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Affected Publication: API Technical Report 5C3, *Calculating Performance Properties of Pipe Used as Casing or Tubing*, 7th Edition, June 2018

Addendum 1

Table of Contents: The entry for Table K.2 shall be changed to the following:

K.2 Performance Property Calculations—Interface Pressure of Casing Connections (SI Units) 260

Table of Contents: The entry for Table L.2 shall be changed to the following:

L.2 Performance Property Calculations—Interface Pressure of Casing Connections (USC Units) 338

Section 1 (Scope), 4th paragraph: The last sentence of the paragraph shall be changed to the following:

Similar caution should be exercised when using the performance equations for drill pipe or for collapse of cold-expanded API 5L pipe.

Section 3.1 (Terms and Definitions): The following terms/definitions shall be added to the section:

3.1.12

JCOE

An acronym-term referring to the process of forming pipe in which steel plate edges are formed into a “J,” the full plate is then shaped into a “C,” then an “O,” welded together and finally expanded “E.”

3.1.26

UOE

An acronym-term referring to the process of forming pipe in which steel plate is shaped into a “U,” then an “O,” welded together and finally expanded “E.”

Section 8.6: The entire section shall be replaced with the following:

8.6 Application of Collapse Pressure Equations to Line Pipe

The collapse pressure equations presented in this section are empirical relations derived from tests on pipe representative of the casing and tubing inventories listed in API 5CT or ISO 11960. Application of these relations outside the range of yield strengths and D/t ratios contained in API 5CT or ISO 11960 is not recommended. These equations do not apply to cold expanded pipe because Bauschinger effects significantly reduce collapse resistance. Some line pipe grades listed in API 5L have a rough casing equivalent in API 5CT or ISO 11960. However, the API 5L pipe inventory contains D/t ratios that often exceed casing D/t ratios.

Cold-expanded line pipe—for example, UOE or JCOE line pipe—can exhibit collapse performance lower than the design equations in this clause. Pipeline design guidelines API 1111 and DNVGL-ST-F101 provide correlations that have been shown to yield more accurate collapse design rating predictions when compared to collapse test results. Both pipeline guidelines provide factors to add a design margin to the predicted collapse pressure, resulting in a design rating approach commensurate with this clause.

For line pipe that is not cold-expanded and has a yield strength and D/t falling within the limits of the sizes and thicknesses listed in API 5CT or ISO 11960, application of the equations in this section should yield

reasonable estimates of minimum collapse pressure. Nevertheless, as with the application of any of the equations in this document, sound engineering judgment should prevail.

Section 10.3, Page 50: The paragraph above Equation (71) shall be changed to the following:

Since the external box diameter is always greater than the contact diameter, which in turn is always greater than the internal pipe diameter, p_2 will always be less than p_1 . Therefore, when the total interface pressure $p_1 + p_2$ equals the internal pressure p_i , the connection has reached the interface pressure threshold p . In other words, if p_i were greater than $p_1 + p_2$, leakage would occur:

Annex K, Section K.2: The title of Table K.2 shall be changed to the following:

Table K.2—Performance Property Calculations—Interface Pressure of Casing Connections (SI Units)

Annex K, Page 260: The title of Table K.2 shall be changed to the following:

Table K.2—Performance Property Calculations—Interface Pressure of Casing Connections (SI Units)

Annex L, Section L.2: The title of Table L.2 shall be changed to the following:

Table L.2—Performance Property Calculations—Interface Pressure of Casing Connections (USC Units)

Annex L, Page 338: The title of Table L.2 shall be changed to the following:

Table L.2—Performance Property Calculations—Interface Pressure of Casing Connections (USC Units)

Bibliography: The following entries shall be added to the bibliography:

[123] API Recommended Practice 1111, *Design, Construction, Operation, and Maintenance of Offshore Hydrocarbon Pipelines (Limit State Design)*

[124] DNVGL-ST-F101, *Submarine Pipeline Systems*

Calculating Performance Properties of Pipe Used as Casing or Tubing

API TECHNICAL REPORT 5C3
SEVENTH EDITION, JUNE 2018

ADDENDUM 1, OCTOBER 2019



AMERICAN PETROLEUM INSTITUTE

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Contents

1	Scope	1
2	Normative References	2
3	Terms, Definitions, Symbols, and Abbreviations	2
3.1	Terms and Definitions	2
3.2	Symbols	4
3.3	Abbreviations	12
4	Conformance—Dual Referencing	13
5	Conformance—Units of Measurement	13
6	Triaxial Yield of Pipe Body	13
6.1	General	13
6.2	Assumptions and Limitations	13
6.3	Data Requirements	14
6.4	Design Equation for Triaxial Yield of Pipe Body	14
6.5	Application of Design Equation for Triaxial Yield of Pipe Body to Line Pipe	16
6.6	Example Calculations	16
7	Ductile Rupture of the Pipe Body	20
7.1	General	20
7.2	Assumptions and Limitations	20
7.3	Data Requirements	21
7.4	Design Equation for Capped-end Ductile Rupture	23
7.5	Adjustment for the Effect of Axial Tension and External Pressure	24
7.6	Example Calculations	28
8	External Pressure Resistance	29
8.1	General	29
8.2	Assumptions and Limitations	29
8.3	Data Requirements	30
8.4	Design Equation for Collapse of Pipe Body	30
8.5	Equations for Empirical Constants	36
8.6	Application of Collapse Pressure Equations to Line Pipe	37
8.7	Example Calculations	38
9	Joint Strength	38
9.1	General	38
9.2	API Casing Connection Tensile Joint Strength	39
9.3	API Tubing Connection Tensile Joint Strength	45
9.4	Line Pipe Connection Joint Strength	47
10	Pressure Performance for Couplings	47
10.1	General	47
10.2	Internal Yield Pressure of Round Thread and Buttress Couplings	47
10.3	Interface Pressure of Round Thread or Buttress Couplings	48
11	Calculated Masses	50
11.1	General	50
11.2	Nominal Linear Masses	51
11.3	Calculated Plain-end Mass	51
11.4	Calculated Threaded and Coupled Mass	51

Contents

11.5	Calculated Upset and Threaded Mass for Integral Joint Tubing and Extreme-line Casing	53
11.6	Calculated Upset Mass	54
11.7	Calculated Coupling Mass	55
11.8	Calculated Mass Removed during Threading	59
11.9	Calculated Mass of Upsets	64
12	Elongation	69
13	Flattening Tests	69
13.1	Flattening Tests for Casing and Tubing	69
13.2	Flattening Tests for Line Pipe	70
14	Hydrostatic Test Pressures	71
14.1	Hydrostatic Test Pressures for Plain-end Pipe, Extreme-line Casing, and Integral Joint Tubing	71
14.2	Hydrostatic Test Pressure for Threaded and Coupled Pipe	71
15	Make-up Torque for Round Thread Casing and Tubing	73
16	Guided Bend Tests for Submerged Arc Welded Line Pipe	73
16.1	General	73
16.2	Background	75
17	Determination of Minimum Impact Specimen Size for API Couplings and Pipe	75
17.1	Critical Thickness	75
17.2	Calculated Coupling Blank Thickness	77
17.3	Calculated Wall Thickness for Transverse Specimens	78
17.4	Calculated Wall Thickness for Longitudinal Specimens	79
17.5	Minimum Specimen Size for API Couplings	80
17.6	Impact Specimen Size for Pipe	82
17.7	Larger Size Specimens	82
17.8	Reference Information	82
	Annex A (informative) Discussion of Equations for Triaxial Yield of Pipe Body	83
	Annex B (informative) Discussion of Equations for Ductile Rupture	96
	Annex C (informative) Rupture Test Procedure	134
	Annex D (informative) Discussion of Equations for Fracture	136
	Annex E (informative) Discussion of Historical API Collapse Equations	143
	Annex F (informative) Development of Probabilistic Collapse Performance Properties	157
	Annex G (informative) Calculation of Design Collapse Strength from Collapse Test Data	192
	Annex H (informative) Calculation of Design Collapse Strengths from Production Quality Data	195
	Annex I (informative) Collapse Test Procedure	209
	Annex J (informative) Discussion of Equations for Joint Strength	214
	Annex K (informative) Tables of Calculated Performance Properties in SI Units	224
	Annex L (informative) Tables of Calculated Performance Properties in USC Units	302
	Bibliography	380

Contents

Figures

1	Illustration of the Effect of Effective Axial Tension and External Pressure on Ductile Rupture	26
2	Threaded and Coupled Pipe	52
3	Upset Pipe	53
4	Upset Pipe—Both Ends	54
5	Pipe Coupling	56
6	Coupling with Special Bevel	57
7	Mass Calculations for Buttress Thread Couplings	58
8	Round Threads and Line Pipe Threads	59
9	Buttress Threads	60
10	Extreme-line Pin Thread	61
11	Integral Joint Tubing	62
12	Extreme-line Casing	63
13	External Upset	64
14	Internal Upset	65
15	Pin Upset	67
16	Box Upset	68
17	Guided Bend Test Jig	74
A.1	von Mises Yield Criterion for a Tube Loaded by Internal and External Pressures and Axial Stress . . .	87
A.2	von Mises Yield Criterion for a Tube Loaded by Internal and External Pressure and Axial Stress, API 5C5 or ISO 13679 Representation	88
A.3	von Mises Yield Criterion Expressed in Terms of Internal and External Pressure and Effective Stress	90
A.4	Comparison of API Historical and Lamé/von Mises Predictions of Yield Pressure with Zero Axial Load as a Function of Pipe Body Cross-sectional Geometry, $k_{wall} = 0.875$	95
B.1	Correlations for Hardening Index from Typical Experimental Data for Steel Grades Listed in Table B.2	100
B.2	Illustration of the Effect of Effective Axial Tension and External Pressure on Ductile Rupture	102
B.3	Ratio of Actual to Predicted Rupture Pressures for Klever-Stewart Model	115
B.4	Rupture De-rating for Cracks (Crack Assumed on Minimum Wall)	117
B.5	Influence of the Imperfection Penalty for 9-5/8 in., 53.5 lb/ft, P110 Casing	118
B.6	J-integral and J_{1C} for a P110 Pipe	120
B.7	J-integral and J_{1C} for a 13-Cr-95 Pipe	121
B.8	Influence of Crack Depth on Ductile Rupture	122
B.9	Distribution Bias to Very Small Defects—Very High COV	128
B.10	Exponential Distribution of Defect Sizes—Large COV	128
B.11	Distribution of Defects More Evenly Dispersed in Interval—COV ~ 50 %	129
B.12	Distribution Bias to Larger but Undetected Sizes—COV ~ 30 %	129
B.13	Upper Tail of Seam Lap Defect Depths Plotted on a Weibull Probability Scale	130
B.14	Effect of “Below-the-Threshold” Imperfection Distribution on the Probability Distribution for Ductile Rupture Strength	132
B.15	Comparison of Shape Factor Effect on the Probability of Failure of a Single Length and a String (Mean Safety Factor of 1.3)	133
B.16	Comparison of Shape Factor Effect on the Probability of Failure of a Single Length and a String (Mean Safety Factor of 1.5)	133
C.1	Illustration of Minimum Specimen Length for a Pipe Rupture Test	135
D.1	Influence of K_{Imat} on Fracture Propagation Pressure (7 in. Diameter, 0.730 in. Wall, C90 with 5 % Imperfection, 0.875 Wall Factor)	141
E.1	Grade N80 Transition Collapse Equation Derivation	156

Contents

F.1	Predictive Accuracy (Mean) vs Dataspace Position	162
F.2	Actual/Klever-Tamano Predicted Strength vs Dataspace Position	164
F.3	Klever-Tamano Predictive Accuracy (Dispersion) vs Dataspace Position	165
F.4	Pipe Dimension and Stress Data	171
F.5	Effect of Input Variable Cross-correlation	173
F.6	Possible PDFs for Calculation of Design Collapse Strengths	174
F.7	Predicted Failure Probabilities for API 5C3 [2]	180
F.8	Predicted Failure Probabilities with Potential Governing Case Means in $H_{t_{des}}$	181
F.9	Effect of $H_{t_{des}}$ on Pipe Mass	182
F.10	Predicted Failure Probabilities for Probabilistic Method	183
F.11	Comparison of Design Margin	184
F.12	Comparison of Design Collapse Strengths with Collapse Test Data (Sharp-kneed Stress-strain Curves), $h_n = 0$	185
F.13	Calibration of h_n via Design Strength (Rounded-kneed Stress-strain Curves)	186
F.14	Comparison of Previous and Revised Design Strengths	187
F.15	Sensitivity Factors	188
G.1	Reduction in Design Strength vs Dataset Size	194
H.1	Case-specific Calibration for Mill FD00 (Multiple Pipe Sizes)	205
H.2	PDF and CDF of Predicted Failure Probability ($L_{nom} = 5960$ psi)	207
H.3	Reduction in Design Strength vs Dataset Size (Mill FD00, 9-5/8 in. 47 lb/ft P110 HRS)	208
I.1	Measurements prior to Collapse Testing	210
I.2	Order of Cutting Specimens from Test Pipe	211
I.3	Example of Preparation of Residual Stress Correction Curve	212

