



# DRILL PIPE

INTERNATIONAL, LLC

License #: 5DP-0026  
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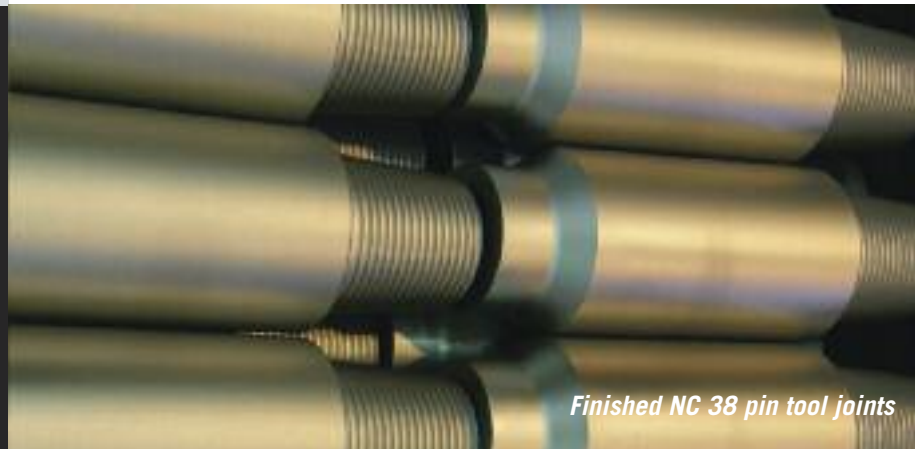
**Drill Pipe International, LLC** formed with the goal of producing a competitively priced, premium quality oil field drill pipe. Quality is guaranteed through every step in the manufacturing process. From arrival to departure, there is no substitute for quality. With over 50 years of experience in the down hole drilling tool industry, Drill Pipe International, LLC strives to meet your every need and create an enjoyable purchasing experience.

## Tubes

When green tubes enter our facility they are inspected for any defects to ensure quality. Drill pipe is available in outside diameter sizes of 2<sup>3</sup>/<sub>8</sub>" to 6<sup>5</sup>/<sub>8</sub>", in range II and III lengths. (See Chart 1)

## Tool Joints

All tool joints are manufactured using state of the art CNC machines, guaranteeing accuracy and quality. Drill Pipe International, LLC thoroughly inspects all bars and forgings from which tool joints will be manufactured. Tool joints are produced using 4137M material and heat treated to API standards before threading. All threading is done in accordance with API spec 7. Hardbanding is available upon customer request. Drill Pipe International has the capacity to meet the needs of any customer.



*Finished NC 38 pin tool joints*



*4" FH box tool joints with hardbanding*



*CNC machine threading pin tool joint*

**CHART 1**

<i>Drill Pipe Size*</i>	<i>Nominal Weight lbs/ft</i>	<i>API Nominal Wall (New)</i>
2 <sup>7</sup> / <sub>8</sub> "	10.40	0.362
3 <sup>1</sup> / <sub>2</sub> "	13.30	0.368
	15.50	0.449
4"	14.00	0.330
	15.70	0.380
4 <sup>1</sup> / <sub>2</sub> "	16.60	0.337
	20.00	0.430
	22.82	0.500
5"	19.50	0.362
	25.60	0.500
5 <sup>1</sup> / <sub>2</sub> "	21.90	0.361
	24.70	0.415

*\*Additional sizes available upon request*



*4"OD range II drill pipe being internally upset*



*Heat treating furnace*



*Upset to grade tube and tool joint being inertia welded*



*Inertia weld pre heating prior to quenching*



*Drill pipe being quenched*

## **Upsetting**

Once green tubes enter our facility they are upset in accordance with API specifications. Drill Pipe International, LLC offers an external upset (EU), internal upset (IU), and an internal-external upset (IEU). Our group 1 and 3 upsets utilize a geometry which minimizes stress concentration. Tool joint assembly is designed to improve the transition from the cross section of the pipe to the tool joint weld neck. Our internal (IU) and internal-external (IEU) upsets are designed to have a longer internal upset taper (miu) than API 5D requires. After upsetting, QC supervisors inspect the pipe to guarantee upset dimensions and quality.

## **Heat Treating**

By maintaining its own heat treating furnace, Drill Pipe International, LLC controls all areas within the manufacturing process. Drill Pipe International, LLC offers all API 5D grades and also offers pipe suitable for sour services. All heat treatment is done in accordance with API and Drill Pipe International, LLC specifications. All mechanical testing is done to API 5D requirements.

## **Non Destructive Testing**

Full length tubes are inspected using ultrasonic inspection, while the upset ends are tested with a wet magnetic particle inspection. This inspection is carried out after the upsets are machined to the required dimensions. These tests guarantee that the drill pipe is free from defects.

## **Inertia Welding**

Tool joints and drill pipe are bonded utilizing inertia welding. These machines guarantee the most consistent and reliable weld available. All inner and outer weld rings are removed from the pipe, and then the weld zone of the drill pipe is quenched and tempered to achieve its proper physicals as required by API Spec 7 SR1. After the welding process is complete, each piece of drill pipe is examined in a wet magnetic particle testing unit and ultrasonic tested by independent third party level 2 inspectors. Welds are also inspected for correct hardness (less than 37 H.R.C) and thickness. At this stage one last quality check is utilized to verify any visual defects. Once drill pipe passes these tests it is stamped to API requirements and ready for finishing.



*Finished drill pipe ready for shipping*

## **Finishing**

Drill pipe is finished to API and customer specifications. Before external coating, zinc based thread compound is applied to all drill pipe threads. After the zinc compound is applied each drill pipe is fitted with standard thread protectors. Upon request drill pipe can be internally plastic coated. Once coated, drill pipe is ready for shipment.

Next time you are in the market for drill pipe, contact a Drill Pipe International, LLC representative for a competitive quote.



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