

Drill Pipe Manufacturer Qualification: API Scope, Specification and Factory Evidence

1/5

1) CERTIFICATION EVIDENCE



API Status

API 5DP certified manufacturer (current)



Facility Identity

Registered facility name and address



Licensed Scope

API 5DP Monogram license for:

- Drill Pipe Body
- Tool Joint (not Finished Drill Pipe Assembly)

2) MANUFACTURING EVIDENCE



Equipment

Suitable and maintained equipment for each manufacturing step



Process Records

Production traveler, process parameters, operator records



Heat-Treatment Records

Furnace charts, time/temperature, quench records



Welding Records

Welding parameters, upset & burn-off data, equipment ID



Machining Capability

Threading, profiling, gauging capability per API 5DP

3) RELEASE EVIDENCE



Dimensional Inspection

OD, ID, wall, length, tool joint dimensions



NDT

UT / MT / PT as applicable per API 5DP / ITP



Mechanical Tests

Per API 5DP / applicable PO



Gauging

Go/No-Go thread & connection gauges



Marking

Permanent marking per API 5DP / PO



Traceability

Heat No., lot, records linked to final product

1 API Scope



Confirm manufacturer API 5DP scope for Drill Pipe Body and Tool Joint only.

2 Complete Specification



Review complete specification, material grade, dimensions, connections, testing.

3 Pipe Body Capability



Verify pipe body manufacturing capability, materials, and dimensional control.

4 Upsetting & Heat Treatment



Upset pipe body ends and perform heat treatment per specification.

5 Tool Joint Capability



Verify tool joint forging, heat treatment, and material control.

6 Friction Welding



Friction weld pipe body to tool joint; control parameters and record results.

7 Connection Machining



Machine and profile connections, verify thread form and dimensions.

FINISHED DRILL PIPE ASSEMBLY

(Verified by Manufacturing, Welding, Inspection and Traceability Evidence)



Finished Drill Pipe Assembly is **NOT** an API 5DP Monogram licensing category. It is verified through this qualification route.

Note: Manufacturer qualification must be based on the exact ordered configuration (size, grade, wall, connection type, etc.) per API 5DP / applicable PO / ITP.

8 Inspection



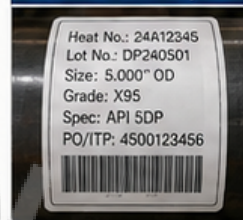
Perform NDT and dimensional inspections per API 5DP / ITP.

10 Delivery Capacity



Verify delivery readiness, packaging, storage, and shipping capability.

9 Traceability



Link heat, lot, and production records to each drill pipe assembly.

! Manufacturer qualification must match the exact ordered drill pipe configuration, not only the company name or certificate.

API 5DP Scope and Facility Verification

FACILITY AND SCOPE VERIFICATION

Verify manufacturer in the current API Composite List (5DP Monogram) for the ordered product.

API Composite List				
Organization	Monograms	Products	Locations	
Monogram	Product	Scope/Grade	Status	Effective Date
5DP	Drill Pipe	E-75, X-95, G-105, S-135	Active	2024-05-01
CURRENT - ACTIVE				



Company

Legal company name matches API Certificate records.



Manufacturing Facility

Registered facility location matches API records.



Certification Status

API 5DP Monogram status is current and active.



Product Scope

Drill Pipe (Body) scope is listed for the ordered size range.



Grade Capability

Ordered grade(s) are within the listed grade capability.



PSL Capability (where applicable)

PSL 1 / PSL 2 capability is verified when specified.

Capability must be verified against current API records and must cover the exact ordered product requirement.

DRILL PIPE BODY

Material Identity
(API 5DP
Approved
Steel Grades)

Dimensional
Control
(OD, Wall
Thickness,
Length,
Straightness)

Heat Treatment
(Normalizing
or Q&T
as applicable)

End Upset
Quality
(OD, ID, Wall
Transitions)

Surface &
NDE Readiness
(Visual / UT
as required)

Licensed API 5DP Scope:
Drill Pipe (Body)

TOOL JOINT

Material Identity
(Forging Quality
& Melt Traceability)

Dimensional
Control
(Thread Form,
OD, Length,
Shoulders)

Heat Treatment
(Q&T to Grade
Requirement)

Machining
Capability
(Thread,
Shoulders,
Wrench Flats)

NDE Readiness
(UT/MPI as
required)

Licensed API 5DP Scope:
Tool Joint

API 5DP Monogram licenses cover Drill Pipe (Body) and Tool Joint only.
Finished Drill Pipe Assembly (welded tube + tool joint) is not a separate
licensed product scope.