Tables

1	Example Calculations: Yield in the Absence of Bending and Torsion	19
2	Suggested Values for Hardening Index in Ductile Rupture Equation	21
3	Example Calculations: Ductile Rupture of an End-capped Pipe	28
4	Example Calculations: Ductile Rupture for a Given True Axial Load	29
5	Yield Collapse Pressure Equation Range	31
6	Equation Factors and D/t Range for Plastic Collapse	33
7	Equation Factors and D/t Range for Transition Collapse	34
8	D/t Range for Elastic Collapse	35
9	Example Calculation: Collapse Resistance with Internal Pressure and Tension	38
10	Casing and Tubing Flattening Tests: Distance between Plates	70
11	Line Pipe Flattening Tests: Distance between Plates	70
12	Factors for Test Pressure Equations	72
13	Values of Strain for Guided Bend Test	74
14	Standard Values for Dimension A_{gbtj} in Guided Bend Test	75
15	Critical Thickness of Various API Couplings	76
16	Calculated Couplings Blank Thickness for API Couplings	77
17	Transverse Impact Specimen Size Required for API Couplings	78
18	Longitudinal Impact Specimen Size Required for API Couplings	79
19	Minimum Size Transverse Charpy Impact Test Specimens for Various API Couplings	81
20	Minimum Size Longitudinal Charpy Impact Test Specimens for API Couplings for All Pipe Less Than Label 1: 3-1/2 Outside Diameter and for Larger Sizes Where Transverse Test Specimens One-Half Size or Larger Are Not Possible	81
B.1	Equations for Rating a Pipe Body for Internal Pressure Resistance	96
B.2	Suggested Values for Hardening Index in Ductile Rupture Equation	99

Contents

B.3	Values of n Used to Evaluate the Klever-Stewart Model	106
B.4	Comparison of Rupture Predictions for Candidate Models	108
B.5	Illustration of Equation Performance over Population	109
B.6	Statistical Evaluation of Klever-Stewart Rupture Model for All Data	110
B.7	Comparison of Rupture Equation (B.6) and Necking Equation (B.18) with Shell Mini-pipe ^[12] Test Data at Axial Tension Exceeding the Capped-end Load (Italic Numbers for p_i/p_{uts} Are Considered Given)	116
B.8	Comparison of Rupture Equation and Test Data at Zero Axial Tension, Ring Tests	116
B.9	Typical J_{1C} Values	119
D.1	Values of G_0 to G_4 for FAD Curve	139
E.1	Yield Collapse Pressure Equation Range	144
E.2	Equation Factors and D/t Range for Plastic Collapse	146
E.3	Equation Factors and D/t Range for Transition Collapse	148
E.4	D/t Range for Elastic Collapse	149
E.5	Average Plastic Collapse Pressure Regression Equations	151
E.6	Minimum Plastic Collapse Equations for Grades K, N, and P	152
E.7	Plastic Collapse Equation Factors for Grades K, N, and P	153
E.8	Plastic Collapse Equation Factors for Grades K, N, and P as Calculated	153
E.9	Tolerance Limit C_c to Be Subtracted from Average Collapse Equations to Convert to a Minimum Base	154
F.1	Comparison of Design Collapse Strengths	159
F.2	Predictive Accuracies (Q&T Only)	160
F.3	Production Quality Data (API Survey Only)—Yield Stress	167
F.4	Production Quality Data (All Datasets)—Other Variables	169
F.5	Development of PDFs for Potentially Governing Cases	173
F.6	Average Predicted Failure Probability for API 5C3 ^[2] (Seamless L80)	180
F.7	Summary of Probabilistic Data	182
F.8	Down-rating Factors	183
F.9	Values of $H_{t_{des}}$ and $k_{y_{des}}$	189
F.10	Iteration for p_o	191
G.1	Dataset Size Factor F (TRL = 0.5 %)	193
H.1	Data Representativeness	196
H.2	Probability Data—Large Datasets	198
H.3	Probability Data—Small Datasets	199
H.4	Input Variable PDFs (Bias and COV Format)	201
H.5	Input Variable PDFs (Mean and SD Format, 9-5/8 in. 47 lb/ft P110 HRS)	202
H.6	Case-specific Calibration for Mill FD00 (9-5/8 in. 47 lb/ft P110 HRS)—Large Datasets	202
H.7	Iteration for D/t	203
H.8	D/t for Each Dataspace Position	203
H.9	Nominal Loads	204
H.10	Mill-specific Design Ratings	205
H.11	Random Realizations of PDF Parameters (9-5/8 in. 47 lb/ft P110 HRS)	206
H.12	Sampling Uncertainties	206
H.13	Predicted Failure Probability for Each Realization ($L_{nom} = 5960$ psi)	207
H.14	Case-specific Calibration for Mill FD00 (9-5/8 in. 47 lb/ft P110 HRS)—Small Datasets	208
I.1	Format for Reporting Collapse Test Data	213
K.1	Performance Property Calculations—External and Internal Pressure for Casing (SI Units)	226
K.2	Performance Property Calculations—Interface Pressure of Casing Connections (SI Units)	260

Contents

K.3	Performance Property Calculations—Axial Tension of Casing Pipe Body and Connections (SI Units)	261
K.4	Performance Property Calculations—External and Internal Pressure for Tubing (SI Units).	278
K.5	Performance Property Calculations—Axial Tension for Tubing Pipe Body and Connections (SI Units)	294
L.1	Performance Property Calculations—External and Internal Pressure for Casing (USC Units).	304
L.2	Performance Property Calculations—Interface Pressure of Casing Connections (USC Units)	338
L.3	Performance Property Calculations—Axial Tension of Casing Pipe Body and Connections (USC Units)	339
L.4	Performance Property Calculations—External and Internal Pressure for Tubing (USC Units).	356
L.5	Performance Property Calculations—Axial Tension for Tubing Pipe Body and Connections (USC Units)	372

Introduction

Performance design of tubulars for the petroleum and natural gas industries, whether it is formulated by deterministic or probabilistic calculations, compares anticipated loads to which the tubular may be subjected to the anticipated resistance of the tubular to each load. Either or both the load and resistance may be modified by a design factor.

Both deterministic and probabilistic (synthesis method) approaches to performance properties are addressed in this technical report. The deterministic approach uses specific geometric and material property values to calculate a single performance property value. The synthesis method treats the same variables as random and thus arrives at a statistical distribution of a performance property. A performance distribution in combination with a defined lower percentile determines the final design equation.

Both the well design process itself and the definition of anticipated loads are currently outside the scope of standardization for the petroleum and natural gas industries. Neither of these aspects is addressed in this technical report. Rather, this text serves to identify useful equations for obtaining the resistance of a tubular to specified loads, independent of their origin. This technical report provides limit state equations (see annexes) that are useful for determining the resistance of an individual sample whose geometry and material properties are given, and design equations that are useful for well design based on conservative geometric and material parameters.

Whenever possible, decisions on specific constants to use in a design equation are left to the discretion of the user.

Calculating Performance Properties of Pipe Used as Casing or Tubing

1 Scope

This technical report illustrates the equations and templates necessary to calculate the various pipe properties, including the following:

- pipe performance properties, such as axial strength, internal pressure resistance, and collapse resistance;
- minimum physical properties;
- product assembly force (torque);
- product test pressures;
- critical product dimensions related to testing criteria;
- critical dimensions of testing equipment;
- critical dimensions of test samples.

For equations related to performance properties, extensive background information is also provided regarding their development and use.

Equations presented here are intended for use with pipe manufactured in accordance with API 5CT or ISO 11960, API 5DP or ISO 11961, and API 5L or ISO 3183, as applicable. These equations and templates may be extended to other pipe with due caution. Pipe cold-worked during production is included in the scope of this technical report (e.g. cold rotary straightened [CRS] pipe). Pipe modified by cold working after production, such as expandable tubulars and coiled tubing, is beyond the scope of this technical report.

Application of performance property equations in this technical report to line pipe and other pipe is restricted to their use as casing/tubing in a well or laboratory test, and requires due caution to match the heat-treat process, straightening process, yield strength, and so forth, with the closest appropriate casing/tubing product. Similar caution should be exercised when using the performance equations for drill pipe or for collapse of cold-expanded API 5L pipe.

This technical report and the equations contained herein relate the input pipe manufacturing parameters in API 5CT or ISO 11960, API 5DP or ISO 11961, and API 5L or ISO 3183 to expected pipe performance. The design equations in this technical report are not to be understood as a manufacturing warrantee. Manufacturers are typically licensed to produce tubular products in accordance with manufacturing specifications that control the dimensions and physical properties of their product. Design equations, on the other hand, are a reference point for users to characterize tubular performance and begin their own well design or research of pipe input properties.

This technical report is not a design code. It only provides equations and templates for calculating the properties of tubulars intended for use in downhole applications. This technical report does not provide any guidance about loads that can be encountered by tubulars or about safety margins needed for acceptable design. Users are responsible for defining appropriate design loads and selecting adequate safety factors to develop safe and efficient designs. The design loads and safety factors will likely be selected based on historical practice, local regulatory requirements, and specific well conditions.

All equations and listed values for performance properties in this technical report assume a benign environment and material properties conforming to API 5CT or ISO 11960, API 5DP or ISO 11961, and API 5L or ISO 3183. Other environments may require additional analyses, such as that outlined in Annex D.

Pipe performance properties under dynamic loads and pipe connection sealing resistance are excluded from the scope of this technical report.

Throughout this technical report tensile stresses are positive.

2 Normative References

This document contains no normative references. For a list of documents and articles associated with API 5C3, see Bibliography.

3 Terms, Definitions, Symbols, and Abbreviations

3.1 Terms and Definitions

For the purposes of this document, the following terms and definitions apply.

3.1.1

Cauchy stress

true stress

Force applied to the surface of a body divided by the current area of that surface.

3.1.2

coefficient of variance

Dimensionless measure of the dispersion of a random variable, calculated by dividing the standard deviation by the mean.

3.1.3

design equation

Equation that, based on production measurements or specifications, provides a performance property useful in design calculations.

NOTE A design equation can be defined by applying reasonable extremes to the variables in a limit state equation to arrive at a conservative value of expected performance; when statistically derived, the design equation corresponds to a defined lower percentile of the resistance probability distribution curve.

3.1.4

deterministic

Approach that assumes that all variables controlling a performance property are known with certainty.

NOTE Pipe performance properties generally depend on one or more controlling parameters; a deterministic equation uses specific geometric and material property values to calculate a single performance property value; for design formulations, this value is the expected minimum.

3.1.5

ductile rupture

Failure of a tube due to internal pressure and/or axial tension in the plastic deformation range.

3.1.6

e

Euler's constant

2.718281828

3.1.7

effective stress

Combination of pressure and axial stress used in this technical report to simplify equations.

NOTE Effective stress as used in this technical report does not introduce a distinct, physically defined stress quantity; effective stress is a dependent quantity, which is determined as a combination of axial stress, internal pressure, external pressure, and pipe dimensions and provides a convenient grouping of these terms in some equations; the effective stress is sometimes called the Lubinski fictitious stress.

3.1.8 engineering strain

Dimensionless measure of the stretch of a deforming line element, defined as the change in length of the line element divided by its original length.

3.1.9 engineering stress

Force applied to the surface of a body divided by the original area of that surface.

3.1.10 fracture pressure

Internal pressure at which a tube fails due to propagation of an imperfection.

3.1.11 inspection threshold

Maximum size of a crack-like imperfection that is defined to be acceptable by the inspection system.

3.1.12 JCOE

An acronym-term referring to the process of forming pipe in which steel plate edges are formed into a "J," the full plate is then shaped into a "C," then an "O," welded together and finally expanded "E."

3.1.13 J-integral

Measure of the intensity of the stress-strain field near the tip of a crack.

3.1.14 label 1

Dimensionless designation for the size or specified outside diameter that may be used when ordering pipe.

3.1.15 label 2

Dimensionless designation for the mass per unit length or wall thickness that may be used when ordering pipe.

