

PRODUCT: AUTOMATED CATWALKS

DATE: April 30, 2009

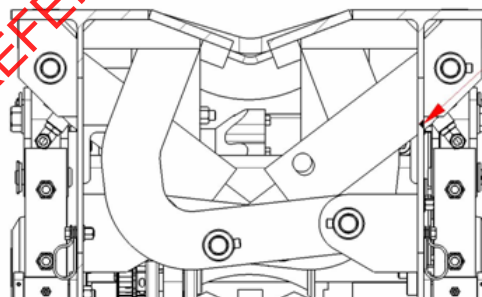
SUBJECT: Cracks in Carrier Sides (reference bulletin # CATWALK 10)

SERIAL NUMBERS: PM3000-1001 to PM3000-1160 / 300158 to 300177

DISCUSSION: There has been incidents of cracking in the Carrier W-Beam web which has been occurring at the kicker cylinder mount location nearest to the lightening holes. This seems to be happening mostly when handling tubulars in excess of 6000 lbs.

RECOMMENDATION: **If cracks are present:**

1. Remove paint a minimum of 1" in all directions around the crack on both sides of the Carrier beam web.
2. Perform a ¼" V-prep along the crack on the outside of the Carrier beam web. Ensure the weld prep extends ¼" beyond the end of the crack.
3. Perform MPI to ensure extent of V-prep is beyond crack.
4. Cautiously apply preheat until average temperature reaches 200 degrees F – **do not heat until red.**
5. Using an E7018 Low Hydrogen rod, perform a ¼" backing weld on the side opposite the V-prep.
6. Using an E7018 Low Hydrogen rod, weld the V-groove fully.
7. Allow to air cool; do not quench.
8. Perform additional MPI to ensure no cracks exist.



V-GROOVE WELD PREP
THIS SIDE

Once crack repair is complete / Or if cracks are not present:

-
- Install stiffener package AY50649 according to the instructions on the drawings.
- Ensure all bare metal is painted.

INFORMATION:

For further information contact:

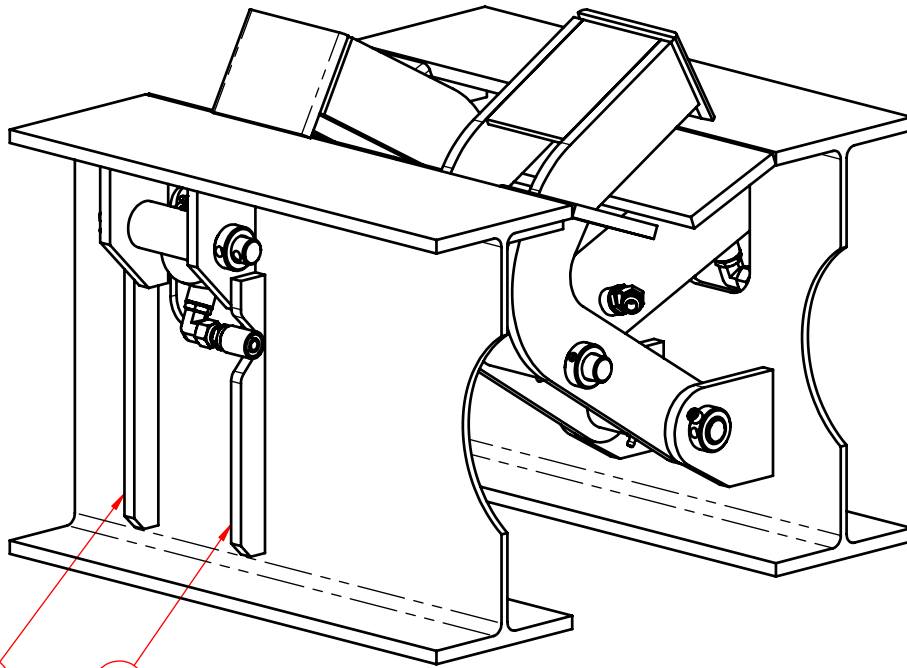
For a complete list of all bulletins go to www.canrig.com

