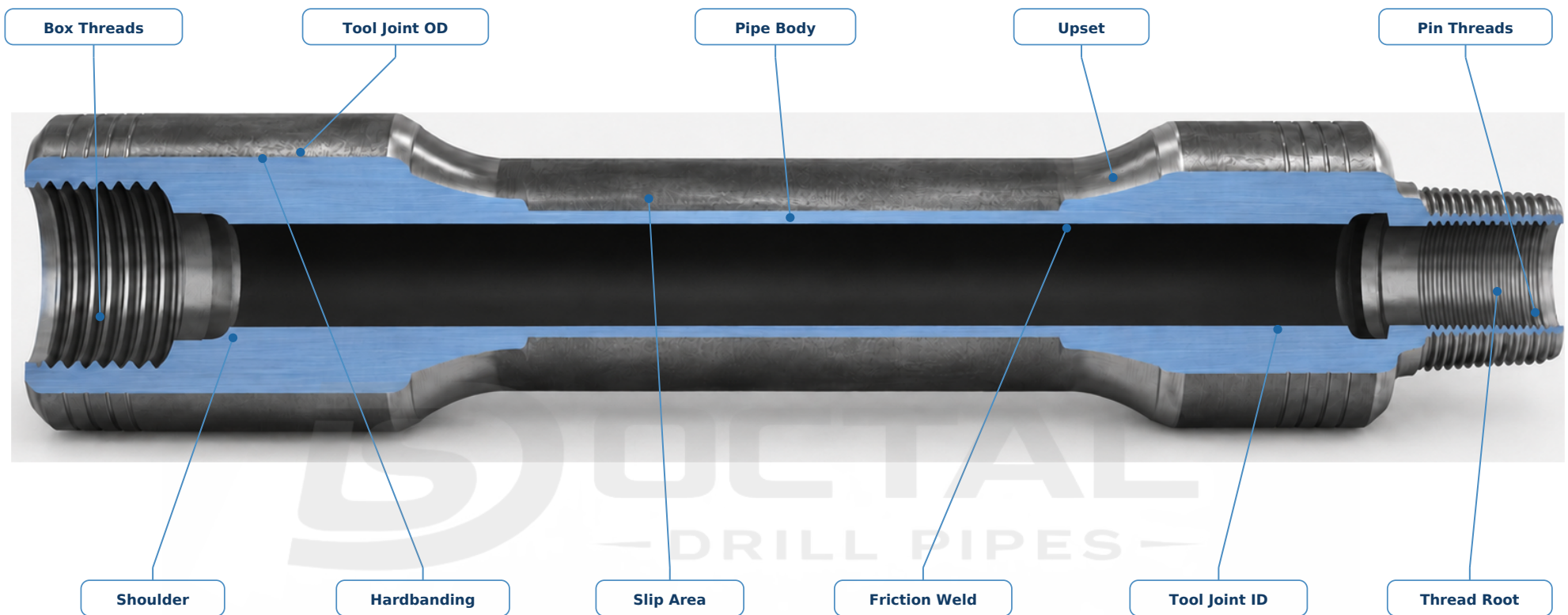


Inspection Zones

A joint is accepted by the condition of every critical zone, not by body wall thickness alone.



Zone	Main concern
Pipe body	Wall loss, pits, and longitudinal or transverse indications
Slip area	Mechanical damage, slip cuts, and fatigue initiation
Friction weld	Weld-zone discontinuities and local fatigue indications
Tool joint	OD/ID wear, hardbanding condition, and remaining section
Threads and shoulder	Cracks, galling, washout, profile damage, and seal-face damage

Inspection Method Matrix

Inspection sensitivity, calibration, and acceptance criteria remain method- and program-specific.

Inspection method	Typical area	Main purpose	Required record
Visual inspection	Full joint	Surface damage, corrosion, and obvious deformation	Joint ID, inspected area, and finding
EMI	Pipe body	Longitudinal and transverse indications	Calibration reference and signal record
UT thickness	Pipe body	Remaining-wall measurement	Minimum measured thickness and location
WFMT / MPI	Tool joints and end areas	Surface-breaking fatigue cracks	Method, magnetization area, and result
Dimensional inspection	Body and tool joint	OD, ID, wall, and finished length	Actual measured values and instrument ID
Thread inspection	Pin, box, and shoulder	Profile damage, galling, and shoulder condition	Connection, finding, and disposition
Straightness inspection	Full joint	Bow and permanent deformation	Measured deviation and reference method
Hardbanding inspection	Tool joint	Wear, cracking, placement, and remaining condition	Location, dimensions, and condition

Acceptance boundary

Do not assign one universal flaw-detection sensitivity to all methods. Calibration, coverage, evaluation thresholds, and acceptance must follow the applicable API RP 7G-2 requirements, purchase specification, or approved operator inspection program.



1 Establish coverage

Match the inspection method and area to the defect mechanism being evaluated.

2 Verify evidence

Record joint identity, calibration reference, inspector qualification, and actual measured values.

