# TenarisHydril Blue® Riser Connection

## Scope

These guidelines apply specifically to the use of TenarisHydril Blue® Riser connections. This document should be used in conjunction with the TenarisHydril Running Manual, which is the main document applicable to the running of all TenarisHydril premium connections.

Tenaris Field Service Representatives can modify these guidelines when circumstances dictate. Implementation will only occur if the representative deems the modification to be non-detrimental to product integrity. All modifications being explained and agreed with the client representative prior to implementation and fully documented in the running report.

## References

- TenarisHydril Running Manual.
- Premium Connection Approved Thread Compounds FTD29356.
- Recommended guidelines for the field inspection of TenarisHydril connections, GDL31457.

## Equipment, Material & Documents

1. Verify the appropriate thread compound is available.

2. Refer to document FTD29356 for a list of compounds approved by Tenaris.

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**3.** Latest version of the specific Product Data Sheet can be obtained from Tenaris web site. In case this is unavailable, request the data sheet from the local Technical Sales representative or contact-tenarishydril@tenaris.com.

**4.** Slip type elevators with low marking dies should be used.

**5.** Tong, back up tong and rotary slips should be dressed with low marking dies.

**6.** Specific tools required for successful running, pulling and inspection of Blue® Riser connection:

- Depth gauge.

## Pre-Running

**1.** Never move or handle pipe without the correct thread protectors securely in place.

**2.** Ensure connections are cleaned and free of all debris and / or contaminants, cleaning methods employed should conform to the recommendations contained within the TenarisHydril Running Manual.

**3.** Verify all pipe and accessories have genuine TenarisHydril manufactured connections.

**4.** Visually inspect threads and seal areas prior to running, ensuring no damage is evident.

**5.** Verify compatibility of the Blue® Riser connection with accessories such as pup joints.

**6.** Connection weight interchange compatibility is indicated in the TenarisHydril premium connections catalogue.

**7.** Verify material grade of all accessories ensuring compatibility with main string.

# Inspection

**1.** Inspection criteria for all TenarisHydril connections is as outlined in the Field Service Operative Guideline GDL31457.

**2.** Pay particular attention to seal areas.

**3.** Ensure the pin and box torque shoulders have no dents, tears or raised material which could interfere with correct assembly.

**4.** Ensure the cylinder area between the last thread and the external seal of the pin has no tearing or raised areas which may contact the corresponding box external seal during make up.

**5.** Any coupling found with tears or gouges deeper than 0.020" / 0.5 mm is a reject and should not be run.

**6.** Any gouge which is suspect should have any raised areas filed flat then checked with a depth gauge.

**7.** Any gouge or tear which traverses from the coupling OD to the face is cause for rejection.

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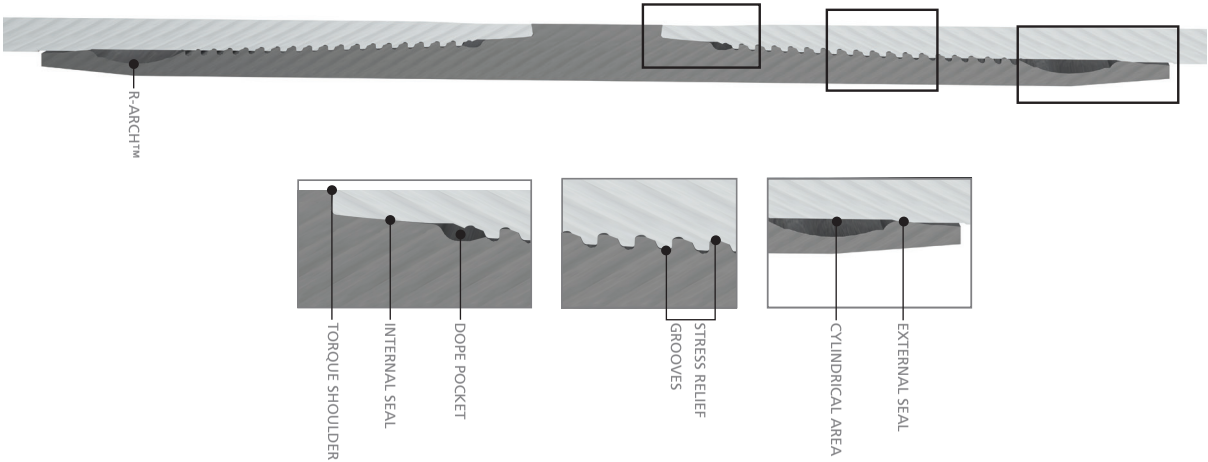
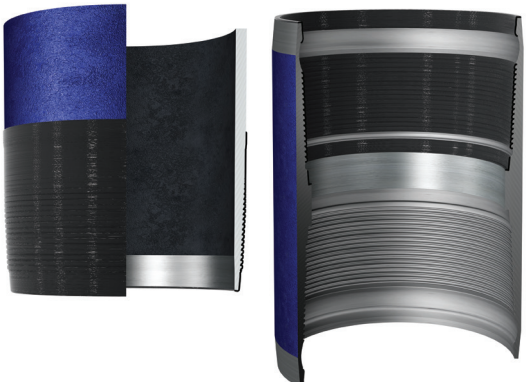
# Blue® Riser Configuration

