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Technology Motion Knowledge

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- 6 Employee Engagement Events
- 7 Koppel Plant Turns Up Heat
- 12 TMK UP™ CWB
Premium Thread Connections Tested



**Igor
Pyshmintsev:
A Matter of
Science**



**All
About
Science**

TABLE OF CONTENTS



- 3 News**
- 6 Employee Engagement Events**
- 7 Koppel Plant Turns Up Heat**
- 8 A Matter of Science**
- 12 TMK UP™ CWB Premium Thread Connections Tested**
- 14 Casing Pipe with Welded Connectors**



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»» TMK IPSCO CO-SPONSORS THE ANNUAL U.S. RUSSIA BUSINESS COUNCIL MEETING

The annual meeting of the U.S. Russia Business Council (USRBC), co-sponsored by TMK IPSCO, provided businesses and entrepreneurs access to the latest information on market conditions, complicated geopolitical relationships, and regulatory developments with leading U.S. and Russian investors and policy experts. The meeting included presentations by former U.S. Secretary of State Henry Kissinger, U.S. Ambassador to the Russian Federation John F. Tefft and Sergey I. Kislyak, Russian Federation Ambassador to the United States. The meeting ended with a panel discussion entitled "The Bilateral Business Environment – Industry Leader Perspectives" in which TMK IPSCO Chairman Piotr Galitzine participated. ■

»» TMK POSTS NINE-MONTH RESULTS

- During the first nine months of 2014, TMK shipped a total of 3,159 thousand tonnes of steel pipe, down 1.3% year-on-year. In 3Q 2014, shipments grew by 6.7% quarter-on-quarter.
- Seamless pipe shipments for the nine-month period grew by 2.3% year-on-year to 1,848 thousand tonnes. Shipments in 3Q 2014 increased by 3.3% quarter-on-quarter to 621 thousand tonnes.
- Welded pipe shipments for the nine-month period dropped by 5.9% year-on-year to 1,311 thousand tonnes due to weaker demand for large diameter pipe (LDP) and industrial pipe. In 3Q 2014, welded pipe shipments were up 11.4% quarter-on-quarter, reaching 482 thousand tonnes.
- Shipments of OCTG pipe, TMK's core product, were up 5.5% year-on-year, reaching 1,417 thousand tonnes in the nine months of 2014. In 3Q 2014, the shipments of this product dropped by 7.1% quarter-on-quarter to 446 thousand tonnes due to a seasonal reduction in oil and gas drilling in Russia.
- Shipments of premium connections for the nine months of 2014 increased to 649 thousand joints, up 13.3% year-on-year. In 3Q 2014, shipments of premium products were up 20.7% quarter-on-quarter, reaching 245 thousand joints.

AMERICAN DIVISION

- TMK's American division, TMK IPSCO, increased its shipments by 6.1% year-on-year, reaching a total of 900 thousand tonnes of tubular products. In 3Q 2014, the division's shipments were up 4.9% quarter-on-quarter to 308 thousand tonnes.
- Seamless pipe shipments for the nine-month period were 404 thousand tonnes, up 19.7%. In 3Q 2014, 148 thousand tonnes were shipped, which is an increase of 17.9% quarter-on-quarter.
- Shipments of seamless OCTG pipe for the nine-month period were up 19.9% to 313 thousand tonnes, driven by the ongoing rise in drilling activity and development of unconventional hydrocarbon reserves in North America. In 3Q 2014, shipments of this pipe were up 16.7% quarter-on-quarter, reaching 115 thousand tonnes.
- Shipments of seamless line pipe were down 33.9% to 26 thousand tonnes for the nine-month period. In 3Q 2014, the division shipped 8 thousand tonnes of this pipe, up 2.5% quarter-on-quarter. These changes in demand are typically inherent in the field development cycle.
- The division's shipments of seamless industrial pipe increased by 73.8% to 66 thousand tonnes in the nine months of 2014, driven by a rise in demand from regional and industrial markets. In 3Q 2014, 25 thousand tonnes of seamless industrial pipe were shipped, up 30.7% quarter-on-quarter. ■

»» TMK MASTER BLACK BELTS



In September 2014 the final session of Six Sigma Master Black Belt training was held in Houston. During the five-week training program, designed and taught by Six Sigma Academy, participants qualified as Lean Six Sigma Master Belt Specialists.

