

DIN EN ISO 13680:2010-12 (E)

Petroleum and natural gas industries –Corrosion-resistant alloy seamless tubes for use as casing, tubing and coupling stock –Technical delivery conditions (ISO 13680:2010);English version EN ISO 13680:2010

Contents

	Page
Foreword.....	4
Introduction	5
1 Scope	6
2 Conformance.....	7
2.1 Dual normative references.....	7
2.2 Units of measurement	7
3 Normative references	7
4 Terms, abbreviated terms, symbols and definitions.....	9
4.1 Terms and definitions	9
4.2 Symbols	12
4.3 Abbreviated terms	12
5 Information to be supplied by the purchaser	13
6 Manufacturing process	14
6.1 Manufacturing of corrosion-resistant alloys	14
6.2 Product manufacturing process	14
6.3 Pipe end sizing.....	15
6.4 Straightening.....	15
6.5 Process requiring validation	15
6.6 Traceability	15
7 Material requirements	16
7.1 Chemical composition	16
7.2 Tensile properties.....	16
7.3 Hardness properties.....	16
7.4 Charpy V-notch test properties — General requirements.....	16
7.5 Charpy V-notch — Absorbed energy requirements for coupling stock — All grades	17
7.6 Charpy V-notch — Absorbed energy requirements for pipe — All grades	18
7.7 Flattening requirements.....	19
7.8 Corrosion properties	20
7.9 Microstructure properties	20
7.10 Surface condition.....	20
7.11 Defects	20
7.12 Hydrostatic test.....	21
8 Dimensions, masses and tolerances.....	21
8.1 Outside diameter, wall thickness and mass	21
8.2 Length	22
8.3 Tolerances	22
8.4 Product ends	22
9 Inspection and testing.....	22
9.1 Test equipment	22
9.2 Type and frequency of tests	23
9.3 Testing of chemical composition	23
9.4 Testing of mechanical characteristics	24
9.5 Tensile test	24
9.6 Hardness test	25
9.7 Impact or flattening test	25
9.8 Microstructural examination.....	28

	Page
9.9	Dimensional testing 28
9.10	Drift test..... 29
9.11	Length..... 29
9.12	Straightness 29
9.13	Mass determination 29
9.14	Hydrostatic test 30
9.15	Visual inspection 30
9.16	Non-destructive examination 31
10	Surface treatment 36
10.1	Group 1 36
10.2	Groups 2, 3 and 4 36
11	Marking 36
11.1	General 36
11.2	Marking on the product..... 37
11.3	Date of manufacture 38
12	Surface protection — Group 1 38
13	Documents 38
13.1	Electronic media 38
13.2	Retention of records 39
13.3	Test certificates 39
14	Handling, packaging and storage..... 40
14.1	General 40
14.2	Handling 40
14.3	Packaging..... 40
14.4	Storage 40
Annex A (normative)	Tables in SI units 41
Annex B (normative)	Figures in SI (USC) Units 61
Annex C (normative)	Tables in USC units..... 66
Annex D (normative)	Purchaser inspection 86
Annex E (normative)	Cleanliness requirements 87
Annex F (informative)	Use of the API Monogram by Licensees..... 89
Annex G (normative)	Product specification level 2 (PSL-2) 92
Bibliography 94