Coiled Line Pipe

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Suggested revisions are invited and should be submitted to the Standards Department, API, 200 Massachusetts Avenue, NW, Suite 1100, Washington, DC 20001, standards@api.org.

Contents

Page

1 Scope 1

2 Normative References 1

3 Terms, Definitions, and Abbreviations 2

4 Information to Be Supplied by the Purchaser 4
4.1 Purchaser Specification 4
4.2 Optional Purchaser Requirements 4
4.3 Requirements Subject to Agreement 5

5 Process of Manufacture and Material 5
5.1 Process of Manufacture 5
5.2 Welding Processes 6
5.3 Heat Treatment 7
5.4 Traceability 7

6 Material Requirements 7
6.1 Chemical Properties 7
6.2 Mechanical Properties 8

7 Dimensions, Masses Per Unit Length, Defects, and End Finishes 11
7.1 General—Dimensions and Masses per Unit Length 11
7.2 Diameter 15
7.3 Wall Thickness 16
7.4 Calculated Mass per Unit Length 16
7.5 Length 17
7.6 Pipe-to-Pipe Welds 17
7.7 Workmanship and Defects 17
7.8 Pipe Ends 19
7.9 Drift Testing 19

8 Inspection and Testing 19
8.1 Test Equipment 19
8.2 Testing of Chemical Composition 20
8.3 Testing of Mechanical Properties 20
8.4 Hydrostatic Tests 21
8.5 Dimensional Testing 22
8.6 Nondestructive Testing 22
8.7 Test Methods 30
8.8 Invalidation of Tests 30
8.9 Retests 30

9 Marking Requirements 32
9.1 General 32
9.2 Sequence of Markings 32
9.3 Length 33

10 Coating and Protection 33
10.1 Coatings 33
10.2 Protection from Corrosion 33

Contents

Page

11 Documents 34
11.1 Product Traceability 34
11.2 Certificate of Conformance 34
11.3 Spool Documentation 34
11.4 Retention of Records 35

Annex A (informative) SI (Metric) Conversion Procedure 37

Annex B (normative) Requirements for Pipe-to-pipe Welding of Coiled Pipe 40

Annex C (normative) Skelp End and Pipe-to-Pipe Welding Procedure Specification 41

Annex D (informative) Coiled Pipe Reels 46

Annex E (informative) Dimensions, Masses per Unit Length and Test Pressures—SI Units 47

Annex F (informative) Elongation Tables 51

Annex G (normative) Supplementary Requirements 53

Annex H (normative) Pipe Ordered for Sour Service 55

Bibliography 64

Figures

1 Tensile Test Full Section Specimen 20
2 Orientation of Tensile Test Strip Specimen in Pipe 20
3 Tensile Test Strip Specimen 20
4 Seam Weld Inspection Reference Standard 27
C.1 Guided-Bend Test Specimen 43
C.2 Jig for Guided Bend Test 44
H.1 Hardness Traverse Schema for Sour Service 59

Tables

3 Purchaser-Specified Information 4
4 Optional Purchaser Requirements 5
5 Stipulations Subject to Agreement 5
1 Special Processes for Welds Without Filler Metal 6
2 Special Processes for Welds with Filler Material 6
6 Chemical Requirements by Percentage of Mass 8
7 Tensile and Hardness Requirements 8
8 Coiled Line Pipe Dimensions, Masses per Unit Length and Test Pressures 12
9 Tolerances for Diameter of Pipe Body 15
10 Tolerances for Diameter at Pipe Ends 16

Contents

		Page
11	Maximum Trim Depth	18
12	ASTM Image Quality Indicator	24
13	ISO Wire Four Percent Image Quality Indicators (Fe 6/12)	24
14	ISO Wire Two Percent Image Quality Indicators (Fe 6/12)	25
15	Acceptable Limits	28
16	Grade Marking Symbols	32
17	Heat Treatment Marking Symbols	33
18	Retention of Records	36
C.1	Guided-bend Test Jig Dimensions	44
E.1	Dimensions, Masses, and Test Pressures	47
F.1	Minimum Elongation Values	51
H.1	Chemical Composition for Sour Service	57
H.2	Tensile Test Requirements for Sour Service	58
H.3	Inspection Frequency	60
H.4	Number, Orientation, and Location of Test Pieces per Sample for Hardness Tests	61

Coiled Line Pipe

1 Scope

1.1 This specification covers welded steel continuously milled coiled line pipe in the outside diameter size range of 0.5 in. to 6.625 in. (12.7 mm to 168.3 mm). Pipe that is pipe-to-pipe welded outside the confines of the manufacturing plant is not included within this document.

1.2 The specification provides standards for pipe suitable for use in conveying gas, water, and oil in both the oil and natural gas industries.

1.3 Grades covered by this specification are X52C, X56C, X60C, X65C, X70C, X80C, and X90C. Grades shall not be mixed within a milled length or a spool.

NOTE Grade designations used herein are composed of the letter X followed by the first two digits of the specified minimum yield strength in U.S. customary units; the letter C is added to indicate coiled pipe.

1.4 Pipe manufactured as Grade X60C or higher may not be substituted for pipe ordered for Grade X52C without purchaser approval.

1.5 Although the coiled line pipe meeting this specification is intended to be suitable for field welding, the manufacturer will not assume responsibility for field welding.

1.6 The size designations used herein are outside-diameter sizes. Pipe sizes 2⅜ and larger are expressed as integers and fractions; pipe sizes smaller than 2⅜ are expressed to three decimal places.

1.7 U.S. customary (USC) units are used in this specification; SI (metric) units are shown in parentheses in the text and in many tables. See Annex A for specific information about conversion factors and rounding procedures.

2 Normative References

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any addenda) applies.

API Standard 1104, *Welding of Pipelines and Related Facilities*

ASME Boiler and Pressure Vessel Code (*BPVC*), Section IX,[1] *Welding and Brazing Qualifications*

ASNT Recommended Practice SNT-TC-1A,[2] *Personnel Qualification and Certification in Nondestructive Testing*

ASTM A370,[3] *Methods and Definitions for Mechanical Testing of Steel Products*

ASTM A450, *Specification for General requirements for Carbon, Ferritic Alloy, and Austenitic Alloy Steel Tubes*

ASTM A751, *Test Methods, Practices, and Definitions for Chemical Analysis of Steel Products*

ASTM E4, *Standard Practices for Force Calibration and Verification of Testing Machines*

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1 American Society of Mechanical Engineers, Two Park Avenue, New York, New York 10016-5900, www.asme.org.

2 The American Society for Nondestructive Testing International Service Center, P.O. Box 28518, 1711 Arlingate Lane, Columbus, Ohio 43228-0518, www.asnt.org.

3 ASTM International, 100 Barr Harbor Drive, P.O. Box C700, West Conshohocken, PA 19428-2959, www.astm.org.