3.1.16 limit state equation

Equation that, when used with the measured geometry and material properties of a sample, produces an estimate of the failure value of that sample.

NOTE A limit state equation describes the performance of an individual sample as closely as possible, without regard for the tolerances to which the sample was built.

3.1.17 logarithmic strain

Dimensionless measure of the stretch of a deforming line element, defined as the natural logarithm of the ratio of the current length of the line element to its original length.

NOTE Alternatively, the logarithmic strain can be estimated as the natural logarithm of one plus the engineering strain.

3.1.18 mass

Label used to represent wall thickness of tube cross section for a given pipe size.

3.1.19**pipe body yield**

Stress state necessary to initiate yield at any location in the pipe body.

3.1.20**principal stress**

Stress on a principal plane for which the shear stress is zero.

NOTE For any general state of stress at any point, there exist three mutually perpendicular planes at that point on which shearing stresses are zero; the remaining normal stress components on these three planes are principal stresses; the largest of these three stresses is called the maximum principal stress.

3.1.21**probabilistic method**

Approach that uses distributions of geometric and material property values to calculate a distribution of performance property values.

3.1.22**synthesis method**

Probability approach that addresses the uncertainty and likely values of pipe performance properties by using distributions of geometric and material property values.

NOTE These distributions are combined with a limit state equation to determine the statistical distribution of a performance property; the performance distribution in combination with a defined lower percentile determines the final design equation.

3.1.23**template**

Procedural guide consisting of equations, test methods, and measurements for establishing design performance properties.

3.1.24**TPI**

Threads per inch.

NOTE 1 thread per inch = 0.0394 threads per millimeter; 1 thread per millimeter = 25.4 threads per inch.

3.1.25**true stress-strain curve**

Plot of Cauchy stress (ordinate) vs. logarithmic strain (abscissa).

3.1.26**UOE**

An acronym-term referring to the process of forming pipe in which steel plate is shaped into a “U,” then an “O,” welded together and finally expanded “E.”

3.1.27**yield**

Permanent, inelastic deformation.

3.1.28**yield stress bias**

Ratio of actual yield stress to specified minimum yield stress.

3.2 Symbols

A hand-tight standoff

A_c empirical constant in historical API collapse equation

A_{crit}	area of the weaker connection component at the critical cross section
A_{gbtj}	critical dimension on guided bend test jig, denoted as dimension A in API 5L or ISO 3183
A_{jc}	area of the coupling cross section, $A_{jc} = \pi/4 (W^2 - d_1^2)$
A_{jp}	area of the pipe cross section under the last perfect thread
A_p	area of the pipe cross section, $A_p = \pi/4 (D^2 - d^2)$
$A_{p\ ave}$	average area of the pipe cross section, $A_{p\ ave} = \pi/4 [D_{ave}^2 - (D_{ave} - 2 t_{c\ ave})^2]$
A_s	cross-sectional area of the tensile test specimen in square millimeters (square inches), based on specified outside diameter or nominal specimen width and specified wall thickness, rounded to the nearest 10 mm ² (0.01 in. ²) or 490 mm ² (0.75 in. ²), whichever is smaller
A_x	maximum diameter at the extreme-line pin seal tangent point
a	for a limit state equation, the maximum actual depth of a crack-like imperfection; for a design equation, the maximum depth of a crack-like imperfection that could likely pass the manufacturer's inspection system
a_N	imperfection depth associated with a specified inspection threshold, i.e. the maximum depth of a crack-like imperfection that could reasonably be missed by the pipe inspection system; e.g. for a 5 % imperfection threshold inspection in a 12.7 mm (0.500 in.) wall thickness pipe, $a_N = 0.635$ mm (0.025 in.)
$a_{t/D}$	average value of t/D ratios used in the regression
B	specified inside diameter of the extreme-line connection, in accordance with API 5B
B_c	empirical constant in historical API collapse equation
B_f	maximum bearing face diameter, special bevel, in accordance with API 5CT or ISO 11960
b	Weibull shape parameter
C_c	empirical constant in historical API collapse equation
C_{iR}	random variable that represents model uncertainty
c	tube curvature, the inverse of the radius of curvature to the centerline of the pipe
D	specified pipe outside diameter
D_{ac}	average outside diameter after cutting
D_{ave}	average pipe outside diameter
D_{bc}	average outside diameter before cutting
D_i	inside diameter of extreme-line box upset, in accordance with API 5B
D_{max}	maximum pipe outside diameter
D_{min}	minimum pipe outside diameter
D_p	extreme-line pin critical section outside diameter, $D_p = H_x + \delta - \varphi$
D_4	major diameter, in accordance with API 5B
d	pipe inside diameter, $d = D - 2t$
d_b	inside diameter of the critical section of the extreme-line box, $d_b = I_x + 2h_x - \Delta + \theta$
d_{iu}	inside diameter of pin upset, in accordance with API 5CT or ISO 11960
d_j	extreme-line specified joint inside diameter, made up

d_{ou}	inside diameter at end of upset pipe
d_{wall}	inside diameter based on $k_{wall} t$, $d_{wall} = D - 2k_{wall} t$
d_1	diameter at the root of the coupling thread at the end of the pipe in the power-tight position
E	Young's modulus
E_c	pitch diameter, at center of coupling
E_{ec}	pitch diameter, at end of coupling
E_s	pitch diameter, at plane of seal
E_0	pitch diameter, at end of pipe
E_1	pitch diameter at the hand-tight plane, in accordance with API 5B
E_7	pitch diameter, in accordance with API 5B
ec	eccentricity
e_m	mass gain due to end finishing
F_a	axial force
F_{eff}	effective axial force
F_c	empirical constant in historical API collapse equation
F_{YAPI}	axial force at yield, historical API equation
f	degrees of freedom = $N_t - 1$
$f(\bar{x})$	joint probability density function of the variables in $\bar{x}$
f_{rn}	root truncation of the pipe thread of API line pipe threads, as follows: 0.030 mm (0.0012 in.) for 27 TPI 0.046 mm (0.0018 in.) for 18 TPI 0.061 mm (0.0024 in.) for 14 TPI 0.074 mm (0.0029 in.) for 11-1/2 TPI 0.104 mm (0.0041 in.) for 8 TPI
f_u	tensile strength of a representative tensile specimen
f_{uc}	tensile strength of a representative tensile specimen from the coupling
f_{umn}	specified minimum tensile strength
f_{umnc}	specified minimum tensile strength of the coupling
f_{umnp}	specified minimum tensile strength of the pipe body
f_{up}	tensile strength of a representative tensile specimen from the pipe body
f_y	yield strength of a representative tensile specimen
f_{ycom}	combined loading equivalent grade
f_{ye}	equivalent yield stress in the presence of axial stress
f_{ymn}	specified minimum yield strength
f_{ymnc}	specified minimum yield strength of the coupling
f_{ymnp}	specified minimum yield strength of the pipe body
f_{ymx}	specified maximum yield strength
f_{yp}	yield strength of a representative tensile specimen from the pipe body

G_c	empirical constant in historical API collapse equation
G_0	influence coefficient for fracture limit state FAD curve
G_1	influence coefficient for fracture limit state FAD curve
G_2	influence coefficient for fracture limit state FAD curve
G_3	influence coefficient for fracture limit state FAD curve
G_4	influence coefficient for fracture limit state FAD curve
g	length of imperfect threads, in accordance with API 5B
$g(\bar{x})$	limit state function
H	is the thread height of a round-thread equivalent Vee thread, as follows: 0.815 mm (0.0321 in.) for 27 TPI 1.222 mm (0.0481 in.) for 18 TPI 1.755 mm (0.0691 in.) for 14 TPI 1.913 mm (0.0753 in.) for 11-1/2 TPI 2.1996 mm (0.08660 in.) for 10 TPI 2.7496 mm (0.10825 in.) for 8 TPI
Ht_{des}	decrement factor, as given in Table F.9
Ht_{ult}	a decrement factor
H_x	maximum extreme-line root diameter at last perfect pin thread
h_B	buttress thread height, equal to: 1.575 for SI units 0.062 for USC units
h_n	stress-strain curve shape factor
h_s	round thread height
h_x	minimum box thread height for extreme-line casing, as follows: 1.52 mm (0.060 in.) for 6 TPI 2.03 mm (0.080 in.) for 5 TPI
I	moment of inertia of the pipe cross section, $I = \pi/64 (D^4 - d^4)$
I_{ave}	average moment of inertia of the pipe cross section, $I = \pi/64 [D_{ave}^4 - (D_{ave} - 2 t_{c ave})^4]$
I_B	length from the face of the buttress thread coupling to the base of the triangle in the hand-tight position, as follows: 0.16 mm (0.400 in.) for Label 1: 4-1/2 12.70 mm (0.500 in.) for sizes between Label 1: 5 and Label 1: 13-3/8, inclusive 9.52 mm (0.375 in.) for sizes greater than Label 1: 13-3/8
I_x	minimum extreme-line crest diameter of box thread at Plane H
J	distance from end of pipe to center of coupling in power-tight position, in accordance with API 5B
J_{lc}	fracture resistance of the material
J_{imat}	fracture resistance of the material in a particular environment
J_p	polar moment of inertia of the pipe cross section, $J_p = \pi/32 (D^4 - d^4)$
J_r	stress intensity ratio based on the J-integral
K	stress intensity factor at the crack tip
K_{imat}	fracture toughness of a material in a particular environment

K_p	ratio of internal pressure stress to yield strength, or $p_i D/(2 f_{ymnp} t)$
K_r	stress intensity ratio
k_A	variable intermediate term in API 5C5 or ISO 13679 representation of von Mises yield criterion
k_a	burst strength factor, having the numerical value 1.0 for quenched and tempered (martensitic structure) or 13Cr products and 2.0 for as-rolled and normalized products based on available test data, and the default value set to 2.0 where the value has not been measured
	NOTE The value of k_a can be established for a specific pipe material based on testing
k_B	variable intermediate term in API 5C5 or ISO 13679 representation of von Mises yield criterion
k_C	variable intermediate term in API 5C5 or ISO 13679 representation of von Mises yield criterion
k_c	constant used in elastic collapse equation
k_{dr}	correction factor based on pipe deformation and material strain hardening, having the numerical value $[(1/2)^{n+1} + (1/\sqrt{3})^{n+1}]$
k_e	bias factor for elastic collapse
$k_{e \text{ des}}$	down-rating factor for design elastic collapse
k_{el}	elongation constant, equal to: 1942.57 for SI units 625,000 for USC units
$k_{e \text{ uls}}$	calibration factor for ultimate elastic collapse, equal to 1.089
k_i	factor used to determine minimum wall thickness for transverse impact specimens, as follows: 1.00 for full-size specimens 0.75 for three-quarter-size specimens 0.50 for one-half-size specimens
k_{lsl}	length conversion factor, equal to: 0.001 for SI units 1/12 for USC units
k_m	mass correction factor, equal to: 1.000 for carbon steel 0.989 for martensitic chromium steel
k_n	stress conversion factor, equal to: $1.18 \times 10^{-4} \text{ MPa}^{-1}$ for SI units $8.12 \times 10^{-7} \text{ psi}^{-1}$ for USC units
k_{pi}	upper quadrant geometry factor in API 5C5 or ISO 13679 representation of von Mises yield criterion
k_{po}	lower quadrant geometry factor in API 5C5 or ISO 13679 representation of von Mises yield criterion
k_{wall}	factor to account for the specified manufacturing tolerance of the pipe wall; e.g. for a tolerance of -12.5% , $k_{wall} = 0.875$
k_{wpe}	mass per unit length conversion factor, equal to: 0.0246615 for SI units 10.69 for USC units
k_y	bias factor for yield collapse
$k_{y \text{ des}}$	down-rating factor for design yield collapse