Part of the Continuous Improvement (CI) program, developed and executed by the TMK Quality Department in 2014, 12 Specialists from various TMK Group facilities completed training held in Hanover, Germany, Taganrog and Volzhskiy, Russia, and Houston, Texas. Newly trained Master Black Belts not only received theoretical knowledge and expertise in becoming mentors and trainers for future CI specialists, but also gained practical experience while visiting facilities that implemented CI initiatives, such as Volkswagen and Toyota.

By investing in training of Master Black Belts, TMK sets a high bar for continuous improvement and effectively running manufacturing and business processes to achieve the next level of competitive excellence.

Congratulations to the 12 new TMK Master Black Belts. Special thanks to interpreter Elena Ovchinnikova and David Hampton, Six Sigma Academy Instructor.

New Master Black Belts (left to right):

Sergey Polozov, TMK Sinarskiy
Vladimir Sazonov, TMK IPSCO
Roman Timoshenko, TMK Tagmet
Anna Sukhman, TMK Neftegazservice
Evgeniy Agrinskiy, TMK Volzhskiy
Elena Ovchinnikova, Interpreter
David Hampton, Six Sigma Academy, Instructor
Margarita Slezkina, TMK Kaztrubprom
Michael Brown, TMK IPSCO
Evgeniya Zakharova, TMK Severskiy
Pavel Kozlovskiy, TMK Sinarskiy
Elena Avdeeva, TMK Moscow, Quality Department
Sergey Struchkov, TMK Volzhskiy
Sergey Verkhoglyad, TMK Tagmet ■



»» TRADE MINISTER VISITS VOLZHISKY

During his visit to Volgograd region in September, Russian Industry and Trade Minister Denis Manturov, along with Andrey Bocharov, then acting Governor of Volgograd region, visited the Volzhskiy pipe plant. The guests were shown the company's technology potential and production capacities, among them the mills where large-diameter pipes used to build trunk pipelines for public utilities, the thermal power industry, the nuclear power sector and agriculture are manufactured. Large-diameter pipe from the Volzhskiy plant was used to build the onshore part of the South Stream pipeline project, and the company intends to bid on orders for the Power of Siberia gas pipeline. ■

»» TESTS COMPLETED

TMK's R&D center in Houston has completed ISO 13679:2002 CAL IV conformance testing of the TMK UP PF premium thread connection with GreenWell lubricant-free coating. The tests were overseen by an independent third party, Texas International Engineering Consultants, and confirmed that the product can be used in challenging onshore and offshore drilling and hydrocarbon production projects.

TMK put the GreenWell lubricant-free coating technology into service last year. This polymer coating is an advanced alternative to standard thread lubricants and, in addition to providing the connections with high sealing reliability, it also meets environmental standards and offers safer operating conditions. A pilot batch of pipe with the innovative coating—Tagmet casing pipe with TMK UP PF connections—has been shipped to Rosneft for use at its Vankor field. ■

»» FOCUS ON ENERGY EFFICIENCY



Volzhsky pipe plant has installed a new Thermax hot water chiller. This is the company's second such machine, purchased as part of the company's program of investment in the use of energy-efficient technologies.

The advanced chillers are designed to cool the plant's primary equipment automation systems, the office and amenity building of the electrometallurgy complex, and the control panels of its production shops. Full automation of the new chillers will allow cooling water temperatures to be kept at optimum level no matter how weather conditions fluctuate, thereby improving the efficiency of the primary process equipment. ■

»» HIGH AWARD



At the end of July in the Kremlin's Catherine Hall, Russian President Vladimir Putin presented some national awards to cultural figures, cosmonauts, businessmen, members of the armed forces, and other professionals. "Our country stands in need of your constructive work," the President told the award recipients. "And what is more, its successful development is largely predicated on that work." Among the award recipients was Dmitry Pumpyanskiy, Chairman of the TMK Board of Directors. The Russian President presented him with a medal for Services to the Fatherland, Tier IV, for his "great contribution to the socioeconomic development of the Russian Federation." ■



»» SHARING EXPERIENCE

Regular meetings of TMK engineering and production quality managers, as well as managers from TMK's Russian, European, Middle East, and American divisions, and TMK Trade House are underway. Among the goals of the semi-annual meetings: evaluating current levels of production development, briefings on implementation of technologies and output of high margin products, assessing the efficiency of the current quality system, sales, and interaction with users on matters of quality, analyzing customer satisfaction, and discussing other emerging issues. ■



»» RELIABLE SUPPLIERS

A witness audit at Volzhsky pipe plant has confirmed that its quality management system (QMS) and pipe products conform to the latest version of API Spec Q1 9th Edition and ISO 9001:2008, resulting in API reaffirming the Volzhsky plant's entitlement to use the API monogram on its API Spec 5L and 5CT products.