FINISHED DRILL PIPE CAPABILITY

Finished drill pipe assembly capability is demonstrated by manufacturing, welding, inspection and traceability evidence.
This is NOT a separate current API 5DP Monogram license.

1 PIPE BODY + TOOL JOINT



Matched body
and tool joint
for assembly per
API 5DP.

2 FRICTION WELDING



Friction weld
per qualified
procedure.

3 WELD-ZONE HEAT TREATMENT



Post-weld heat
treatment of
weld zone per
API 5DP.

4 INSPECTION & VERIFICATION



NDT & dimensional
inspection of
weld and ends.
UT of weld zone
per API 5DP.

5 FINAL RELEASE



Traceability
package and
release per
API 5DP /
applicable PO / ITP.



Finished Drill Pipe Assembly capability is verified
through this manufacturing route and supporting
evidence, not by a separate API 5DP "Drill Pipe
Assembly" license category.



Manufacturer qualification must match the ordered size, grade, upset, connection and inspection requirement
per API 5DP / applicable PO / ITP.

Verify current facility status against the API Composite List.

Complete Drill Pipe Specification Before Supplier Evaluation

ORDERED 5 IN. DRILL PIPE ASSEMBLY – EXAMPLE CONFIGURATION



ORDER-DEFINITION FIELDS (TO BE CONFIRMED ON PO)

	API 5DP (Mandatory)	-----
	PSL if specified (PSL 1 / PSL 2)	-----
	Additional NDT per PO / ITP (Requirements)	-----
	Connection requirements (NC type, Thread form, Gauging, etc.)	-----

All requirements depend on the exact ordered configuration and are verified per API 5DP / applicable PO / ITP.

PO CONFIGURATION CHECK

INCOMPLETE
(Not Acceptable for Qualification)

Example PO Description

5 in. S135



Why Incomplete?

- Missing critical specification data
- Cannot determine capability requirements
- Cannot verify compliance per API 5DP
- Inadequate for technical evaluation



COMPLETE
(Acceptable for Qualification)

Example PO Description

5 in. x 19.50 lb/ft, S135, IEU, NC50, R2



Why Complete?

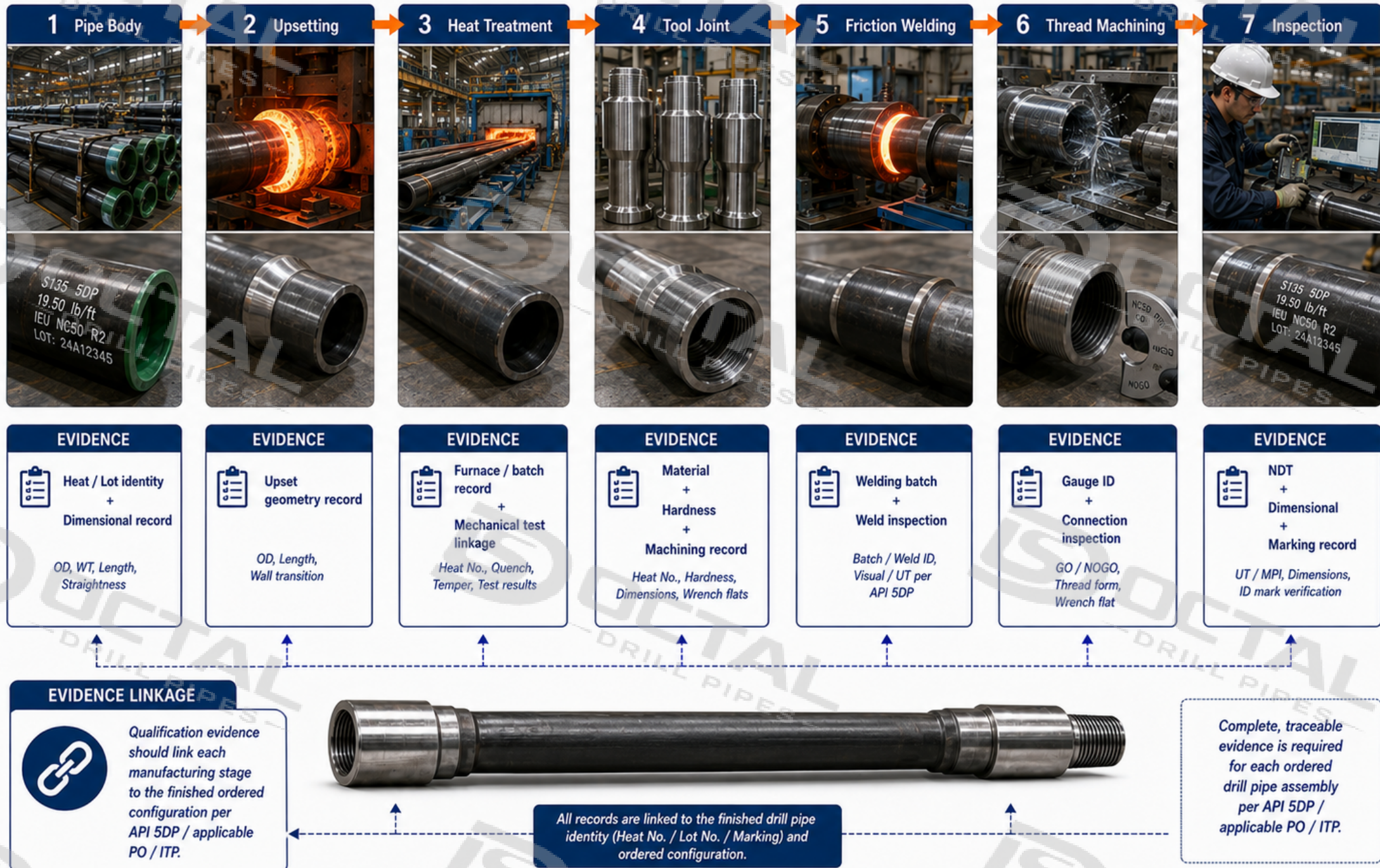
- All critical parameters defined
- Capability requirements are clear
- Enables verification per API 5DP
- Adequate for technical evaluation

