


<b>Safety Bulletin</b>			 <b>TESCO</b> <sup>®</sup> Tesco Corporation 5616 – 80th Avenue SE Calgary, Alberta, Canada T2C 4N5 Tel: 1-877-TESCO-77 (North America) Tel: 1 (713) 359-7195 (AMSS 24-hour support) Tel: 1 (713) 359-7295 (International) Email: bulletins@tescocorp.com www.tescocorp.com www.tescoparts.com
<b>No: SB094</b>	<b>Rev: 0</b>	<b>Date: March 19, 2015</b>	
<b>Dropped Casing Incident Due to Incorrectly Making Up Casing Connection</b>			
<input type="checkbox"/> <b>Internal Use Only</b>	<input checked="" type="checkbox"/> <b>External Use</b>	<input type="checkbox"/> <b>Mandatory</b>	<input checked="" type="checkbox"/> <b>Recommended</b>

**NOTE:** All numbers in parentheses are TESCO part numbers unless otherwise noted.

**BACKGROUND INFORMATION:**

It has come to Tesco’s attention that a customer was incorrectly making up a 13-3/8" buttress connection on a casing string. For reasons unknown at this time, the customer could not properly make-up a connection between a newly installed casing joint and the casing string as per the API specifications relating to casing connections or by manufacturer recommended practices for proprietary connections. There were still four threads (four full turns) remaining before the coupling meets the base of the engraved triangle on the casing (see Figure 1 and Figure 2). Instead of replacing this casing joint, as was suggested by Tesco personnel, the company man and tool pusher decided to weld the coupling to the casing. When the string was run again, this particular joint failed, resulting in a “drop-casing” incident. There were no reported injuries to rig personnel.



**Figure 1: Failed connection on casing joint**

Further examination into the incident identified two major issues:

1. The coupling was not made up to the base of the triangle mark, therefore not all of the threads were engaged. When the casing string, which weighs approximately 267,000 lbs. (4900 ft. of 54.5 ppf. casing), was hanging off from the coupling, the engaged threads were “stripped out”, causing the casing string to drop.
2. Since the threads were not engaged properly, the coupling was welded by the customer to the casing to increase the strength of the connection. However, the added weld was not sufficient enough to make up for the lost strength of the threads that were not engaged. Welding on the casing without a proper weld procedure and a properly controlled environment is not an acceptable industry practice. The weld would have adversely affected the metallurgical properties of the casing material in the heat-affected zone. The higher the grade of the casing, the worse this effect would be.

Copyright © 2015 Tesco Corporation. TESCO® is a registered trademark in the United States and Canada. Casing Drive System™, CDS™, Multiple Control Line Running System™ and MCLRS™ are trademarks in the United States. All information in this document is proprietary and confidential, and shall remain the sole property of Tesco Corporation. This document shall not be used, copied, or reproduced in whole or in part, nor shall be revealed in any manner to outside parties without prior written permission from Tesco Corporation.



**Figure 2: Casing threads that were not engaged and threads that were stripped out**

**AFFECTED PRODUCTS:**

All casing running jobs using the Tesco Casing Drive Systems or conventional methods.

**ACTION REQUIRED:**

If a scenario arises similar to the one described above, all employees are empowered with full authority to stop any job they believe is being performed with compromising safety. This not only helps ensure employee well-being, but it also establishes field-wide responsibility for the safety of all operations.

The Stop Work Authority (SWA) gives every employee both the authority and the responsibility to stop work when unsafe acts or conditions are observed. When the Stop Work Authority is instituted, work must be stopped immediately. The proper management personnel must then be notified and the unsafe conditions must be corrected before work can resume.

Under NO circumstances shall repercussions be directed towards personnel who use our Stop Work Authority.

Contact your immediate supervisor or Tesco if there is any uncertainty whether or not a practice or procedure is unacceptable.

Version	Date (D/M/Y)	ECN	Description of changes
Rev 0	03/19/2015	157-0065	Initial release of document

Copyright © 2015 Tesco Corporation. TESCO® is a registered trademark in the United States and Canada. Casing Drive System™, CDS™, Multiple Control Line Running System™ and MCLRS™ are trademarks in the United States. All information in this document is proprietary and confidential, and shall remain the sole property of Tesco Corporation. This document shall not be used, copied, or reproduced in whole or in part, nor shall be revealed in any manner to outside parties without prior written permission from Tesco Corporation.