

Slip-on Weld Casing Head Installation



Installation Procedure
for
Slip-on Weld Casing Head



Required Forms:

- ① DELIVERY TICKET
- ② FIELD SERVICE ORDER
- ③ JSA

SLIP-ON WELD CASING HEAD

Product Description

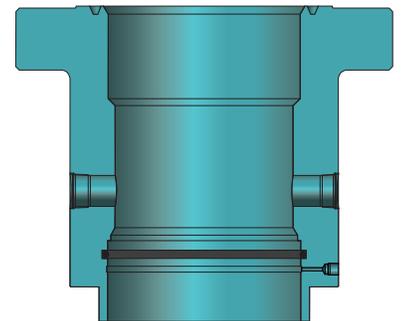
The C-22 Casing Head is the industry standard bowl design. It accepts a wide variety of wear bushings and test plugs that are readily available. The flange can be incorporated with two or four BP pins to secure the wear bushing during drilling. It can also have a full set of lock-down pins to safely secure a mandrel casing hanger. Outlets can be either threaded, studded, or flanged.

The C-22 bowl will accept several different types of casing hangers; C-22 automatic slip type (Medium weight), C-21 manual slip type (low weight), and various types of mandrel hangers. The casing head can be ported for DDV installation, pinned for dual completion alignment pins, and can be used in conjunction with a multi-bowl system.

Bottom preps can be Slip-on-Weld without O-ring, Slip-on-Weld with O-ring, Threaded 8rd box or 8rd pin, or Slip-Lock. Various sizes of base plates can be pre-installed to help support the casing string and stack weight. They provide support by creating a base that allows some of the weight to be transferred to the conductor pipe. UWS can design the proper size base plate for your well.

PURPOSE

This procedure covers *Slip-on-Weld* Casing Head installation.



PRODUCT DESCRIPTION	1
PURPOSE	1
REQUIRED EQUIPMENT	2
A. CASING CUT PROCEDURE	3
B. BEVEL PROCEDURE	4
C. INSTALLATION PROCEDURE	5
D. WELDING PROCEDURE	6
REVISION LOG	7
E. RECOMMENDED FIELD WELDING PROCEDURE	9

Required Equipment:

MAIN EQUIPMENT

Service Truck with Basic Tools

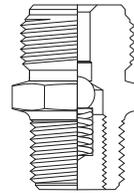
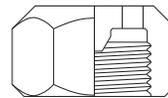
Test Pump

Wire Brush or Grinder with Flapper Wheel

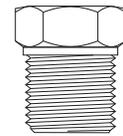
FITTINGS

Test Port Fitting

Solid Cavity Pipe Plugs, 1/2" NPT



Test Port Fitting



1/2" NPT Pipe Plug

REQUIRED SPARE PARTS

Internal O-rings (Qty. 2)

Test Port Fittings, 1/2" NPT (Qty. 2)

Pipe Plugs, 1/2" NPT (Qty. 2)

FLUIDS

Approved Test Fluids *(see page 6)*

OPTIONAL EQUIPMENT

Base Plate

A. Casing Cut Procedure:

for Heads with No Base Plate

- 1 Determine the correct elevation for the casing head and cut the conductor pipe level with the cellar floor.
- 2 Cut the surface casing so the casing head is at the desired height. (see below)