$k_{y\text{uls}}$	calibration factor for ultimate yield collapse, equal to 0.9911
L	length
L_c	minimum length of full crest threads from end of pipe, in accordance with API 5B
L_{ef}	length of pipe including end finish
L_{et}	engaged thread length, $[= L_4 - M]$ for nominal make-up, in accordance with API 5B
L_{eu}	length from end of pipe to start of taper, in accordance with API 5CT or ISO 11960
L_{iu}	length of pin upset, in accordance with API 5CT or ISO 11960
L_j	length of a standard piece of pipe
L_r	load ratio
L_1	length from the end of the pipe to the hand-tight plane, in accordance with API 5B
L_7	length of perfect threads, in accordance with API 5B
M	specified outside diameter of the extreme-line connection; length from the face of the coupling to the hand-tight plane for line pipe and for round thread casing and tubing, in accordance with API 5B
M_b	bending moment
m_c	coupling mass
m_{cB}	coupling mass of buttress thread casing
m_{crsb}	coupling mass removed by special bevel
m_{csb}	coupling mass with special bevel
m_{eu}	length of box upset taper, in accordance with API 5CT or ISO 11960
m_{exu}	external upset mass
m_{eiu}	external-internal upset mass
m_{irt}	integral joint mass removed by threading and recessing
m_{inu}	internal upset mass
m_{iu}	length of pin upset taper, in accordance with API 5CT or ISO 11960
m_{prt}	pin mass removed by threading
m_{xbu}	extreme-line pin upset mass
m_{xpu}	extreme-line pin upset mass
m_{xrt}	extreme-line mass removed by threading and recessing
m_{rt}	mass removed by threading
mu	model uncertainty
N	number of thread turns make-up
N_L	coupling length, in accordance with API 5CT or ISO 11960
N_t	number of tests
n	dimensionless hardening index used to obtain a curve fit (see B.2.3.3) of the true stress-strain curve derived from the uniaxial tensile test
O_x	minimum diameter at the extreme-line box seal tangent point
ov	ovality

P_j	joint strength
p	thread pitch, as follows: 3.175 mm (0.125 in.) for round thread casing 5.080 mm (0.200 in.) for buttress thread casing
p_c	collapse resistance
p_{des}	design collapse pressure
p_{desi}	design collapse pressure corrected for internal pressure
$p_{des e}$	collapse pressure corrected for axial stress and internal pressure
p_e	elastic collapse term
p_{ec}	elastic collapse pressure difference
$p_{e des}$	design elastic collapse term
$p_{e ult}$	ultimate elastic collapse term
p_E	pressure for elastic collapse
p_{ht}	hydrostatic test pressure
p_i	internal pressure
p_{iF}	internal pressure at fracture
p_{iS}	internal pressure at thread separation
p_{iR}	internal pressure at ductile rupture of an end-capped pipe
p_{iRa}	p_{iR} adjusted for axial load and external pressure
p_{iYAPI}	internal pressure at yield for a thin tube
p_{iYc}	internal pressure at yield for coupling
p_{iYLC}	internal pressure at yield for a capped-end thick tube
p_{iYLo}	internal pressure at yield for an open-ended thick tube
p_o	external pressure
$p_{o ult}$	ultimate external pressure for collapse
p_P	pressure for plastic collapse
p_{Pav}	pressure for average plastic collapse
p_T	pressure for transition collapse
p_{ult}	ultimate collapse pressure
p_y	yield collapse term
p_{yc}	yield collapse pressure difference
$p_{y des}$	design yield collapse term
p_{yM}	through-wall von Mises yield pressure difference
p_{Yp}	pressure for yield strength collapse
$p_{y Tresca}$	Tresca yield pressure for collapse
$p_{y ult}$	ultimate yield collapse term
$p_{y vme}$	von Mises yield pressure for collapse
Q	diameter of coupling recess, in accordance with API 5B

r	radial coordinate, $(d/2) \leq r \leq (D/2)$
rs	residual stress (compression at ID face is negative)
S	distance between flattening plates
S_p	standard error of estimate of the regression equation
s_{rn}	root truncation of the pipe thread of round threads, as follows: 0.36 mm (0.014 in.) for 10 TPI 0.43 mm (0.017 in.) for 8 TPI
$s_{t/D}$	standard deviation of t/D ratios used in the regression
T	applied torque
T_d	taper (on diameter)
t	specified pipe wall thickness
t_{ave}	actual average pipe wall thickness disregarding crack-like imperfections
$t_{c\ ave}$	actual average pipe wall thickness
$t_{c\ max}$	maximum pipe wall thickness
$t_{c\ min}$	minimum pipe wall thickness
t_{max}	actual maximum pipe wall thickness disregarding crack-like imperfections
t_{min}	actual minimum pipe wall thickness disregarding crack-like imperfections
t_p	tolerance interval corresponding to a confidence level of p that the proportion of the population not included does not exceed
W	specified coupling outside diameter, in accordance with API 5CT or ISO 11960
u_p	fractile corresponding to confidence level p
$u_{1-\theta}$	fractile, the deviation from the mean of a standardized normal cumulative distribution that includes the fraction $1 - \theta_p$ of the population
W_L	calculated mass of a piece of pipe of length L
w_{ij}	upset and threaded mass per unit length
w_{pe}	plain-end mass per unit length
w_{tc}	threaded and coupled mass per unit length
w_u	upset mass per unit length
$\bar{x}$	vector of random variables
Z_p	correction factor for variation in t/D from average
Δ	taper drop in extreme-line pin perfect thread length, as follows: 6.43 mm (0.253 in.) for 6 TPI 5.79 mm (0.228 in.) for 5 TPI
α	sensitivity factor
β	first-order reliability index
δ	extreme-line taper rise between Plane H and Plane J, as follows: 0.89 mm (0.035 in.) for 6 TPI 0.81 mm (0.032 in.) for 5 TPI
ε_{eng}	engineering strain

ε_{el}	minimum gauge length extension in 50.8 mm (2.0 in.), in percent, rounded to the nearest 0.5 % below 10 % and to the nearest unit percent for 10 % and larger
ε_{ln}	logarithmic strain
ε_{ymn}	strain at which specified minimum yield strength is determined
θ	one-half of the extreme-line maximum thread interference, $\theta = (H_x - I_x)/2$
θ_p	the proportion of the population not included
μ	mean
μ_{ec}	mean calculated eccentricity as a percent, [eccentricity = $100 (t_{c \max} - t_{c \min})/t_{c \text{ ave}}$]
μ_{fy}	mean calculated f_y as a percent
μ_{ov}	mean calculated ovality as a percent, [ovality = $100 (D_{\max} - D_{\min})/D_{\text{ave}}$]
μ_{rs}	mean calculated residual stress (compression at ID face is negative)
ν	Poisson's ratio
π	circumference of a circle divided by its diameter, assigned a value of 3.1416
ϕ_f	probability of failure
σ	standard deviation
σ_a	component of axial stress not due to bending
σ_b	component of axial stress due to bending
σ_c	true (Cauchy) stress
σ_e	equivalent stress
σ_{eff}	effective stress
σ_f	fiber stress corresponding to the percent of specified yield strength as given in Table 12
σ_h	circumferential or hoop stress
σ_{pmx}	maximum principal stress
σ_r	radial stress
σ_{res}	residual stress
σ_{th}	threshold stress
σ_{ye}	equivalent yield strength in the presence of axial tension
σ_{ymne}	equivalent minimum yield strength in the presence of axial tension
τ_{ha}	torsional (shear) stress
φ	one-half of the maximum extreme-line seal interference, $\varphi = (A_x - O_x)/2$

3.3 Abbreviations

CRS	cold rotary straightened
CVN	Charpy V-Notch
DCB	double cantilever beam
FAD	failure assessment diagram
FORM	first-order reliability method

HC	high-collapse
HRS	hot rotary straightened
OCTG	oil country tubular goods
SORM	second-order reliability method
TRL	target reliability level
ULS	ultimate limit state

4 Conformance—Dual Referencing

In the interests of worldwide application of this technical report, the American Petroleum Institute (API) Subcommittee on Tubular Goods (SC5) has decided, after detailed technical analysis, that certain documents listed in the Bibliography and prepared by API SC5 or other technical committees are interchangeable in the context of the relevant requirement with the relevant document prepared by the International Organization for Standardization (ISO) or ASTM International. These latter documents are cited in the running text following the API reference and preceded by or, for example, “API XXXX or ISO YYYY” or “ISO YYYY or ASTM ZZZZ.” Application of an alternative document cited in this manner may lead to technical results different from the use of the preceding API reference. However, both results are acceptable and these documents are thus considered interchangeable in practice.

5 Conformance—Units of Measurement

In this technical report, data are expressed in both the International System of Units (SI) and the United States customary (USC) system of units. For a specific order item, it is intended that only one system of units be used, without combining data expressed in the other system.

6 Triaxial Yield of Pipe Body

6.1 General

The criterion for triaxial pipe body yield is that proposed by von Mises. The elastic state leading to incipient yield consists of the superposition of:

- radial and circumferential stress as determined by the Lamé Equations for a thick cylinder;
- uniform axial stress due to all sources except bending;
- axial bending stress for a Timoshenko beam;
- torsional shear stress due to a moment aligned with the axis of the pipe.

Details of the derivation of the design equation can be found in Annex A.

6.2 Assumptions and Limitations

6.2.1 General

Equations (1) to (7) are based on the assumptions given in 6.2.2 to 6.2.5.

6.2.2 Concentric, Circular Cross-sectional Geometry

The equations for radial stress, circumferential or hoop stress, bending and torsion presume the pipe cross section to consist of inner and outer surfaces that are circular and concentric.

6.2.3 Isotropic Yield

The yield strength of the material of which the pipe is composed is assumed to be independent of direction. An axial sample and a circumferential sample are assumed to possess identical elastic moduli and yield stress in both tension and compression.

6.2.4 No Residual Stress

For determination of the onset of yield, residual stresses due to manufacturing processes are assumed to be negligible and are ignored.

6.2.5 Cross-sectional Instability (Collapse) and Axial Instability (Column Buckling)

Particularly in instances where $p_o > p_i$, it is possible for the pipe cross section to collapse due to instability prior to yield. For external pressure greater than internal pressure, see Section 8 on collapse. Similarly, if $\sigma_{eff} < 0$, it is possible for the pipe to buckle as a column prior to yield, and the bending stress due to buckling should be included in the yield check.

6.3 Data Requirements

The following input data are required to complete the calculation for triaxial yield of the pipe body:

c	tube curvature, the inverse of the radius of curvature to the centerline of the pipe;
D	specified pipe outside diameter;
E	Young's modulus;
F_a	axial force;
f_{ymn}	specified minimum yield strength;
k_{wall}	factor to account for the specified manufacturing tolerance of the pipe wall; e.g. for a tolerance of -12.5% , $k_{wall} = 0.875$;
p_i	internal pressure;
p_o	external pressure;
T	applied torque;
t	specified pipe wall thickness.

6.4 Design Equation for Triaxial Yield of Pipe Body

The onset of yield is defined as follows:

$$\sigma_e = f_{ymn} \quad (1)$$

where $\sigma_e < f_{ymn}$ corresponds to elastic behavior;

f_{ymn} is the specified minimum yield strength;

σ_e is the equivalent stress.

The equivalent stress is defined as follows:

$$\sigma_e = [\sigma_r^2 + \sigma_h^2 + (\sigma_a + \sigma_b)^2 - \sigma_r\sigma_h - \sigma_r(\sigma_a + \sigma_b) - \sigma_h(\sigma_a + \sigma_b) + 3\tau_{ha}^2]^{1/2} \quad (2)$$

with

$$\sigma_r = [(p_i d_{wall}^2 - p_o D^2) - (p_i - p_o) d_{wall}^2 D^2 / (4r^2)] / (D^2 - d_{wall}^2) \quad (3)$$

$$\sigma_h = [(p_i d_{wall}^2 - p_o D^2) + (p_i - p_o) d_{wall}^2 D^2 / (4r^2)] / (D^2 - d_{wall}^2) \quad (4)$$

$$\sigma_a = F_a / A_p \quad (5)$$

$$\sigma_b = \pm M_b r / I = \pm E c r \quad (6)$$

$$\tau_{ha} = T r / J_p \quad (7)$$

where

- A_p is the area of the pipe cross section, $A_p = \pi/4 (D^2 - d^2)$;
- c is the tube curvature, the inverse of the radius of curvature to the centerline of the pipe;
- D is the specified pipe outside diameter;
- d is the pipe inside diameter, $d = D - 2t$;
- d_{wall} is the inside diameter based on $k_{wall} t$, $d_{wall} = D - 2k_{wall} t$;
- E is Young's modulus;
- F_a is the axial force;
- I is the moment of inertia of the pipe cross section, $I = \pi/64 (D^4 - d^4)$;
- J_p is the polar moment of inertia of the pipe cross section, $J_p = \pi/32 (D^4 - d^4)$;
- k_{wall} is the factor to account for the specified manufacturing tolerance of the pipe wall; e.g. for a tolerance of -12.5 %, $k_{wall} = 0.875$;
- M_b is the bending moment;
- p_i is the internal pressure;
- p_o is the external pressure;
- r is the radial coordinate, as follows:
 $(d/2) \leq r \leq (D/2)$ for σ_a , σ_b , and τ_{ha}
 $(d_{wall}/2) \leq r \leq (D/2)$ for σ_r and σ_h ;
- T is the applied torque;
- t is the specified pipe wall thickness;
- σ_a is the component of axial stress not due to bending;
- σ_b is the component of axial stress due to bending;

- σ_e is the equivalent stress;
- σ_h is the circumferential or hoop stress;
- σ_r is the radial stress;
- τ_{ha} is the torsional (shear) stress.

