
**Petroleum and natural gas industries —
Procedures for testing casing and tubing
connections**

*Industries du pétrole et du gaz naturel — Procédures de test des
connexions pour tubes de cuvelage et de production*

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Contents

Page

Foreword.....	vi
Introduction.....	vii
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.....	4
4 General requirements.....	8
4.1 Connection geometry, test load envelope and performance data sheet	8
4.2 Quality control.....	9
5 General test requirements.....	9
5.1 Test classes.....	9
5.2 Test matrix.....	10
5.3 Test programme.....	14
5.4 Calibration and accreditation requirements.....	15
5.5 Rehearsal tests.....	16
5.6 Material property tests.....	16
5.7 Make-up and break-out procedures.....	17
5.8 Internal pressure leak detection.....	18
5.9 Internal pressure leak trap device.....	18
5.10 External pressure leak detection.....	25
5.11 Data acquisition and test methods.....	28
5.12 Thermal cycling tests.....	30
6 Connection test specimen preparation.....	32
6.1 General connection test objectives.....	32
6.2 Connection test specimen identification and marking.....	33
6.3 Connection test specimen preparation.....	33
6.4 Connection test specimen machining.....	35
6.5 Machining tolerances.....	36
6.6 Tolerance limits on machining objectives.....	37
6.7 Grooved torque shoulder.....	37
7 Test procedures.....	38
7.1 Principle.....	38
7.2 Make-up/break-out tests.....	38
7.3 Test load envelope tests.....	40
7.4 Limit load tests.....	52
7.5 Limit load test path (see Figures 18 and 19).....	55
8 Acceptance criteria.....	57
8.1 Make-up and break-out tests.....	57
8.2 Test load envelope tests.....	58
8.3 Limit load tests.....	58
9 Test reports.....	59
Annex A (normative) Connection geometry and performance data sheet.....	60
Annex B (informative) Connection test load envelope and limit loads.....	67
Annex C (normative) Data forms.....	85

Annex D (normative) Connection full test report	115
Annex E (normative) Connection testing summary report.....	118
Annex F (informative) Frame load range determination	121
Annex G (informative) Interpolation and extrapolation considerations	122
Annex H (informative) Special application testing	124
Annex I (informative) Rationale for design basis	130
Annex J (normative) Independent seal testing of connections with metal-to-metal and resilient seals.....	133
Bibliography.....	139
Table 1 — Test matrix — Test series and specimen identification numbers.....	11
Table 2 — Connection test specimen objectives for all CAL.....	32
Table 3 — Guidelines for selecting connection test specimens for testing a metal-to-metal sealing, tapered thread connection with a torque shoulder.....	33
Table 4 — Tolerance limits on machining objectives.....	36
Table 5 — Specimen description and summary of test series for a metal-to-metal sealing, tapered thread connection with a torque shoulder.....	38
Table 6 — Test Series A load steps (see Figures 13 or 14, as applicable) — Testing in quadrants I, II, III, IV (no bending) at ambient temperature	42
Table 7 — Test Series B load steps without bending for connection rated equal to pipe body (see Figure 15) — Testing in quadrants I and II without bending at ambient temperature	46
Table 8 — Test Series B load steps with bending for connection rated equal to pipe body (see Figure 16) — Testing in quadrants I and II with bending at ambient temperature	47
Table A.1 — Connection geometry and performance property data sheet.....	61
Table A.2 — Example Series A test load envelope for a connection rated equal to pipe body — 178 mm <i>D</i> × 10,16 mm wall thickness × grade P-110 (7 in 29 lb/ft P-110) strength (see Figure A.1).....	62
Table A.3 — Detailed load steps	63
Table B.1 — Areas and dimensions	70
Table B.2 — Required dimensions for critical cross-section computation.....	84
Table F.1 — Typical results from frame load range determination (200 kN to 2 000 kN).....	121
Figure 1 — Connection application level test programme.....	12
Figure 2 — Collared leak trap device for internal pressure leak detection.....	19
Figure 3 — Flexible boot leak trap device for internal pressure leak detection	20
Figure 4 — Ported box leak trap device for internal pressure leak detection.....	20
Figure 5 — Internal pressure leak detection by bubble method	22
Figure 6 — Example of a plot for determining leak detection sensitivity.....	23
Figure 7 — Leak detection by helium mass spectrometer method	24
Figure 8 — Example set-up for Test Series A	25