Each parameter (size, weight, grade, upset, connection, thread form, NDE, coating, etc.) affects the required manufacturing capability and inspection plan per API 5DP / PO / ITP.



Manufacturer capability can only be evaluated against a complete ordered configuration.

Factory Evidence by Manufacturing Stage



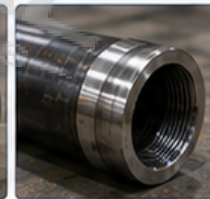
Manufacturer Release Decision

1 Correct API / facility scope



- ✓ API 5DP (latest edition) and Q1 registered facility
- ✓ Scope and product category cover ordered configuration
- ✓ Applicable PO / ITP requirements are within scope

2 Complete product specification



- ✓ Size, weight, grade, upset type, connection type, thread form
- ✓ All dimensions, tolerances and material per API 5DP
- ✓ Surface protection, marking and packaging defined

3 Manufacturing capability demonstrated



- ✓ Process route qualified: heat treat, machining, threading, upset
- ✓ Equipment, controls, and gauges suitable and calibrated
- ✓ In-process controls and operator qualifications in place

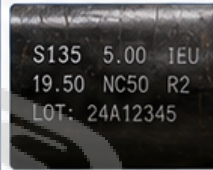


4 Inspection records acceptable



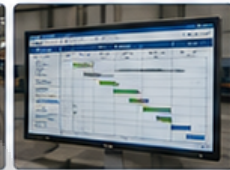
- ✓ All inspections and NDT performed per API 5DP / ITP
- ✓ Acceptance criteria met: OD, WT, length, straightness, UT / MPI / Dimensional, threads, coating, marking
- ✓ Gauge and NDT equipment calibrated and in date

5 Full joint traceability



- ✓ Heat / Lot No., pipe body, tool joints and NDE records linked
- ✓ Marking on pipe and tool joints matches documentation
- ✓ Records retained and retrievable for minimum 10 years

6 Production schedule supports actual order



- ✓ Capacity, lead time and delivery per ordered quantity
- ✓ Raw material availability and heat program confirmed
- ✓ Packaging, preservation and shipment plan in place

QUALIFIED CONFIGURATION (Release Against Actual Ordered Configuration)



- ✓ Meets every requirement of API 5DP and applicable PO / ITP
- ✓ All parameters verified for this order
- ✓ Factory evidence supports release
- ✓ Configuration approved for shipment

VS.



QUALIFIED COMPANY IN GENERAL (Not Sufficient for Specific Order Release)

- ✗ General capability does not guarantee this configuration meets requirements
- ✗ Changes in size, grade, upset, connection, process or inspection invalidate release
- ✗ Order must be qualified and verified separately



Qualification applies to the ordered size, grade, upset, connection and inspection requirement.

All acceptance is per API 5DP / applicable PO / ITP.

Release only when all six approval gates are satisfied. Manufacturer capability is evaluated and accepted only for the actual ordered configuration.