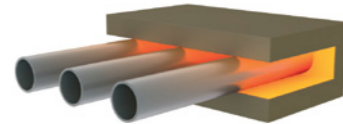


Drill Pipe Flowchart

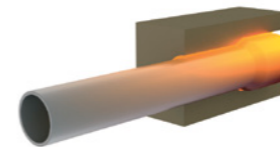
1. Inspection table



2. Heating



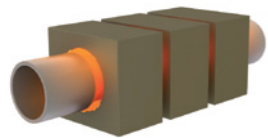
3. Upsetting



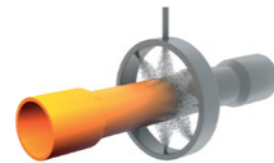
4. Magnetic particle inspection (MPI) of pipe end



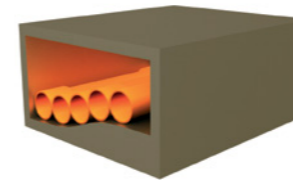
5. Heat treatment of pipe



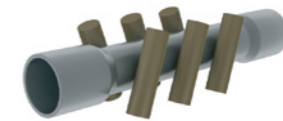
6. Quenching. Water cooling



7. Tempering



8. Straightening



9. Ultrasonic NDT of pipe and MPI of pipe end



10. Pipe ready for welding



- a. Tool-joint delivery from Manufacturer
 b. Tool-joint depreservation
 c. Incoming inspection of tool-joint



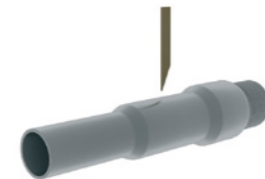
11. Friction welding of tool-joint to drill pipe



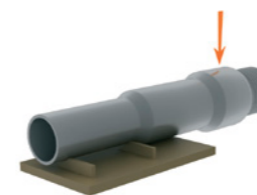
12. Heating and heat treatment of weld area



13. Finish machining of weld area



14. Seam test for bending



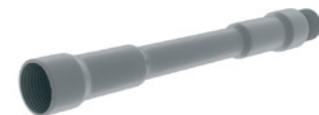
15. Flaw detecting of weld point



16. Inspection, weighing, marking, stamping



17. Finished drillpipe



18. Paint pipe body and protection of threading



19. Storage