Figure 9 — Example of leak detection system for Test Series A.....	26
Figure 10 — Test Series C thermal/mechanical cycles for CAL II, III, and IV.....	30
Figure 11 — Connection test specimen nomenclature and unsupported length	34
Figure 12 — Torque shoulder pressure bypassing grooves.....	37
Figure 13 — Test Series A load path for connection rated greater than or equal to pipe body in compression.....	44
Figure 14 — Test Series A load path for connection rated less than pipe body in compression	45
Figure 15 — Test Series B load paths without bending for connection rated equal to pipe body.....	49
Figure 16 — Test Series B load paths with bending for connection rated equal to pipe body	50
Figure 17 — Test Series B load paths for connection rated less than pipe body in compression and with bending.....	51
Figure 18 — Limit load test paths for connections rated equal to or stronger than pipe body	53
Figure 19 — Limit load test paths for connections weaker than pipe body	54
Figure B.1 — Pipe body and connection test load envelopes at specified dimensions	68
Figure C.1 — Recommended layout of mother joints for test and material specimens.....	86
Figure G.1 — Example premium connection design space	123
Figure J.1 — Ported box leak trap device for internal pressure leak detection showing modifications for resilient seal.....	135
Figure J.2 — Connection acceptance levels with resilient seal ring.....	136
Figure J.3 — Alternative testing sequence for a connection with metal-to-metal (MTM) and resilient seal (RS) features	138

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

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ISO 13679 was prepared by Technical Committee ISO/TC 67, *Materials, equipment and offshore structures for petroleum, petrochemical and natural gas industries*, Subcommittee SC 5, *Casing, tubing and drill pipe*.

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Introduction

This International Standard is part of a process to provide reliable tubing and casing connections for the oil and natural gas industry which are fit for purpose. It has been developed based on improvements to API Recommended Practice 5C5 and proprietary test procedures, with input from leading users, manufacturers and testing consultants from around the world. This International Standard represents the knowledge of many years of testing and qualification experiences.

The validation of connection test load envelope and failure limit loads is relevant to design of tubing and casing for the oil and natural gas industries. Tubing and casing are subject to loads which include internal pressure, external pressure, axial tension, axial compression, bending, torsion, transverse forces and temperature changes. The magnitude and combination of these loads result in various pipe body and connection failure modes. Although pipe body test and limit loads are well understood in general, the same cannot be stated for the connection. These failure modes and loads are generally different and often less than that of the pipe. Consequently experimental validation is required. Well design matches the test and limit loads of both the connection and pipe to the well conditions to provide load capacities with suitable reliability.

The validation of test and limit loads requires testing at the extremes of performance parameters to these defined loads. Testing at the extremes of the performance parameters assures that the production population, which falls within these limits, will meet or exceed the performance of the test population. Thread connection performance parameters include dimensional tolerances, mechanical properties, surface treatment, make-up torque and the type and amount of thread compound. For typical proprietary connections, worst-case tolerances are known and defined in this International Standard. For other connections design analysis is required to define worst case tolerance combinations.

Users of this International Standard should be aware that further or differing requirements might be needed for individual applications. This International Standard is not intended to inhibit a vendor from offering, or a purchaser from accepting, alternate equipment or engineering solutions for the individual application. This may be particularly applicable when there is innovative or developing technology. Where an alternative is offered, the vendor should identify any variations from this International Standard and provide details.