Volzhsky pipe plant and Seversky pipe plant also successfully underwent a recertification audit for conformance of their QMS to Gazprom Company Standard 9001-2012, receiving high marks for production standards, personnel competence and improvements in their work to eliminate non-conformances. ■



EMPLOYEE ENGAGEMENT EVENTS

TMK IPSCO Develops New Communication Tool

TMK IPSCO recently implemented Employee Engagement Events, or E3s, to increase the cascading of information within the organization and to further engage employees throughout the company. E3s are conducted via videoconference, which allows employees to see live presentations from the TMK IPSCO leadership team and ask questions in real-time.

"I feel empowered to receive information first-hand from key decision-makers within the organization," said Genay Gibson, Houston ULTRA HR manager. "It was also exciting to see co-workers from other plants and know that they were part of this event."

TMK IPSCO hosted the first meeting in August from its research and development center in Houston, followed by an event in October at the Koppel, Pennsylvania plant. Company-wide meetings will be hosted at other facilities in the future.

Each meeting has had well over 500 participants. Chief Human Resources Officer Peter Smith believes E3s will encourage employee participation at a greater level.

"We wanted to improve communications across all levels of the company. We want everyone to understand the direction of the company and to know about key developments and other news that will affect them," said Smith.

The first E3 centered on TMK IPSCO's long-term strategies, including "to the right and up" and the "balanced campus approach." Employees from around the company submitted nearly

30 questions beforehand, from which management built the entire presentation. Management also addressed plant-specific questions.

Presenters included TMK IPSCO Chairman Piotr Galitzine, President and CEO Dave Mitch, Chief Manufacturing Officer Dave Diederich, Chief Commercial Officer Scott Barnes and Smith.

Galitzine outlined TMK's strategy, while Mitch focused on safety and first-half performance. Barnes updated employees on the results of the anti-dumping trade case, and Diederich discussed plant operations. Smith opened the event with a warm welcome and coordinated the closing question-and-answer segment.

During the second E3, Galitzine recapped the plant visits by TMK Chairman Dmitry Pumpyanskiy; Mitch discussed third quarter performance and fourth quarter goals; Chief Quality Officer Pras Adhikari discussed our "zero is achievable" stance on quality, and Chief Information Officer Sam Smolak updated employees on the status of implementing a new enterprise resources planning system. Smith again facilitated the question-and-answer segment.

"The questions alert us to what's top of mind for our employees and helps management propose solutions that will be beneficial to our employees in the long-run," said Smith.

E3s are recorded and later shared with employees who are unable to attend. The third Employee Engagement Event will be held in January 2015. ■



KOPPEL PLANT TURNS UP HEAT

Continuous Improvements in Production

Koppel's quench and temper department (Q&T), more commonly known as the heat treating facility, has made a series of upgrades over the past three years which have resulted in a 30% production increase, cost savings and higher quality.

"It's a story of continuous improvement," says assistant plant manager John Dluhos.

Untreated "green" pipe arrives from the company's seamless plant in nearby Ambridge, Pa., and is placed in a 30 million BTU/hour, natural gas-powered furnace and heated to 1600 degrees F. The furnace operated at 12 tons/hour in 2012; an upgrade to the burner system increased furnace throughput to 13 tons/hour, which meant pipe spent less time in the furnace. To take full advantage of the time savings, the 50-foot wide pipe moving system was "supercharged" to move the pipe even more quickly, increasing throughput to 15 tons/hour. In November of 2013 the facility produced a record 18.6 tons/hour, and in August of this year a new record of 19.6 tons/hour was set.

