

Quality Requirements for Casing and Tubing (API)

Revision history

VERSION	DATE	PURPOSE
1.0	April 2022	First Edition

Acknowledgements

This IOGP Specification was prepared by a Joint Industry Programme 33 Standardization of Equipment Specifications for Procurement organized by IOGP with support by the World Economic Forum (WEF).

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Foreword

This specification was prepared under Joint Industry Programme 33 (JIP33) "Standardization of Equipment Specifications for Procurement" organized by the International Oil & Gas Producers Association (IOGP) with the support from the World Economic Forum (WEF). Companies from the IOGP membership participated in developing this specification to leverage and improve industry level standardization globally in the oil and gas sector. The work has developed a minimized set of supplementary requirements for procurement, with life cycle cost in mind, resulting in a common and jointly agreed specification, building on recognized industry and international standards.

Recent trends in oil and gas projects have demonstrated substantial budget and schedule overruns. The Oil and Gas Community within the World Economic Forum (WEF) has implemented a Capital Project Complexity (CPC) initiative which seeks to drive a structural reduction in upstream project costs with a focus on industry-wide, non-competitive collaboration and standardization. The CPC vision is to standardize specifications for global procurement for equipment and packages. JIP33 provides the oil and gas sector with the opportunity to move from internally to externally focused standardization initiatives and provide step change benefits in the sector's capital projects performance.

This specification has been developed in consultation with a broad user and supplier base to realize benefits from standardization and achieve significant project and schedule cost reductions.

The JIP33 work groups performed their activities in accordance with IOGP's Competition Law Guidelines (November 2020).

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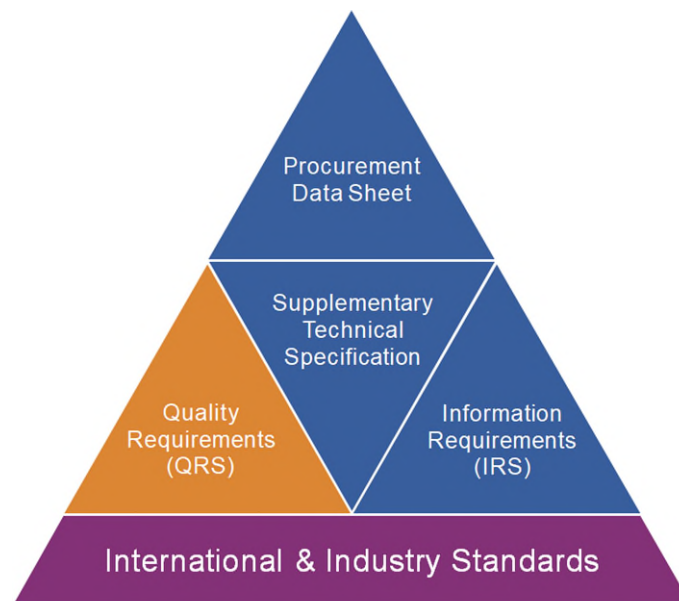
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Introduction

The purpose of this quality requirements specification (QRS) is to specify quality management requirements and the proposed extent of purchaser intervention activities for the procurement of casing and tubing in accordance with IOGP S-735 for application in the petroleum and natural gas industries.

Purchaser intervention activities are identified through the selection of one of four conformity assessment system (CAS) levels based on a risk and criticality assessment. The applicable CAS level is specified by the purchaser in the procurement data sheet or purchase order.

This QRS shall be used in conjunction with the specification (IOGP S-735), the procurement data sheet (IOGP S-735D) and the information requirements specification (IOGP S-735L) which together comprise the full set of specification documents. The introduction section in the specification provides further information on the purpose of each of these documents and the order of precedence for their use.



JIP33 Specification for Procurement Documents Quality Requirements Specification

1 Scope

To specify quality management requirements for the supply of casing and tubing to IOGP S-735 including:

- a) manufacturer quality management system requirements;
- b) purchaser conformity assessment (surveillance and inspection) activities;
- c) traceability requirements.

2 Normative references

For the purpose of this document, the documents referenced in IOGP S-735 and those listed below, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

API Specification Q1, *Specification for Quality Management System Requirements for Manufacturing Organizations for the Petroleum and Natural Gas Industry*

IOGP S-735, *Supplementary Specification to API Specification 5CT Casing and Tubing*

ISO 9001, *Quality management systems — Requirements*

ISO 29001, *Petroleum, petrochemical and natural gas industries — Sector-specific quality management systems — Requirements for product and service supply organizations*

3 Terms and definitions

For the purpose of this document, the terms and definitions given in IOGP S-735 and ISO 9000 (normative to ISO 9001), and the following shall apply.

3.1

conformity assessment

demonstration that specified requirements are fulfilled

Note 1 to entry: Conformity assessment (or assessment) includes but is not limited to review, inspection, verification and validation activities.

Note 2 to entry: Assessment activities may be undertaken at a supplier/sub-supplier's premises, virtually by video link, desktop sharing, etc. or by review of information.

