades H40, J55, K55, N80 all types, R95; and L80 Type 1	30
8.8.3	Grades P110 and Q125	31
8.8.4	Disposition	31
8.9	Straightness	31

8.9.1	Pipe.....	31
8.9.2	Coupling stock, coupling material and accessory material.....	31
8.10	Drift requirements.....	31
8.11	Tolerances on dimensions and masses.....	32
8.11.1	Outside diameter	32
8.11.2	Wall thickness	32
8.11.3	Mass	32
8.11.4	Inside diameter	33
8.11.5	Upset dimensions.....	33
8.11.6	Extended length upsets.....	33
8.12	Product ends.....	33
8.12.1	Plain-end pipe	33
8.12.2	Product with API threads	33
8.12.3	Rounded nose	33
8.12.4	Threading.....	33
8.12.5	Special end finish.....	34
8.13	Defects.....	34
8.13.1	Pipe and accessory made from pipe	34
8.13.2	Accessory material not made from pipe, coupling stock and coupling material	34
8.13.3	Process control plan.....	35
8.14	Coupling make-up and thread protection.....	35
8.14.1	All Grades except Q125	35
8.14.2	Grade Q125	35
9	Couplings	35
9.1	General requirements	35
9.2	Alternative grades or heat treatments	36
9.3	Mechanical properties	36
9.4	Dimensions and tolerances	36
9.4.1	All Grades except Q125	36
9.4.2	Grade Q125	37
9.5	Regular couplings	37
9.6	Special-clearance couplings — All Grades except Q125	37
9.7	Combination couplings	37
9.8	Seal-ring couplings	37
9.9	Special-bevel tubing regular couplings — All Grades	37
9.10	Threading — Couplings	38
9.11	Surface inspection	38
9.12	Measurement of imperfections	38
9.13	Repair and removal of imperfections and defects	39
9.14	Thread surface treatment — Grade Q125	39
9.15	Couplings and coupling blank protection — Grades C90, T95, C110 and Q125	39
10	Inspection and testing	39
10.1	Test equipment	39
10.2	Lot definition for testing of mechanical properties	39
10.2.1	Grades H40, J55, K55, N80 all types, L80 Type 1, R95 and P110 — Coupling stock, coupling material and pipe (except pup joints heat-treated after cutting to blank or individual length)	39
10.2.2	Grades L80 13Cr, C90, T95, C110 and Q125 — Coupling stock, coupling material and pipe (except pup joints heat-treated after cutting to blank or individual length)	39
10.2.3	Coupling blanks, pup joints or accessory material heat-treated after cutting to blank or individual length	40
10.3	Testing of chemical composition	40
10.3.1	Heat analyses	40
10.3.2	Product analyses	40
10.3.3	Test method	40
10.3.4	Recheck of product analyses — All Grades	41

10.4	Tensile tests	41
10.4.1	Stress-relief temperature — All grades	41
10.4.2	Heat-control tensile tests — All Grades except Q125	41
10.4.3	Frequency of testing and location of test specimen — Casing and tubing	41
10.4.4	Frequency of testing and test specimen location — Coupling stock, coupling material, coupling blanks, pup joints and accessory material	41
10.4.5	Test specimens — General	42
10.4.6	Test specimens — Additional requirements for coupling blanks, coupling stock coupling material and pup joint and accessory materials — Grades C110 and Q125	42
10.4.7	Test method	42
10.4.8	Invalidation of tests	43
10.4.9	Retests — All products (except coupling blanks, coupling stock, coupling material, pup joints or accessory material) — Grades C90, T95, C110 and Q125	43
10.4.10	Retests — Coupling blanks, coupling stock, coupling material, pup joints or accessory material in Grades C90, T95, C110 and Q125	43
10.5	Flattening test	43
10.5.1	General requirement for testing	43
10.5.2	Frequency of testing	43
10.5.3	Test specimens	44
10.5.4	Test method for Grades H40, J55, K55, N80 all types, R95, and L80 Type 1	44
10.5.5	Test method for Grade P110 pipe and Grade Q125 casing	44
10.5.6	Invalidation of tests	44
10.5.7	Retests	44
10.6	Hardness test	44
10.6.1	Frequency of testing — General	44
10.6.2	Frequency of testing — Heat-control tests — Grade L80	45
10.6.3	Frequency of testing — Grade L80	45
10.6.4	Frequency of testing and test specimen location — Non-upset pipe — Grades C90, T95 and C110	45
10.6.5	Frequency of testing and test specimen location — Upset pipe — Grades C90 and T95	45
10.6.6	Frequency of testing and test specimen location — Coupling blanks, coupling stock, coupling material, pup joints and accessory material — Grades C90, T95 and C110	45
10.6.7	Frequency of testing — Grade Q125	46
10.6.8	Test specimens	46
10.6.9	Test method	46
10.6.10	Invalidation of tests	48
10.6.11	Periodic checks of hardness-testing machines	48
10.6.12	Verification of hardness-testing machines and indenters	48
10.6.13	Retests — Grade L80	49
10.6.14	Retests — Grades C90, T95 and C110 products except for coupling blanks, pup joints or accessory material heat-treated after cutting to individual lengths	49
10.6.15	Retests — Grades C90, T95 and C110 coupling blanks, pup joints or accessory material heat-treated after cutting to individual lengths	50
10.6.16	Retests — Grade Q125 — General	50
10.6.17	Retests — Grade Q125 — Casing, coupling stock and coupling material	50
10.6.18	Retests — Grade Q125 — Coupling blanks, pup joints and accessory material	50
10.6.19	Rejected lots — Grades L80 all types, C90, T95, C110 and Q125	50
10.7	Impact test	50
10.7.1	Sampling — Grades J55 and K55	50
10.7.2	Sampling — Grades N80 all types, R95, L80, C90, T95, C110 and P110	50
10.7.3	Sampling and test specimen location — Grade Q125	51
10.7.4	Test specimens	51
10.7.5	Test method	51

