

ISO/PAS 24565:2022-01 (E)

Petroleum and natural gas industries - Ceramic lined tubing

Contents		Page
Foreword		v
Introduction		vi
1 Scope		1
2 Normative references		1
3 Terms, definitions, symbols and abbreviated terms		2
3.1 Terms and definitions.....		2
3.2 Symbols and abbreviated terms.....		3
3.2.1 Symbols.....		3
3.2.2 Abbreviated terms.....		3
4 CLT configuration and materials		4
4.1 Configuration.....		4
4.2 Pipe ends.....		5
4.3 Connection type.....		5
4.4 Material requirements.....		6
4.4.1 Backing pipe.....		6
4.4.2 Thermite.....		6
4.4.3 End cap and CB ring.....		6
5 Manufacturing		6
5.1 Treatment of backing pipe.....		6
5.1.1 Distinguishing of the used tubing.....		6
5.1.2 Blast-cleaning.....		7
5.1.3 Straightening of the used tubing.....		7
5.2 Manufacture of CLT.....		7
5.2.1 Thermite mixing.....		7
5.2.2 Filling.....		7
5.2.3 Lining.....		7
5.2.4 Heat treatment.....		7
5.2.5 Installation of the end cap.....		7
5.2.6 Threading.....		7
5.3 Manufacture of CB Ring.....		8
5.4 Installation of CB Rings.....		8
5.5 Traceability.....		8
5.6 Purchaser inspection.....		8
6 Inspection and testing		8
6.1 General.....		8
6.2 Inspection of backing pipe.....		8
6.3 Inspection of ceramic liner.....		9
6.3.1 Surface.....		9
6.3.2 Thickness.....		9
6.3.3 Hardness and density.....		9
6.4 Inspection of CLT.....		9
6.4.1 Dimensions test.....		9
6.4.2 Length measurement.....		9
6.4.3 Straightness evaluation.....		10
6.4.4 Thread and end cap inspection.....		10
6.4.5 Drift test.....		11
6.4.6 Hydrostatic test.....		11

6.4.7	Corrosion test.....	11
6.4.8	Tensile and impact test.....	12
6.4.9	Connection test.....	12
6.5	Additional tests.....	12
6.5.1	General.....	12
6.5.2	Impact test.....	12
6.5.3	Crushing strength test.....	12
6.5.4	Bonding strength test.....	12
6.5.5	Bending test.....	13
6.5.6	Thermal shock test.....	14
6.6	CB ring test.....	14
6.7	End cap test.....	14
6.8	Inspection frequency and acceptance criteria.....	14
6.8.1	Lot.....	14
6.8.2	Inspection frequency.....	14
6.8.3	Acceptance criteria.....	15
7	Documentation.....	15
7.1	Documents provided by the purchaser.....	15
7.2	Documents provided by the manufacturer.....	16
8	Marking, packaging, transportation, and storage.....	16
8.1	Marking.....	16
8.2	Packaging.....	17
8.3	Transportation.....	17
8.4	Storage.....	17
	Annex A (informative) Testing method for surface quality of ceramic liner.....	18
	Annex B (normative) List of CLT products.....	19
	Annex C (informative) Testing method of ceramic liner thickness.....	23
	Bibliography.....	25