

KAWASAKI STEEL TECHNICAL REPORT

No.19 (November 1988)

Steel Pipe

Development of Premium Threaded Connection "FOX"

Development of Premium Threaded Connection "FOX"



Synopsis:

Development of a new type of self-climbing nut with high strength.

Pipe wall



Axial tension
(equivalent to



Axial
tension

... ..

change change

[Redacted]

[Redacted]

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Table 1 Results of make and break test and gas leak

Run	Make test	Break test	Gas leak
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Run	DOX (mg/L)	SSC (NTU)	Color (PCU)	UV ₂₅₄ (L/mg·m)	TOC (mg/L)	DOC (mg/L)	DOC/TOC (%)
1	0.1	1.2	1.5	0.15	1.0	0.8	80
2	0.1	1.5	1.8	0.18	1.2	1.0	83
3	0.1	1.8	2.2	0.22	1.5	1.2	80
4	0.1	2.1	2.6	0.26	1.8	1.5	83
5	0.1	2.4	3.0	0.30	2.1	1.8	86
6	0.1	2.7	3.4	0.34	2.4	2.1	88
7	0.1	3.0	3.8	0.38	2.7	2.4	89
8	0.1	3.3	4.2	0.42	3.0	2.7	90
9	0.1	3.6	4.6	0.46	3.3	3.0	91
10	0.1	3.9	5.0	0.50	3.6	3.3	92
11	0.1	4.2	5.4	0.54	3.9	3.6	92
12	0.1	4.5	5.8	0.58	4.2	3.9	93
13	0.1	4.8	6.2	0.62	4.5	4.2	93
14	0.1	5.1	6.6	0.66	4.8	4.5	94
15	0.1	5.4	7.0	0.70	5.1	4.8	94
16	0.1	5.7	7.4	0.74	5.4	5.1	94
17	0.1	6.0	7.8	0.78	5.7	5.4	95
18	0.1	6.3	8.2	0.82	6.0	5.7	95
19	0.1	6.6	8.6	0.86	6.3	6.0	95
20	0.1	6.9	9.0	0.90	6.6	6.3	95
21	0.1	7.2	9.4	0.94	6.9	6.6	96
22	0.1	7.5	9.8	0.98	7.2	6.9	96
23	0.1	7.8	10.2	1.02	7.5	7.2	96
24	0.1	8.1	10.6	1.06	7.8	7.5	96
25	0.1	8.4	11.0	1.10	8.1	7.8	96
26	0.1	8.7	11.4	1.14	8.4	8.1	96
27	0.1	9.0	11.8	1.18	8.7	8.4	96
28	0.1	9.3	12.2	1.22	9.0	8.7	97
29	0.1	9.6	12.6	1.26	9.3	9.0	97
30	0.1	9.9	13.0	1.30	9.6	9.3	97
31	0.1	10.2	13.4	1.34	9.9	9.6	97
32	0.1	10.5	13.8	1.38	10.2	9.9	97
33	0.1	10.8	14.2	1.42	10.5	10.2	97
34	0.1	11.1	14.6	1.46	10.8	10.5	97
35	0.1	11.4	15.0	1.50	11.1	10.8	97
36	0.1	11.7	15.4	1.54	11.4	11.1	97
37	0.1	12.0	15.8	1.58	11.7	11.4	98
38	0.1	12.3	16.2	1.62	12.0	11.7	98
39	0.1	12.6	16.6	1.66	12.3	12.0	98
40	0.1	12.9	17.0	1.70	12.6	12.3	98
41	0.1	13.2	17.4	1.74	12.9	12.6	98
42	0.1	13.5	17.8	1.78	13.2	12.9	98
43	0.1	13.8	18.2	1.82	13.5	13.2	98
44	0.1	14.1	18.6	1.86	13.8	13.5	98
45	0.1	14.4	19.0	1.90	14.1	13.8	98