"Throughput wasn't the only thing that we improved," said Bruce Webb, Q&T Operations Engineer. "We replaced our cold bar straightener with a hot straightener, which corrects end hook and ovality to ¼ API standard. This hot straightening puts less stress on the pipe, resulting in better quality for the customer," Webb explained. "It also lets us produce a better surface quality."

The precision of this machine is important, particularly for pipe that will receive TMK UP ULTRA™ threads at the company's Brookfield, Ohio plant.

In 2012 an automated, state-of-the-art weigh/measure/stencil system was added, which improved the quality of the finished pipe with consistent, easy-to-read dot-matrix printing and color banding. The stencil identifies the pipe's mill order, heat number and data that tracks the customer's order number.

"This machine allows us to stencil each piece in the same place with the same quality every time and eliminates a number of time-consuming manual steps," Webb said.

Last year an ultra violet coating line was added for casing pipe. The system heats the pipe surface with infrared light, applies a volatile organic compound (VOC)-free coating, then fuses it to the pipe in seconds with ultra violet light. The result is a clean, rust resistant surface that holds the

stencil well. Previously this was an outsourced process, which required additional transport of the pipe at additional expense.

New to the facility this year is a 20,000 psi hydrotester. Previously hydrotesting was performed on two portable units by an outside vendor; the new system saves both time and expense.

The hydrotester fills each pipe with water, pressurizes it to 20,000

psi, releases the pressure and drains the pipe, all in less than 30 seconds.

The plant also added a non-destructive testing Tuboscope unit, which checks the wall thickness and looks for transverse and longitudinal defects through electromagnetic inspection. Throughput of the unit has increased from 178 pieces per shift in 2012 to 250 per shift in 2013. In July of this year, the station reached a record of 270 per shift.

"We have increased our heat treating capability by more than 30%, while reducing cost and increasing quality at the same time. Continuous improvement has become a way of life for us here," Dluhos said. ■



A MATTER OF SCIENCE

The role that science and innovative solutions play in the area of oil and gas production has never been more significant. The need to develop a new generation of hydrocarbon reserves demands the mobilization of all available resources as well as new approaches.

In this interview, Igor Pyshmintsev, Director General of the Russian Research Institute for the Tube and Pipe Industries (RosNITI), addresses the role of science in pipe manufacturing and in service to the customer.

Mr. Pyshmintsev, how have the requirements for pipe products changed?

A growing demand for hydrocarbons, coupled with falling production volumes at significantly depleted fields, means oil and gas companies are more actively conducting exploration and development drilling under new conditions. This requires the use of new technologies such as directional and horizontal drilling. A consequence of increasing the depth and complexity of wells is greater loads on equipment. And, more corrosive operating environments—high temperature, high concentrations of hydrogen sulfide, CO₂, and chlorine ions, and an acidic, damp environment—are becoming serious tests for pipe and other downhole equipment. Developing this new type of well infrastructure requires innovative pipe products with new properties.

Just how competitive are Russian pipe manufacturers in offering products to the oil and gas industry that are suitable for today's conditions?

Having invested significant resources in the tube and pipe industries, Russia is now able to meet the domestic market demand for OCTG pipe products. Previously, the gas industry was dependent on imported products.

New steelmaking facilities are meeting the demand for high-quality stock material for seamless pipe, and newly redesigned pipe-rolling

plants are in operation. Systems capable of performing hot-rolling of high-precision pipe at high output were recently added at the Seversky Pipe Plant and TAGMET. Systematic development of finishing capacities and process control ensures that pipe reliability and useful characteristics are at high levels.

Does TMK offer products that are not found anywhere else in the world?

Advancements made by Russian metallurgists and pipe manufacturers have been applied to the strongest pipeline in the world, the Bovanenkovo-Ukhta pipeline, where large-diameter pipe of grade K65 (X80) was used. This is a first from





the perspective of the gas pipeline profile and the pipe characteristics. In Eastern Siberia there are many areas with tectonic activity which must be factored into pipe manufacturing. We have viable solutions to address such potential danger, some of which have already been tested in production and adopted by the end-users.

