



# WORKSTRINGS INTERNATIONAL

A SUPERIOR ENERGY SERVICES COMPANY

## Pipe Care and Handling - Golden Rules

### Golden Rules for Basic Drill Pipe Care and Handling

- 1) Always makeup to the recommended **MAXIMUM** makeup torque. Do **NOT** exceed recommended max makeup torque. See performance sheet.
- 2) **ADJUST** makeup torque according to thread compound friction factor (FF) greater than 1.0 FF to 1.15 FF compound. Questions? Contact Workstrings Engineering.
- 3) Connections received with **STORAGE COMPOUND** require the **COMPLETE REMOVAL** prior to the application of a running thread compound.
- 4) Be **LIBERAL** with the thread compound in the box, the base of the box and on the pin; use a copper-based or a compatible thread compound. Ensure **360 DEGREES** of coverage of the threads, torque shoulders, as well as **360 DEGREES** of coverage on the seal surfaces on completion pipe.
- 5) Stabbing guides are **MANDATORY** for all Grant Prideco dual shouldered tool joints, VAM connections and most Tenaris/Hydril connections.
- 6) Always **ENSURE** proper pipe alignment.
- 7) **MINIMIZE** clamp pressure.
- 8) **MAXIMIZE** the distance between the box shoulder and lower jaw die per OEM guidelines (1"-2" minimum for most tool joints).
- 9) When moving pipe horizontally, do it with **PROTECTORS** on the **CONNECTIONS**.
- 10) Always return drill pipe with **PLASTIC** composite thread protectors and **ADD FRESH THREAD COMPOUND** when laying down the pipe.
- 11) Consider running a **FRICTION-REDUCING** or **LUBRICATING FLUID** to reduce down-hole torque and abrasion. Drill pipe non rotating protectors are discouraged and can cause pipe damage.
- 12) Always **STOP** pipe movement before setting slips, especially while tripping in the hole.
- 13) **ENSURE** Top Drive Saver Sub pin connection are free of damage and debris.
- 14) Recommend running **WORKSTRINGS' ELEVATORS** with **WORKSTRINGS' DRILL PIPE** to ensure the **CORRECT ELEVATOR BORE** is used.
- 15) Ensure that the correct Top Drive Bell Guide is installed.

### Preventing and Troubleshooting Connection Damages

- 1) Ensure torque gauges are **CALIBRATED** correctly.
- 2) Ensure the connections are **CORRECTLY** aligned.
- 3) Break out torques greater than 90% of the original make-up torque indicate down-hole make-up and should be addressed.
- 4) Ensure the thread compound is **CLEAN, DEBRIS & WATER FREE AND APPLIED CORRECTLY**. Keep lid on compound container when not being used.
- 5) Ensure that the rig's **WEIGHT COMPENSATOR** is working properly and a minimum amount of weight is applied during connection make-up.
- 6) Use a **SLOW** rotation speed during spin-up and break-out of the first 5-6 threads. Do **NOT** exceed recommended maximum spin-up RPM as recommended per the OEM guidelines. Premium connections should start slow up to 25 RPM until proper engagement is verified then increase speed up to ~100 RPM to shoulder engagement. This may be less critical for API and GPDS™/uGPDS™/EIS™/HT™ connections, as the connection taper stabs deeper. However, following the same slow/fast spinning is a good practice.

### Hardbanding, Internal Coating and Rust Grip® External Coating

- 1) When tripping, check the condition of the **HARDBANDING** on the drill pipe.
- 2) If the hardbanding is **WORN** down flush to the tool joint, ensure the pipe does not go back in the well open hole, especially the horizontal section.
- 3) Check the **HARDBANDING** between each well and replace any that is less than 1/32" raised.
- 4) Use **TEFLON, POLYURETHANE or PLASTIC-COATED METAL DRIFTS ONLY**; metal drifts will damage internal coating.
- 5) Use **RUST GRIP®** external coating to prevent O.D. corrosion in corrosive completion fluids. **RUST GRIP®** can only be used on Workstrings' owned tubular assets.

**NOTE:** More detailed running procedures for proprietary rotary-shouldered connections are available from the OEM's website (NOV Grant Prideco, Vallourec and Tenaris), Workstrings Engineering or Workstrings' website.

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## **WORKSTRINGS<sup>™</sup> INTERNATIONAL**

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<https://workstringsinternational.com/spec-sheets/index.asp>

### **Global Headquarters**

Broussard, LA - USA

Phone: +1 337-989-9675

Email: [info@workstrings.com](mailto:info@workstrings.com)

### **Engineering & Marketing**

Houston, TX - USA

Phone: +1 281-999-0047

Email: [marketing@workstrings.com](mailto:marketing@workstrings.com)

### **EMEA Corporate**

Aberdeen - UK

Phone: +44 1224-724900

Email: [sales.uk@workstrings.com](mailto:sales.uk@workstrings.com)

[www.workstringsinternational.com](http://www.workstringsinternational.com)