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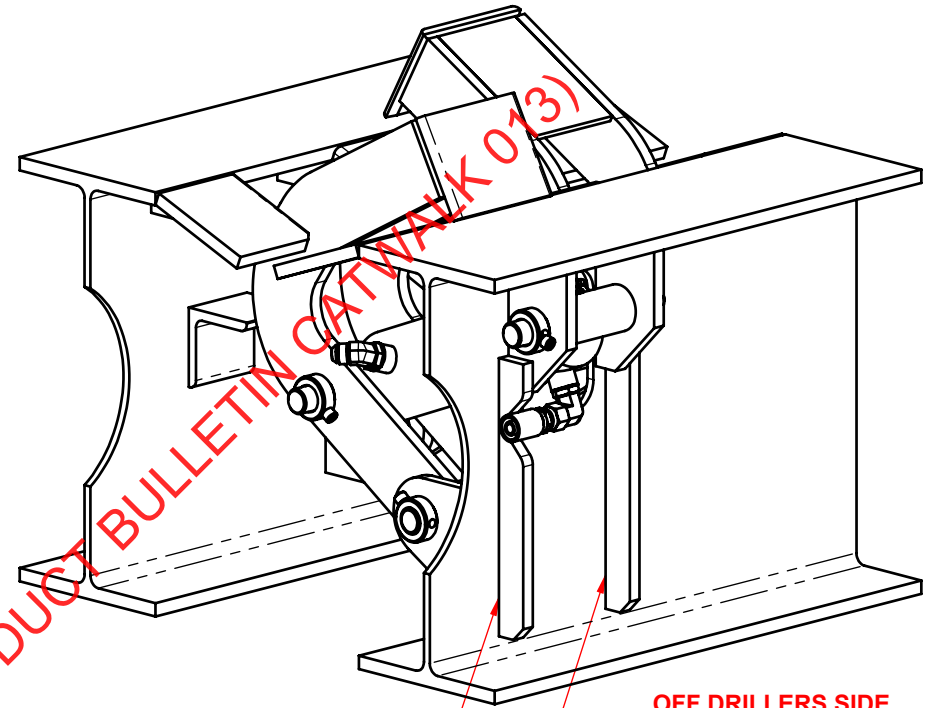
(OBSOLETE PLEASE REFER TO PRODUCT BULLETIN CATWALK 013)



2

1

DRILLERS SIDE



1

2

OFF DRILLERS SIDE

(OBSOLETE PLEASE REFER TO PRODUCT BULLETIN CATWALK 073)

NOTE:

- 1) THIS ILLUSTRATION IS A SIMPLIFIED REPRESENTATION OF THE PC3000 CARRIER AT THE MIDDLE KICKER CYLINDER LOCATIONS.
- 2) THE STIFFENING BARS SHOWN (ITEMS 1 & 2) ARE TO BE WELDED IN PLACE AS SHOWN AT ALL 6 KICKER CYLINDER LOCATIONS.