3 Apply the acceptance basis

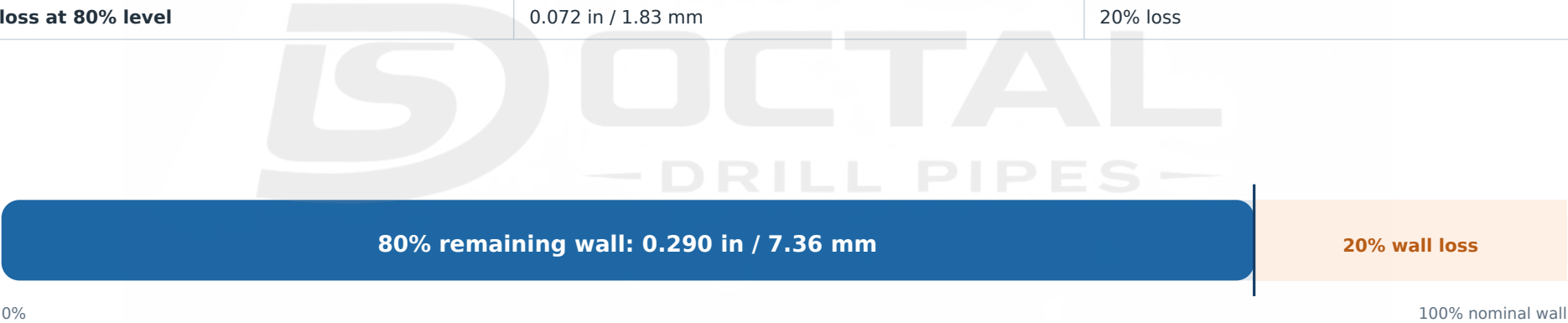
Compare each finding with the applicable criteria before assigning a disposition.

Remaining Wall and Classification Example

Body-wall classification is one input to acceptance; it does not approve the entire joint.

The example below uses a nominal 0.362 in wall. Values are rounded for reporting; the minimum actual measurement location should remain traceable to the individual joint.

Condition	Remaining wall	Relative level
Nominal wall	0.362 in / 9.19 mm	100%
80% of nominal wall	0.290 in / 7.36 mm	80%
Wall loss at 80% level	0.072 in / 1.83 mm	20% loss



Classification reference

An 80% remaining wall is a common Premium Class reference, not an automatic service approval.

Local damage still controls

Pits, cracks, slip cuts, and local indications may reject a joint that meets the general wall percentage.

Connections remain separate

Tool-joint OD/ID, shoulder, thread roots, and friction weld require their own acceptance checks.

Other classes require verification

Class 2 and other classification values must be taken from the applicable edition and project program.

Acceptance Decision Matrix

A finding is converted into a disposition only after the applicable acceptance basis is identified.

ACCEPT
Meets the applicable acceptance criteria

HOLD
Engineering or records review required

REPAIR + RE-INSPECT
Repair alone does not restore acceptance

REJECT
Not acceptable for the intended classification

Finding	Possible disposition
General wall loss	Classify using the measured minimum wall and the applicable classification basis.
Local corrosion pit	Evaluate depth, shape, location, surrounding wall, and the stated acceptance basis.
Tool-joint OD loss	Compare actual OD with the connection-specific minimum and remaining-section requirement.
Thread damage	Repair, recut, hold, or reject according to remaining dimensions and approved procedure.
Shoulder washout	Repair only when seal-face and connection geometry can be restored within limits; re-inspect after repair.
Weld indication	Evaluate by the applicable NDT method, calibration, coverage, and acceptance criteria.
Fatigue crack	Reject, or process only under a specifically approved repair and requalification procedure.
Missing traceability	Hold until joint identity, inspection status, and supporting records are resolved.

Decision rule Never record a repaired joint as accepted until the repair scope, remaining dimensions, required re-inspection, and final disposition have been documented.

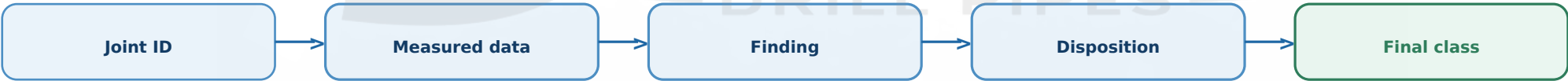


Required Traceability

A formal inspection report must connect measurements and findings to one identifiable joint.

The report should contain enough information for a purchaser, operator, or later inspector to reproduce the acceptance decision without relying on an unrecorded verbal explanation.

1 Unique joint identification	8 Inspection date
2 Pipe size, nominal weight, and grade	9 Inspector qualification
3 Connection	10 Findings and disposition
4 Actual body wall	11 Repair or recut status
5 Tool-joint OD and ID	12 Final classification
6 Inspection methods	13 Link to heat or manufacturing records where available
7 Calibration references	



Minimum technical basis

Finished-pipe identity and dimensions: API Spec 5DP and purchase specification. Used drill stem inspection and classification: applicable API RP 7G-2 edition. Final service acceptance: operator program, intended well conditions, connection-specific limits, and documented engineering disposition.