

Chrome / CRA

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1. This section applies to high chromium content steels (13% and higher) and other Corrosion Resistant Alloys (CRAs), commonly known as "Chrome/CRA".
2. Always handle chrome and CRA steels with due care and attention preventing aggressive contact with carbon steel.
3. Use teflon or plastic drift mandrels when drifting.
4. For chrome and CRA cover pipe racks, storage posts and V-Door with rubber or other soft material to prevent aggressive steel contact when running.
5. Slips, elevators, tong and back up tong jaws should be fitted with low / non-marking non-ferrous dies when running chrome and CRA.
6. Gouging / tearing of pipe body is unacceptable.
7. Maximum die indentations from slips, elevators, and tong jaws should not exceed those indicated in the table below.

MAXIMUM INDENTATION DEPTH	CHROME 9% - 13%	CRA
Pipe Body	0.012"	0.009"
Coupling	0.012"	0.009"

8. Ensure handling / lift plugs are peened and moly coated prior to use.
9. The use of a torque turn monitoring system is strongly recommended for all chrome TenarisHydril connections.
10. Always use a stabbing guide.
11. Stab pipe in a smooth controlled fashion.
12. Walk pipe all the way in to hand tight position prior to final make up with a power tong.
13. Walk pipe fully out by hand after initially breaking the connection with a power tong.
14. In the case a mechanically operated pipe positioning system (stabbing arm) is used for running/pulling operations, it is recommended to verify it does not interfere with the make-up process. If the stabbing arm position or grip pressure applied by the equipment is excessive, it can impede the free rotation of the pipe during the make-up, resulting in an anomalous make-up graph and potential connection damage.
15. Advise the stabbing arm operator to adjust the stabbing arm pressure and alignment for each make-up to reduce excessive thread interference.
16. Verify the stabbing arm rollers spin freely allowing the pipe to rotate unrestricted.
17. The use of a weight compensator is strongly recommended when running or pulling to assist in pipe maneuvering to establish a smooth, controlled and safe motion, and during walking in/out process.
18. Ensure maximum hand tight position is reached by utilizing a strap wrench in conjunction with the weight compensator to stab-in.

19. Walking chrome pipe in or out by hand is best practice, however there are occasions due to operational set up or regional regulations when it is not possible to do so.
20. In such an instance the pipe can be rotated in or out slowly using the power tong in high gear and low RPM.
21. Maintain a constant speed during spin in or out not exceeding 5 RPM.
22. Any indication of early torque build during assembly indicates the assembly should be aborted and the connections disassembled, cleaned and inspected.
23. Thread compound application is indicated in the product specific running guidelines.
24. On connections in doped version and chromium content 13% or higher, a thin coat of moly coat spray may be applied on the pin seals and threads subject to Field Services Representative advice and in agreement with client representative prior to implementation.
25. For Wedge™ Series 400, Wedge™ Series 500, Wedge™ Series 600, SLX® and MACII™ connections apply a thin coat of moly coat spray to any shiny areas of the pin seals.
26. Allow any application of moly coat to dry prior to applying thread compound.
27. For guidelines on running chrome pipe with CRT equipment, refer to document GDL23359; Casing Running Tools.

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