The $\pm$ sign in Equation (6) indicates that the component of axial stress due to bending can be positive (tension) or negative (compression), depending on the location of the point in the cross section. Points in the pipe cross section closer to the center of tube curvature than the centerline of the pipe experience compressive bending stress. Points in the pipe cross section farther from the center of tube curvature than the centerline of the pipe experience tensile bending stress.

The variable c has units of radian/length, which are not the norm for the petroleum industry. The more common measure of c in the industry is $^{\circ}/30\text{ m}$ ($^{\circ}/100\text{ ft}$). If, therefore, the required units for c are radians/meter, and c is expressed in $^{\circ}/30\text{ m}$ ($^{\circ}/100\text{ ft}$), the right-hand side of Equation (6) should be multiplied by the constant $\pi/(180 \times 30) = 5.8178 \times 10^{-4}\text{ rad}\cdot\text{m}/^{\circ}-30\text{ m}$ [$\pi/(180 \times 100) = 1.7453 \times 10^{-4}\text{ rad}\cdot\text{ft}/^{\circ}-100\text{ ft}$].

In the presence of bending, Equation (2) should be evaluated four times, i.e. at the inner and outer radii on both the tensile and compressive sides of the cross section. In the presence of torsion, Equation (2) should be evaluated two times, i.e. at the inner and outer radii. In the absence of both bending and torsion, Equation (2) should be evaluated once, at the minimum value of the radius. In all cases, the maximum computed value of σ_e should be used in Equation (1).

The purpose of the design equation is to determine the stress state that results in the onset of pipe yield when the properties of the pipe are at their worst-case, minimum allowable values. The wall thickness of the pipe at all times accounts for the extreme allowable thin-wall eccentricity that comes about naturally as part of the pipe manufacturing process.

6.5 Application of Design Equation for Triaxial Yield of Pipe Body to Line Pipe

The pipe body yield strength of line pipe can be calculated by means of equations presented in this section, minding the limitations given in 6.2.

6.6 Example Calculations

6.6.1 Initial Yield of Pipe Body, Lamé Equation for Pipe When External Pressure, Bending, and Torsion Are Zero

The Lamé Equations for the radial and hoop stresses of the pipe are based on the three-dimensional equations of equilibrium for a linear elastic cross section. As such, these equations are triaxial equations and provide the most accurate calculation of pipe stresses. Two equations are provided: open-end with zero axial stress and closed-end with axial stress due to internal pressure acting on the end cap.

6.6.1.1 Yield Design Equation, Special Case for Capped-end Conditions

Initial yield of a capped-end thick tube is a special case of Equations (1) and (2) when external pressure, bending, and torsion are zero. The axial stress is generated solely by the action of internal pressure on the ends of the sample (e.g. the capped-end condition).

A design equation for initial yield of the pipe body with capped-end conditions and using the Lamé Equations for the radial and hoop stresses should be formulated from Equation (2), evaluated at the inner diameter. The resulting design equation is as follows:

$$p_{iYLC} = f_{ymn} / \{ (3 D^4 + d_{wall}^4) / (D^2 - d_{wall}^2)^2 + d^4 / (D^2 - d^2)^2 - 2 d^2 d_{wall}^2 / [(D^2 - d^2) (D^2 - d_{wall}^2)] \}^{1/2} \quad (8)$$

where

D is the specified pipe outside diameter;

d is the pipe inside diameter, $d = D - 2t$;

d_{wall} is the inside diameter based on $k_{wall} t$, $d_{wall} = D - 2k_{wall} t$;

f_{ymn} is the specified minimum yield strength;

k_{wall} is the factor to account for the specified manufacturing tolerance of the pipe wall; e.g. for a tolerance of -12.5% , $k_{wall} = 0.875$;

p_{iYLC} is the internal pressure at yield for a capped-end thick tube;

t is the specified pipe wall thickness.

There is no adjustment to Equation (8) for axial tension, as all axial tension is generated by the action of internal pressure on the (closed) ends of the pipe. The more general case, where axial stress is generated by other than the action of internal pressure on the ends of the pipe, is addressed by the triaxial yield criterion, Equations (1) and (2).

6.6.1.2 Yield Design Equation, Special Case for Internal Pressure with Zero Axial Load

Initial yield of an open-ended thick tube is a special case of Equations (1) and (2) when the uniform axial stress, external pressure, bending, and torsion are zero.

A design equation for initial yield of the pipe body with open-end conditions and using the Lamé Equations for the radial and hoop stresses should be formulated from Equation (2) evaluated at the inner diameter. The resulting design equation is as follows:

$$p_{iYLO} = f_{ymn} (D^2 - d_{wall}^2) / (3 D^4 + d_{wall}^4)^{1/2} \quad (9)$$

where

D is the specified pipe outside diameter;

d_{wall} is the inside diameter based on $k_{wall} t$, $d_{wall} = D - 2k_{wall} t$;

f_{ymn} is the specified minimum yield strength;

k_{wall} is the factor to account for the specified manufacturing tolerance of the pipe wall; e.g. for a tolerance of -12.5% , $k_{wall} = 0.875$;

p_{iYLO} is the internal pressure at yield for an open-ended thick tube;

t is the specified pipe wall thickness.

The more general case, where axial stress is non-zero, is addressed by the triaxial yield criterion, Equations (1) and (2).

6.6.2 Initial Yield Pressure of Pipe Body, Historical API Equation

6.6.2.1 General

The Barlow Equation for pipe yield, which is the historical API equation, is based on a one-dimensional (not triaxial) approximate equation of the von Mises yield condition, combined with an approximate expression for the hoop stress in the pipe. In essence, the Barlow Equation approximates the hoop stress and then equates this approximation to the yield strength. This approximation is less accurate than the Lamé Equation of yield discussed in 6.6.1. Because the Barlow Equation neglects axial stress, there is no distinction between pipe with capped ends, pipe with open ends, or pipe with tension end load.

6.6.2.2 Historical, One-dimensional Yield Pressure Design Equation

Initial yield of a thin tube is defined by the following expression:

$$p_{iYAPI} = [2f_{ymn}(k_{wall}t)/D] \quad (10)$$

where

D is the specified pipe outside diameter;

f_{ymn} is the specified minimum yield strength;

k_{wall} is the factor to account for the specified manufacturing tolerance of the pipe wall; e.g. for a tolerance of -12.5% , $k_{wall} = 0.875$;

p_{iYAPI} is the internal pressure at yield for a thin tube;

t is the specified pipe wall thickness.

This equation is subject to the same assumptions and limitations as the more general expressions from which it may be derived (by methods other than that used by Barlow) (see 6.2).

6.6.3 Pipe Body Yield Strength, Historical API Equation

Pipe body yield strength is the axial load required to yield the pipe in the absence of internal and external pressure, bending, and torsion. It is taken as the product of the cross-sectional area and the specified minimum yield strength for the particular grade of pipe by:

$$F_{YAPI} = f_{ymn} A_p \quad (11)$$

where

A_p is the area of the pipe cross section, $A_p = \pi/4 (D^2 - d^2)$;

D is the specified pipe outside diameter;

d is the pipe inside diameter, $d = D - 2t$;

F_{YAPI} is the axial force at yield, historical API equation;

f_{ymn} is the specified minimum yield strength;

t is the specified pipe wall thickness.

6.6.4 Yield in the Absence of Bending and Torsion

If bending and torsion are zero, Equation (2) reduces to:

$$\sigma_e = [\sigma_r^2 + \sigma_h^2 + \sigma_a^2 - \sigma_r\sigma_h - \sigma_r\sigma_a - \sigma_h\sigma_a]^{1/2} \quad (12)$$

Consider, for example, the case of a tube being lowered open-ended into a vertical well full of fluid with mass density 1.080 kg/dm^3 (9 lb/gal). The internal pressure and external pressure at any depth are equal, and the bottom of the tube is exposed to an axial compression equal to the product of the fluid pressure and the tube cross-sectional area. Ignoring connections, let the tube be of outside diameter 244.48 mm (9.625 in.), of wall thickness 13.84 mm (0.545 in.), and have $k_{\text{wall}} = 0.875$. Assume the mass density of steel is 7.85 kg/dm^3 (0.2836 lb/in.³). Compute the yield state of the uppermost cross section of the tube when the tube is at a depth of 3000 m (9842.5 ft). The tube has a minimum yield stress of 551.6 MPa (80,000 psi).

Table 1 presents the results of the calculation in both SI and USC units.

Table 1—Example Calculations: Yield in the Absence of Bending and Torsion

Term	SI		USC	
	Value	Units	Value	Units
Load				
F_a	1,995,717	N	448,655	lb
p_i	31.73	MPa	4601	psi
p_o	31.73	MPa	4601	psi
c	0	°/30 m	0	°/100 ft
T	0	N-m	0	ft-lb
Geometry				
D	244.48	mm	9.625	in.
t	13.84	mm	0.545	in.
k_{wall}	0.875		0.875	
Material				
E	206,842	MPa	30,000,000	psi
Calculations				
d	216.80	mm	8.535	in.
d_{wall}	220.26	mm	8.671	in.
A_p	10,028	mm ²	15.55	in. ²
I	66,920,762	mm ⁴	160.8	in. ⁴
J_p	133,841,524	mm ⁴	321.6	in. ⁴
σ_a	199.01	MPa	28,859	psi
Inner radius				
σ_b	0	MPa	0	psi
σ_h	-31.73	MPa	-4602	psi
σ_r	-31.73	MPa	-4602	psi
τ_{ha}	0	MPa	0	psi
σ_e, σ_b^+	230.74	MPa	33,461	psi
σ_e, σ_b^-	230.74	MPa	33,461	psi
Outer radius				
σ_b	0	MPa	0	psi
σ_h	-31.73	MPa	-4602	psi
σ_r	-31.73	MPa	-4602	psi
τ_{ha}	0	MPa	0	psi
σ_e, σ_b^+	230.74	MPa	33,461	psi
σ_e, σ_b^-	230.74	MPa	33,461	psi

Since both bending and torsion are zero in this example, there is no need to calculate σ_e at both the inner and outer radii of the tube, as yield will always occur at the inner radius. The calculations have been included here for completeness.

As the equivalent stress is less than the yield stress, the tube does not yield at its uppermost cross section.

7 Ductile Rupture of the Pipe Body

7.1 General

The equations for ductile rupture pertain to the actual failure of the pipe body due to internal pressure. Whereas the yield equations of Section 6 are intended to describe the onset of permanent plastic deformation and not loss of pressure integrity, the rupture equations are intended to describe the ultimate pressure capacity of the pipe at a pressure that fails the pipe body with loss of internal pressure integrity.

The equations for ductile rupture depend on the minimum physical wall thickness, the pipe outer diameter, the maximum depth of imperfections that have a reasonable probability of passing through the inspection process undetected, the fracture toughness of the material, the work hardening of the material, and the ultimate tensile strength of the pipe. Yield strength has no direct impact on the ductile rupture pressure except through the correlation of the work hardening parameter n .

The ductile rupture equations can be derived from the mechanics of pipe equilibrium combined with a model of pipe plasticity and a model of the effect of imperfections. The selection of the basic equation, the application of the basic equation to API/ISO tubular products, and the verification of the equation with actual test data are discussed in detail in Annex B. The ductile rupture limit state and design equations consist of the following three interlinked concepts:

- equation for equilibrium-plasticity based rupture of a pipe with known physical wall thickness and diameter;
- reduction in performance due to wall loss in proportion to depths of imperfections that may not be detected by the manufacturing and inspection system;
- criterion for minimum toughness at which ductile rupture applies.

These equations are applicable to direct pressure and axial loading, but do not describe the capacity of the pipe under fatigue loading. The subtraction to the pipe wall for the presence of imperfections and the interrelated role of pipe toughness are based on a fracture mechanics approach relating J_{IC} toughness measurements of sample pipes to numerically calculated crack-tip intensities (J-integrals) as a function of imperfection depth. This is explained in detail in Annex B.

7.2 Assumptions and Limitations

These equations are applicable only when the pipe material in its environment has sufficient toughness to meet a minimum criterion such that the deformation of the pipe, in its environment, through to rupture is ductile and not brittle, even in the presence of small imperfections.

