

(43) International Publication Date
4 February 2016 (04.02.2016)

(51) International Patent Classification:

E21B 17/042 (2006.01) *E21B 19/16* (2006.01)
F16L 15/06 (2006.01)

(21) International Application Number:

PCT/US2015/042629

(22) International Filing Date:

29 July 2015 (29.07.2015)

(25) Filing Language:

English

(26) Publication Language:

English

(30) Priority Data:

14/448,385 31 July 2014 (31.07.2014) US

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P.O. Box 4740, Houston, TX 77210-4740 (US).(81) Designated States (unless otherwise indicated, for every
kind of national protection available): AE, AG, AL, AM,
AO, AT, AU, AZ, BA, BB, BG, BH, BN, BR, BW, BY,
BZ, CA, CH, CL, CN, CO, CR, CU, CZ, DE, DK, DM,
DO, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, GT,HN, HR, HU, ID, IL, IN, IR, IS, JP, KE, KG, KN, KP, KR,
KZ, LA, LC, LK, LR, LS, LU, LY, MA, MD, ME, MG,
MK, MN, MW, MX, MY, MZ, NA, NG, NI, NO, NZ, OM,
PA, PE, PG, PH, PL, PT, QA, RO, RS, RU, RW, SA, SC,
SD, SE, SG, SK, SL, SM, ST, SV, SY, TH, TJ, TM, TN,
TR, TT, TZ, UA, UG, US, UZ, VC, VN, ZA, ZM, ZW.(84) Designated States (unless otherwise indicated, for every
kind of regional protection available): ARIPO (BW, GH,
GM, KE, LR, LS, MW, MZ, NA, RW, SD, SL, ST, SZ,
TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, RU,
TJ, TM), European (AL, AT, BE, BG, CH, CY, CZ, DE,
DK, EE, ES, FI, FR, GB, GR, HR, HU, IE, IS, IT, LT, LU,
LV, MC, MK, MT, NL, NO, PL, PT, RO, RS, SE, SI, SK,
SM, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ,
GW, KM, ML, MR, NE, SN, TD, TG).

Declarations under Rule 4.17:

- as to applicant's entitlement to apply for and be granted a patent (Rule 4.17(ii))
- as to the applicant's entitlement to claim the priority of the earlier application (Rule 4.17(iii))

Published:

- with international search report (Art. 21(3))

(54) Title: FATIGUE RESISTANT THREAD PROFILE WITH COMBINED CURVE ROUNDING

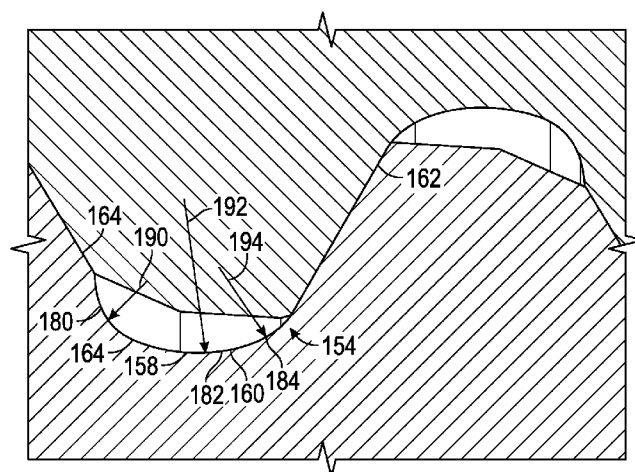


FIG. 3

(57) Abstract: A threaded connector that includes a pin end having external threads and a box end having internal threads that are complementary to the external threads has a thread profile that defines at least a portion of either or both of the internal threads and the external threads. The thread profile may include a thread root connecting a first flank to a second flank and the thread root may be at least partially defined by a plurality of tangentially interconnected radii. The plurality of radii may include at least a medial radius, a first distal radius on one side of the medial radius, and a second distal radius on the another side of the medial radius. The medial radius may be larger than the first and the second distal radius. Alternatively, the thread profile includes a thread root connecting a first flank to a second flank that is at least partially defined by a plurality of radii, each radius having a different length and each defining a circular arc.



