

Label	Specific Outside Diameter		Wall Thickness		Mass of Plain end Pipe		Standard Test Pressure		
							H40	J55	K55
1	mm	inch	mm	inch	Kg/m	lb/ft	MPa	MPa	MPa
4-1/2	114.30	4.500	5.21	0.205	14.02	9.41	20.1	27.6	27.6
			5.69	0.224	15.24	10.24	22.0	30.2	30.2
			6.35	0.250	16.91	11.36	24.5	33.7	33.7
			7.37	0.290	19.44	13.05	28.5	39.1	39.1
5-1/2	139.70	5.500	6.20	0.244	20.41	13.71	19.6	26.9	26.9
			6.98	0.275	22.85	15.36	22.1	30.3	30.3
			7.72	0.304	25.13	16.89	24.4	33.5	33.5
			9.17	0.361	29.52	19.83	29.0	39.8	39.8
6-5/8	168.28	6.625	7.32	0.288	29.06	19.51	19.2	26.4	26.4
			8.94	0.352	35.13	23.60	23.5	32.2	32.2
			10.59	0.417	41.18	27.67	27.8	38.2	38.2
			12.06	0.475	46.46	31.23	31.6	43.5	43.5
7	177.80	7.00	5.87	0.231	24.89	16.72	14.6	20.0	20.0
			6.91	0.272	29.12	19.56	17.2	23.6	23.6
			8.05*	0.317	33.70	22.65	20.0	27.5	27.5
			9.19	0.362	38.21	25.69	22.8	31.3	31.3
			10.36	0.408	42.78	28.75	25.7	35.3	35.3
			11.51*	0.453	47.20	31.70	28.6	39.3	39.3
7-5/8	193.68	7.625	7.62	0.300	34.96	23.49	17.4	23.9	23.9
			8.33	0.328	38.08	25.59	19.0	26.1	26.1
			9.52	0.375	43.24	29.06	21.7	29.8	29.8
			10.92	0.430	49.22	33.07	24.9	34.2	34.2
8-5/8	219.08	8.625	6.71	0.264	34.14	23.60	13.5	18.6	18.6
			7.72	0.304	40.24	27.04	15.6	21.4	21.4
			8.94*	0.352	46.33	31.13	18.0	24.7	24.7
			10.16	0.400	52.35	35.17	20.5	28.1	28.1
			11.43	0.450	58.53	39.33	23.0	31.6	31.6
9-5/8	244.48	9.625	7.92	0.312	46.20	31.06	14.3	19.6	19.6
			8.94	0.352	51.93	34.89	16.1	22.2	22.2
			10.03*	0.395	57.99	38.97	18.1	24.9	24.9
			11.05	0.435	63.61	42.73	20.0	27.4	27.4
			11.99	0.472	68.75	46.18	21.7	29.7	29.7
10-3/4	273.05	10.750	7.09	0.279	46.50	31.23	8.6	11.8	11.8
			8.89	0.350	57.91	38.91	10.8	14.8	14.8
			10.16	0.400	65.87	44.26	12.3	16.9	16.9
			11.43	0.450	73.75	49.55	13.9	19.0	19.0

* Standard drift. Alternative drift on request.

PRESSURE HOLDING TIME = 05 Second Minimum

Tolerances: -

1) Outside Diameter:

Label 1 mm (in)	Outside Diameter, D
D ≥ 114.3 (4.500)	+ 1 % of D - 0.5 % of D

1) Wall Thickness:

Tolerance for Pipe
-12.5%

3) Mass

Single Lengths
+ 6.5% -3.5%

Mechanical Properties :

Group 1	Grade - H40		Grade - J55		Grade - K55	
	Mpa	PSI	Mpa	PSI	Mpa	PSI
Yield Strength	276 - 552	40030-80060	379 - 552	54970-80060	379 - 552	54970-80060
Tensile Strength (min)	414	60045	517	74985	655	95000

Elongation % minimum : Min .Elong. shall be determined by : $e = 1942.57 A^{0.2} / U^{0.9}$
(Where A= Area of test specimen, U= Min. specified tensile strength)

Flattening Test:

Grade	D/t ratio	Distance between plates - mm
H40	W 16 <16	0.5 XD D X (0.830-0.020 6 D/t)
J55 K55	W 16 3.93 to 16 <3.93	0.65 X D D X (0.980 - 0.020 6 D/t) D X (1.104 - 0.051 8 D/t)

Chemical Properties : Composition (Max. %)

Group 1	C	Mn 1	P	S
Grade H40	--	--	0.030	0.030
Grade J55	--	--	0.030	0.030
Grade K55	--	--	0.030	0.030

* ALSO CASING WITH SPECIAL CHEMISTRY UP-GRADABLE TO L-80 AND N-80 GRADE

Seam Normalizing : the weld seam of electric-welded pipe shall be heat-treated after welding to a minimum temperature of 540°C (1000°F) or processed in such a manner that no untempered martensite remains

Length: R3 (39 to 42ft)

Pipe Ends: Plain Square cut ends

Destructive & Non-Destructive Testing:

Hydrostatic Testing: 100% of pipe shall be tested at a Pressure specified in above table.

NDT Group 1: Weld seam of each pipe shall be tested by online Eddy Current Test and online automatic ultrasonic test.

Flattening Test:
i) NO opening of the weld before the distance between the plates specified in above table.
ii) No evidence of lamination or burnt metal shall develop during the flattening until opposite wall of the pipe meet.

Drift Test: Each length of pipe shall be drift tested throughout its entire length.

Charpy V Notch: API 5CT Group 1, Grades H40, J55 & K55 : There is no mandatory CVN impact requirement.

Marking: Stenciling as per the specification & customer requirement.