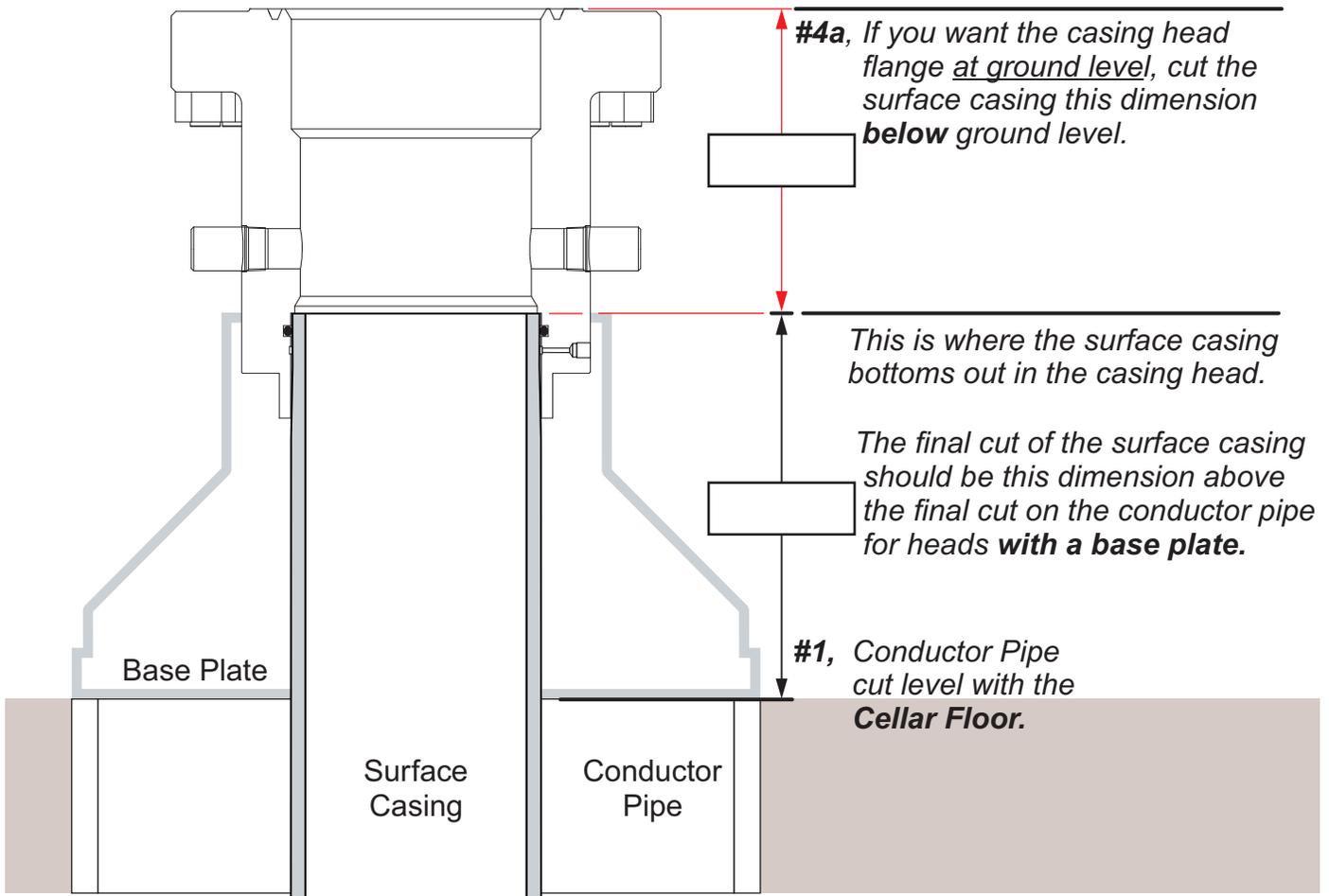
for Heads with a Base Plate

- 3 Measure the distance from the bottom of the base plate to the bottom of the SOW prep.

- 4 Measure the distance from the top of the casing head flange to the bottom of the SOW prep.

This dimension determines the final location of the casing head.

- a. If you want the casing head flange at ground level, cut the surface casing this dimension below ground level.
- b. Add or subtract from this dimension accordingly to ensure casing head flange is at the desired height.



B. Bevel Procedure:

- 1 Before installing the casing head on the surface casing, ensure the final cut is level and beveled as follows:
 - O.D. bevel:** 3/8" x 3/16"
 - I.D. bevel:** 1/8" x 45 degree
 - All finish cuts should be smooth.
 - Take a rag and wipe the top of the surface casing.

If it snags or hangs up, re-grind the bevels.

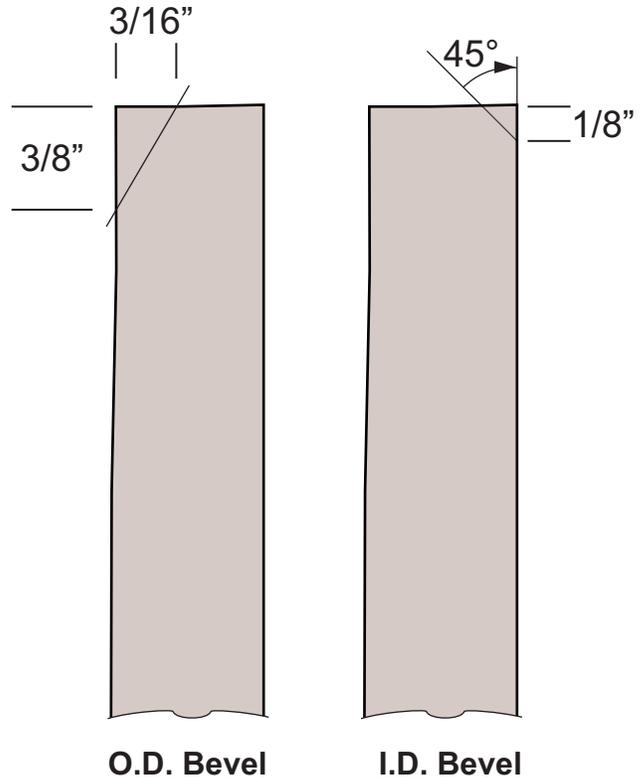
- 2 Ensure the O.D. of the surface casing is clean.