46	0.1	14.7	19.4	1.94	14.4	14.1	98
47	0.1	15.0	19.8	1.98	14.7	14.4	98
48	0.1	15.3	20.2	2.02	15.0	14.7	98
49	0.1	15.6	20.6	2.06	15.3	15.0	98
50	0.1	15.9	21.0	2.10	15.6	15.3	98
51	0.1	16.2	21.4	2.14	15.9	15.6	98
52	0.1	16.5	21.8	2.18	16.2	15.9	98
53	0.1	16.8	22.2	2.22	16.5	16.2	98
54	0.1	17.1	22.6	2.26	16.8	16.5	98
55	0.1	17.4	23.0	2.30	17.1	16.8	98
56	0.1	17.7	23.4	2.34	17.4	17.1	98
57	0.1	18.0	23.8	2.38	17.7	17.4	98
58	0.1	18.3	24.2	2.42	18.0	17.7	98
59	0.1	18.6	24.6	2.46	18.3	18.0	98
60	0.1	18.9	25.0	2.50	18.6	18.3	98
61	0.1	19.2	25.4	2.54	18.9	18.6	98
62	0.1	19.5	25.8	2.58	19.2	18.9	98
63	0.1	19.8	26.2	2.62	19.5	19.2	98
64	0.1	20.1	26.6	2.66	19.8	19.5	98
65	0.1	20.4	27.0	2.70	20.1	19.8	98
66	0.1	20.7	27.4	2.74	20.4	20.1	98
67	0.1	21.0	27.8	2.78	20.7	20.4	98
68	0.1	21.3	28.2	2.82	21.0	20.7	98
69	0.1	21.6	28.6	2.86	21.3	21.0	98
70	0.1	21.9	29.0	2.90	21.6	21.3	98
71	0.1	22.2	29.4	2.94	21.9	21.6	98
72	0.1	22.5	29.8	2.98	22.2	21.9	98
73	0.1	22.8	30.2	3.02	22.5	22.2	98
74	0.1	23.1	30.6	3.06	22.8	22.5	98
75	0.1	23.4	31.0	3.10	23.1	22.8	98
76	0.1	23.7	31.4	3.14	23.4	23.1	98
77	0.1	24.0	31.8	3.18	23.7	23.4	98
78	0.1	24.3	32.2	3.22	24.0	23.7	98
79	0.1	24.6	32.6	3.26	24.3	24.0	98
80	0.1	24.9	33.0	3.30	24.6	24.3	98
81	0.1	25.2	33.4	3.34	24.9	24.6	98
82	0.1	25.5	33.8	3.38	25.2	24.9	98
83	0.1	25.8	34.2	3.42	25.5	25.2	98
84	0.1	26.1	34.6	3.46	25.8	25.5	98
85	0.1	26.4	35.0	3.50	26.1	25.8	98
86	0.1	26.7	35.4	3.54	26.4	26.1	98
87	0.1	27.0	35.8	3.58	26.7	26.4	98
88	0.1	27.3	36.2	3.62	27.0	26.7	98
89	0.1	27.6	36.6	3.66	27.3	27.0	98
90	0.1	27.9	37.0	3.70	27.6	27.3	98
91	0.1	28.2	37.4	3.74	27.9	27.6	98
92	0.1	28.5	37.8	3.78	28.2	27.9	98
93	0.1	28.8	38.2	3.82	28.5	28.2	98
94	0.1	29.1	38.6	3.86	28.8	28.5	98
95	0.1	29.4	39.0	3.90	29.1	28.8	98
96	0.1	29.7	39.4	3.94	29.4	29.1	98
97	0.1	30.0	39.8	3.98	29.7	29.4	98
98	0.1	30.3	40.2	4.02	30.0	29.7	98
99	0.1	30.6	40.6	4.06	30.3	30.0	98
100	0.1	30.9	41.0	4.10	30.6	30.3	98

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L80

L80, 3 1/2' x 9.2 lb/ft

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