

Classification of Used Drill Pipe Tubes and Tool Joints

	Condition	Premium Class	Class 2
TUBES	Min. remaining wall thickness	>80%	>70% ¹
	Slip cuts and gouges ² (Depth)	<10% of Avg. adjacent wall ³	<20% of Avg. adjacent wall ³
	Diameter reduction	<3% of specified OD	<4% of specified OD
	Diameter increase	<3% of specified OD	<4% of specified OD
	Cracks	None	None
TOOL JOINTS	Torsional strength	>80% of a Premium Class Tube	>80% of a Class 2 Tube
	Pin stretch	<0.006% in 2"	<0.006 in 2"
	Other dimensions	As specified in Table 3.7	As specified in Table 3.7
	Cracks	None	None

1. Minimum remaining wall thickness must be $\geq 80\%$ under transverse cuts and gouges.
2. Cuts and gouges may be removed by grinding provided the remaining wall is not reduced below the minimum remaining wall shown in this table.
3. Average adjacent wall is determined by averaging the wall thickness on each side of the imperfection adjacent to the deepest penetration.

Dimensional Acceptance Criteria For Used Drill Pipe Tubes

Nom. OD (in)	Nom. Wt. (lb/ft)	ID (in)	Premium Class			Class 2		
			Minimum Wall (80%)	Min. OD (in)	Max. OD (in)	Minimum Wall (70%)	Min. OD (in)	Max. OD (in)
2-3/8	6.65	1.815	.224	2.304	2.446	.196	2.28	2.47
2-7/8	10.40	2.151	.290	2.789	2.961	.253	2.76	2.99
3-1/2	13.30	2.764	.294	3.395	3.605	.258	3.36	3.64
	15.50							
4	14.00	3.340	.264	3.880	4.120	.231	3.84	4.16
	15.70							
4-1/2	16.60	3.826	.270	4.365	4.365	.236	4.32	4.68
	20.00	3.640	.344			.301		
	22.82	3.500	.400			.350		
5	19.50	4.276	.290	4.850	5.150	.253	4.80	5.20
	25.60	4.000	.400			.350		
5-1/2	21.90	4.778	.289	5.335	5.665	.253	5.28	5.72
	24.70	4.670	.332			.290		
6-5/8	25.20	5.965	.264	6.426	6.824	.231	6.36	6.89
	27.70	5.901	.290			.253		