Use a wire brush or a flapper wheel and **thoroughly clean the top 6" of the O.D.** of the surface casing.

- 3 Examine the casing head.

Verify the following:

- SOW Prep is clean and free of grease or debris.
 - Ring Groove and casing hanger bowl are clean and undamaged.
 - All valves, flanges or nipples are undamaged.
 - Base Plate is clean and undamaged.
- 4 Apply a light coat of oil to the internal O-ring in the SOW prep.

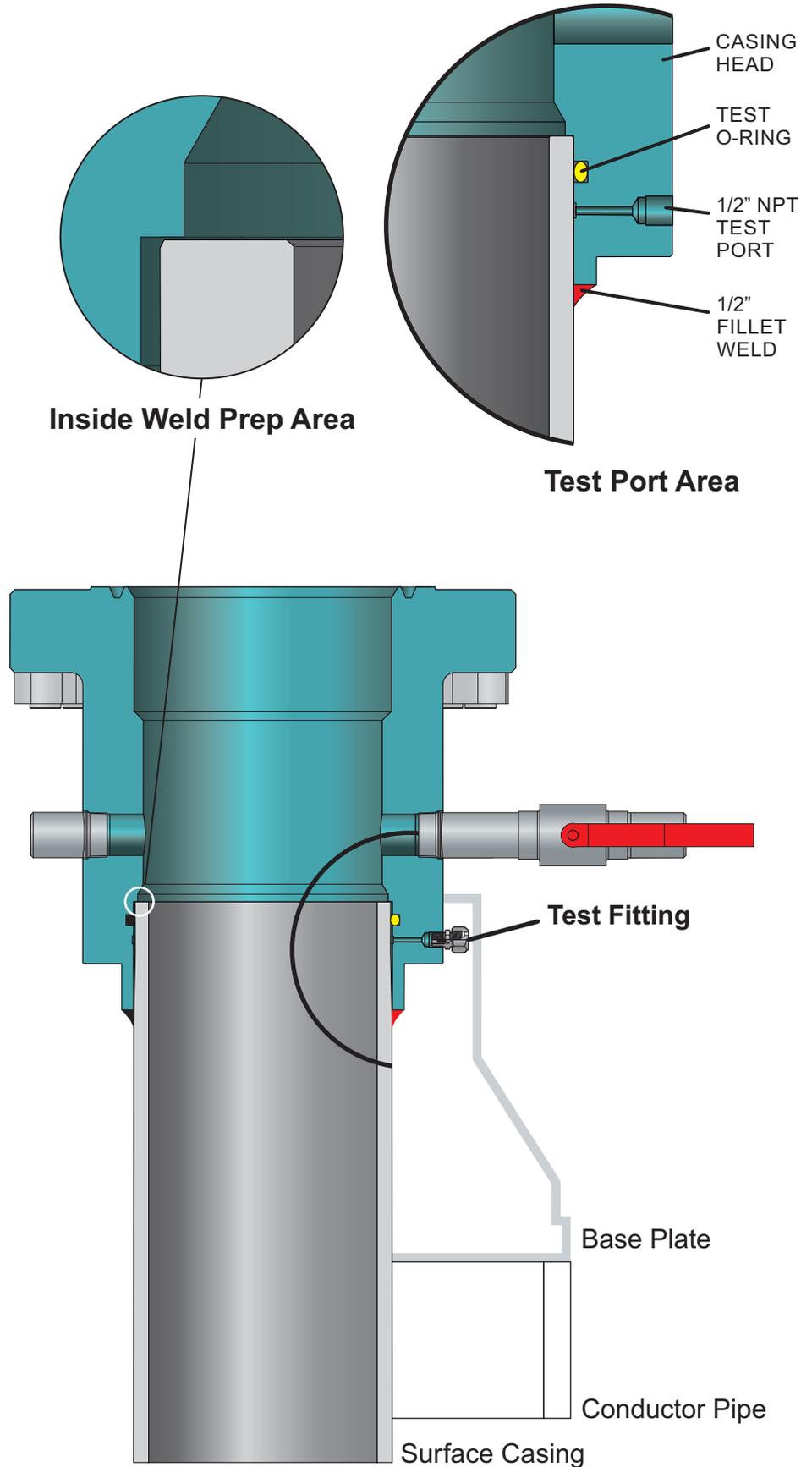


C. Installation Procedure:

- 1 Remove the 1/2" NPT pipe plug from the SOW prep test port.
- 2 Align the Casing Head above the surface casing and ensure that it is safely secured and level.
- 3 Carefully lower the Casing Head assembly over the casing stub.
 - Look into the bore from the top and verify that the casing head is all the way down.
 - The top of the surface casing should touch the load shoulder in the SOW prep.

OPTIONAL

- 4 Verify that the base plate is contacting the conductor pipe.