3.2

conformity assessment system

CAS

system that provides different levels of purchaser interventions to assess and verify supplier conformance to specified requirements

Note 1 to entry: CAS A applies to the highest risk and associated extent of verification. CAS D is the lowest.

3.3

hold point

H

<conformity assessment> point in the chain of activities beyond which an activity shall not proceed without the approval of the purchaser or purchaser's representative

3.4 witness point W

<conformity assessment> point in the chain of activities that the manufacturer shall notify the purchaser or purchaser's representative before proceeding

Note 1 to entry: The operation or process may proceed without witness if the purchaser does not attend after the agreed notice period.

3.5 surveillance S

<conformity assessment> observation, monitoring or review by the purchaser or purchaser's representative of an activity, operation, process, product or associated information

Note 1 to entry: Surveillance is typically an on-site activity, purchaser may observe the activity or review records associated with the activity to verify conformance.

3.6 review R

<conformity assessment> review of the manufacturer's information to verify conformance to requirements

Note 1 to entry: Physical activity will not be observed by purchaser. Records associated with the activity are to be delivered in accordance with the Information requirements specification (IRS).

4 Symbols and abbreviations

For purposes of this document, the following symbols and abbreviations apply.

CAS	conformity assessment system
IRS	information requirements specification
QMS	quality management system
QRS	quality requirements specification (this document)
SL	specification level

5 Quality requirements

5.1 Quality management system

The manufacturer shall operate and maintain a quality management system (QMS) that conforms with ISO 9001, ISO 29001, API Specification Q1 or an equivalent quality management system standard.

5.2 Conformity assessment system (CAS)

5.2.1

The conformity assessment system (CAS) provides different levels of assessment of the supplier's control activities. The CAS level is defined by the purchaser, using a risk-based approach, and included in the purchase order/contract. The defined CAS level may be adjusted by the purchaser during manufacture based on supplier performance and re-assessment of risk.

NOTE For industrial proven solutions, CAS level D is specified unless risk assessment indicates that a more stringent CAS level is required.

5.2.2

Quality plans and inspection and test plans shall include provision for purchaser's intervention activities based on the CAS level selected in the procurement data sheet or purchase order. See Annex A.

5.2.3

Supplier performance in meeting the requirements may be routinely assessed during execution of the scope and where appropriate, corrective action requested and conformity assessment activities increased or decreased consistent with criticality and risk.

6 Certification and traceability

Material certification and traceability shall be maintained in accordance with API 5CT and IOGP S-735, 6.4, 13.2 and 13.3.

7 Evidence - conformance records

Documents and information shall be provided for in accordance with the associated IRS.

Annex A (normative)

Purchaser Conformity Assessment System Requirements

This annex defines four conformity assessment systems (CAS) or levels of purchaser assessment.

	PURCHASER ASSESSMENT ACTIVITIES	CAS			
		A	B	C	D
1	Operational planning and control activities				
1.1	Attend pre-inspection/pre-production meeting (IOGP S-735, 6.5, 9.7, 10.6, 10.15, Annex L)	H	H	-	-
2	Design and development activities				
2.1	PPQ, MPQ or validation activity according to Annex L, M, N or P (as applicable if activity includes inspector involvement) (IOGP S-735, 7.14, 10.15, 13.5, Annex L, Annex M, Annex N, Annex P)	H	W	W	R
3	Control of external supply				
3.1	Review of ladle heat analysis records (IOGP S-735, 10.3)	S	S	-	-
3.2	Review of billet/green (untreated) materials (IOGP S-735, 9.1, 9.10, 14.1)	S	S	-	-
4	Product and service provision				
4.1	Product manufacture				
4.1.1	Review of ladle heat analysis records (IOGP S-735, 10.3)	S	S	-	-
4.1.2	Review of billet/green (untreated) materials (IOGP S-735, 9.1, 9.10, 14.1)	S	S	-	-
4.1.3	Monitor thermomechanical processing for as-rolled (non-heat treated) grades (IOGP S-735, 9.2)	W	S	-	-
4.1.4	Monitor heat treatment (IOGP S-735, 6.2, 6.5, 9.1, 9.2, 10.2, 10.8, 11.2, 13.3, Table C.3, Table E.3)	W	S	-	-
4.1.5	Review of hot straightening (IOGP S-735, 6.3, 6.5, 10.4.1)	S	S	-	-
4.1.6	Monitor traceability throughout processes (IOGP S-735, 6.4, 10.13, 11.1.7, 13.3)	S	S	S	-
4.2	Electric resistance welding (EW)				
4.2.1	Review of skelp receiving inspection (IOGP S-735, 10.3.2, 10.4.2, 10.4.5)	S	S	-	-
4.2.2	Monitor slitting, edge preparation (IOGP S-735, 10.4)	S	S	-	-
4.2.3	Review the metallographic welding inspection (IOGP S-735, 10.11, 10.15.10, K.6.3, K.6.5, K.13)	S	S	-	-
4.2.4	Monitor flattening test (IOGP S-735, 10.5, Table C.41, Table E.41)	W	S	S	-
4.3	Destructive testing				
4.3.1	Monitor test frequency and specimen sampling (IOGP S-735, Table C.37-Table C.40, Table E.37-Table E.40)	S	S	S	-

