

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 |