D. Welding Procedure:

- 1 Level the casing head and weld it to the surface casing per the enclosed procedure.
 - Have the welder follow proper **Pre-heat** and **Post-heat** procedures.
- 2 Allow the weld to cool.

You should be able to hold your hand on the weld for 10 seconds.

- Insert the test fitting and test the weld.

Acceptable Test Medias:

- Water
- Water Soluble Oil
- Inert Gas
 - Nitrogen
 - Argon

Do not exceed 80% of the casing collapse rating. (1,000 psi is usually sufficient.)

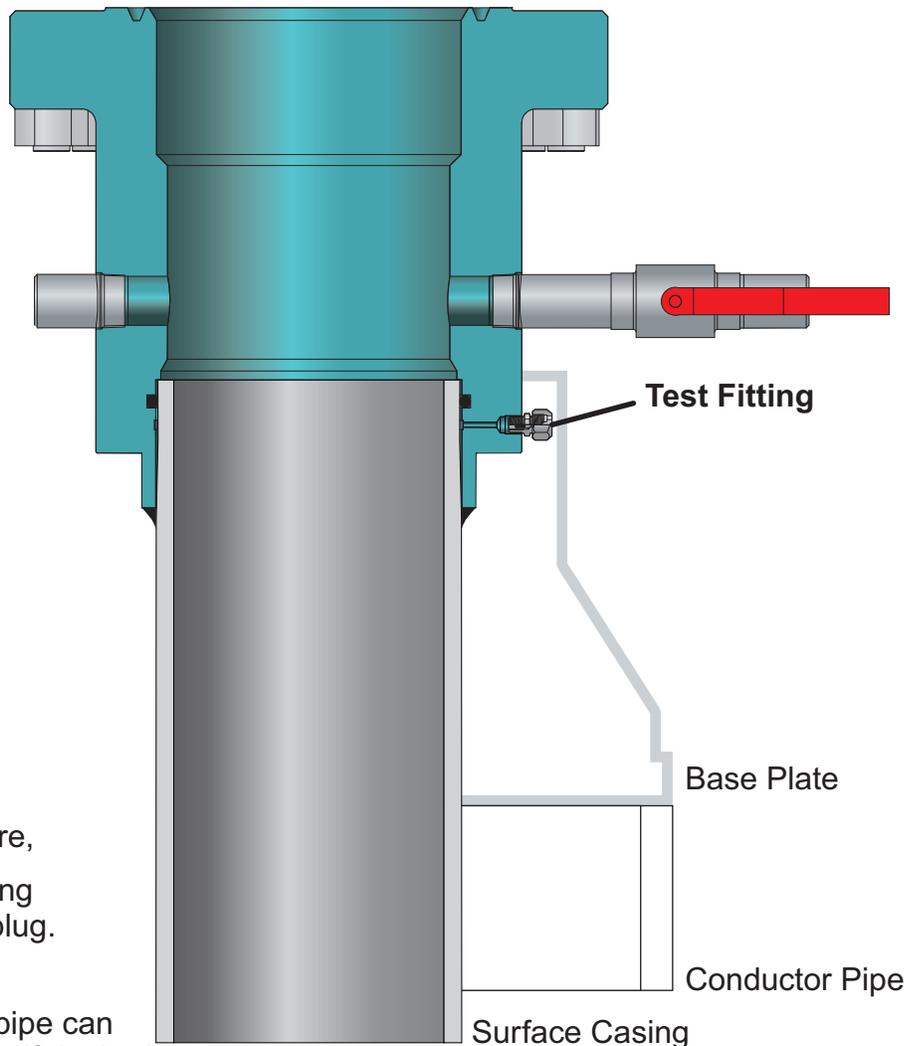
- 3 After a successful 15-minute test, or as required by the **Well Site Supervisor**:
 - Remove the test pump,
 - Bleed off internal pressure,
 - Replace the test port fitting with the 1/2" NPT pipe plug.
- 4 At this time, the conductor pipe can be welded to the base plate, if desired.

[click to view](#)

Recommended Welding Procedures

LEAKS:

- If the O.D. weld leaks, the hole or crack must be completely ground out, pre-heated & re-welded.
- If the I.D. O-ring leaks, the inside must be welded, using the same procedure.
- Before re-welding, verify that the test fitting has been removed.



Revision Log			
Revision	Date	Details	
0	February 2, 2015	Field Procedure	

ENGINEERING			
Approval Log	<i>Approved By:</i> _____ <small>SIGNATURE</small>		
	_____ <small>PRINT NAME</small>		
Revision	REVIEWER NAME	REVIEWER TITLE	DATE
0			

FIELD	
Date of Printing	



E. Recommended Field Welding Procedure



E. Recommended Field Welding Procedure *(Continued)*



E. Recommended Field Welding Procedure *(Continued)*



