

WI-2284 Ballot

API 5CRA Clean-up based on Feedback from API Audits

Ballot Rational: This ballot is based on feedback from API auditors regarding areas that need improvement.

Blue Text = Changes

~~Strikethrough in Blue Text~~ = Deletions

3 Normative references

“The following referenced documents, as applicable for the product, are indispensable for the application of this document...”

4.1.13

pipe

plain end, either upset or non-upset, furnished without threads, casing, tubing and pup joint as group

6.6 Traceability

The manufacturer shall establish and follow procedures for maintaining heat, remelt ingot and/or lot identity until all required heat, remelt ingot and/or lot tests and inspections are performed and conformance with specification requirements has been shown.

Each piece of product shall be uniquely identified so that test and inspection data can be related to individual pieces. It is the responsibility of the manufacturer to maintain the identification of material until it is received by the purchaser.

9.9.3 Wall thickness at end of products

“Wall thickness measurements shall be made with a mechanical caliper, micrometer or with a properly calibrated nondestructive examination device of appropriate accuracy. When mechanical calipers or micrometers are used, the shape of the contacts or anvil in contact with the inside diameter shall be either round, point or knife edge...”

9.16.7 Reference standards

“Ultrasonic and electromagnetic inspection systems for other than laminar imperfection and wall-thickness verification shall use reference standards containing notches or holes as shown in Figure B.8 and Table A.22 or Table C.22 to verify equipment response from artificial reference indicators...”

11.2.3 Die stamping

Die stamping: "When die-stamping is specified in the purchase agreement, the low-stress die-stamping or vibro-etching or equivalent shall include as a minimum a unique identification of each ~~piece product~~ ~~(unique product number)~~.

11.2.4 Paint or ink stenciling

"Each piece ~~Product~~ shall be paint or ink stenciled in the following sequence:..."

11.2.4 subsection i):

unique ~~identification product number~~;

Table A.15:

In row 5 (Label 1), 15.00 (Label 2), change drift diameter from "106,78" to "**108,78**" in column 6.

Table A.17, Footnote 'b':

The tolerance is quoted for a single length. On each ~~quantity of 18 t per~~ order item of 18 144 kg ~~or more~~, the tolerance is -1,75 %

Table A.22 — Artificial reference indicator

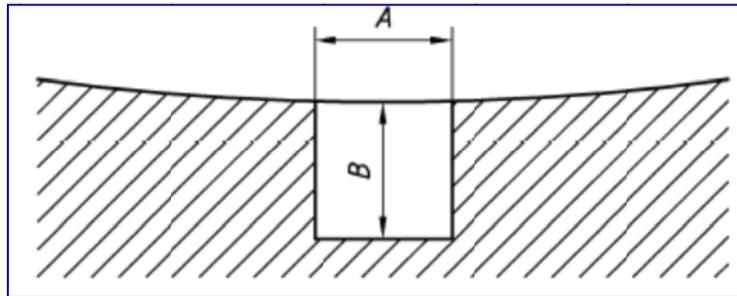
Add below table footnotes: **NOTE** See Figure B.8

Table A.28 — PSL-2 chemical composition of corrosion-resistant alloy and material categories

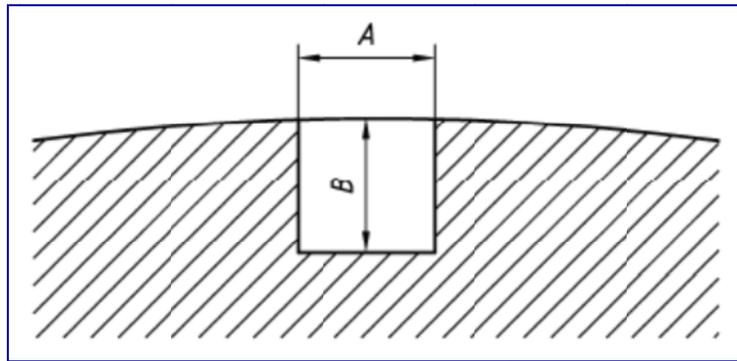
UNS Number S32750 row, Maximum Mo Limit: Change from "4,0" to "**5,0**"

UNS Number N06255 row, Maximum Si Limit: Change from "0,03" to "**1,00**"

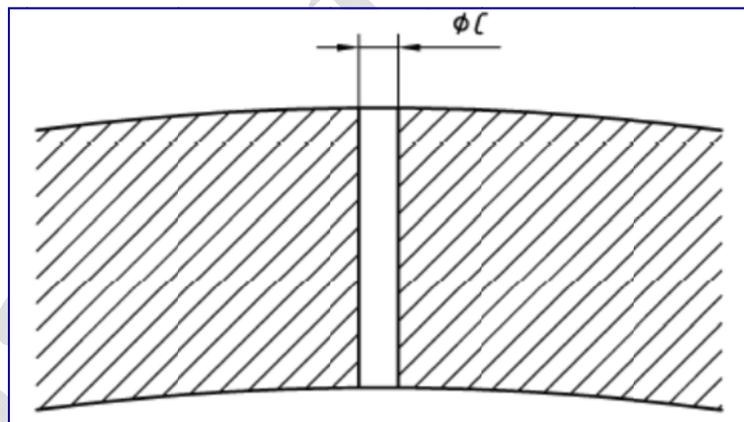
Add new Figure B.8:



a) Notch — Inner surface



b) Notch — Outer surface



c) Radially drilled hole

Key

- A notch width
- B notch depth
- C hole diameter

Figure B.8 — Non-destructive examination reference indicators

Table C.17, Footnote ‘b’:

The tolerance is quoted for a single length. On each ~~quantity of 18 t per~~ order item of 40 000 lb or more, the tolerance is -1,75 %

Table C.22 — Artificial reference indicator

Add below table footnotes: NOTE See Figure B.8

Table C.28 — PSL-2 chemical composition of corrosion-resistant alloy and material categories

UNS Number S32750 row, Maximum Mo Limit: Change from “4.0” to “**5.0**”

UNS Number N06255 row, Maximum Si Limit: Change from “0.03” to “**1.00**”