**TITLE: FATIGUE RESISTANT THREAD PROFILE WITH
 COMBINED CURVE ROUNDING**

BACKGROUND OF THE DISCLOSURE

1. Field of the Disclosure

[0001] This disclosure relates generally to oilfield downhole tools and more particularly to methods and devices for transferring rotary power to a consumer.

2. Description of the Related Art

[0002] Threaded connections are a prevalent method to join two or more members such as pipe sections. In certain applications, as during hydrocarbon exploration and recovery operations, a string of pipe sections joined by threaded connections may be rotated in a well bore. For example, a drill string may be rotated to urge a bottomhole assembly into a subterranean formation. The bottomhole assembly (BHA) also may include components that are mated or joined with threaded connections. In certain instances, drilling activity may cause the string and BHA to bend. As is known, the bending of threaded connection induces compression on one side of the threaded connection and a tension on the other side of the threaded connection. Because the threaded connection is rotating, the tension and compression is cyclical. It is, of course, also known that cyclical bending stresses imposed by even moderate loadings may lead to failure of the threaded connection (e.g., high cycle fatigue).

[0003] The harsh drilling conditions of the well bore environment or deviated well bores can cause such cyclical bending stresses in these threaded connections. Unfortunately, conventional threaded connections, such as those specified by the American Petroleum Institute (API), do not always possess sufficient bending fatigue resistance to support advanced drilling programs or complex well bore trajectories. For example, in some instances, drilling operations and hydrocarbon recovery may require a highly deviated well bore, e.g., a well bore having a sharp radius portion.

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Form deviated wellbore sections requires a BHA and drill string that can withstand a relatively high "build-up rate." Conventional threaded connections subjected to such build-up rates can suffer reduced operational lifetime or require additional maintenance or rework. Moreover, even common drilling conditions slowly degrade conventional threaded connections such that these connections must be either changed-out or reworked. The costs incurred in such activity not only include the maintenance itself but, for example, the delay in drilling activities.

[0004] The present invention addresses these and other drawbacks of conventional threaded connections.

SUMMARY OF THE DISCLOSURE

[0005] In aspects, the present disclosure provides a threaded connector that includes a pin end having external threads and a box end having internal threads that are complementary to the external threads. The connector also includes a thread profile that defines at least a portion of either or both of the internal threads and the external threads. The thread profile may include a thread root connecting a first flank to a second flank and the thread root may be at least partially defined by a plurality of tangentially interconnected radii. The plurality of radii may include at least a medial radius, a first distal radius on one side of the medial radius, and a second distal radius on the another side of the medial radius. The medial radius may be larger than the first and the second distal radius.

[0006] In a related aspect, the present disclosure uses a thread profile that includes a thread root connecting a first flank to a second flank. The thread root may be at least partially defined by a plurality of radii, each radius having a different length and each defining a circular arc.

[0007] In further aspects, the present disclosure provides a method for forming a threaded connection. The method may include forming a pin end to have external threads, and forming a box end to have internal threads that are complementary to the

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external threads. A thread profile that defines at least a portion of one or both of the internal threads and the external threads may include a thread root connecting a first flank to a second flank. The thread root may be at least partially defined by a plurality of tangentially interconnected radii. The plurality of radii may include at least a medial radius, a first distal radius on one side of the medial radius, and a second distal radius on the another side of the medial radius. The medial radius may be larger than the first and the second distal radius.

[0008] Illustrative examples of some features of the disclosure thus have been summarized rather broadly in order that the detailed description thereof that follows may be better understood, and in order that the contributions to the art may be appreciated. There are, of course, additional features of the disclosure that will be described hereinafter and which will form the subject of the claims appended hereto.