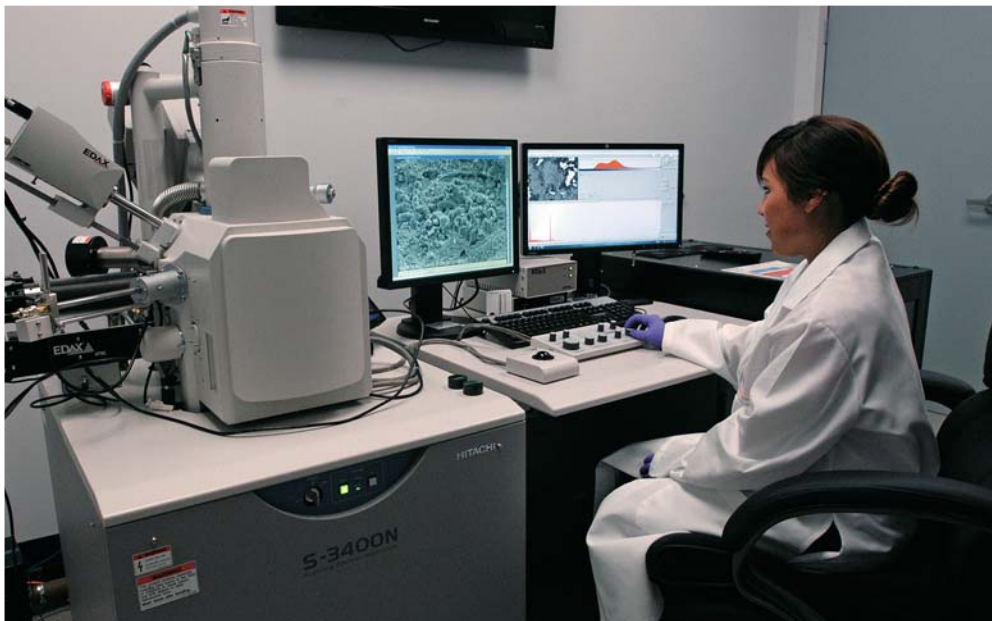
So it seems that the role of science in manufacturing has become even more significant?

Yes, the role of science and, most definitely, serving the customer's needs. It is extremely important to be able to respond flexibly to the rapidly changing requirements for pipe products and to factor those changes into manufacturing and scientific research plans. Customer demands define what products we develop and then put into production.

How do you rate the scientific capabilities of TMK?

TMK is one of a few pipe-manufacturing companies that has its own full-fledged research facilities. Production activity within the company is carried out in lockstep with the scientific research and experimental development work. Our Russian Research Institute for the Tube and Pipe Industries (RosNITI) focuses on scientific studies and the creation, development and introduction of high-tech products. It is the only scientific center in Russia that specializes in pipe manufacturing technology and testing. Our second research and development center, in Houston, is accredited as an ISO-certified, premium thread-testing laboratory. We are also building an R&D center in the tech city of Skolkovo (near Moscow, Russia).

“Developing this new type of well infrastructure **requires innovative pipe products...**”



Why did we need another research and development center?

The TMK R&D center in Skolkovo will be a consolidating site where scientific research and experimental development work come together. Its specialty will be in creating, realizing and implementing innovations focused on long-term prospects. Right now at RosNITI and in Houston we are resolving, with great success, immediate and near-term challenges. Because of TMK's growth, the company now has a new planning horizon where forecasting and developing the market for the science specific to this industry is important. This will be the focus of this new center.

At what stage is the project now?

The agreement between TMK and Skolkovo to create the center was signed in April 2013, after which a TMK Scientific and Technical Center engineering company was formed. The center will house laboratories for the investigation of materials, design engineering, process development, and as an area for the physical modeling and testing of new types of connections. We will test engineering prototypes, fabricate preproduction prototypes and check product readiness for certification testing. The new center will also be directly engaged in upgrading the skills of employees and in training in new technical proficiencies.

When will the center begin operation?

In 2016, but already RosNITI staff are working on new ideas that will be developed at the new center. This is how we will ensure the portability of technologies and experience, and create a link between the institute and the R&D center.

What will be the most important focus areas in the activities of the new center?

The center will create and develop expertise for the company in areas that are new to us: solutions for oil and gas services, such as how to develop fields, which technologies to use, equipment and type of pipe. The tube and pipe industries must be developed based on how to meet the needs in oilfield services.

Are the most urgently needed solutions for offshore development and deep water drilling?

