

Golden Rules for Pipe Care & Handling

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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