

## **Recommended Practice for Running Tool Inspection and Repairing**

**This document is applicable to inspection and repairing for running tools for the connections below:**

- 1. FLUSHMAX, FLUSHMAX-II, FLUSHMAX-III**
- 2. MO-FXL**
- 3. MO-XFC**

### 1. Reference

- 1.1 API5CT Casing and Tubing
- 1.2 API5C1 Recommended Practice for Care and Use of Casing and Tubing
- 1.3 Field Inspection and Repairing Procedure for the appropriate connection
- 1.4 Phosphate and Rework of Phosphate Ancillary Generic Procedure
- 1.5 Drawing of Lift Nubbins for the appropriate connection

### 2. Equipment

- 2.1 High Pressure Cleaning System
- 2.2 Wet Fluorescent Magnetic Particle Inspection System
- 2.3 Phosphating System
- 2.4 Paint Equipment, Paint Removal Equipment System
- 2.5 Adequate Supply of Moisture/Water Displacing Compound
- 2.6 Storage Compound (Kendex is recommendable.)

### 3. Inspection Items

- 3.1 Visual Inspection
- 3.2 Wet Magnetic Particle Inspection (Wet-MPI)

### 4. Certification

- 4.1 Inspectors performing a Wet-MPI shall be qualified and certified in accordance with SNT-TC-1A for Level I and II magnetic particle inspectors.
- 4.2 All magnetic particle inspection system shall be calibrated and certified for proper operation on a six (6) month interval.

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## 5. Visual Inspection

### 5.1 Preparation

- 1) Thread Protector
  - A) Clean thread protector using the high-pressure cleaning system.
- 2) Pin and/or Box Connection
  - A) Clean connection using the high-pressure cleaning system.
  - B) Dry the connection and wipe or blow out solvent and water from thread roots

### 5.2 Visual inspection at pin and/or box thread

- 1) Thread shall be free from any imperfection which could break continuity of the thread.
- 2) Minor imperfection and minor corrosion pits and/or steps are acceptable provided thread surface does not protrude from original contour of thread crests or flanks.
- 3) Minor protrusion on the thread crest is acceptable.
- 4) Mash on the thread is NOT allowed.

### 5.3 Visual inspection at external and internal shoulders

- 1) External and internal shoulders shall be free from any imperfection which is protruding from original surface contour of shoulders.

## 6. Wet Magnetic Particle Inspection (Wet-MPI)

6.1 All thread and shoulders shall be inspected by Wet-MPT.

6.2 In addition to the above, annually, entire length of each crossover and lift nubbin shall be inspected by Wet-MPI, when the tool was used in the last 12 months.

## 7. Re-Phosphate

7.1 When any shiny area is observed at thread, re-phosphate shall be applied.

## 8. Storage

### 8.1 Installing Protector

- A) Apply adequate moisture/water displacing liquid.
- B) Apply adequate storage compound (Kendex is recommendable) on entire thread including both external and internal shoulders.
- C) Apply each protector on thread after cleaning and drying the protector.
- D) A heavily damaged protector shall be replaced.

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## 9. Marking

9.1 Mark stencil tools with identification to include company name, date of inspection and representative.

## 10. Rejection

10.1 Any pin or box, which does not meet API5CT, a Metal One field inspection and repairing procedure and this procedure shall be rejected.

10.2 All rejects shall be clearly identified as "REJECTED" with the entire area painted "RED".