DIN EN ISO 11960:2005-07 (E)

Petroleum and natural gas industries - Steel pipes for use as casing or tubing for wells (ISO 11960:2004); English version EN ISO 11960:2004

Contents

Page

Foreword ... 5

Introduction ... 6

1 Scope ... 7

2 Conformance ... 8
2.1 Normative references ... 8
2.2 Units of measurement ... 8

3 Normative references ... 8

4 Terms, definitions, symbols and abbreviated terms ... 10
4.1 Terms and definitions ... 10
4.2 Symbols and abbreviated terms ... 14

5 Information to be supplied by the purchaser ... 15
5.1 Casing ... 15
5.2 Tubing ... 17
5.3 Coupling stock and accessories ... 18

6 Process of manufacture ... 18
6.1 General ... 18
6.2 Heat treatment ... 19
6.3 Straightening ... 19
6.4 Traceability ... 20
6.5 Processes requiring validation ... 21

7 Material requirements ... 21
7.1 Chemical composition ... 21
7.2 Tensile properties ... 21
7.3 Charpy V-notch test — General requirements ... 22
7.4 Charpy V-notch test — Absorbed energy requirements for coupling stock, coupling blanks and couplings ... 23
7.5 Charpy V-notch test — Absorbed energy requirements for pipe ... 24
7.6 Charpy V-notch test — Absorbed energy requirements for casing and tubing accessories ... 26
7.7 Maximum hardness ... 27
7.8 Hardness variation — Grades C90, T95 and Q125 ... 27
7.9 Process control — Grades C90, T95 and Q125 ... 27
7.10 Hardenability — Minimum percentage martensite for quenched and tempered products ... 27
7.11 Grain size — Grades C90 and T95 ... 28
7.12 Surface condition — Grades L80 9Cr and L80 13Cr ... 28
7.13 Flattening — Electric-welded pipe ... 28
7.14 Sulfide stress cracking test — Grades C90 and T95 ... 28

8 Dimensions, masses, tolerances, pipe ends and defects ... 30
8.1 Labels and sizes ... 30
8.2 Dimensions and masses ... 30
8.3 Diameter ... 30
8.4 Wall thickness ... 31
8.5 Mass ... 31
8.6 Length ... 31
8.7 Casing jointers ... 31
8.8 Height and trim of electric-weld flash ... 32
8.9 Straightness ... 32
8.10 Drift requirements ... 33
8.11 Tolerances on dimensions and masses ... 33

8.12 Pipe ends 34
8.13 Defects 36
8.14 Coupling make-up and thread protection 36

9 Couplings 37
9.1 General requirements 37
9.2 Alternative grades or heat treatments 37
9.3 Process of manufacture — Groups 1, 2 and 3 38
9.4 Process of manufacture — Grade Q125 38
9.5 Mechanical properties 38
9.6 Dimensions and tolerances 38
9.7 Regular couplings 38
9.8 Special-clearance couplings — Groups 1, 2 and 3 39
9.9 Combination couplings 39
9.10 Reducing couplings — Groups 1, 2 and 3 39
9.11 Seal-ring couplings 39
9.12 Special-bevel tubing couplings — Groups 1, 2 and 3 39
9.13 Threading 39
9.14 Surface inspection 40
9.15 Measurement of imperfections 41
9.16 Repair and removal of imperfections and defects 41
9.17 Thread surface treatment — Grade Q125 41
9.18 Couplings and coupling blank protection — Grades C90, T95 and Q125 41

10 Inspection and testing 41
10.1 Test equipment 41
10.2 Lot definition for testing of mechanical properties 41
10.3 Testing of chemical composition 42
10.4 Tensile tests 43
10.5 Flattening test 45
10.6 Hardness test 46
10.7 Impact test 50
10.8 Grain size determination — Grades C90 and T95 52
10.9 Hardenability — Grades C90 and T95 52
10.10 Sulfide stress-cracking test — Grades C90 and T95 52
10.11 Metallographic evaluation — EW Grades P110 and Q125 52
10.12 Hydrostatic tests 52
10.13 Dimensional testing 54
10.14 Visual inspection 57
10.15 Non-destructive examination (NDE) 57

11 Marking 64
11.1 General 64
11.2 Stamp marking requirements 65
11.3 Stencil marking requirements 66
11.4 Colour identification 66
11.5 Thread and end-finish marking — All groups 67
11.6 Pipe-threader marking requirements — All groups 67

12 Coating and protection 68
12.1 Coatings — All groups 68
12.2 Thread protectors 68

13 Documents 69
13.1 Electronic media — All groups 69
13.2 Certification — Groups 1, 2 and 3 69
13.3 Certification requirements — Grade Q125 69
13.4 Retention of records 69

14 Minimum facility requirements for various categories of manufacturer 70
14.1 Pipe mill 70
14.2 Processor 70
14.3 Pipe threader 70

Page

14.4 Coupling, pup-joint or accessory manufacturer **70**
Annex A (normative) **Supplementary requirements** **72**
Annex B (normative) **Purchaser inspection** **86**
Annex C (normative) **Tables in SI units** **87**
Annex D (normative) **Figures in SI (USC) units** **160**
Annex E (normative) **Tables in USC units** **190**
Annex F (informative) **Marking instructions for API licensees** **264**
Annex G (informative) **Procedures used to convert from USC units to SI units** **269**
Annex H (normative) **Product Specification Levels** **282**
Annex I (normative) **Requirements for thread protector design validation** **289**
Annex J (informative) **Summary of Product Specification Level (PSL) requirements** **293**
Bibliography **297**