

To: QB2 End Users
From: EVRAZ Research & Development
Date: October 22, 2013
Re: PC-FB-002: Updated QB2 Field Running Procedures

As part of our commitment to continual improvement, EVRAZ has published a revision of its QB2 Field Running Procedures. The Field Bulletin is also available online at www.evrazna.com.

Changes incorporate client feedback to ensure that QB2 running procedures reflect current practices in the field. Torque tables, make-up speed, and other critical data remain unchanged from previous revisions.

Dope Application

Successful make-up of the QB2 connection hinges on dope application. TOPCO QB2-50M was created specifically for use with the QB2 and is essential to its performance.

To ensure proper application, the following procedure should be used:

- The thread compound container must remain free of all contaminants (i.e.: water, ice, sand, solvent, sawdust, etc.) and should be thoroughly stirred prior to application to ensure proper mixing of solid particles.
- During cold weather, the thread compound should be stored inside and applied warm, if possible. In addition, steaming of the pipe ends is recommended to facilitate application of QB2-50M.
- Apply a thin, even coat of the thread compound to the pin seal and the pin and coupling threads. Thread compound on the coupling seal shall average two or more times the thickness of the compound on other surfaces, while thread compound remaining in the coupling's dope relief groove shall be minimized. A moustache brush is recommended. A thin even coat is defined as approximately 0.030" to 0.040" (0.75mm to 1mm) with thread form still clearly visible. **Do not over-coat.**



High Shoulders

EVRAZ realizes that in the field, factors can contribute to a connection shouldering high. If the connection shoulders above the maximum shoulder rating, then the following procedure is recommended:

- Back out the connection entirely.
- Both the coupling and the pin end should be cleaned thoroughly, wiped dry, and inspected for damage.
 - o If no damage has occurred, re-make the connection as outlined above.
 - o If the threads or either of the pin or coupling seals have been damaged, the joint or joints should be laid down.
- Should several joints exhibit high shoulder torques, high shoulder torque threshold and optimal final torque may be increased in 5% increments to a maximum of 10% above the value specified in Appendix A Table 1 for the remainder of the job or until such time as a pattern of normal shoulder torques is achieved.