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BRIEF DESCRIPTION OF THE DRAWINGS

[0009] For detailed understanding of the present disclosure, references should be made to the following detailed description of the preferred embodiment, taken in conjunction with the accompanying drawings, in which like elements have been given like numerals and wherein:

FIG. 1 shows a schematic diagram of a well construction system with a bottomhole assembly utilizing the threaded connection of the present disclosure;

FIG. 2 shows a sectional schematic view of an exemplary connection that may use thread arrangements in accordance with the present disclosure;

FIG. 3 illustrates an exemplary thread root having three radii in accordance with one embodiment of the present disclosure;

FIG. 4 illustrates an exemplary thread root having two radii in accordance with one embodiment of the present disclosure; and

FIGS. 5A and 5B illustrate exemplary thread roots having three radii in accordance with embodiments of the present disclosure.

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DETAILED DESCRIPTION OF THE DISCLOSURE

[0010] The present invention relates to an apparatus and methods for increasing the fatigue resistance of pin and box connections or couplings subjected to cyclic bending stresses, particularly in oilfield applications. Aspects of the present disclosure provide an optimized thread profile rounding that may reduce the local stress at the root of a thread and thus may increase the fatigue strength of a thread connection. The optimized shape of the rounding at the thread root may be a combination of at least two radii having different sizes. The present invention is susceptible to embodiments of different forms. There are shown in the drawings, and herein will be described in detail, specific embodiments of the present invention with the understanding that the present disclosure is to be considered an exemplification of the principles of the invention, and is not intended to limit the invention to that illustrated and described herein.

[0011] In **Fig. 1**, there is shown an embodiment of a drilling system **10** utilizing a bottomhole assembly (BHA) **60** configured for drilling wellbores. While a land system is shown, the teachings of the present disclosure may also be utilized in offshore or subsea applications. In **FIG.1**, a laminated earth formation **11** is intersected by a wellbore **12**. The BHA **60** is conveyed via a drill string **22** into the wellbore **12**. The drill string **22** may be jointed drill pipe or coiled tubing, which may include embedded conductors for power and / or data for providing signal and / or power communication between the surface and downhole equipment. The BHA **60** may include a drill bit **62** for forming the wellbore **12**. In some embodiments, the BHA **60** may include one or more rotary power sources such as a drilling motor **120**.

[0012] In a common mode of operation, a pressurized drilling fluid is pumped down to the BHA **60** from the surface via the drill string **22**. This flowing drilling fluid may be utilized to energize the drilling motor **120**, which generates rotary power that rotates the drill bit **62**. The flowing drilling mud can also energize turbines or other similar devices that extract energy from the flowing drilling fluid. The extracted

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energy may be utilized to generate electricity and / or pressure hydraulic fluids. It should be understood that generating rotary power (*i.e.*, generating useful torque) and electrical power generation and pressuring of fluids are merely illustrative of a variety of functions that may be performed by a consumer of rotary power.

[0013] Referring to **Fig. 2**, the threaded connection may include a pin end **150** and a box end **152**. In a conventional manner, the pin end **150** has external threads **154** and the box end **152** has internal threads **156**. The **Fig. 2** connection may be used to connect the jointed pipe of the drill string **22** (**Fig. 1**), the subs and other components of the BHA **60** (**Fig. 1**), etc. The **Fig. 2** connection may also be used in any other well tools including, but are not limited to, under-reamers, reamers, pipe cutting tools, etc.

