

DOUBLE WALL CASING & TOOLING STEEL AND WELDING INFORMATION

- 1. Casing joint, made in forged steel of grade 40Cr (Equivalent to American grade of AST5140)
Production process: Forging of raw steel mater -- heat treatment of the steel pipes ----- straightening ----- machining.
Rockwell Hardness: no less than 50
- 1. Casing, made in material grade 16Mn (equivalent to American grade of ASTCr.D) Welding electrode type: 506
- 1. Drilling tools:
Made in material grade 16Mn (Equivalent to American grade of ASTCr.D).

Our standard spec of dimension for 36" tools is as below:

1.	Core Barrel: Shell Thickness 25mm, Shell Height: 1500mm, Bit type: B47K
1.	Rock Auger: Cutting Flight Thickness 30mm, Guiding Flight Thickness: 25mm, Effective Height: 1800mm, Bit type: B47K
1.	Cleanup bucket: Shell Thickness 20mm, Shell Height: 1500mm, Double bottom plate: 40mm and 50mm cutting edge made in steel of AR400 or equivalent

DOUBLE WALL CASING

Option 1: Joint made from rolled steel. (Usually for purpose of temporary use)

- 1) Material grade 16Mn (equivalent to American grade of ASTCr.D)
- 2) Chemical contents

Grade	Chemical contents (percentage by weight) (%)							
	C	Si	Mn	P≤	S≤	Cr	Mo	V
16Mn	0.12~0.20	0.20~0.60	1.20~1.60	0.030	0.030	-	-	-

- 3) Electrode type: 506
- 4) Warranty: 6months, for material and workmanship based on use in Normal Working Conditions

Option 2: Joint made from forged steel. (Usually for purpose of long-term use)

- 1) Material grade 40Cr (equivalent to American grade of AST5140)
- 2) Chemical contents
C 0.37~0.45 Si 0.17~0.37 Mn 0.50~0.80 Cr 0.80~1.10 S ≤0.030 P≤0.030 Ni ≤0.25 Cu ≤0.030
- 3) Electrode Type: 506.
- 4) Warranty: 12 months for material and workmanship based on use in Normal Working Conditions