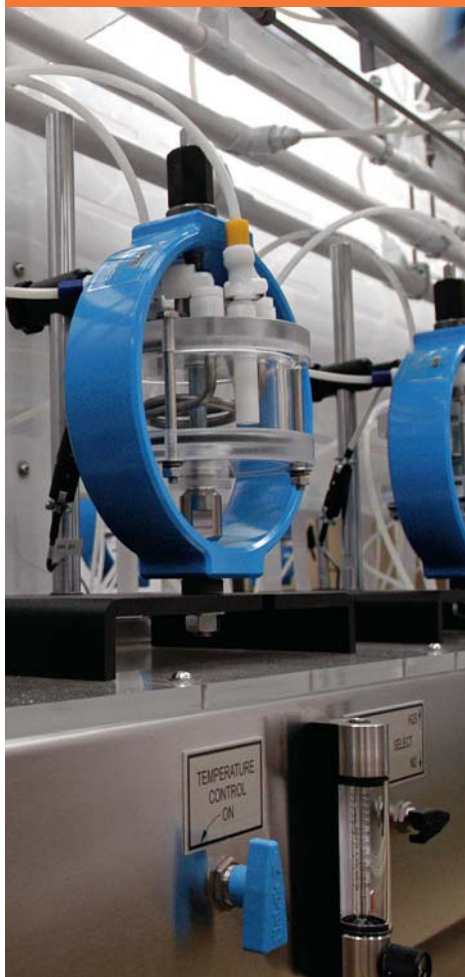
The prospects for hydrocarbon production are extremely important. It is a field in which domestic tube and pipe industries do not have much experience yet because there wasn't the need. Today, investments in new plant manufacturing capacity are enabling pipe manufacturers to meet the growing demand. So far, foreign contractors are the ones working offshore and in deep water projects, but

the entry of other companies in this market is inevitable.

The requirements for pipe products used in offshore operations will also be examined at the center. We will acquire machinery that is not available in Russia for testing offshore production pipe.

Does TMK already have some product offerings for offshore production?

TMK has created a coating for the threaded connection most in demand in offshore operations. We improved the traditional threaded connection assembled using conventional dope by coating the threaded connection with a composite that protects it from corrosion and simultaneously functions as a lubricant. It is impenetrable and cannot be washed away by water, and it is anti-frictional. A connection that uses this coating can be made up, broken down, and reused the same way as if a liquid lubricant were present. The GreenWell lubricant-free coating is our technology. It is environmentally friendly and safe. Customers are already using this new product.



Pipe made from alternative composite materials has already been used in the public utility sector and in construction. Could this be an alternative to metal?

Composite pipe are finding their niche in the energy sector. RosNITI, together with a number of oil production companies, is working to evaluate their potential. But no one is saying yet that pipe made from composite materials has significant application in the oil and gas industry. Steel remains the primary material for many reasons. Steel has unique properties and is ductile. Products made from steel are capable of withstanding substantial loads and are indispensable as an engineering structural material. A unique virtue of steel is that it can be reused many times without losing its properties, giving it an indefinite life cycle.