[0014] Referring to **Fig. 3**, there is shown in greater detail a root **158** of a thread profile of the external thread **154**. As used herein, the term “thread profile” refers to the thread form or configuration of a thread in an axial plane and which is generally considered to include a crest, a root, and flanks. The stress concentration at the root **158** is influenced by a length of a radius defining one or more circular arcs of a surface **160** between a load flank **162** and a trailing flank **164** of a thread, *e.g.*, thread **154**. As used herein, the radius of a circle is the length of the line from the center to any point on its edge. Typically, the stress decreases with increased radius length. If certain parameters of the thread profile are fixed (*e.g.*, pitch or tooth width, flank angle, height etc.) the possibility of increasing the radius is minimal. Herein, referring to a radius of a root is the same as referring to a circular arc defined by that radius; *i.e.*, such references are to be considered interchangeable. Thus, when a root of a thread profile is said to have a specified radius, it is meant that at least a portion of a surface defining that root follows a circular arc defined by the specified radius. The length of an arc depends on both radius and a spanning angle.

[0015] Embodiment of the present disclosure use a combination of radii (hereafter, Combined Curve Rounding - CCR) with increased radius lengths to thereby increase the corresponding radius curvature at selected locations along the surface **160** joining

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the load flank **162** and the trailing flank **164**. In the non-limiting embodiment of **Fig. 3**, the surface **160** joining the load flank **162** and the trailing flank **164** is defined by arcs **180**, **182**, **184**, each having a radius **190**, **192**, **194**. CCR involves placing a relatively small “sharp” radius at the less critical positions of the thread root (*e.g.*, immediately adjacent to the flanks) and increasing the radius at the more critical position - typically in the medial portion, or middle, of the root **158**. In a non-limiting arrangement, the radius **190** may be 0.70 mm, the radius **192** may be 1.8 mm, and the radius **194** may be 0.60 mm. When compared to a conventional profile that is defined by a single radius of 1.15 mm, the critical maximum radius at the thread root **158** may be increased by more than 50% (from 1.15mm to 1.8mm). Moreover, the depth of the thread profile is slightly reduced and thus consumes less radial space for pin and box threads.

[0016] Referring to **Fig. 4**, in embodiments, a thread profile using CCR at the thread root **158** may include 2 different radii (*e.g.*, **R1** and **R2**). Radius **R1 200** may be at least 1.5 times larger than Radius **R2 202**. Referring to **Fig. 5A**, in another embodiment, a thread profile may use three radii (**R1**, **R2** and **R3**). In such embodiments, Radius **R1 206** may be two to four times larger than Radius **R2 208** and two to four times larger than **R3 210**. The smaller radii (**R2 208** and **R3 210**) may be on opposing sides of the largest radius (**R1 206**). All of the radii (**R1-R3 206, 208, 210**) are preferably connected tangentially among themselves. The straight load flank **162** may be tangentially connected to a smaller radius (**R2**). The smaller radius **R3** may either be tangentially connected directly to the trailing flank **164**. The arcs of each radius **R1, R2, R3** connect at end points. By tangentially connected, it is meant that a tangent line of each radius at an end point is substantially aligned; *e.g.*, less than 10 degrees angular misalignment. In embodiments where a slanted load flank is used (*e.g.*, 25° to 35°), the arc associated with radius **R2 208** may cover about 25° to 45° and the arc associated with the radius **R1 206** may cover about 35° to 65°.

[0017] Alternatively, as shown in **Fig. 5B**, a run-out at an angle Θ_{R3} **220** may be smaller than an angle Θ_{SF} **222** of the trailing flank **164**. The load flank **162** may

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include a tangential connection as described previously. The $\Theta R3$ 220, ΘSF 222 may be with reference to a plane 224 that is orthogonal to a longitudinal axis 226 (Fig. 2) of the connection.

[0018] It should be appreciated that these values are provided with specificity merely for convenience and that the present invention is by no means limited to these values. Furthermore, it should be understood that these values are subject to applicable machining tolerances. Thus, these values merely indicate the general optimization technique that may be applied to minimize local stresses under given geometric constraints. It is believed that the general relationships between the described features of the thread profile will enhance the fatigue strength of nearly any diameter size connection utilizing an exemplary thread profile of the present invention.