This International Standard consists of the following major parts. Based on manufacturer's-supplied data specified in Annex A and/or calculations in Annex B, tests are conducted in accordance with Clauses 4 to 8 and reported on the data forms given in Annex C. Annex D lists all the information that is to be provided in the full report whereas Annex E lists the information that is to be provided in a summary test report. This summary test report lists the minimum information necessary to fully specify the connection tested and its preparation is intended for broader distribution. Annex F gives an example of a load frame calibration. Annex G gives considerations for possible connection product line qualification. Annex H provides guidelines for supplemental tests, which may be required for special applications. Annex I gives the design rationale for this International Standard. Annex J gives requirements for connections that contain both a metal-to-metal seal and a resilient seal which are tested separately.

Supplementary tests may be appropriate for specific applications that are not evaluated by the tests herein. The user and manufacturer should discuss well applications and limitations of the connection being considered.

Representatives of users and/or other third party personnel are encouraged to monitor the tests. ISO 13679 covers the testing of connections for the most commonly encountered well conditions. Not all possible service scenarios are included. For example, the presence of a corrosive fluid, which may influence the service performance of a connection, is not considered.

This International Standard includes provisions of various nature. These are identified by the use of certain verbal forms:

— SHALL is used to indicate that a provision is a REQUIREMENT, i.e. MANDATORY;

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Petroleum and natural gas industries — Procedures for testing casing and tubing connections

1 Scope

This International Standard establishes minimum design verification testing procedures and acceptance criteria for casing and tubing connections for the oil and natural gas industries. These physical tests are part of a design verification process and provide objective evidence that the connection conforms to the manufacturer's claimed test load envelope and limit loads.

It categorizes test severity into four test classes.

It describes a system of identification codes for connections.

This International Standard does not provide the statistical basis for risk analysis.

This International Standard addresses only three of the five distinct types of primary loads to which casing and tubing strings are subjected in wells: fluid pressure (internal and/or external), axial force (tension or compression), bending (buckling and/or wellbore deviation), as well as make-up torsion. It does not address rotation torsion and non-axisymmetric (area, line or point contact) loads.

This International Standard specifies tests to be performed to determine the galling tendency, sealing performance and structural integrity of casing and tubing connections. The words casing and tubing apply to the service application and not to the diameter of the pipe.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 3183-1, *Petroleum and natural gas industries — Steel pipe for pipelines — Technical delivery conditions — Part 1: Pipes of requirement class A*

ISO 3183-2, *Petroleum and natural gas industries — Steel pipe for pipelines — Technical delivery conditions — Part 2: Pipes of requirements class B*

ISO 3183-3, *Petroleum and natural gas industries — Steel pipe for pipelines — Technical delivery conditions — Part 3: Pipes of requirement class C*

ISO 10400:1993, *Petroleum and natural gas industries — Formulae and calculation for casing, tubing, drill pipe, and line pipe properties*

ISO 10422, *Petroleum and natural gas industries — Threading, gauging and thread inspection of casing, tubing and line pipe threads*

ISO 11960, *Petroleum and natural gas industries — Steel pipes for use as casing or tubing for wells*

ISO 13680, *Petroleum and natural gas industries — Corrosion-resistant alloy seamless tubes for use as casing, tubing and coupling stock — Technical delivery conditions*

API Bul 5C3, *Bulletin on formulas and calculations for casing, tubing, drill pipe and line pipe properties*

API Spec 5B, *Specification for threading, gauging, and thread inspection of casing, tubing, and line threads (U.S. Customary Units)*

API Spec 5L, *Specification for line pipe*

3 Terms, definitions, symbols and abbreviated terms

For the purposes of this document, the following terms, definitions, symbols and abbreviated terms apply.

3.1 Terms and definitions

3.1.1

ambient temperature

actual room temperature in the test lab with no residual heat remaining in test specimens from previous thermal tests

3.1.2

axial-pressure load diagram

plot of pressure versus axial load showing pipe and/or connection test load envelope or limit load extremes

3.1.3

connection

assembly consisting of either two pins and a coupling or one pin and an integral box

3.1.4

failure load

load at which the pipe body or connection will fail catastrophically as in an axial separation, a rupture, large permanent deformation (e.g. buckling or collapse) or massive loss of sealing integrity

3.1.5

galling

cold welding of contacting material surfaces followed by tearing of the metal during further sliding/rotation

NOTE 1 Galling results from the sliding of metallic surfaces that are under high bearing forces. Galling can generally be attributed to insufficient lubrication between the mating surfaces. The purpose of the lubricating medium is to minimize metal-to-metal contact and allow efficient sliding of the surfaces. Other ways to prevent galling are to reduce the bearing forces or reduce the sliding distance.