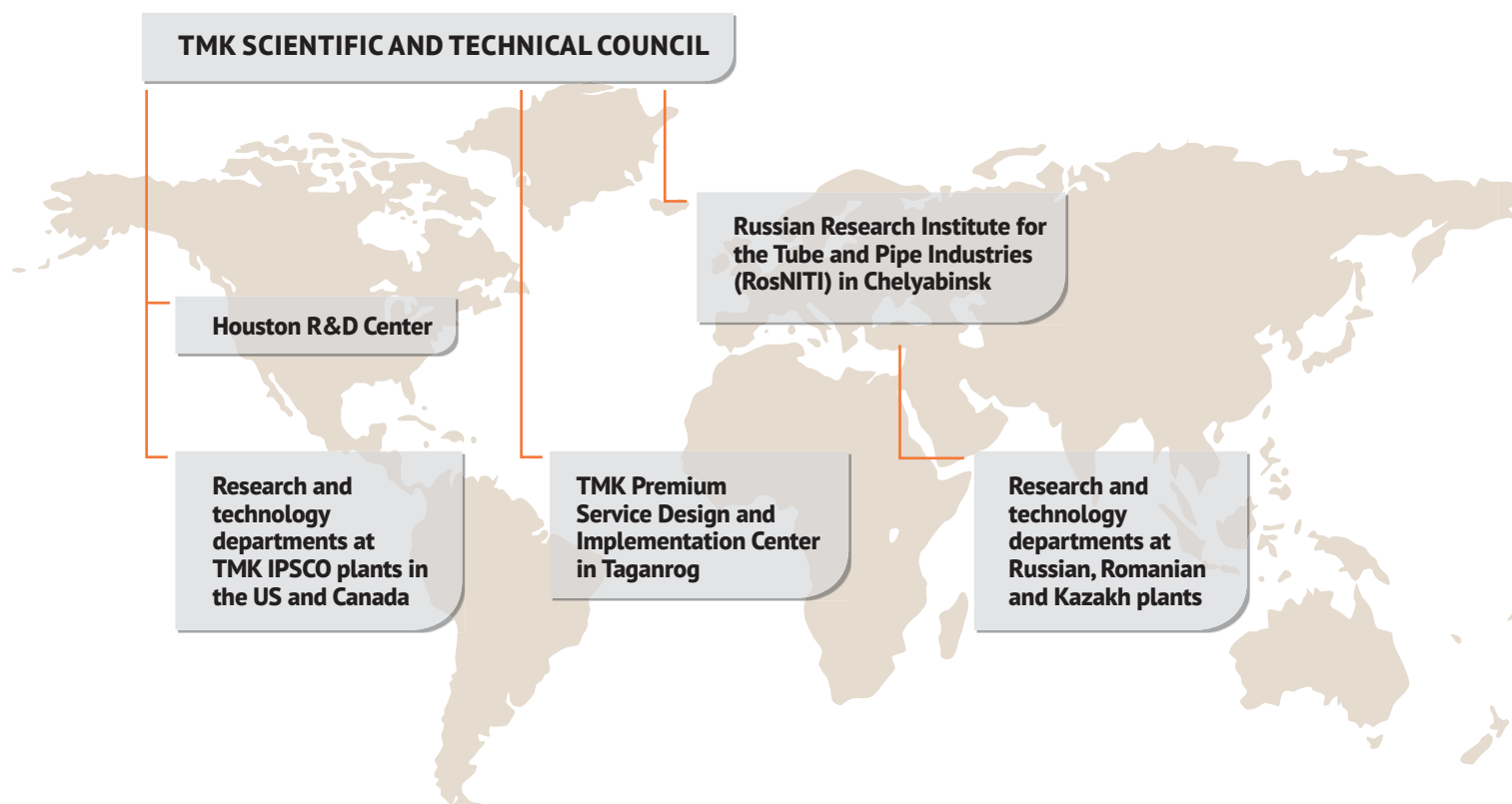
Though steel is the most advanced material available to us now, we are actively using polymers to improve the characteristics of steel pipe and to make various kinds of coatings, including anti-corrosion coatings. This affords us the opportunity to delve deeper into studying the advantages of composite materials, to improve our own steel pipe products and to bring to market new and effective solutions.

Are we looking at solutions for the Arctic?

That is a large and serious undertaking, one on which we began work long ago and continue to work on actively. TMK has developed and successfully field-tested Arctic-grade pipe products, including those made from 13Cr and superchrome martensitic class steel. Pipe made from these grades of steel has the necessary cold-resistant characteristics and has demonstrated good results in terms of resistance to corrosive environments.

All the developments we are now working on, and those that we will tackle at the Skolkovo center, suggest we have a broad field for developing the company. TMK currently has all the necessary expertise to develop the most complex products, from the selection of materials to well completion services and solutions. We are developing new materials, improving the pipe manufacturing process, and introducing new types of products, all of which help us be more successful for our customers. ■

