

Technical Bulletin

SB No: TB030

Rev: **B**

Date: December 14, 2006

Description: Drilling Load Path Material



TESCO

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Introduction

This bulletin is distributed to address the manufacture of Tesco Top Drive saver subs located below the Mud Safety Valve. All saver subs shall be machined in accordance with a Tesco approved drawing. Unless otherwise specified on the approved Tesco drawing, the saver subs shall be machined from material with the minimum mechanical properties stated on the attached specification TPI-0013. Requests for substitution, deviations or clarification of this specification shall be submitted to Tesco Engineering prior to machining. All saver sub threaded connections shall be cut and gauged by a qualified machine and inspection facility in accordance with the appropriate API* or Propriety Specification.

* Reference API Spec. 7 - 40th Edition

Components Affected

All saver subs used on Tesco Top Drives when conventional drill pipe drilling.

NOTE: This bulletin does not address load path components used above Casing Drilling and Casing Running equipment.

Action Required

Ensure that all existing and new manufactured saver subs are manufactured in compliance with this bulletin.

Contact your local TESCO Parts and Service Center for further information regarding this bulletin.

TESCO CORPORATION PROCESS INSTRUCTION

MATERIAL SPECIFICATIONS:

MATERIAL GRADE: AISI/SAE 4145 H MODIFIED HTSR

ULTIMATE TENSILE STRENGTH (KSI): MIN: N/A MAX: N/A

YIELD STRENGTH (KSI): MIN: 120 MAX: N/A

PERCENT ELONGATION: ▲ Lo/d: 4/5 MIN%: 14/12

CHARPY IMPACT PROPERTIES: 40 ft lb MINIMUM @ +20°C (+70°F)

HARDNESS: N/A UNITS

MILL TEST REPORT REQUIRED: (Y/N): Y

MATERIAL ACCEPTANCE PRIOR TO PROCESSING REQ'D: (Y/N): Y

PARTICULARS: ACCEPTANCE SUBJECT TO TESCO ENGINEERING APPROVAL PRIOR TO MACHINING.

NON-DESTRUCTIVE TESTING REQUIREMENTS:

N.D.E. REQUIRED: (Y/N): Y

PARTICULARS: REFERENCE ASTM E709 AND API RP7G ▲

POST MACHINING INSPECTION REQUIRED: (Y/N): Y

PARTICULARS: 100% VISUAL, 100% WET FLUORESCENT MAGNETIC PARTICLE INSPECTION.

OTHER INSPECTION REQUIREMENTS: (Y/N): N

PARTICULARS: _____

MARKING REQUIREMENTS: (Y/N): Y

PARTICULARS: APPLY TPI NUMBER TO RAW MATERIAL USING PAINT MARKER

▲

APPLICATIONS: SAVER SUBS, DRILLABLE PICKUP SUBS, CABLE HEAD SUBS

COMMENTS: _____

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REV.	BY	YY/MM/DD	ICD#	DESCRIPTION
0	DDM	010320		ISSUED FOR MANUFACTURE
1	AHT	05/10/11	DJS-025	ADD NOTES TO N.D.E. & DEL. CROSSOVER SUBS FROM APP.
2	CXU	06/12/01	84-0009	CHANGE "ROOM TEMP" TO "+20°C (+70°F)"



TITLE <u>AISI-SAE 4145 H MOD NON-LOADPATH COMPONENTS</u>				
DRAWN	D. CHK.	E. CHK.	APPD.	TESCO PROCESS INSTRUCTION
<u>DDM</u>				<u>TPI-0013</u>
				REV. <u>2</u>