



**SEAL-LOCK HT
ANCILLARY
SPECIFICATIONS**

SECTION	V	
Approved Engineer	RJH	04/20/96
Approved Mgr Engr	DR	04/20/96
Approved VP QA	HDG	04/20/96
REVISION	001	04/20/96

SUBJECT: STEEL IMPERFECTIONS

1.0 SCOPE

1.1 This document sets forth the procedure for the evaluation of pipe or steel imperfections in the connection area for **SEAL-LOCK HT** connectors.

2.0 REFERENCES

2.1 The following documents were used as references in the context of this specification:

2.1.1 API Specification 5CT

2.1.2 API Specification 5B

3.0 ACCEPTANCE CRITERIA

3.1 Pin Connector OD

3.1.1 The minimum length of full formed threads shall be free of all discontinuities except (1 and 2 indicated below) minor/repairable thread damage, minor pitting and inclusions.

3.1.2 Imperfections are allowed in the imperfect thread length provided the imperfection depth does not exceed 12 1/2% of the tube's nominal wall thickness when measured from the projected tube surface. (3 indicated below) Linear imperfections detected in the imperfect thread root cone shall be removed, the surfaces well contoured, and the remaining wall thickness (87 1/2% minimum) verified.

1. Minor Pitting - Thread surface minor pitting shall be defined as isolated corrosion pitting in the full form thread length which does not affect the thread height or form per Hunting's definition of full form thread.

2. Minor/Repairable Thread Damage - No absolute blanket acceptance/rejection criteria concerning thread damage can be specified due to factors such as actual full form thread length, depth, and location of the damage. Impact type damage that is 0.125" or less in circumferential length, spans across less than two (2) full form threads or is less than 0.005" in depth may be repaired by removing all protrusions on the load flank and thread crests by light filing.

3. Linear Imperfections - as defined in the latest edition of API Specification 5CT.

3.2 Pin Connector ID

3.2.1 Steel imperfections detected on the ID surface directly beneath the pin connector full form thread length shall not be greater than 12 1/2% of the nominal wall thickness as measured from the ID surface.

3.2.2 Linear imperfections shall be removed and the surrounding ID surface well contoured.

3.3 Coupling/Box OD

3.3.1 Steel imperfections detected on the OD surface of a coupling or box connector are acceptable if the depth does not exceed 0.015". The maximum permissible imperfection depth is a function of actual coupling OD and the position the imperfection is located on the OD surface. Each imperfection that exceeds 0.015" in depth must be evaluated for acceptance/rejection by Hunting's Q.A. department on an individual basis.



***SEAL-LOCK HT
ANCILLARY
SPECIFICATIONS***

SECTION	V	
Approved Engineer	RJH	04/20/96
Approved Mgr Engr	DR	04/20/96
Approved VP QA	HDG	04/20/96
REVISION	001	04/20/96

SUBJECT: STEEL IMPERFECTIONS

3.4 Coupling/Box ID

3.4.1 The coupling ID or thread surfaces shall be free of all discontinuities except for minor pitting and minor/repairable thread damage as defined above in paragraph 3.1.

4.0 REJECTION

4.1 Any connector that does not meet the acceptance criteria in Section 3.0 of this document shall be rejected and identified in such a manner that the rejected parts do not get shipped as prime.