NOTE 2 There are several degrees of galling used for repair and reporting purposes as defined in 3.1.5.1 to 3.1.5.3.

3.1.5.1

light galling

galling that can be repaired by the use of abrasive paper

3.1.5.2

moderate galling

galling that can be repaired by the use of fine files and abrasive paper

3.1.5.3

severe galling

galling that cannot be repaired by the use of fine files and abrasive paper

3.1.6

leak

any positive displacement of fluid in the measuring system during hold periods

3.1.7**limit load**

load combination extreme (axial load and/or pressure) which defines the failure conditions for the connection or maximum load resulting in large permanent deformation (such as buckling) prior to catastrophic failure

3.1.8**lot**

lengths of pipe with the same specified dimensions and grade from the same heat of steel which are heat-treated as part of a continuous operation (or batch)

3.1.9**metal-to-metal seal**

seal or sealing system that relies on intimate and usually high contact stress of mating metal surfaces to achieve a seal

NOTE The thread compound can affect, both beneficially and detrimentally, the performance of a metal seal.

3.1.10**mother joint**

length of pipe or coupling stock from which short lengths are cut for machining connection test specimens

3.1.11**multiple seals**

sealing system, which consists of more than one independent barrier, and of which each barrier forms a seal itself

3.1.12**pipe string**

pipe body and the connection

3.1.13**pup joint**

short pipe length usually with threaded ends

3.1.14**resilient seal**

seal or sealing system, which relies on entrapment of a seal ring within a section of the connection (e.g. in the thread-form, on a seal area, etc.) to achieve a seal

3.1.15**seal**

barrier to prevent the passage of fluids

3.1.16**seal ovality**

maximum seal diameter minus the minimum seal diameter divided by the average seal diameter multiplied by 100

NOTE Seal ovality is expressed as a percentage.

3.1.17**single seal**

one barrier or multiple barriers that cannot be physically differentiated in their function

3.1.18**specimen**

connection between two pieces of pipe

NOTE The specimen can be composed of one coupling and two pins for coupled connections, or one pin and one box for integral connections.

3.1.19

test load envelope

extremes of loads (axial load, pressure, bending) and temperature within which the connection will perform cyclically

NOTE The manufacturer has the primary responsibility for defining the test load envelope for their connection products (see 4.1).

3.1.20

thread lot

all products manufactured on a given machine during a continuous production cycle that is not interrupted by a catastrophic tool failure or injurious machine malfunction (excluding worn tools or minor tool breakage), tool holder change (except rough boring bar) or any other malfunction of either threading equipment or inspection gauges

3.1.21

thread seal

seal or sealing system which relies on intimate fitting of the thread-form and usually entrapment of the thread compound within the thread-form to achieve a seal

3.2 Symbols and abbreviated terms

3.2.1 Symbols

- A_i Area calculated based on the pipe inside diameter
- A_o Area calculated based on the pipe outside diameter
- A_p Cross-section area of pipe body
- C Compressive axial force
- D Specified pipe outside diameter
- D_i Inside diameter
- D_o Outside diameter
- D_{leg} Effective dogleg severity expressed in degrees per thirty metres
- E_r Error in load frame calibration
- E_{rp} Error in load frame calibration expressed in percent
- F Failure
- F_a Axial force, tension or compression
- F_b Bending equivalent axial force
- F_c Published joint strength of the connection when the joint strength is the compressive rated load of the connection
- F_f Actual load frame axial force, tension or compression
- F_i Indicated load frame axial force, tension or compression