»» R&D STRUCTURE AT TMK



TMK UP™ CWB PREMIUM THREAD CONNECTIONS TESTED

FOR DRILLING WITH CASING

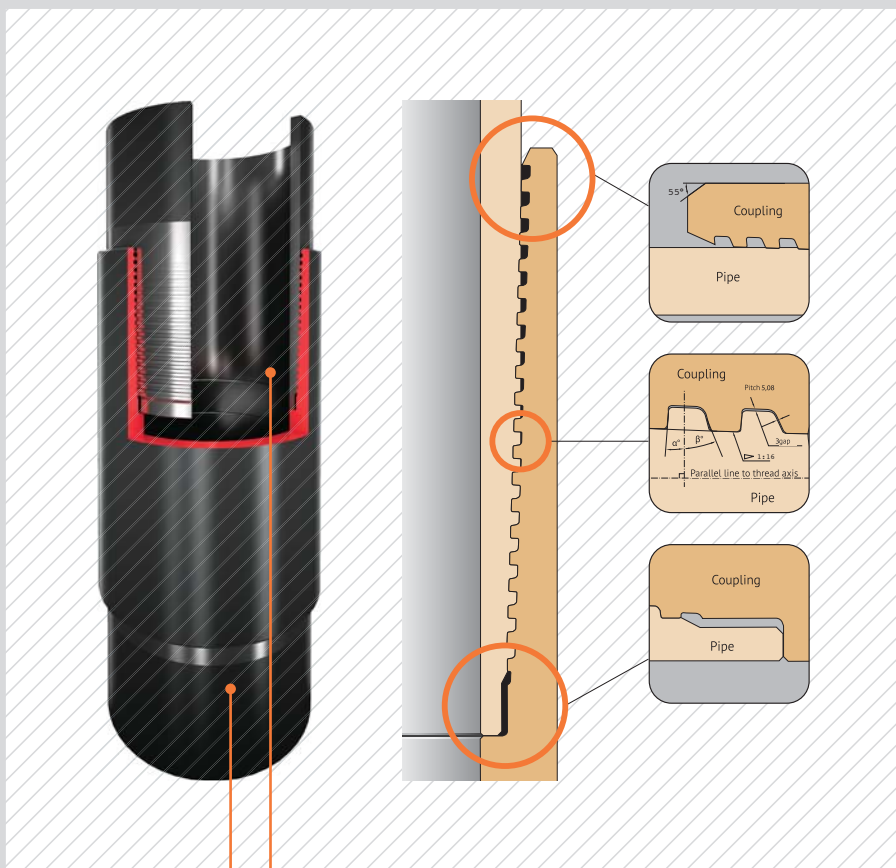
TMK has launched production of a new type of premium connection: high performance, multipurpose TMK UP CWB connections. They will be used for casing oil and gas wells and will allow casing while drilling to be performed by rotating the casing as it is being run. The new product was developed in 2014 and put into production by TMK Premium Service.

The TMK UP CWB connection was successfully leak tested under combined load at VNIITneft OCTG Development and Operation Research Institute.

The TMK UP CWB connection is an improved modification of the buttress connections, which are widely used by Russian oil and gas production companies. It has two distinct features.

First, an additional stop face, which is designed to precisely achieve the desired makeup tightness. This will improve the sealing reliability of the connection and enhance its operational performance. And second, the TMK UP CWB is compatible with other types of connections—OTTM (box), OTTG (box), and buttress—and can be used as a sub. ■





SIZES: 114.30 – 339.72 MM

TRAPEZOIDAL TAPERED BUTTRESS THREAD

- Smooth runout onto pipe body
- Large free stab length of pipe into box
- Positive load flank angle
- Thread provides strong seal

RESULT:

- The ultimate load of the connection is equal to the ultimate tensile load of the pipe body
- Ease of makeup
- Exceptional abrasion strength
- Enhanced torque resistance
- Internal flush joint
- Multiple makeup tolerance with no loss of properties

ADDITIONAL STOP FACE

- Easy makeup to full tightness
- Desired makeup tightness precisely achieved
- Enhanced joint sealing reliability
- Enhanced performance

RESULT:

- Stable performance of connection
- No fluid flow disturbance inside the pipe
- Closes the internal circuit of the pipe

CASING PIPES WITH WELDED CONNECTORS

FOR DEEP-WATER WELLS

The Volzhsky pipe plant has launched the commercial production of large-diameter casing pipes with welded connectors. They are designed to be used as surface casing for deep-water wells. Surface casing is run in the near-surface part of the well to reinforce the drilled-out hole and lessen the risk of rock collapse. Welded connectors make the casing joints reliable.

The launch of this type of product will help implement the government strategy of producing substitutes for imported tubulars. Until now, Russia did not produce large-diameter casing pipe with welded connectors.



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