

S135 Drill Pipe Finished-Joint Structure and Review Path

API 5DP high-strength drill pipe assembly review for finished-joint release



01

S135 Grade

135 ksi minimum yield strength

02

Finished Joint

Pipe body, upset ends and welded tool joints

03

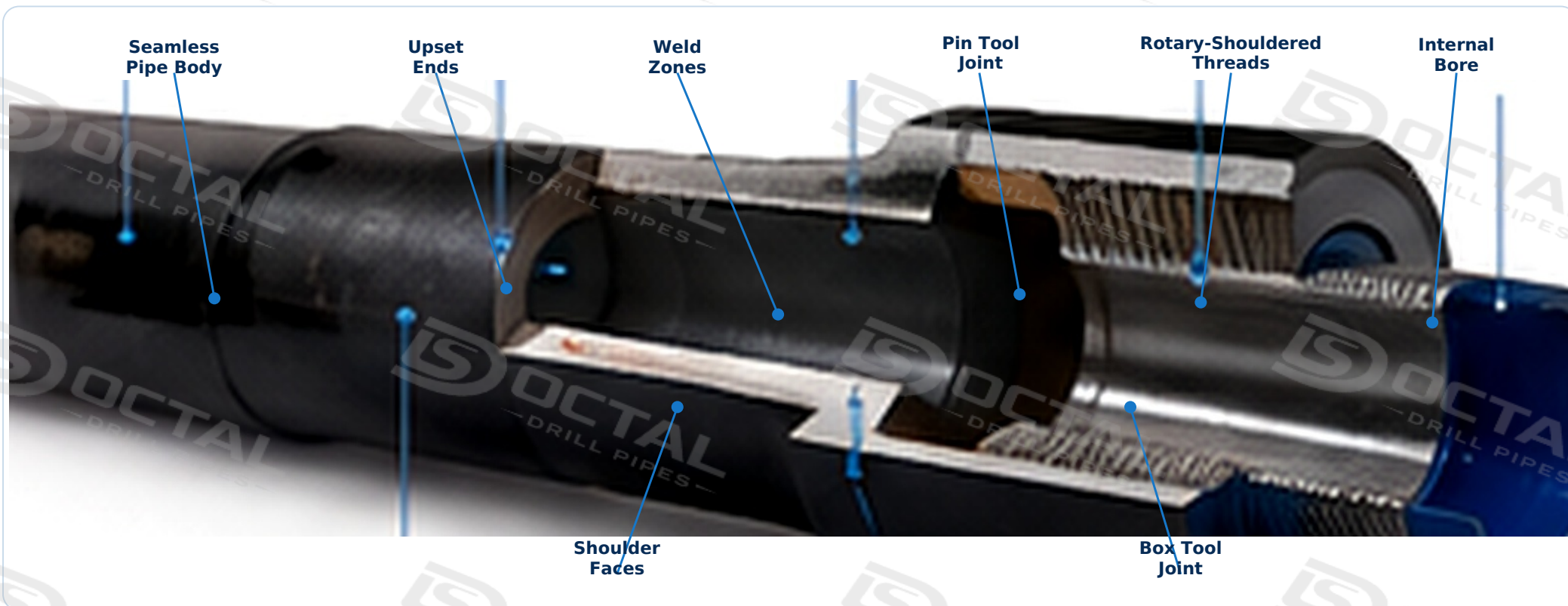
Review Focus

Threads, shoulders, bore and weld zones

04

Release Evidence

Marking, NDT, dimensional and thread records



Structure logic

A finished S135 drill pipe joint is reviewed as one drilling-string assembly: pipe body, upset transitions, friction-welded tool joints, rotary-shouldered threads, shoulder faces and internal bore must remain compatible.

03 FINISHED-JOINT AREA INSPECTION TABLE

FINISHED-JOINT AREA	MAIN FUNCTION	SHIPMENT CHECK FOCUS
Seamless Pipe Body	Carries tensile load and torsion through the drill string	Grade marking, OD, wall thickness, straightness and surface condition
Upset Ends	Strengthen the transition between pipe body and tool joints	Upset profile, transition smoothness and visible defect check
Weld Zones	Join the pipe body with pin and box tool joints	Weld alignment, flash removal, hardness review and required NDT records
Pin and Box Tool Joints	Provide make-and-break connection ends for repeated rig operation	Tool-joint OD/ID, bore condition, shoulder condition and surface protection
Rotary-Shouldered Threads	Transfer torque through threaded connections and shoulders	Connection identity, thread condition, shoulder cleanliness and protector fitting



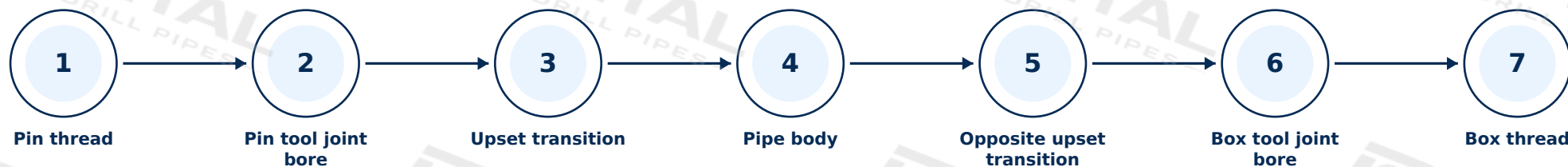
Release interpretation

Tables carry the inspection data. Images support geometry recognition and do not replace physical inspection records.

04 PRACTICAL REVIEW PATH



Review sequence



FINAL DRIFT LOGIC

Key internal-clearance rule

The smallest local bore controls drift passage and internal tool clearance. The review path must include both threads, tool-joint bores, upset transitions and the full pipe body before shipment release.