

To: EVRAZ NA QB2 Users
From: EVRAZ NA Tubular
Date: August 21st, 2013
Re: Field Bulletin 001-13: OD Turning Requirement for QB2 on Seamless Casing

Going forward, the EVRAZ NA QB2 premium connection will have the outer diameter of the casing turned to nominal in the threaded area when machined on seamless casing. These connections may be identified by a stencil adjacent to the mill end that reads:

**Pipe Diameter Cleanup
EVRAZ Field Bulletin 001-13**

Prior to cutting the QB2 thread form and seal, the pipe outer diameter will be machined to nominal for a length equal to the make-up loss, with a tolerance of + 0.2". As a result, a ring of machined pipe will be visible past the coupling when the connection is made up, up to 0.2" in length.

The following picture is an example of a seamless QB2 pin end with outer diameter turned. Aside from the stenciling, the new connection is easily identified as there are no longer black crested threads in the thread runout (mill scale on runout thread crests). That being said, there still may be localized areas on the circumference in the thread runout where the outer diameter did not turn off; this is perfectly acceptable.



Figure 1, Example of an EVRAZ QB2 Connection
That has had the Diameter Machined

For more information please contact the Calgary sales office: 403 543-8000