Bending stresses (for instance, due to buckling or bending due to curvature of the well trajectory) are not included in the equation for ductile rupture pressure. Hence, the ductile rupture equation may not apply to pipe that is buckled (nor to pipe in a dogleg).

7.3 Data Requirements

7.3.1 General

The following input data are required to complete the calculation for ductile rupture of the pipe body:

a_N imperfection depth associated with a specified inspection threshold, i.e. the maximum depth of a crack-like imperfection that could reasonably be missed by the pipe inspection system; e.g. for a 5 % imperfection threshold inspection in a 12.7 mm (0.500 in.) wall thickness pipe, $a_N = 0.635$ mm (0.025 in.);

D specified pipe outside diameter;

f_{umn} specified minimum tensile strength;

k_a burst strength factor, having the numerical value 1.0 for quenched and tempered (martensitic structure) or 13Cr products and 2.0 for as-rolled and normalized products based on available test data, and the default value set to 20 where the value has not been measured;

NOTE The value of k_a can be established for a specific pipe material based on testing.

k_{wall} factor to account for the specified manufacturing tolerance of the pipe wall; e.g. for a tolerance of -12.5 %, $k_{wall} = 0.875$;

n dimensionless hardening index used to obtain a curve fit (see B.2.3.3) of the true stress-strain curve derived from the uniaxial tensile test;

t specified pipe wall thickness.

7.3.2 Determination of the Hardening Index

In the absence of stress-strain information, the following values of n are suggested.

Table 2—Suggested Values for Hardening Index in Ductile Rupture Equation

API Grade	n
H40	0.14
J55	0.12
K55	0.12
M65	0.12
N80	0.10
L80 Type 1	0.10
L80 Chrome	0.10
C90	0.10
R95	0.09
T95	0.09
P110	0.08
Q125	0.07

If the grade of the material is unknown but is not high-hardening, the hardening index can alternatively be determined from the following correlation:

$$n = 0.1693 - k_n f_y \quad (13)$$

where f_y has units of MPa (psi);

f_y is the yield strength of a representative tensile specimen;

k_n is the stress conversion factor, equal to:

$1.8 \times 10^{-4} \text{ MPa}^{-1}$ for SI units

$8.12 \times 10^{-7} \text{ psi}^{-1}$ for USC units;

n is the dimensionless hardening index used to obtain a curve fit (see B.2.3.3) of the true stress-strain curve derived from the uniaxial tensile test.

The effort expended to determine n should be weighed against the fact that the equation for ductile rupture is relatively insensitive to this quantity for commonly used oil country tubular goods (OCTG). However, if a high-hardening material such as duplex steel is used, it is important to determine n to avoid a nonconservative rupture strength prediction. Values of n for these materials can be as high as 0.30.

7.3.3 Determination of the Burst Strength Factor, k_a

7.3.3.1 General

The burst strength factor k_a quantifies the impact that the material toughness has on ductile rupture when a crack of depth a_N is present. The value of k_a does not need to be determined for each pipe order; instead, it is recommended that k_a be determined for a fixed tubular product line with a fixed process control plan. For a material with high material toughness, k_a will be 1.0 or lower, and the influence the crack has on the ductile rupture pressure will be no greater than the depth of the crack. However, for a pipe material with lower material toughness, k_a can be larger, say 2.0, so that the penalty from having the crack is as though the crack had twice its actual depth.

When k_a has not been determined for the pipe material, use a k_a value of 2.0. The value of k_a has been measured to be 1.0 for quenched and tempered (martensitic structure) pipe and for 13Cr products. The value of k_a can be established for a specific pipe material based on testing. One of two methods presented below can be used to calculate k_a .

7.3.3.2 Analytical Method for Determining k_a

The following procedure should be used.

- a) Construct a finite element model of a pipe with three separate cases of crack depth: zero, 5 %, and 12.5 %. Model the crack as an infinitely long, longitudinal crack on the ID of the pipe. In the finite element model, use the specified pipe wall thickness (do not reduce the pipe wall for manufacturing eccentricity) and a typical stress-strain curve for the material being analyzed.
- b) Use the finite element model to simulate applying internal pressure to the pipe model in order to calculate the value of the J-integral of the pipe as a function of internal pressure (see B.7.2 for examples).

- c) Experimentally measure the critical J_{1c} value of the pipe material in air. J_{1c} is a parameter similar to K_{1c} , but based on a different type of test. See ASTM E1152-95 [1] for the precisely defined test methodology.
- d) Terminate each of the finite element J-integral curves at the critical value of J_{1c} measured in the test. The internal pressure corresponding to this terminal point (where the J-integral equals J_{1c}) represents the rupture pressure in the presence of the crack, for a material with toughness reflected by J_{1c} .
- e) Next, divide the rupture pressure for pipe with a crack depth 5 % by the rupture pressure for pipe with no crack, using the finite element results combined with the J_{1c} measurement. Next, set this ratio equal to $(1 - k_a a/t)$ where a/t is the ratio of the crack depth to the specified pipe wall thickness (i.e. 5 % in this case). Solve this equation for the value of k_a .
- f) Repeat the above calculation using the finite element model results for the crack with 12.5 % depth.
- g) Average the two values of k_a from steps e) and f) and use the average in the rupture equation.

7.3.3.3 Experimental Method for Determining k_a

An alternative way to measure k_a in lieu of the J_{1c} measurement and the finite element calculation is to conduct full-scale pipe burst tests using a pipe with no measurable crack-like imperfection, another pipe with a crack-like imperfection of 5 % depth, and another pipe with a crack-like imperfection of 12.5 % depth. Then construct the ratios of the rupture pressures as described above and calculate k_a . The limitation and difficulty with this approach is that it is not valid unless the imperfection is sharp and crack-like. A mechanical or EDM notch is not adequate for this purpose. This means that the crack-like imperfection needs to be generated either as part of the pipe manufacturing process or else through fatigue pre-cracking. In general, the finite element approach combined with the J_{1c} measurement is easier to pursue.

7.3.3.4 Sensitivity of k_a

It turns out that k_a is a weakly sensitive parameter in regard to the grade of the pipe; that is, k_a primarily depends on the manufacturing process and does not vary much by grade within a fixed process. This is understandable since k_a only represents a potential amplification of the pipe's response to the presence of the crack while being loaded to rupture. Because of this, it is recommended that k_a only be determined for a specific grade of product and not for specific sizes or orders of product.

7.4 Design Equation for Capped-end Ductile Rupture

Minimum ductile rupture of a tube is defined by:

$$p_{IR} = 2k_{dr} f_{umr} (k_{wall} t - k_a a_N) / [D - (k_{wall} t - k_a a_N)] \quad (14)$$

where

a_N is the imperfection depth associated with a specified inspection threshold, i.e. the maximum depth of a crack-like imperfection that could reasonably be missed by the pipe inspection system. For example, for a 5 % imperfection threshold inspection in a 12.7 mm (0.500 in.) wall thickness pipe, $a_N = 0.635$ mm (0.025 in.);

D is the specified pipe outside diameter;

- f_{um} is the specified minimum tensile strength;
- k_a is the burst strength factor, having the numerical value 1.0 for quenched and tempered (martensitic structure) or 13Cr products and 2.0 for as-rolled and normalized products based on available test data, and the default value set to 2.0 where the value has not been measured; the value of k_a can be established for a specific pipe material based on testing;
- k_{dr} is the correction factor based on pipe deformation and material strain hardening, having the numerical value $[(1/2)^{n+1} + (1/\sqrt{3})^{n+1}]$;
- k_{wall} is the factor to account for the specified manufacturing tolerance of the pipe wall; e.g. for a tolerance of -12.5% , $k_{\text{wall}} = 0.875$;
- n is the dimensionless hardening index used to obtain a curve fit (see B.2.3.3) of the true stress-strain curve derived from the uniaxial tensile test;
- p_{IR} internal pressure at ductile rupture of an end-capped pipe;
- t specified pipe wall thickness.

The value selected for k_{dr} renders p_{IR} the average of rupture pressures predicted using Tresca yield condition and von Mises yield condition.

The factor k_{wall} addresses minimum pipe body wall thickness without considering imperfections. This value may be adjusted if minimum wall is guaranteed by a particular process or purchasing agreement.

Crack-like imperfections are accounted for by a_N . The term $k_a a_N$ represents a further reduction in minimum wall thickness associated with crack-like imperfections that are outside the sensitivity setting of the inspection equipment and assumed coincident with the location of minimum wall thickness. This stacking of minimum wall thickness and a crack-like imperfection depends on the frequency of occurrence of thin wall and the frequency of occurrence of sharp-bottomed imperfections approaching the depth of the inspection threshold.

For the deterministic calculation of rupture pressure, it is necessary to calculate a conservative ductile rupture design pressure. In this case, the frequency of occurrence of the imperfection is set to 100 % and the imperfection depth equals the inspection threshold.

For the probabilistic calculation of rupture pressure (see Annex B), the depth of the imperfection still equals the depth of the inspection threshold, but the calculation takes account of the actual frequency of occurrence of thin wall and the actual frequency of occurrence of sharp-bottomed imperfections with depth comparable to the inspection threshold.

7.5 Adjustment for the Effect of Axial Tension and External Pressure

7.5.1 General

The ductile rupture strength Equation (14) was developed for the situation of an end-capped pipe, where the axial tension is determined by the internal pressure acting on the closed inner pipe surface area. This is a special case of a more general situation where a pipe may reach a maximum internal pressure load, that is a rupture load, under the simultaneous action of arbitrary external pressure and arbitrary axial tension or compression. The combined loads together determine when the pipe is going to yield and how it will plastically deform toward the point of rupture. A fundamental criterion when this rupture load is attained can still be expressed, but this will now be a more involved equation governed by the formulation of the von Mises or Tresca yield surface in terms of axial stress, radial stress, and hoop stress.

Moreover, rupture is the prevailing failure mechanism only if the axial tension is not too large. For large axial tension and smaller internal overpressure, a maximum axial load (a precursor to necking and axial splitting of the pipe) is reached before the maximum pressure phenomenon occurs.

Below, equations for both rupture and necking under combined loads are described, together with a criterion to identify which phenomenon occurs first. The equation is given in terms of “effective axial tension” associated with “effective axial stress” defined in A.1.3.2.4. For effective axial tension, these approximate equations are very accurate when compared to the exact theoretical equation [24]; performance against combined loading test data is given in B.6.2.

For negative values of effective axial tension, i.e. effective axial compression, the pipe can buckle as a column, depending on the quality of lateral support. If buckling is adequately suppressed, the equation for rupture under combined loads is valid also for effective axial compression. However, for higher values of effective axial compression, it is the phenomenon of local buckling of the pipe wall (“wrinkling”) that presents the governing failure mechanism. Therefore, there exists a value of effective axial compression that limits the validity of the exact combined loading rupture equation.

