



After stabbing the stabber must maintain the pipe in a vertical position.

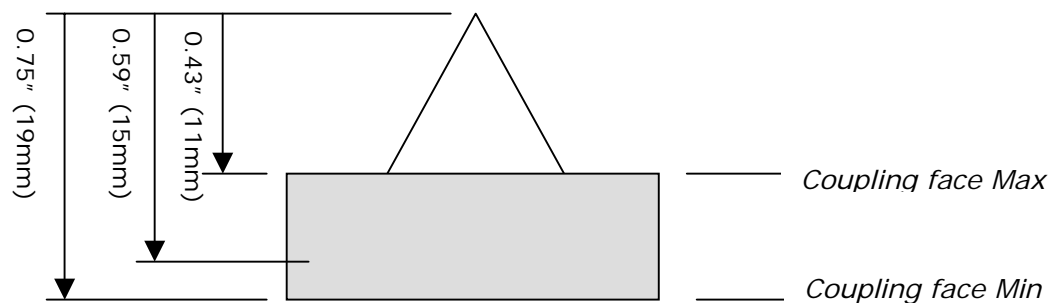
For bigger casing thread engagement is achieved by using the make-up tong. To avoid excessive torque during thread engagement the anchor cable of the tong should be load free.

Vallourec & Mannesmann strongly recommend using a torque monitoring system.

Big Omega connections must be made up with a certain torque value

- A triangle is stencilled on each thread. A long white line on the pipe –end site, marks the location.
- To find the proper torque at least 10 power make ups to the base of this triangle should be carried out. The average torque value of these make ups is the proper torque to run the total casing string.
- Power make-up procedure **should not** be interrupted until the proper torque value is reached.
- Every connection should be checked for correct power make-up position. The coupling status after power make-up must be within the tolerance area of 0.433" (11mm) to 0.748" (19mm) referred to the apex of triangle.

Make-up Position

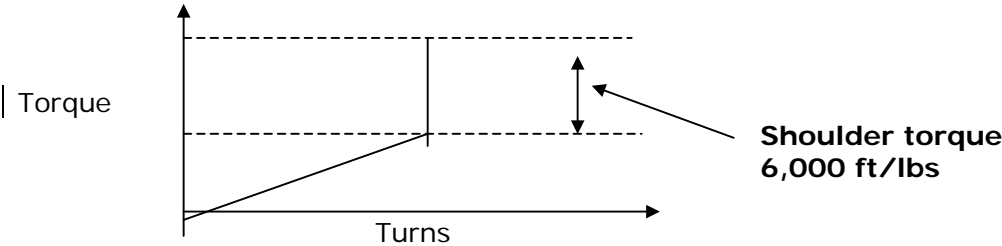


Make-up torque table as guide for choice of power tong capacity. **Big Omega**

OD Inch	Guiding make-up torque values with API mod thread compound All grades	
	Ft.lbs	Nm
14	12000	16500
16	13000	17500
18 5/8	15000	20500
18.788	15000	20500
20	16000	22000
24	17000	23500
24 1/2	18000	25000
26	20000	27500

Make-up torque table for shoulder torque to be applied. **Big Omega IS**

O D Inch	Torque to be applied to internal shoulder		
	Grade	Ft/lbs	Nm
18 5/8	X56	6,000	8,000
20	L80	6,000	8.000



Commonly experienced torque factors:

- API modified thread compound: 1.0
- Liquid-O-Ring 104: 0.8
- Jet Lube TF15: 0.9
- Bakerlock: 1.3