4 TPI ≤ 11 7/8"
3 TPI ≥ 12 3/4"


R-ARCH™
TORQUE SHOULDER
INTERNAL SEAL
DOPE POCKET
STRESS RELIEF GROOVES
CYLINDRICAL AREA
EXTERNAL SEAL

# Thread Compound Application



**1.** Apply a liberal coating of thread compound on the pin connection, fully covering all threads, seals and pin nose.

**2.** Unlike other TenarisHydril connections it is not necessary to see the thread profile after applying thread compound.

**3.** Apply thread compound liberally to the box seals and threads.

**4.** Do not fill the dope pocket or R-Arch™.

**5.** If required an increased quantity of thread compound can be applied to both pin and box connections.

**6.** For Tenaris approved thread compounds, apply the friction factor indicated in FTD29356.

## Torque Application

**1.** The use of computer make up analysis equipment is strongly recommended when assembling Blue® Riser connections.

**2.** Shoulder points for Blue® Riser can be found in the product data sheet.

**3.** Reference torque should initially be set at 5% of optimum.

**4.** The dump valve should be set at optimum torque, verify correct operation on the pipe body prior to first make up.

**5.** The connection should take approximately three turns from stabbing to power tight assembly.

**6.** Set the computer turns to 3 initially then adjust as necessary to attain good graph depiction.

**7.** Refer to the TenarisHydril Running Manual, make up acceptance section for further explanation.

**8.** The computer make up profile for Blue® Riser connections should be similar to the ones below.

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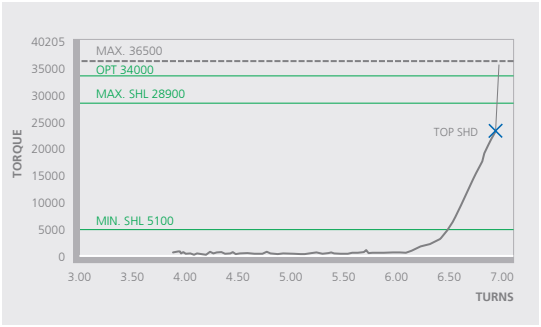


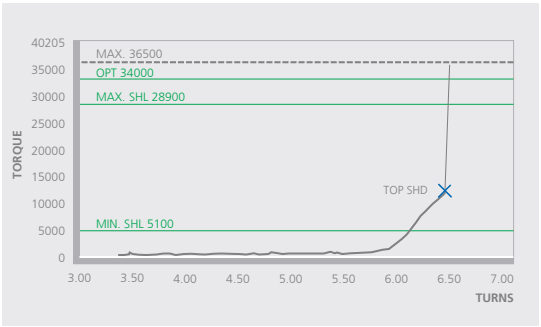


**9.** TenarisHydril Blue® Riser connections have limited same size / weight interchange capability, if mixing weight / grade ensure compatibility of design and apply the lower torque values of the two connections.

## Running

**1.** It is strongly recommended to use slip type elevators with low marking dies.

**2.** The use of collar lift elevators abutting the coupling face is restricted to a maximum lift of a single joint.

**3.** The use of a stabbing guide is strongly recommended.

**4.** The use of a weight compensator is strongly recommended for large OD and heavy pipe.

**5.** To avoid cross threading stab pipe in a smooth controlled fashion ensuring the pipe is vertical when doing so, continue to support and stabilise the pipe throughout the stabbing and make up operation.

**6.** Upon commencement of initial rotation use low RPM (5 RPM or below) in order to ensure the pipe has not cross threaded during stabbing.

**7.** If cross threading is evident, immediately reverse rotate the pipe, completely disassemble, clean and inspect both connections.

**8.** Maximum spin in speed should not exceed 5 RPM.

**9.** Final make up should be conducted between 3 RPM minimum and 5 RPM maximum.

**10.** Ensure rotating and back up tong have low marking dies to prevent damage to the pipe body.

**11.** Gouges or tears inflicted on the pipe body should not exceed 0.020" / 0.5 mm.

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Penetration depth 0.003"

Penetration depth 0.035"

# Pulling

**1.** Automatic stabbing system or stabber is highly recommended to maintain the pipe in a vertical position.

**2.** The use of a stabbing guide is recommended to assist in centralising the pin to prevent hang up.

**3.** Apply the back up tong jaw below the centre of the coupling.

**4.** Never position the tong near the coupling face or over the R-Arch™.

**5.** Apply power tong in low RPM (5 RPM Max) to break and spin out the connection, ensuring the pipe is stabilized during the break out process.

**6.** Visual inspection is recommended to classify the thread condition. Any rejected connections should be clearly marked and segregated for further investigation.

**7.** Apply clean, dry thread protectors after applying storage compound on clean, dry connections.

**8.** Storage / thread compound should always be applied to connections post job, even rejects.

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