[0019] In alternative embodiments to the present invention, the threads may be cold worked to increase of fatigue resistance, copper plated to increase of galling resistance, and/or shot peened to increase resistance against stress/corrosion/cracking. The threads may also include stress relief groove(s) to increase of fatigue resistance.

[0020] The foregoing description is directed to particular embodiments of the present disclosure for the purpose of illustration and explanation. It will be apparent, however, to one skilled in the art that many modifications and changes to the embodiment set forth above are possible without departing from the scope of the disclosure. It is intended that the following claims be interpreted to embrace all such modifications and changes.

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THE CLAIMS

1. A threaded connector, comprising:
 - a pin end having external threads;
 - a box end having internal threads that are complementary to the external threads; and
 - a thread profile that defines at least a portion of one of the internal threads and the external threads, the thread profile including a thread root connecting a first flank to a second flank, the thread root being at least partially defined by a plurality of tangentially interconnected radii, the plurality of radii including at least:
 - a medial radius,
 - a first distal radius on one side of the medial radius, and
 - a second distal radius on the another side of the medial radius, wherein the medial radius is larger than the first and the second distal radius.
2. The connector of claim 1, wherein the first distal radius is tangentially connected to the first flank and the second distal radius is tangentially connected to the second flank.
3. The connector of claim 1, wherein the medial radius is at least 1.5 times greater than one of the first distal radius and the second distal radius.
4. The connector of claim 3, wherein the medial radius is no greater than 4.5 times of one of the first distal radius and the second distal radius.
5. The connector of claim 1, wherein each of the plurality of radii define a circular arc.

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6. The connector of claim 1, wherein each radii has an associated arc, wherein the arcs connect to one another at endpoints, and wherein tangent lines of two radii are substantially aligned at each endpoint.
7. The threaded connector of claim 1, wherein the pin end and the box end are disposed along one of: (a) a drill string, and (b) a BHA.
8. The connector of claim 1, wherein the second distal radius is connected to the second flank at an angle smaller than an angle defining an outer surface of the second flank.
9. A threaded connector, comprising:
 - a pin end having external threads;
 - a box end having internal threads that are complementary to the external threads;
 - a thread profile defining at least a portion of one of the internal threads and the external threads, the thread profile including a thread root connecting a first flank to a second flank, the thread root being at least partially defined by a plurality of radii, each radius having a different length and each defining a circular arc.
10. The connector of claim 9, wherein the first flank is a slanted load flank, and wherein a first radius of the plurality of radii defines an arc between about 25° to 45° and a second radius of the plurality of radii defines an arc between about 35° to 65°.
11. The connector of claim 9, wherein the plurality of radii is tangentially interconnected.
12. The connector of claim 9, wherein the plurality of radii includes a medial radius that is at least 1.5 times greater than an adjacent radius.

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13. The connector of claim 9, wherein the plurality of radii includes a medial radius that is no greater than 4.5 times than an adjacent radius.

14. A method for forming a threaded connection, comprising:

forming a pin end to have external threads; and

forming a box end to have internal threads that are complementary to the external threads, wherein a thread profile that defines at least a portion of one of the internal threads and the external threads includes a thread root connecting a first flank to a second flank, and wherein the thread root is at least partially defined by a plurality of tangentially interconnected radii, the plurality of radii including at least:

- a medial radius,
- a first distal radius on one side of the medial radius; and
- a second distal radius on the another side of the medial radius, wherein the medial radius is larger than the first and the second distal radius.

15. The method of claim 14, wherein the first distal radius is tangentially connected to the first flank and the second distal radius is tangentially connected to the second flank.

16. The method of claim 14, wherein the medial radius is at least 1.5 times greater than one of the first distal radius and the second distal radius.

17. The method of claim 16, wherein the medial radius is no greater than 4.5 times of one of the first distal radius and the second distal radius.