REV.	DESCRIPTION	DATE
A	RFM	15-Apr-2009

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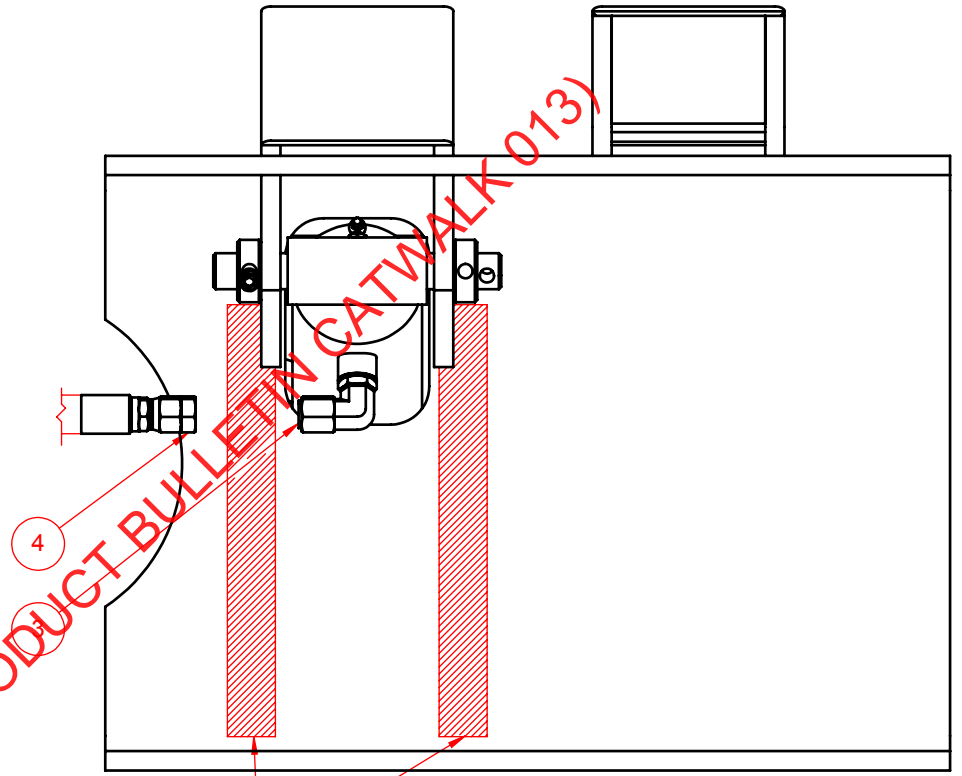
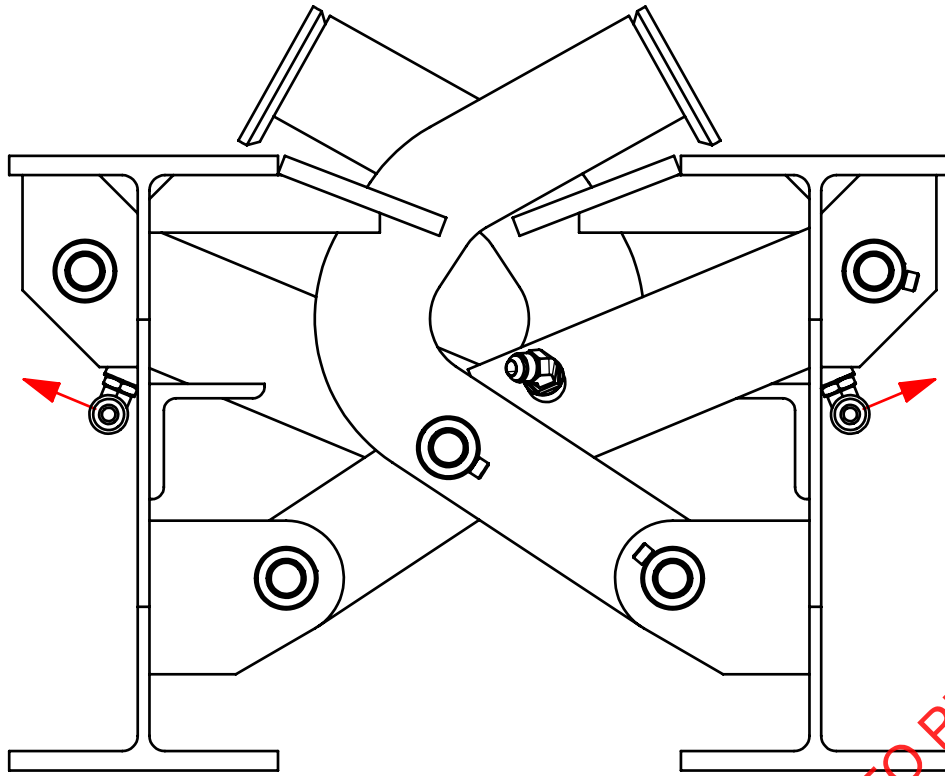


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TITLE:

PC3000 CARRIER WEB STIFFENING RETRO-FIT

DRAWN BY:	DATE:	DRAWING NO:	SHEET:	REV:
TLK	15-Apr-2009	AY50649	1 OF 3	A



(OBSOLETE PLEASE REFER TO PRODUCT BULLETIN CATWALK 013)

PRE-WELD PREPARATION

- 1) REMOVE HOSE FITTING FROM CYLINDER
- 2) ROTATE CYLINDER FITTING SLIGHTLY (5°) IN THE DIRECTION DISPLAYED BY THE ARROWS.
- 3) PLUG THE HOSE FITTING WITH ITEM 4 AND CAP THE CYLINDER FITTING WITH ITEM 3 PRIOR TO ANY GRINDING.
- 4) GRIND OFF EXISTING PAINT AND EXISTING WELD (WHERE NECESSARY) AS ILLUSTRATED.

