

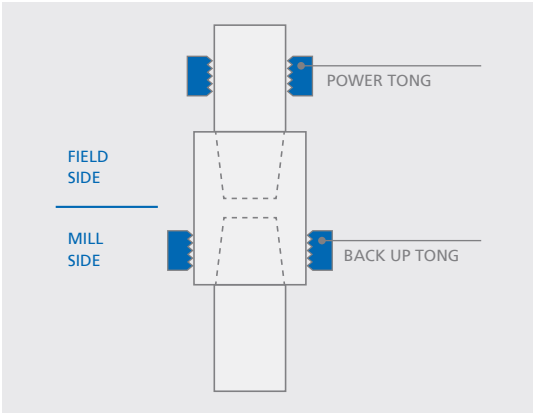
# Pulling

## BREAK OUT

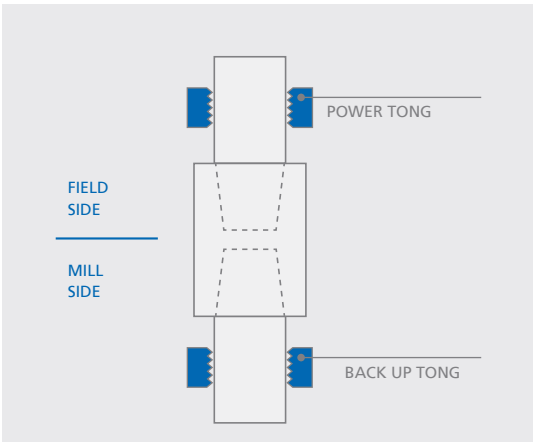
1. A weight compensator should be used for chrome, pipe with an OD  $\geq 14$ " and stands of 3 pipe  $\geq 7$ ".
2. Use power tongs in low gear to break out connections.
3. Do not hammer on connections to assist breakout as this may cause damage.
4. During break and spinout, ensure the pipe is vertical to spin freely which may necessitate slacking off or unlatching elevators.
5. To break out a Blue<sup>®</sup> Series, Legacy series, Wedge<sup>™</sup> Series 400 (with the exception of Wedge 441<sup>®</sup>) coupled connection, or TXP<sup>®</sup> Series connection, set the back up tongs on the mill side of the coupling, leaving the field side free to disengage.

For Wedge 441<sup>®</sup>, Wedge<sup>™</sup> Series 500 and Wedge<sup>™</sup> Series 600 coupled connections, place the back up tongs on the pipe body below the coupling. This will extend connection life. Coupling turn should not occur due to the higher buck on torque applied to the mill end.

If gripping the coupling of Wedge 441<sup>®</sup>, Wedge<sup>™</sup> Series 500 and Wedge<sup>™</sup> Series 600 cannot be avoided, use a full wraparound back up tong and grip the coupling as close to the pipe end as possible. The back ups should be released as soon as the field end is disengaged, and re-set on the pipe body for spin out completion if necessary.



Tong positioning for breaking out of Blue® Series, Legacy Series, Wedge™ Series 400 (excluding Wedge 441®) coupled connections and TXP® Series.



Tong positioning for break out of Wedge 441®, Wedge™ Series 500 and Wedge™ Series 600 coupled connections.

6. Never grip the connection OD of any integral connection.
7. Rotation speed should not exceed 15 RPM.
8. Slow rotation speed towards the end of spin out to prevent heavy pipe 'drop' especially for pipe with an OD  $\geq 14$ " and stands of 3 pipe  $\geq 7$ ". Count rotations until complete spin out of first joint then slow spin out speed prior to final rotation on subsequent joints.
9. Chrome and CRA connections should be walked out by hand with the use of a strap wrench.
10. Excess torque during break out or irregular rotation speed indicates poor alignment that may cause damage. Any rotational movement should be stopped until the cause is determined and corrected.
11. If excess torque is required to break out any connection check the pipe body for indications of crushing by the tong jaws.
12. Exercise care when lifting the pin out of the box. Maintaining breakout rotation and keeping the pin centered in the box when disengaging can prevent thread hang up and damage. The use of a stabbing guide will help in this process.
13. A safety clamp should be used when pulling Flush, Near Flush and Special Clearance Couplings.
14. Always use slip type elevators with special clearance and / or special bevel couplings.
15. An extension plate with the minimum length of 10" may be required to ensure the slip type elevators set on the pipe body and not on the coupling.

## Laying Down

- Wash connections with fresh water to remove any corrosive well fluid.
- Ensure all threads and seal areas are adequately covered with thread or storage compound.
- Install a clean, undamaged thread protector on box and pin ends. The protector should be on straight and tight.
- Do not apply thread compound to Dopeless® connections.
- Dry the connections and protectors prior to fitting securely.
- Always use the correct protectors with the rubber rings firmly in place for Dopeless® connections.
- Ideally the bore of the pipe should be flushed clean of well fluid.

## Surplus pipe

- Once running is completed, immediately clean and dry all remaining connections.
- Apply appropriate storage compound to the connections.
- Do not apply storage compound to Dopeless® connections.
- Install clean, dry thread protectors of the correct type.
- Ensure no corrosive fluids, debris or water come into contact with the connections during transportation and / or storage.

- Dopeless® connections should be clean and dry prior to installing the correct Dopeless® protectors with the rubber rings in place.
- Any pulled pipe should be treated in the same manner.

## End of job / storage

- Clean any used connections to remove dope, mud and corrosive fluids.
- Thoroughly flush the bores of pipe to remove all contaminants and / or debris.
- Inspect cleaned connections for damage.
- Apply a corrosion-inhibiting storage compound on clean, dry connections.
- For Dopeless® connections ensure they are clean of any contaminants and dry, do not apply any compound.
- Install clean, dry, undamaged thread protectors, ensure the correct protectors with the rubber rings in place are used for Dopeless® connections.
- For long term storage of Dopeless® connections, refurbishment by qualified personnel is recommended.
- Damaged and rejected connections should also be protected in order to prevent the connection sustaining irreparable damage and possibly rendering the whole joint as scrap.
- Rejected connections should be properly marked.
- All pipe returned from the rig should be fully cleaned and inspected as soon as possible.

- Pipe with Dopeless® connections returned from the rig should be inspected and refurbished by a Tenaris representative as soon as possible.
- If refurbishment cannot be done prior to storage, storage compound may be applied to Dopeless® connections. In this case, remove rubber rings from the Dopeless® thread protectors prior to installation. Storage compound should be removed prior to re-run by following the Dopeless® cleaning process.

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