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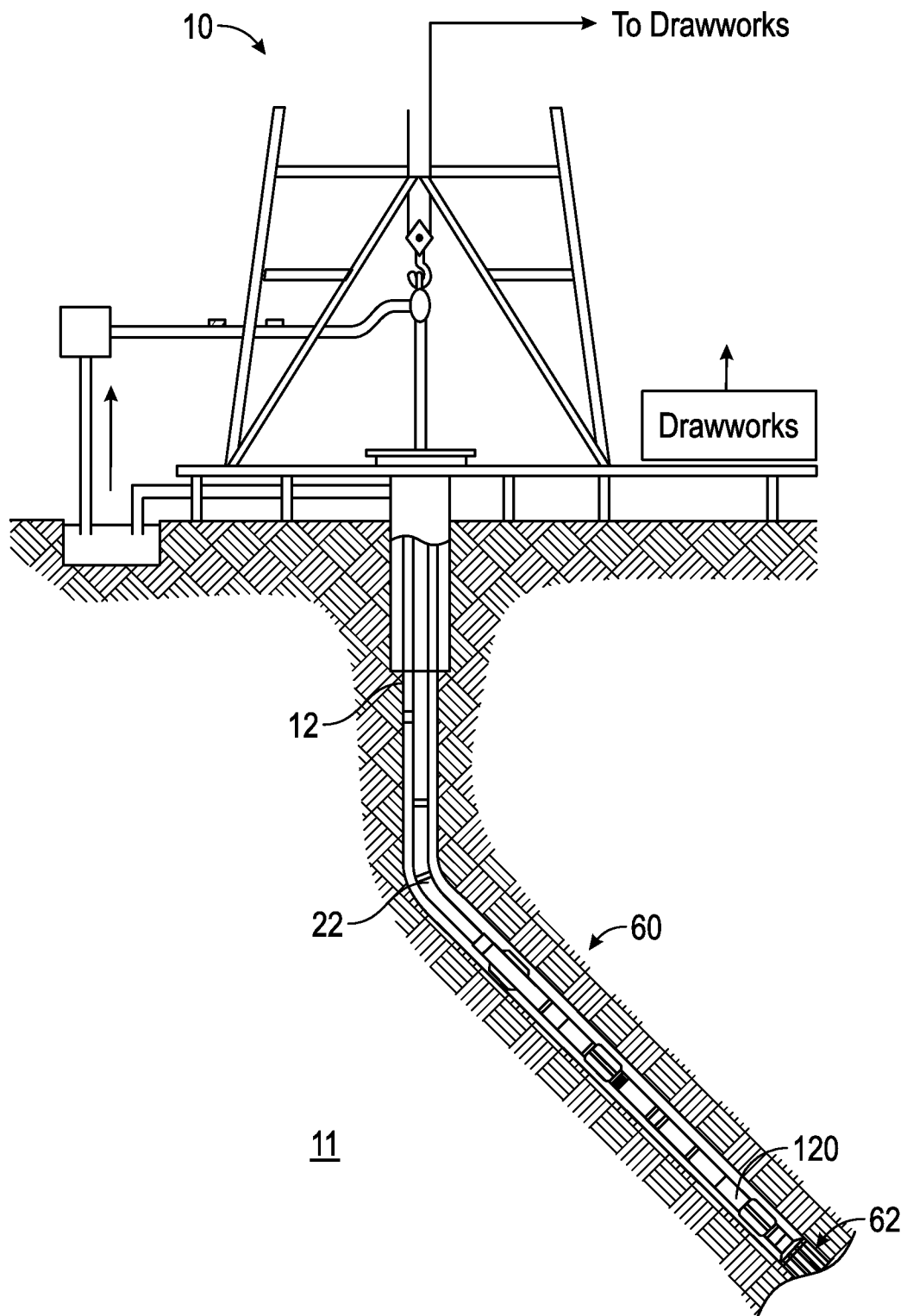