F_t	Published joint strength of the connection when the joint strength is the tensile parting or failure load of the connection
F_y	Published joint strength of the connection when the joint strength is the tensile yield load of the connection
I	Moment of inertia
K_c	Compression efficiency factor of the connection
K_{pi}	Internal pressure efficiency factor of the connection
K_{pe}	External pressure efficiency factor of the connection
K_t	Tension efficiency factor of the connection
k_i, k_o	Geometric variable
L_A	Length of pin A end from coupling face (or connection) to end cap or grip length
L_B	Length of pin B end from coupling face (or connection) to end cap or grip length
L_c	Length of coupling or connection if integral
L_{pj}	Minimum unsupported pipe joint length
M	Bending moment
M_o	Super bending moment
p_c	ISO 10400 collapse rating for specified wall thickness and actual specimen yield strength
p_i	Internal pressure
p_{ib}	Internal pressure with bending
p_{ih}	High internal pressure
p_{in}	Normalized internal test pressure
p_{il}	Low internal pressure
p_{iyp}	ISO 10400:1993, Section 3, internal yield pressure for the pipe body
p_o	External pressure
p_{ob}	External pressure with bending
p_{on}	Normalized external test pressure
p_{tc}	Thermal cycle pressure at elevated temperature
p_y	Maximum pressure for an internal fibre stress S_{yt}

q_{ac}	Actual leak rate to be reported
q_o	Observed leak rate
R	Radius of curvature of the pipe body at the axis of the pipe
S_t	100 % of minimum of the specimen mother joint tensile strength (measured at room temperature or at elevated temperature as given in Table 1) for a pipe member or coupling in a T&C specimen (pin or box member for an integral connection)
S_y	100 % of minimum of the specimen mother joint yield strength (measured at room temperature or at elevated temperature as given in Table 1) for a pipe member or coupling in a T&C specimen (pin or box member for an integral connection)
S_{yt}	95 % S_y for Series A and B tests, and 80 %, 90 % and 95 % for Series C tests (see 5.12.4)
t	Specified pipe wall thickness
t_{ac}	Actual minimum wall thickness
T	Tension axial force
η_{lds}	Leak detection system efficiency
σ	Stress
σ_a	Axial stress without bending
σ_{ab}	Axial stress with bending
σ_{ao}	Axial stress with super critical bending
σ_b	Axial stress due to bending
σ_{bo}	Axial stress due to super critical bending
σ_c	Axial compressive yield strength if available or otherwise axial tensile yield strength
σ_h	Hoop (tangential) stress
σ_{ho}	Hoop (tangential) stress at outside diameter
σ_r	Radial (normal) stress
σ_{ro}	Radial (normal) stress at outside diameter
σ_t	Transverse tensile yield strength if available or otherwise axial tensile yield strength
σ_{tc}	Defined transverse compressive yield strength if available or otherwise axial tensile yield strength
σ_v	Von Mises equivalent stress
σ_y	Axial tensile yield strength, normally the ISO/API axial tensile yield strength

3.2.2 Abbreviations

CAL	Connection application level for which the successfully tested pipe [size, mass (label: weight), grade] and connections are intended to be used
CCS	Critical cross-section
CCW	Counter-clockwise direction
CW	Clockwise direction
CEPL	Capped end pressure load (tension)
CEYP	Capped end yield pressure
CRA	Corrosion-resistant alloy
EUE	External upset end
FMU	Final make-up specimen condition
kips	1 000 lbf (pound-force)
ksi	1 000 lbf (pound-force) per square inch
lb	Pound mass
LL	Limit load
LP	Load point
LP1	Limit load test path 1
LP2	Limit load test path 2
LP3	Limit load test path 3
LP4	Limit load test path 4
LP5	Limit load test path 5
LP6	Limit load test path 6
LP7	Limit load test path 7
LP8	Limit load test path 8
M/B	Make-up/break-out
MBG	Make/break galling test specimen condition
MC	Mechanical cycle
MT	Material test coupon
MTC	Metal seal threaded and coupled connection
MTM	Metal-to-metal seal

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