

## 1.10 Make up dopes

### Type of compounds

All make-up dopes should conform to API 5A3 or qualified to Vallourec & Mannesmann Tubes specification.

Make-up dopes	Manufacture	Comments
Bestolife PTC	Bestolife Corporation	Green dope
Kendex Enviro Seal	Kendex	Green dope
Malleus STC1		Green dope
White Tubular Protection International (Veritas 635SR)		Green dope
Premium Grease Plus	Total	Green dope
The above dopes were satisfactorily tested in the laboratory with VAM connections and confirmed their good behaviour when used in the field.		
If due to strong request from the customer another make-up dope may be used but only under the customers responsibility.		

This dope guarantees:

- Antigalling properties
- Good metal to metal seal tightness \* leak proof connection.

Before starting the job, check that:

1. The compound is acceptable.
2. If any expiry date is marked on the canister and it has not been exceeded.
3. There is sufficient quantity of thread compound to complete the job.

In cases the friction factor cannot be positively determined, get a written approval from the customer and use VAM barrettes to check the make-up.

### Recommendations

- Use a new unopened canister cleaned and free of foreign particles (i.e. filings, chips...).
- Keep water, filings, drilling fluids and all other foreign material out of the compound.
- Use clean flat nylon brushes to apply the compound.
- Close the canister after using it.
- In cold weather, keep the compound in a warm place.
- In hot weather make sure compound is regularly mixed.

## 1.10 Make up dopes

### **1 - SCOPE OF APPLICATION**

This specification gives dopes for make-up of VAM connections:

- dopes that are recommended because of experience (field running) or test;
- dopes which shall be used for some specific customers (end users).

### **2 - RECOMMENDED MAKE-UP DOPES FOR VAM CONNECTIONS**

#### **2.1 – API Modified Thread Compound**

All make-up dopes that are in conformance with API Recommended Practices 5A2 and 5A3 respectively regarding their composition and their performances can be used with VAM connections whatever is the manufacturer.

#### **2.2 – Other recommended make-up dopes**

The following make-up dopes can be used for all VAM connections except Big Omega and *DINO VAM*.

Make-up dope	Manufacturer	Qualification level (1)			Comments
		<i>C-Steel</i>	<i>13%Cr</i>	<i>S13%Cr CRA</i>	
Malleus STC1	Shell	approved	approved		Green dope
Multi Make White (2) (Mercasol 633 SR)	Tubular Protection International	approved	approved		Green dope
Seal Guard (revision 2)	Jet Lube	approved	approved	approved	Green dope
TIFORA PG (N30964)	Total	approved	approved		Green dope
<i>Seal Guard ECF</i>	<i>Jet Lube</i>	<i>approved</i>	<i>approved</i>	<i>approved</i>	<i>Green dope</i>
<i>3010 NM Special</i>	<i>Bestolife</i>	<i>approved</i>	<i>approved</i>		<i>Green dope</i>

Table 1: Approved make-up thread compounds other than API Modified for all VAM connections

- (1) “approved” means that the dope can ensure a minimum of 5 to 10 Make and Break without galling.
- (2) This is the old version of Multi Make White (Mercasol 633 SR); New Multi Make White (Mercasol 633 SR) is not qualified so far.

For Big Omega only :

<b>Make-up dope</b>	<b>Manufacturer</b>	<b>Comments</b>
Liquid O Ring 104	Weatherford	-
TF 15	Jet Lube	-
Bakerlock	Baker	-
<i>2010 NM Ultra</i>	<i>Bestolife</i>	-

**Table 2:** Recommended make-up thread compounds other than API Modified for Big Omega connections

*For DINO VAM only :*

<b><i>Make-up dope</i></b>	<b><i>Manufacturer</i></b>	<b><i>Comments</i></b>
<i>2010 NM Ultra</i>	<i>Bestolife</i>	-

**Table 3:** Recommended make-up thread compounds other than API Modified for DINO VAM connections

### **3 – OTHER MAKE-UP DOPES**

**Only the make-up thread compounds listed in Section 2 are approved for VAM connections.**

**If, due to strong request from the customer a Licensee shall use another make-up dope, it may be done under the customer's responsibility.**

The following table lists the make-up thread compounds required by some customers and to be applied by the VAM licensees.

<b>Customer (end user)</b>	<b>Manufacturer</b>	<b>Dope</b>
BP	BP	AS 13
Exxon Mobil	Exxon Jet Lube Esso Japan Bestolife	709 TF 15 Penekote 706 PTC
Phillips Norway	Loctite	Seal Lube LTF4444
WOP (Australia)	Shell	HP Thread Compound (No Lead)

**Table 4: Make-up thread compounds other than API Modified used by some customers**

**In case of doubt, please contact VAM Services.**

- Remove any other thread compound from the rig floor to prevent any confusion.
- **NEVER USE WIRE BRUSHES.**

**Note:** If the connection is wet, it should be dried as best as possible, with compressed air or with a rag before applying compound.

Application of compound

The minimum quantity of compound should be shared between Pin and Box end as follows:

2/3 on box in the best distribution  
1/3 on pin

**NEVER LEAVE THE BOX UNGREASED UNLESS OTHERWISE ADVISED**

**Note:** - It is acceptable to apply 100% of compound to BOX ends of VAM PRO and DINO VAM connections.

Apply the dope evenly in order to get a uniform coating on all parts of the connection.

**Note:** If a dope applicator is used for the box end, it shall be adjusted to apply the above recommended quantity of dope.

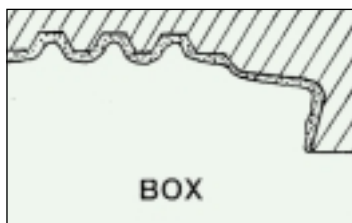
The use of such a device does not waive applying dope on the pin end.

How to dope couplings

Evenly apply the correct quantity of dope to all the machined surfaces in the coupling interior except the machined weight bore D1.

The dope must reach the bottom of the thread.

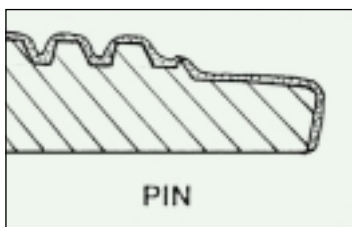
Example of how to dope a VAM coupling



### How to dope the pin ends

Evenly apply the correct quantity of dope to the thread, even imperfect threads as well as the machined ends (ring, seal, bore, face).

The dope must "reach" the bottom of the thread.



If the connection cannot be effectively dried, compound must be applied to both pin and box ends as the pipe is standing in the V-door or pipe deck.

**Caution:** If a connection needs to be broken-out because of non-acceptable criteria, the connection must be completely broken-out.

**Breaking out a connection for 2 turns only and making it up again is forbidden.**

Clean and dope again before remake-up.

**REMEMBER: GOOD DOPING IS THE KEY TO SUCCESS.**

**Check relevant connection for dope quantity.**