

GENERAL SPECIFICATION

Drilling & Wells

GS EP FP 337

Manufacture of OCTG Crossovers

04	12/2019	General revision – Covers all topics raised during Maersk Oil Gap Analysis
03	10/2015	Update of design, inspection and testing, Quality Assurance and Third Party Inspection sections
02	01/2012	Revision of the referential following E&P reorganisation, March 2011
01	09/2009	Update of reference documents
00	05/2007	First issue
Rev.	Date	Purpose of the revision

Owning entity: DSO/FP	Managing entity: DSO/FP
Other Approving entity(ies):	

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1. Scope

This document, based on the requirements of [GS EP FP 330](#) and [GS EP FP 335](#), defines the technical requirements for permanently installed downhole OCTG crossovers to be manufactured and supplied for use within the Company.

This General Specification is applicable to crossovers specified with different diameter connections or different type of connections from one side to the other that are intended to be part of the permanent well installation. The crossover shall be manufactured from [API SPEC 5CT](#) or [API SPEC 5 CRA](#) material grades and Company free-issue material.

2. Reference documents

The reference documents listed below form an integral part of this General Specification.

External Documents

Unless otherwise stipulated, the applicable version of these documents, including relevant appendices and addendums, is the latest revision published at the effective date of this document.

Reference	Title
API SPEC 5CRA	Specification for Corrosion Resistant Alloy Seamless Tubes for Use as Casing, Tubing and Coupling Stock
API SPEC 5CT	Specification for Casing and Tubing
API SPEC Q1	Specification for Quality Management System Requirements for Manufacturing Organizations for the Petroleum and Natural Gas Industry
ASNT SNT-TC-1A	Personnel Qualification and Certification in Nondestructive Testing
EN 10204	Metallic products - Types of inspection documents
ISO 8501-1	Preparation of steel substrates before application of paints and related products - Visual assessment of surface cleanliness - Part 1: Rust grades and preparation grades of uncoated steel substrates and of steel substrates after overall removal of previous coatings
ISO 9712	Non-destructive testing - Qualification and certification of NDT personnel
ISO 10005	Quality management - Guidelines for quality plans
ISO 14001	Environmental Management Systems - Requirements with guidance for use
NACE MR 0175/ISO 15156	Petroleum and natural gas industries - Materials for use in H ₂ S-containing environment in oil and gas production

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Total General Specifications

Unless otherwise stipulated, the applicable version of these documents, including relevant appendices and addendums, is the latest revision published.

Reference	Title
GS EP FP 330	Specification for new seamless OCTG carbon & low alloy material Manufacturing
GS EP FP 331	Purchase from stock of Conductor Pipe and seamless OCTG in carbon, low alloy and corrosion-resistant material
GS EP FP 335	Specification for new seamless OCTG in corrosion-resistant material Manufacturing

3. Application

Any Crossover supplied to Company under this specification shall be manufactured by a Company-approved Manufacturer. Approval is granted by the QAQC entity within D&W in HQ.

3.1 Waiver / Derogation

Any significant deviation from the requirements stipulated in this document shall be approved by the relevant HQ DSO Product Line, upon recommendation of the QAQC entity within D&W in HQ following the submission by the D&W entity of the subsidiary of a formal derogation request.

Should the equipment delivered by the Manufacturer not fulfil the requirements of this General Specification, and should the Manufacturer not be granted the derogation by the purchaser, then the Third-Party inspection representative will not accept the materials.

4. Glossary

CRA	Corrosion Resistant Alloy
D&W	Drilling and Wells
GRAL	General Rolling Action List: Continuous improvement process tracking system
HQ	Head Quarters
IQ-ALL	Integrity & Quality for ALL: Inspection and Vendor Management web application
MPI	Magnetic Particle Inspection
NCR	Non-Conformance Report
NDE/NDT	Non-Destructive Examination / Non-Destructive Testing
OCTG	Oil Country Tubular Goods
PO	Purchase Order
PSL	Product Specification Level
QAQC	Quality Assurance Quality Control
QCP	Quality Control Plan (also known as QP or ITP in some organizations)

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QMS Quality Management System
TPI Third-Party Inspection

5. Purchase Requirements

The Purchaser should consult **the relevant Company standard** before selecting the Manufacturer.

The Manufacturer of the crossover shall be licensed to [API SPEC 5CT](#) and [API SPEC Q1](#).

When enquiring or placing orders for equipment to be manufactured in accordance with this Company specification, the Purchaser shall specify the following details as described in Section 5.1.

5.1 Requirements to be specified on Purchase Order / Enquiry

The following information, as a minimum, shall be described in the Purchase Order:

- I. Standard [API SPEC 5CT](#) or agreed proprietary specification, or this Company specification or any Company approved quality plan with the given Supplier.
- II. Quantity.
- III. Specified outside diameters.
- IV. Specified mass (weight) or wall thickness.
- V. Length.
- VI. Grade and type where applicable.
- VII. Drift (special if required).
- VIII. Marking requirements.
- IX. Thread and storage compound.
- X. Thread protectors.
- XI. Coatings – (internal / external).
- XII. Packaging instructions.
- XIII. Quality assurance requirements.
- XIV. Delivery date and shipping instructions
- XV. Certification requirements.
- XVI. Any already granted deviation from this General Specification requirements.

A copy of the Purchase Order shall be provided to Company QAQC entity in D&W at HQ and / or to Company affiliate QAQC entity (if any) for technical and quality review and TPI allocation.

5.2 Vendor Acknowledgement of the Purchase Order

Prior to the acknowledgement of the Purchase Order, the Vendor shall:

- Ensure that the requirements from above Section 5.1 are fulfilled,