	PURCHASER ASSESSMENT ACTIVITIES <i>(continued)</i>	CAS			
		A	B	C	D
4.3.2	Review of product analysis and grain size (IOGP S-735, 10.3)	S	S	-	-
4.3.3	Review of hardenability test (IOGP S-735, 7.10, 10.6.10, 10.9)	W	S	S	-
4.3.4	Monitor tensile, impact, hardness and collapse to failure tests — first article (IOGP S-735, 7.3, 7.5, 7.7, 7.10, 10.4.5, 10.6, 10.7, Table C.37 to Table C.40, Table E.37 to Table E.40, K.11.1)	W	W	S	-
4.3.5	Review tensile, impact, hardness and collapse to failure tests — subsequent production (IOGP S-735, 7.3, 7.5, 7.7, 7.10, 10.4.5, 10.6, 10.7, Table C.37-Table C.40, Table E.37-Table E.40, K.11.1)	W	S	S	-
4.3.6	Review of sulfide stress cracking testing IOGP S-735, 7.14, 10.6, 10.10, Table 20, Table 21)	W	S	S	-
4.4	Threading manufacturing and thread inspection				
4.4.1	Monitor end sizing with or without thermal recovery — first article (IOGP S-735, 6.5.1, Annex N)	W	W	S	-
4.4.2	Review end-sizing with or without thermal recovery — subsequent production (IOGP S-735, 6.5.1, Annex N)	W	S	S	-
4.4.3	Monitor thread inspection — first article (IOGP S-735, 9.10)	W	W	S	-
4.4.4	Review thread inspection including review of onsite thread gauge records — subsequent production (IOGP S-735, 8.13.1, 9.10)	W	S	S	-
4.4.5	Monitor non-destructive examination — couplings and pin ends (IOGP S-735, 9.4, 10.15)	W	S	-	-
4.4.6	Monitor application of surface treatment (IOGP S-735, 7.12, 8.8, 9.11, 9.14, 12.1, Table 12)	W	S	S	-
4.4.7	Monitor of seal ring inspection and installation in coupling (IOGP S-735, 9.8, K.8)	W	S	-	-
4.5	Visual, dimensional, non-destructive examination, marking and coating				
4.5.1	Monitor visual inspection (IOGP S-735, 10.14)	W	S	-	-
4.5.2	Monitor dimensional examination and full-length drift IOGP S-735, 8.2 to 8.6, 8.10, 10.13)	W	S	S	-
4.5.3	Review of hydrostatic testing (EW pipe only) (IOGP S-735, 10.12)	S	S	-	-
4.5.4	Monitor of non-destructive examination — calibration and set-up (IOGP S-735, 10.15, Table C.42-Table C.44, Table E.42-Table E.44)	W	W	S	-
4.5.5	Review of non-destructive examination on body — subsequent production (IOGP S-735, 10.15, Table C.42-Table C.44, Table E.42-Table E.44)	W	S	S	-
4.5.6	Review of non-destructive examination — second method on body (IOGP S-735, 10.15, Table C.42-Table C.44, Table E.42-Table E.44)	W	S	S	-

	PURCHASER ASSESSMENT ACTIVITIES <i>(continued)</i>	CAS			
		A	B	C	D
4.5.7	Monitor cropping or non-destructive examination of untested ends (IOGP S-735, 10.15.13)	W	S	S	-
4.5.8	Monitor prove-up and dispositioning of imperfections (IOGP S-735, 8.13.1, 10.15.16, 10.15.18)	W	S	S	-
4.5.9	Monitor weighing, length measurement, marking body and coating (IOGP S-735, 8.11.2, A.2, A.4.5, P.2.1, Table C.46, Table E.46)	S	S	-	-
4.6	Assembly				
4.6.1	Monitor of marking — coupling (IOGP S-735, 11.1.11, A.2)	S	S	-	-
4.6.2	Review of thread and/or storage compound type and application (IOGP S-735, 9.14, 1.1.2)	S	S	-	-
4.6.3	Monitor making-up couplings — first article (includes end drift and protector installation) (IOGP S-735, 8.14, 12.2)	W	W	S	-
4.6.4	Review making-up couplings, end drift and protector installation — subsequent production (IOGP S-735, 8.14, 12.2)	W	S	S	-
5	Release of product or service				
5.1	Monitor handling, packaging and preservation (IOGP S-735, 12.1)	W	S	S	-
5.2	Release product (includes certificates, tally list, packing list, conformity) (IOGP S-735, 13.2)	H	H	W	-
Key H: Hold point W: Witness point R: Review S: Surveillance					

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