7.5.2 Design Equation for Ductile Rupture under Combined Loads

In the presence of external pressure and axial tension or compression different from capped-end conditions, the general equation for ductile rupture is as follows:

$$p_{iRa} = p_o + \min[1/2(p_M + p_{ref T}), p_M] \quad (15)$$

with

$$p_M = p_{ref M} [1 - k_R (F_{eff}/F_{uts})^2]^{1/2} \quad (16)$$

where

$$F_a = \pi t (D - t) \sigma_a \quad (17)$$

$$F_{eff} = F_a + p_o \pi t (D - t) - p_M t (D - t) / [(k_{wall} t - k_a a_N) (D - k_{wall} t + k_a a_N)] \pi / 4 [D - 2 (k_{wall} t - k_a a_N)]^2 \quad (18)$$

$$F_{uts} = \pi t (D - t) f_{umn} \quad (19)$$

$$p_{uts} = 2 f_{umn} (k_{wall} t - k_a a_N) / [D - (k_{wall} t - k_a a_N)] \quad (20)$$

$$p_{ref} = 1/2 (p_{ref M} + p_{ref T}), \text{ used in Figure 1} \quad (21)$$

$$p_{ref M} = (2/\sqrt{3})^{1+n} (1/2)^n p_{uts} \quad (22)$$

$$p_{ref T} = (1/2)^n p_{uts} \quad (23)$$

$$k_R = (4^{1-n} - 1)/3^{1-n} \quad (24)$$

and

a_N is the imperfection depth associated with a specified inspection threshold, i.e. the maximum depth of a crack-like imperfection that could reasonably be missed by the pipe inspection system, e.g. for a 5 % imperfection threshold inspection in a 12.7 mm (0.500 in.) wall thickness pipe, $a_N = 0.635$ mm (0.025 in.);

D is the specified pipe outside diameter;

F_a is the axial force;

$f_{\text{um}}n$ is the specified minimum tensile strength;

F_{eff} is the effective axial load, i.e. for perfect pipes the axial load additional to the end-cap forces induced by internal and external pressures;

k_a is the burst strength factor, having the numerical value 1.0 for quenched and tempered (martensitic structure) or 13Cr products and 2.0 for as-rolled and normalized products based on available test data, and the default value set to 2.0 where the value has not been measured;

NOTE The value of k_a can be established for a specific pipe material based on testing.

k_{wall} is the factor to account for the specified manufacturing tolerance of the pipe wall; e.g. for a tolerance of -12.5% , $k_{\text{wall}} = 0.875$;

n is the dimensionless hardening index used to obtain a curve fit (see B.2.3.3) of the true stress-strain curve derived from the uniaxial tensile test;

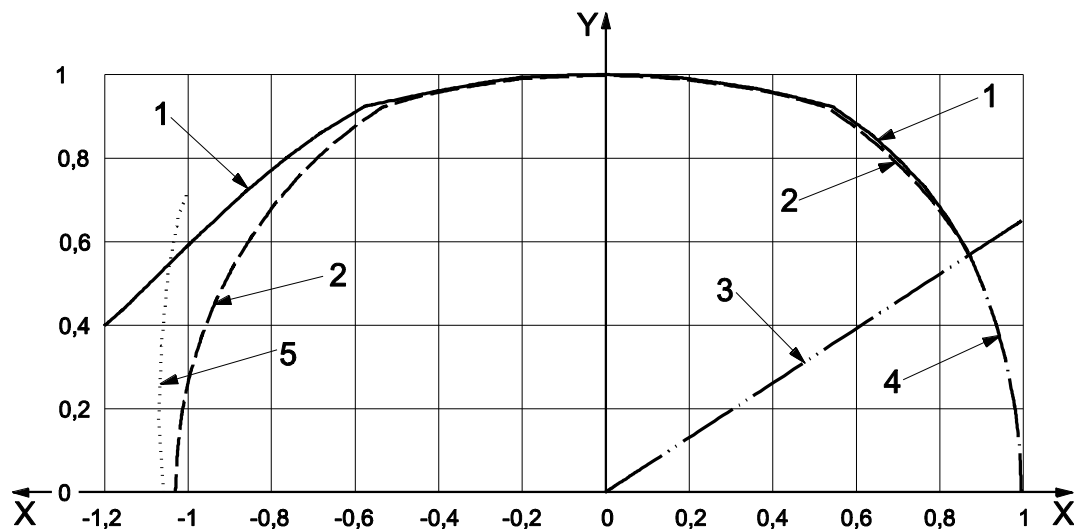
p_{iR} is the internal pressure at ductile rupture of an end-capped pipe;

p_{iRa} is p_{iR} adjusted for axial load and external pressure;

p_o is the external pressure;

t is the specified pipe wall thickness.

Equation (15) is illustrated in Figure 1, together with the exact formulation.



Key

- X effective axial tension ($F_{\text{eff}}/F_{\text{uts}}$)
- Y pressure differential $(p_i - p_o)/p_{\text{ref}}$
- 1 rupture (exact)
- 2 rupture [Equation (15)]
- 3 transition
- 4 necking [Equation (26)]
- 5 wrinkling

Figure 1—Illustration of the Effect of Effective Axial Tension and External Pressure on Ductile Rupture

Under capped-end conditions, the effective axial load is zero and Equation (15) reduces to Equation (14).

The rupture equation is valid; i.e. rupture occurs before necking, when:

$$F_{\text{eff}}/F_{\text{uts}} \leq (\sqrt{3}/2)^{1-n} \quad (25)$$

7.5.3 Design Equation for Ductile Necking under Combined Loads

In the presence of internal and external pressure, the general equation for ductile necking is as follows:

$$F_{\text{eff}} = F_{\text{uts}} \sqrt[3]{[1 - k_N [(p_i - p_o)/p_{\text{ref M}}]^2]} \quad (26)$$

where

$$F_a = \pi t (D - t) \sigma_a \quad (27)$$

$$F_{\text{eff}} = F_a + p_o \pi t (D - t) - p_M t (D - t) / [(k_{\text{wall}} t - k_a a_N) (D - k_{\text{wall}} t + k_a a_N)] \pi / 4 [D - 2 (k_{\text{wall}} t - k_a a_N)]^2 \quad (28)$$

$$F_{\text{uts}} = \pi t (D - t) f_{\text{umN}} \quad (29)$$

$$p_{\text{uts}} = 2 f_{\text{umN}} (k_{\text{wall}} t - k_a a_N) / [D - (k_{\text{wall}} t - k_a a_N)] \quad (30)$$

$$p_{\text{ref M}} = (2/\sqrt{3})^{1+n} (1/2)^n p_{\text{uts}} \quad (31)$$

$$k_N = 4^{1-n} - 3^{1-n} \quad (32)$$

Under zero pressure conditions, the effective axial load equals the true axial load, and Equation (26) for the maximum axial load reduces to the ultimate tensile strength.

The necking equation is valid; i.e. necking occurs before rupture, when:

$$(p_i - p_o)/p_{\text{ref M}} \leq (1/2)^{1-n} \quad (33)$$

7.5.4 Boundary between Rupture and Necking

Comparing Equations (15) and (26) reveals that the necking criterion is reached earlier than the rupture criterion when:

$$F_{\text{eff}}/F_{\text{uts}} \geq (3/2) (p_i - p_o)/p_{\text{uts}} \quad (34)$$

and this criterion (also shown in Figure 1) describes the boundary between rupture and necking.

7.5.5 Axisymmetric Wrinkling under Combined Loads

Figure 1 shows that in the axial compression range, i.e. for negative values of the effective axial load, Equation (15) is conservative when compared to both the exact rupture equation and the local pipe wall buckling limit, called wrinkling. Although it would be easy to construct an equation such as Equation (16) with a different factor k_R that would better fit the exact rupture curve in the effective axial compression range, it is perceived such a separate equation would not have great practical impact.

7.6 Example Calculations

7.6.1 Ductile Rupture of an End-capped Pipe

For an end-capped pipe under pressure load, the effective axial load is zero and Equations (14) and (15) are the same. Moreover, if burst tests are performed on end-capped pipes with an additional axial load applied at the closed pipe ends, this is a situation where the effective axial load is given and Equation (15) can be used directly to calculate the rupture pressure for any value of effective axial load.

Compute the ductile rupture pressure of a 177.8 mm (7 in.) tube with wall thickness 11.51 mm (0.453 in.) made of P110 material. The tube is end-capped, and no additional axial load is present. Use the hardening index suggested in Table 2 and assume an inspection threshold of 5 % of the wall thickness.

Table 3 presents the results of the calculation in both SI and USC units.

Table 3—Example Calculations: Ductile Rupture of an End-capped Pipe

Term	SI		USC	
	Value	Units	Value	Units
Load				
F_{eff}	0	N	0	lb
Geometry				
D	177.8	mm	7	in.
t	11.51	mm	0.453	in.
k_{wall}	0.875		0.875	
Material				
E	206,842	MPa	30,000,000	psi
f_{um}	862	MPa	125,000	psi
Calculations				
n	0.08		0.08	
a_N	0.575	mm	0.0227	in.
k_a	1		1	
p_{IR}	99.7	MPa	14,460	psi

7.6.2 Ductile Rupture for a Given True Axial Load

If the true axial load on the pipe is given, the pressure differential p_M cannot be calculated directly from Equation (15), because the effective axial load is a function of p_M . The solution can be found by solving for p_M iteratively, or by rewriting Equation (15) as a quadratic equation in the unknown p_M .

Compute the ductile rupture pressure of a 177.8 mm (7 in.) tube with wall thickness 11.51 mm (0.453 in.) made of P110 material. The axial compressive load is 889,600 N (200,000 lb). Use the hardening index suggested in Table 2 and assume an inspection threshold of 5 % of the wall thickness.

Table 4 presents the results of the calculation in both SI and USC units.

Table 4—Example Calculations: Ductile Rupture for a Given True Axial Load

Term	SI		USC	
	Value	Units	Value	Units
Load				
F_a	−889,600	N	−200,000	lb
p_o	0	MPa	0	psi
Geometry				
D	177.8	mm	7	in.
t	11.51	mm	0.453	in.
k_{wall}	0.875		0.875	
k_a	1		1	
Material				
E	206,842	MPa	30,000,000	psi
f_{umn}	862	MPa	125,000	psi
Calculations				
n	0.08		0.08	
a_N	0.5758	mm	0.0227	in.
F_{uts}	5,180,423	N	1,164,663	lb
p_{uts}	97.22	MPa	14,100	psi
$P_{ref T}$	91.98	MPa	13,340	psi
$P_{ref M}$	107.43	MPa	15,581	psi
k_R	0.93901		0.93901	
p_M	92.47	MPa	13,412	psi
p_{iRa}	92.22	MPa	13,376	psi

8 External Pressure Resistance

8.1 General

The collapse design equation is intended for load cases when the external fluid pressure exceeds internal fluid pressure. A convenient, theoretically rigorous equation for cross-sectional collapse of a tube that accounts for realistic imperfections does not currently exist. The approach taken here combines theoretical, numerical, and statistical tools.

The equations in Section 8 are taken directly from Reference [2]. The collapse equations presented here were originally developed in USC units and should only be used in these units.

8.2 Assumptions and Limitations

The following limitation applies to the design equations for external pressure resistance:

- the axial tension correction does not include the nonuniform axial stress component due to bending. Including bending is a design issue left to the individual user.

8.3 Data Requirements

The following input data are required to complete the calculation for collapse of the pipe body:

- D specified pipe outside diameter;
- f_{ymn} specified minimum yield strength;
- t specified pipe wall thickness.

8.4 Design Equation for Collapse of Pipe Body

8.4.1 General

The minimum collapse strength for pipe with no axial force or internal pressure is given by a series of equations, depending on the specified minimum yield strength and cross-sectional dimensions of the tube body.

8.4.2 Yield Strength Collapse Pressure Equation

The yield strength collapse pressure is not a true collapse pressure, but rather the external pressure, p_{Yp} , that generates minimum yield stress, f_{ymn} , on the inside wall of a tube as calculated by:

$$p_{Yp} = 2 f_{ymn} [(D/t) - 1]/[(D/t)^2] \quad (35)$$

where

- D is the specified pipe outside diameter;
- f_{ymn} is the specified minimum yield strength;
- p_{Yp} is the pressure for yield strength collapse;
- t is the specified pipe wall thickness.

Equation (35) for yield strength collapse pressure is applicable for D/t values up to the value of D/t corresponding to the intersection with the plastic collapse [Equation (37)]. This intersection is calculated by:

$$(D/t)_{yp} = \{[(A_c - 2)^2 + 8(B_c + C_c/f_{ymn})]^{1/2} + (A_c - 2)\}/[2(B_c + C_c/f_{ymn})] \quad (36)$$

where

- A_c is the empirical constant in historical API collapse equation;
- B_c is the empirical constant in historical API collapse equation;
- C_c is the empirical constant in historical API collapse equation;
- f_{ymn} is the specified minimum yield strength.

The parameters used to calculate collapse pressures depend on the pipe yield strength and on the axial load, as explained in later subsections.

The applicable D/t ratios for yield strength collapse are shown in Table 5.

Table 5—Yield Collapse Pressure Equation Range

Grade ^a	D/t Range ^b
H40	16.40 and less
–50	15.24 and less
J55, K55	14.81 and less
–60	14.44 and less
–70	13.85 and less
C75, E75	13.60 and less
L-N-80	13.38 and less
C90	13.01 and less
R95, T95, X95	12.85 and less
–100	12.70 and less
P105, G105	12.57 and less
P110	12.44 and less
–120	12.21 and less
Q125	12.11 and less
–130	12.02 and less
S135	11.92 and less
–140	11.84 and less
–150	11.67 and less
–155	11.59 and less
–160	11.52 and less
–170	11.37 and less
–180	11.23 and less

^a Grades indicated without letter designation are not API grades but are grades in use or grades being considered for use and are shown for information purposes.

^b The D/t range values were calculated from Equations (36), (43) or (48), (44) or (49), and (45) or (50).

