

TenarisHydril PJD™ Connection

Scope

These guidelines apply specifically to the use of TenarisHydril PJD™ 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.

3. Latest version of the specific Product Data Sheet can be obtained from Tenaris website. In case this is unavailable, request the data sheet from the local Technical Sales representative or contact-tenarishydril@tenaris.com.
4. Ensure the single joint elevators to be used are the insert type and have the correct inserts in order to fully seat against the box upset.

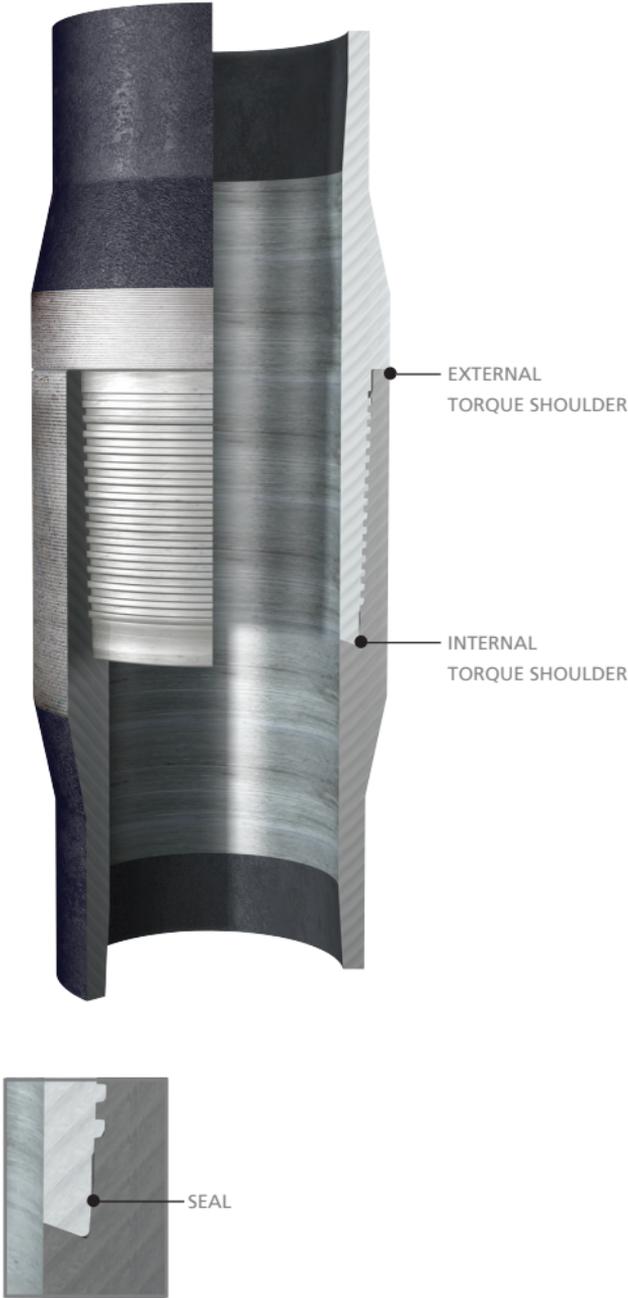
Pre-Running

1. Never move or handle pipe without the correct thread protectors securely in place.
2. Ensure connections are clean 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 PJD™ connection with any accessories such as cement heads, safety valves, cross overs, etc.
6. Verify material grade of all accessories ensuring compatibility with main string.

PJD™ Configuration

Metal to Metal Seal
Modified Buttress Thread

IDM Code GDL234701Z / March 2020



Inspection

1. Inspection criteria for all Tenaris connections is as outlined in the Field Service Operative Guideline GDL31457.
2. Pay particular attention to seal area.
3. Ensure there is no raised steel areas at both internal and external torque shoulders which could preclude correct make up.
4. Ensure the area between the last thread and the external torque shoulder of the pin has no tearing or raised areas which may contact the corresponding box area during make up.

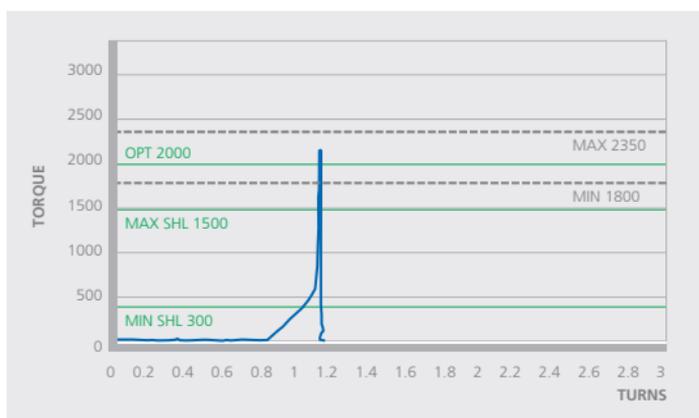
Thread Compound Application



1. Apply thread compound to both pin and box threads, seals and torque shoulders.
2. Do not over apply, thread profile should be clearly visible.

Torque Application

1. The use of computer make up analysis equipment is strongly recommended when assembling PJD™ connections.
2. Shoulder points for PJD™ 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, verify correct operation on the pipe body prior to first make up.
5. Set the computer turns to 2 initially then adjust as necessary to attain good graph depiction.
6. Refer to the TenarisHydril Running Manual, make up acceptance section for further explanation.
7. The computer make up profile for PJD™ connections should be similar to the one below.



8. PJD™ connection is interchangeable for same size / weight, if mixing weight / grade apply the lower torque values of the two connections.

Running

1. The use of a stabbing guide is strongly recommended.
2. The use of slip type elevators is strongly recommended.
3. Never use drill pipe elevators to run or pull PJD™.
4. Use insert type single joint elevators to pick up or lay down pipe from the rig floor, ensure the inserts are of the correct size and seat evenly on the box upset.
5. The use of a weight compensator is strongly recommended for chrome pipe.
6. 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.
7. Upon commencement of initial rotation use low RPM (5 RPM or below) in order to ensure the pipe has not cross threaded during stabbing.
8. If cross threading is evident immediately reverse rotate the pipe, completely disassemble, clean and inspect both connections.
9. Maximum spin in speed should not exceed 15 RPM.
10. Apply power tong at low RPM (do not exceed 5 RPM) for final make up.
11. Walk chrome pipe all the way in to hand tight, then apply tong only for final make up.
12. Apply the tongs to the pipe body, do not grip the pin or box connections.

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. The use of slip type elevators is strongly recommended.
4. A weight compensator is strongly recommended for chrome pipe.
5. Apply the back up tong jaw on the pipe body, never grip the box connections.
6. Apply power tong in low RPM (3-5 RPM) to break the connection, ensuring the pipe is stabilised during the break out process.
7. Do not exceed 15 RPM during spin out.
8. Walk chrome pipe all the way out after initial break.
9. Visual inspection is recommended to classify the thread condition. Any rejected connections should be clearly marked and segregated for further investigation.
10. Apply clean, dry thread protectors after applying storage compound on clean, dry connections.
11. Storage / thread compound should always be applied to connections post job, even rejects.

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