10.7.6	Invalidation of tests	51
10.7.7	Retest of a length — All Grades	51
10.7.8	Replacement of a reject length — All Grades	52
10.7.9	Multiple length rejection — Grade Q125	52
10.8	Grain size determination — Grades C90, T95 and C110	52
10.8.1	Sampling	52
10.8.2	Test method	52
10.9	Hardenability — Grades C90, T95 and C110	52
10.10	Sulfide stress-cracking test — Grades C90, T95 and C110	52
10.11	Metallographic evaluation — All EW Grades	52
10.12	Hydrostatic tests	53
10.12.1	Hydrostatic test procedures	53
10.12.2	Hydrostatic test requirements	53
10.12.3	Test pressure calculation	54
10.13	Dimensional testing	55
10.13.1	General	55
10.13.2	Diameter measurement	55
10.13.3	Diameter retests	55
10.13.4	Wall thickness measurement	56
10.13.5	Drift test	56
10.13.6	Length measurement	56
10.13.7	Mass (weight) determination	56
10.13.8	Straightness evaluation	57
10.13.9	Internal upset inspection	57
10.14	Visual inspection	57
10.14.1	General	57
10.14.2	Pipe body, coupling stock and coupling material (excluding pipe ends)	58
10.14.3	Pipe ends	58
10.14.4	Disposition	58
10.15	Non-destructive examination (NDE)	58
10.15.1	General	58
10.15.2	NDE personnel	59
10.15.3	Reference standards	59
10.15.4	NDE system capability records	59
10.15.5	Pipe body or coupling stock inspection — General	60
10.15.6	Full-body, full-length NDE of casing and tubing — Grades H40, J55, K55, N80 all types, L80 and R95	60
10.15.7	Full-body, full-length NDE of casing and tubing — Grade P110 to A.8 SR16	60
10.15.8	Full-body, full-length NDE of casing and tubing — Grade P110 and Grade P110 to A.8 SR16 and A.2 SR2	61
10.15.9	Full-body, full-length NDE of casing and tubing — Grades L80 13Cr, C90, T95, C110 and Q125	61
10.15.10	NDE of the weld seam of welded pipe	61
10.15.11	NDE of coupling stock, accessory material (except Grades L80 13Cr, C90, T95, C110 and Q125) and pup joints	62
10.15.12	NDE of coupling stock and accessory material — Grades L80 13Cr, C90, T95, C110 and Q125	62
10.15.13	NDE of coupling stock and accessory material — Grades C90 and T95	63
10.15.14	Untested pipe ends, coupling stock ends and accessory material ends	64
10.15.15	Pipe upsets	64
10.15.16	Pipe, coupling stock and accessory material requiring further evaluation	64

10.15.17	Evaluation of indications (prove-up)	65
10.15.18	Disposition of pipe containing defects	65
10.15.19	Disposition of coupling stock and accessory material containing defects	66
11	Marking	67
11.1	General	67
11.2	Stamp marking requirements	68
11.2.1	Methods	68
11.2.2	Size	68
11.2.3	Location	68
11.2.4	Grades H40, J55, K55, N80 all types and P110	68
11.2.5	Grades R95, L80 all types, C90, T95, C110 and Q125	68
11.2.6	Make-up triangle marking	69
11.3	Stencil marking requirements	69
11.4	Colour identification	69
11.4.1	Colour coding	69
11.4.2	Product 1,8 m (6 ft) and longer	69
11.4.3	Loose couplings	70
11.4.4	Special-clearance couplings	70
11.4.5	Pup joints shorter than 1,8 m (6 ft) in length	70
11.4.6	Grade colour-codes	70
11.5	Thread and end-finish marking	70
11.5.1	API thread marking	70
11.5.2	Plain-end and special end-finish markings	70
11.6	Pipe-threader marking requirements	70
12	Coating and protection	71
12.1	Coatings	71
12.1.1	Coatings for protection during transit	71
12.1.2	Coatings for long-term storage	71
12.2	Thread protectors	72
12.2.1	General	72
12.2.2	Grade L80 13Cr	72
12.2.3	Driftable thread protectors	72
13	Documents	72
13.1	Electronic media	72
13.2	Certification requirements	72
13.3	Content of the certificate	72
13.4	Retention of records	74
14	Minimum facility requirements for various categories of manufacturer	74
14.1	Pipe mill	74
14.2	Processor	74
14.3	Pipe threader	74
14.4	Coupling, pup-joint or accessory manufacturer	75
Annex A (normative) Supplementary requirements	76	
Annex B (normative) Purchaser inspection	91	
Annex C (normative) Tables in SI units	92	
Annex D (normative) Figures in SI (USC) units	159	
Annex E (normative) Tables in USC units	182	
Annex F (informative) Procedures used to convert from USC units to SI units	248	
Annex G (normative) Requirements for thread protector design validation	260	
Annex H (normative) High collapse requirements	265	
Bibliography	267	