

Chrome / CRA

IDM Code GDIL23358/1 / March 2018

1. Always handle chrome and CRA steels with due care and attention preventing aggressive contact with carbon steel.
2. Use teflon or plastic drift mandrels when drifting.
3. 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.
4. Slips, elevators, tong and back up tong jaws should be fitted with low / non-marking non-ferrous dies when running chrome and CRA.
5. Gouging / tearing of pipe body is unacceptable.
6. 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 " |

7. Ensure handling / lift plugs are peened and moly coated prior to use.
8. Use a torque turn monitoring system for all chrome TenarisHydril connections.
9. Always use a stabbing guide.
10. Stab pipe in a smooth controlled fashion.
11. Walk pipe all the way in to the hand tight position prior to final make up with a power tong.
12. Walk pipe fully out by hand after initially breaking the connection with a power tong.
13. A weight compensator will assist the walking in / out process.
14. The use of a weight compensator is strongly recommended when running or pulling.
15. 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.
16. In such an instance the pipe can be rotated in or out slowly using the power tong in high gear.
17. Maintain a constant speed during spin in or out not exceeding 5 RPM.
18. Any indication of early torque build during assembly indicates the assembly should be aborted and the connections disassembled, cleaned and inspected.
19. Thread compound application is indicated in the product specific running guidelines.

20. For non Dopeless® TenarisHydril Blue® Series connections $\geq 13\%$ chrome, a thin coat of moly coat spray can be applied on the pin seals and threads.
21. Allow the moly coat to dry prior to applying thread compound.
22. For 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.
23. Allow any application of moly coat to dry prior to applying thread compound.
24. For guidelines on running chrome pipe with CRT equipment, refer to CRT section of this manual.