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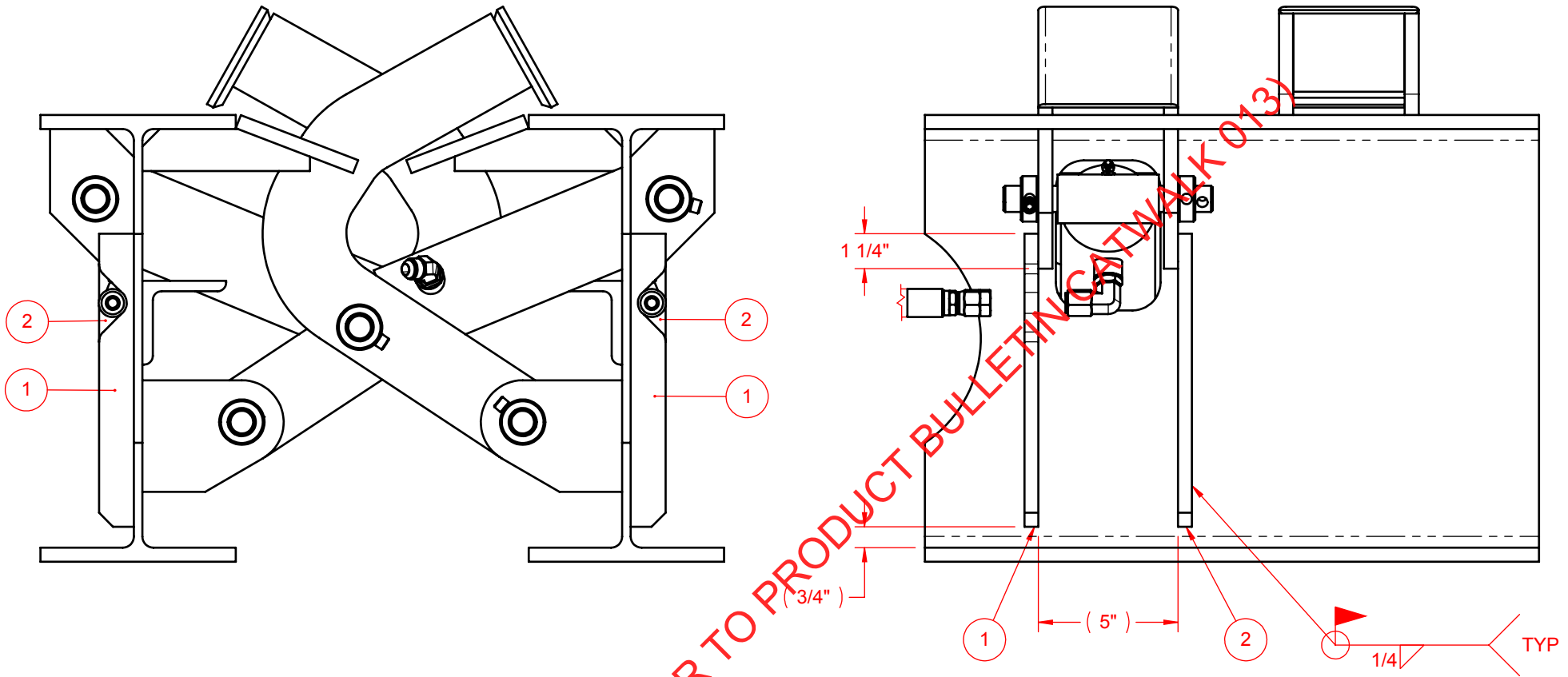
DRAWN BY:
TLK

DATE:
15-Apr-2009

DRAWING NO:
AY50649

SHEET:
2 OF 3

REV:
A



(OBSOLETE PLEASE REFER TO PRODUCT BULLETIN CFWALK 0137)

NOTE:

- 1) ALL BARE METAL MUST BE PAINTED UPON COMPLETION OF WELDING.
- 2) KEEP HOSE PLUG AND CYLINDER FITTING CAP IN PLACE UNTIL WELDING AND PAINTING HAS BEEN COMPLETED.

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