8.4.3 Plastic Collapse Pressure Equation

The minimum collapse pressure for the plastic range of collapse is calculated by:

$$p_P = f_{ymn} [A_c/(D/t) - B_c] - C_c \quad (37)$$

where

A_c is the empirical constant in historical API collapse equation;

- B_c is the empirical constant in historical API collapse equation;
- C_c is the empirical constant in historical API collapse equation;
- D is the specified pipe outside diameter;
- f_{ymn} is the specified minimum yield strength;
- p_p is the pressure for plastic collapse;
- t is the specified pipe wall thickness.

The equation for minimum plastic collapse pressure is applicable for D/t values ranging from $(D/t)_{yp}$, Equation (36) for yield strength collapse pressure, to the intersection with Equation (39) for transition collapse pressure $(D/t)_{pt}$. Values for $(D/t)_{pt}$ are calculated by means of:

$$(D/t)_{pt} = [f_{ymn} (A_c - F_c)] / [C_c + f_{ymn} (B_c - G_c)] \quad (38)$$

where

- A_c is the empirical constant in historical API collapse equation;
- B_c is the empirical constant in historical API collapse equation;
- C_c is the empirical constant in historical API collapse equation;
- F_c is the empirical constant in historical API collapse equation;
- f_{ymn} is the specified minimum yield strength;
- G_c is the empirical constant in historical API collapse equation.

The factors and applicable D/t range for the plastic collapse equation are shown in Table 6.

Table 6—Equation Factors and D/t Range for Plastic Collapse

Grade ^a	A_c	B_c	C_c psi	D/t Range ^b
H40	2.950	0.0465	754	16.40 to 27.01
–50	2.976	0.0515	1056	15.24 to 25.63
J55, K55	2.991	0.0541	1206	14.81 to 25.01
–60	3.005	0.0566	1356	14.44 to 24.42
–70	3.037	0.0617	1656	13.85 to 23.38
C75, E75	3.054	0.0642	1806	13.60 to 22.91
L-N-80	3.071	0.0667	1955	13.38 to 22.47
C90	3.106	0.0718	2254	13.01 to 21.69
R95, T95, X95	3.124	0.0743	2404	12.85 to 21.33
–100	3.143	0.0768	2553	12.70 to 21.00
P105, G105	3.162	0.0794	2702	12.57 to 20.70
P110	3.181	0.0819	2852	12.44 to 20.41
–120	3.219	0.0870	3151	12.21 to 19.88
Q125	3.239	0.0895	3301	12.11 to 19.63
–130	3.258	0.0920	3451	12.02 to 19.40
S135	3.278	0.0946	3601	11.92 to 19.18
–140	3.297	0.0971	3751	11.84 to 18.97
–150	3.336	0.1021	4053	11.67 to 18.57
–155	3.356	0.1047	4204	11.59 to 18.37
–160	3.375	0.1072	4356	11.52 to 18.19
–170	3.412	0.1123	4660	11.37 to 17.82
–180	3.449	0.1173	4966	11.21 to 17.47

^a Grades indicated without letter designation are not API grades but are grades in use or grades being considered for use and are shown for information purposes.

^b The D/t range values and equation factors were calculated from Equations (36), (38), (43) or (48), (44) or (49), (45) or (50), (46) or (51), and (47) or (52).

8.4.4 Transition Collapse Pressure Equation

The minimum collapse pressure for the plastic to elastic transition zone p_T is calculated by:

$$p_T = f_{ymn} [F_c/(D/t) - G_c] \quad (39)$$

where

- D is the specified pipe outside diameter;
- F_c is the empirical constant in historical API collapse equation;
- f_{ymn} is the specified minimum yield strength;
- G_c is the empirical constant in historical API collapse equation;
- p_T is the pressure for transition collapse;
- t is the specified pipe wall thickness.

The equation for p_T is applicable for D/t values from $(D/t)_{pt}$, Equation (38) for plastic collapse pressure, to the intersection $(D/t)_{te}$ with Equation (41) for elastic collapse. Values for $(D/t)_{te}$ are calculated by:

$$(D/t)_{te} = [2 + B_c/A_c]/[3(B_c/A_c)] \quad (40)$$

where

A_c is the empirical constant in historical API collapse equation;

B_c is the empirical constant in historical API collapse equation.

The factors and applicable D/t range for the transition collapse pressure equation are shown in Table 7.

Table 7—Equation Factors and D/t Range for Transition Collapse

Grade ^a	F_c	G_c	D/t Range ^b
H40	2.063	0.0325	27.01 to 42.64
–50	2.003	0.0347	25.63 to 38.83
J55, K55	1.989	0.0360	25.01 to 37.21
–60	1.983	0.0373	24.42 to 35.73
–70	1.984	0.0403	23.38 to 33.17
C75, E75	1.990	0.0418	22.91 to 32.05
L-N-80	1.998	0.0434	22.47 to 31.02
C90	2.017	0.0466	21.69 to 29.18
R95, T95, X95	2.029	0.0482	21.33 to 28.36
–100	2.040	0.0499	21.00 to 27.60
P105, G105	2.053	0.0515	20.70 to 26.89
P110	2.066	0.0532	20.41 to 26.22
–120	2.092	0.0565	19.88 to 25.01
Q125	2.106	0.0582	19.63 to 24.46
–130	2.119	0.0599	19.40 to 23.94
S135	2.133	0.0615	19.18 to 23.44
–140	2.146	0.0632	18.97 to 22.98
–150	2.174	0.0666	18.57 to 22.11
–155	2.188	0.0683	18.37 to 21.70
–160	2.202	0.0700	18.19 to 21.32
–170	2.231	0.0734	17.82 to 20.60
–180	2.261	0.0769	17.47 to 19.93
^a Grades indicated without letter designation are not API grades but are grades in use or grades being considered for use and are shown for information purposes. ^b The D/t range values and equation factors were calculated from Equations (36), (38), (43) or (48), (44) or (49), (45) or (50), (46) or (51), and (47) or (52).			

8.4.5 Elastic Collapse Pressure Equation

The minimum collapse pressure for the elastic range of collapse is calculated by:

$$p_E = 46.95 \times 10^6 / [(D/t) (D/t - 1)^2] \quad (41)$$

where

D is the specified pipe outside diameter;

p_E is the pressure for elastic collapse;

t is the specified pipe wall thickness.

The applicable D/t range for elastic collapse is shown in Table 8.

Table 8— D/t Range for Elastic Collapse

Grade ^a	D/t Range ^b
H40	42.64 and greater
–50	38.83 and greater
J55, K55	37.21 and greater
–60	35.73 and greater
–70	33.17 and greater
C75, E75	32.05 and greater
L-N-80	31.02 and greater
C90	29.18 and greater
R95, T95, X95	28.36 and greater
–100	27.60 and greater
P105, G105	26.89 and greater
P110	26.22 and greater
–120	25.01 and greater
Q125	24.46 and greater
–130	23.94 and greater
S135	23.44 and greater
–140	22.98 and greater
–150	22.11 and greater
–155	21.70 and greater
–160	21.32 and greater
–170	20.60 and greater
–180	19.93 and greater
^a Grades indicated without letter designation are not API grades but are grades in use or grades being considered for use and are shown for information purposes. ^b The D/t range values were calculated from Equations (40), (43) or (48), and (44) or (49).	

8.4.6 Collapse Pressure under Axial Tension Stress and Internal Pressure

The above equations for collapse resistance p_c are valid for zero axial stress and zero internal pressure. The external pressure at collapse under combined axial stress and internal pressure can be calculated by replacing the collapse resistance p_c by the collapse pressure differential $p_c - p_i$ and at the same time modifying the yield stress to a combined loading equivalent grade according to Equation (42) for $\sigma_a + p_i \geq 0$:

$$f_{ycom} = \{[1 - 0.75((\sigma_a + p_i) / f_{ymn})^2]^{1/2} - 0.5 (\sigma_a + p_i) / f_{ymn}\} f_{ymn} \quad (42)$$

where

f_{ycom} is the combined loading equivalent grade, the equivalent yield strength in the presence of axial stress and internal pressure;

f_{ymn} is the specified minimum yield strength;

σ_a is the component of axial stress not due to bending;

p_i is the internal pressure.

Collapse resistance equation factors and D/t ranges for the combined loading equivalent grade are then calculated by means of Equations (36), (38), (40), (43) or (48), (44) or (49), (45) or (50), (46) or (51), and (47) or (52). Using equation factors for the combined loading equivalent grade, collapse resistance under axial stress and internal pressure is calculated by means of Equations (35), (37), (41), and (39).

API collapse resistance equations are not valid for the yield strength of combined loading equivalent grade (f_{ycom}) less than 24,000 psi.

Equation (42) is based on the Hencky-von Mises maximum strain energy of distortion theory of yielding.

8.5 Equations for Empirical Constants

The following equations may be used to calculate the empirical constants in the historical API collapse equations. There are two versions of each equation, one each for SI and USC units.

SI units:

$$A_c = 2.8762 + 0.15489 \times 10^{-3} f_{ymn} + 0.44809 \times 10^{-6} f_{ymn}^2 - 0.16211 \times 10^{-9} f_{ymn}^3 \quad (43)$$

$$B_c = 0.026233 + 0.73402 \times 10^{-4} f_{ymn} \quad (44)$$

$$C_c = -3.2125 + 0.030867 f_{ymn} - 0.15204 \times 10^{-5} f_{ymn}^2 + 0.778 \times 10^{-9} f_{ymn}^3 \quad (45)$$

$$F_c = 3.237 \times 10^5 [(3 B_c/A_c)/(2 + B_c/A_c)]^3 / \{ f_{ymn} [(3 B_c/A_c)/(2 + B_c/A_c) - B_c/A_c][1 - (3 B_c/A_c)/(2 + B_c/A_c)]^2 \} \quad (46)$$

$$G_c = F_c B_c/A_c \quad (47)$$

where

A_c is the empirical constant in historical API collapse equation;

B_c is the empirical constant in historical API collapse equation;

C_c is the empirical constant in historical API collapse equation;

F_c is the empirical constant in historical API collapse equation;

f_{ymn} is the specified minimum yield strength;

G_c is the empirical constant in historical API collapse equation.

USC units:

$$A_c = 2.8762 + 0.10679 \times 10^{-5} f_{ymn} + 0.21301 \times 10^{-10} f_{ymn}^2 - 0.53132 \times 10^{-16} f_{ymn}^3 \quad (48)$$

$$B_c = 0.026233 + 0.50609 \times 10^{-6} f_{ymn} \quad (49)$$

$$C_c = -465.93 + 0.030867 f_{ymn} - 0.10483 \times 10^{-7} f_{ymn}^2 + 0.36989 \times 10^{-13} f_{ymn}^3 \quad (50)$$

$$F_c = 46.95 \times 10^6 [(3 B_c/A_c)/(2 + B_c/A_c)]^3 / \{ f_{ymn} [(3 B_c/A_c)/(2 + B_c/A_c) - B_c/A_c][1 - (3 B_c/A_c)/(2 + B_c/A_c)]^2 \} \quad (51)$$

$$G_c = F_c B_c/A_c \quad (52)$$

where

A_c is the empirical constant in historical API collapse equation;

B_c is the empirical constant in historical API collapse equation;

C_c is the empirical constant in historical API collapse equation;

F_c is the empirical constant in historical API collapse equation;

f_{ymn} is the specified minimum yield strength;

G_c is the empirical constant in historical API collapse equation.

8.6 Application of Collapse Pressure Equations to Line Pipe

The collapse pressure equations presented in this section are empirical relations derived from tests on pipe representative of the casing and tubing inventories listed in API 5CT or ISO 11960. Application of these relations outside the range of yield strengths and D/t ratios contained in API 5CT or ISO 11960 is not recommended. These equations do not apply to cold expanded pipe because Bauschinger effects significantly reduce collapse resistance. Some line pipe grades listed in API 5L have a rough casing equivalent in API 5CT or ISO 11960. However, the API 5L pipe inventory contains D/t ratios that often exceed casing D/t ratios.

Cold-expanded line pipe—for example, UOE or JCOE line pipe—can exhibit collapse performance lower than the design equations in this clause. Pipeline design guidelines API 1111 and DNVGL-ST-F101 provide correlations that have been shown to yield more accurate collapse design rating predictions when compared to collapse test results. Both pipeline guidelines provide factors to add a design margin to the predicted collapse pressure, resulting in a design rating approach commensurate with this clause.

For line pipe that is not cold-expanded and has a yield strength and D/t falling within the limits of the sizes and thicknesses listed in API 5CT or ISO 11960, application of the equations in this section should yield reasonable estimates of minimum collapse pressure. Nevertheless, as with the application of any of the equations in this document, sound engineering judgment should prevail.