

WI-2284: Clean-up based on Feedback from API Audits

Ballot 4059 Comment Resolutions

Blue-underline = Changes, Red-stricken = Deletions, Other changes deemed to be accepted.

3 Normative references

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

Add new clause shown below and renumber subsequent clauses:

4.1.11
length
piece of plain end product

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

9.6 Hardness test

9.6.4 Retests

If any mean hardness number fails to conform to specified requirements but it does not exceed the specified requirements by more than 2,0 HRC units, three additional indentations shall be made in the immediate area to determine a new mean hardness number.

If the new mean hardness number conforms to the requirements, the ~~piece-length~~ shall be accepted.

If the new mean hardness number fails to conform to the requirements, the ~~piece-length~~ shall be rejected.

If a length is rejected due to exceeding maximum mean hardness or exceeding the maximum hardness variation, the manufacturer may elect to make retests on three additional lengths from the same lot from the same end as the original test specimen. If all the retests conform to the requirements, the lot shall be accepted. If one or more of the retest specimens fails to conform to the specified requirements, the manufacturer may elect to test each of the remaining lengths in the lot or reject the lot.

Rejected lots may be re-heat-treated and tested as new lots (as applicable).

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..."

9.9 Dimensional testing

9.9.1 General

Each ~~product~~ length shall be inspected to verify compliance with the requirements of Clause 8.

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..."

11.2.1 Marking location and size

The die stamping and/or paint stencilling shall be placed on the outside surface of each ~~product~~ length starting after the colour coding. The height of marking shall be as given in [Table A.24](#) or [Table C.24](#).

11.2.3 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-length product~~ (unique product number)."

11.2.4 Paint or ink stenciling

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

11.2.4 subsection i):

unique length 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.

14.3 Packaging

14.3.2 Identification

f) number of ~~pieces~~ lengths;

Table A.16

Column 1, casing and tubing row: Maximum permissible variation on 100 % ~~on-of~~ each ~~quantity of 18 t~~ per-order item of 18 144 kg or more

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](#)

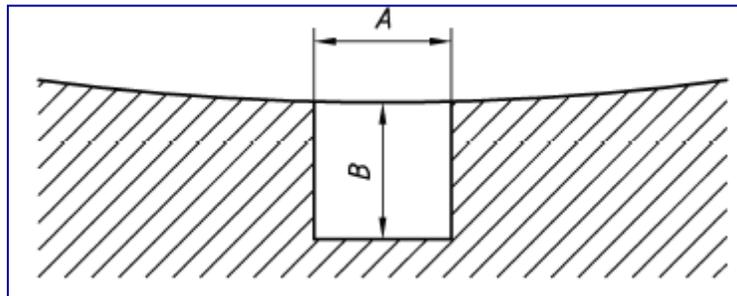
Table A.28—PSL-2 chemical composition of corrosion-resistant alloy and material categories

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

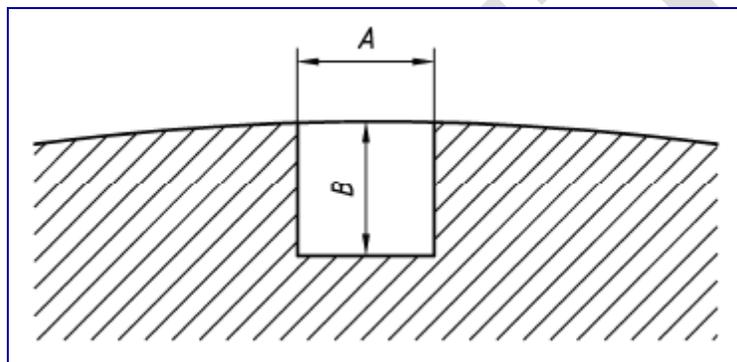
UNS Number N06255 row, Maximum Si Limit: Change from "0,03" to "**1,00**"

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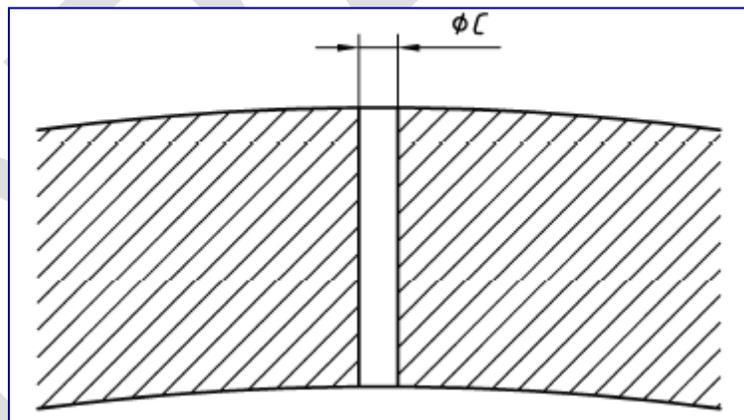
Add new Figure B.8:



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.16

Column 1, casing and tubing row: Maximum permissible variation on 100 % ~~on~~of each ~~quantity~~
~~of 18 t per~~ order item of 40 000 lb or more

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**”

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