FIG. 1

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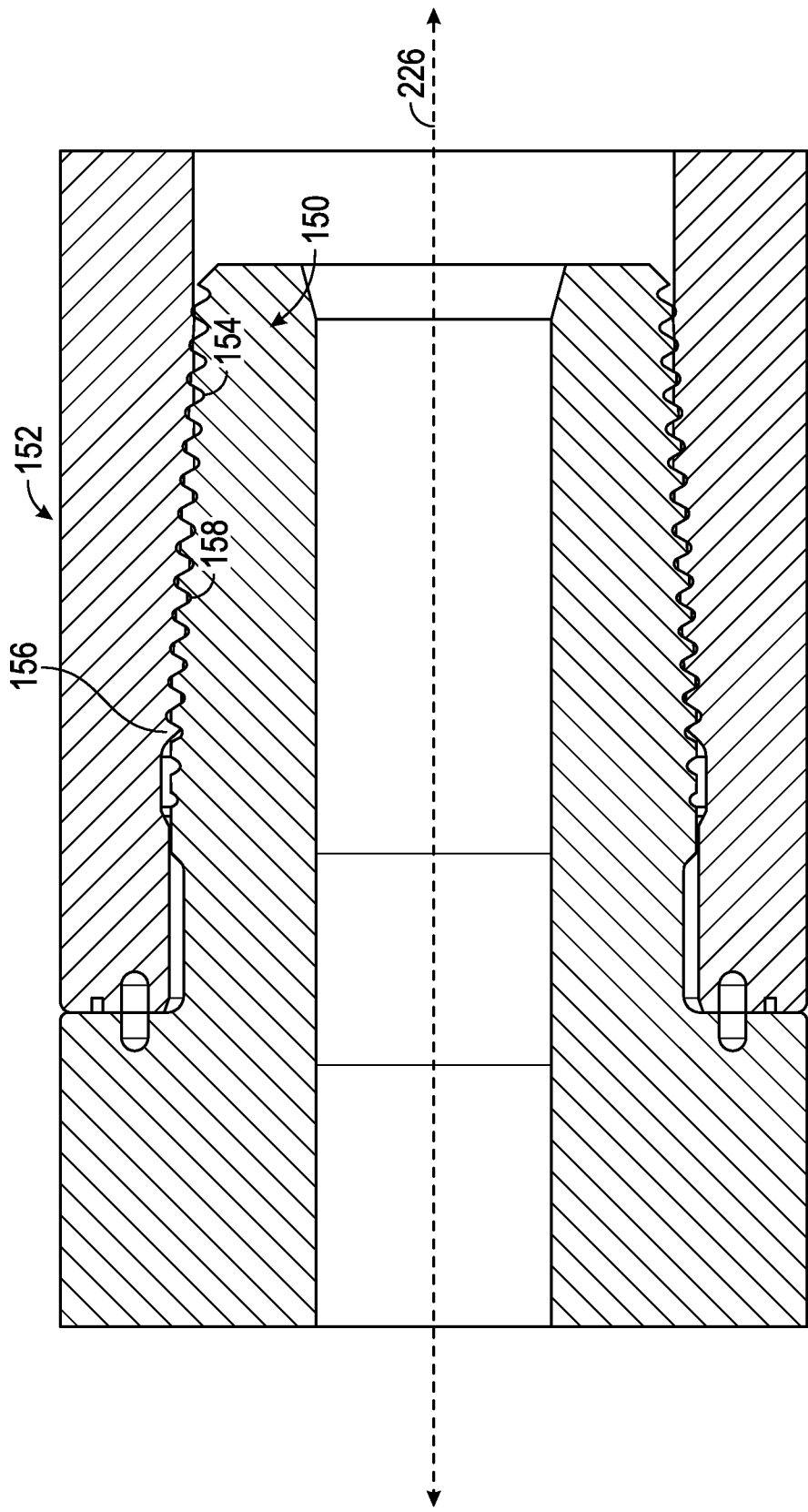


FIG. 2

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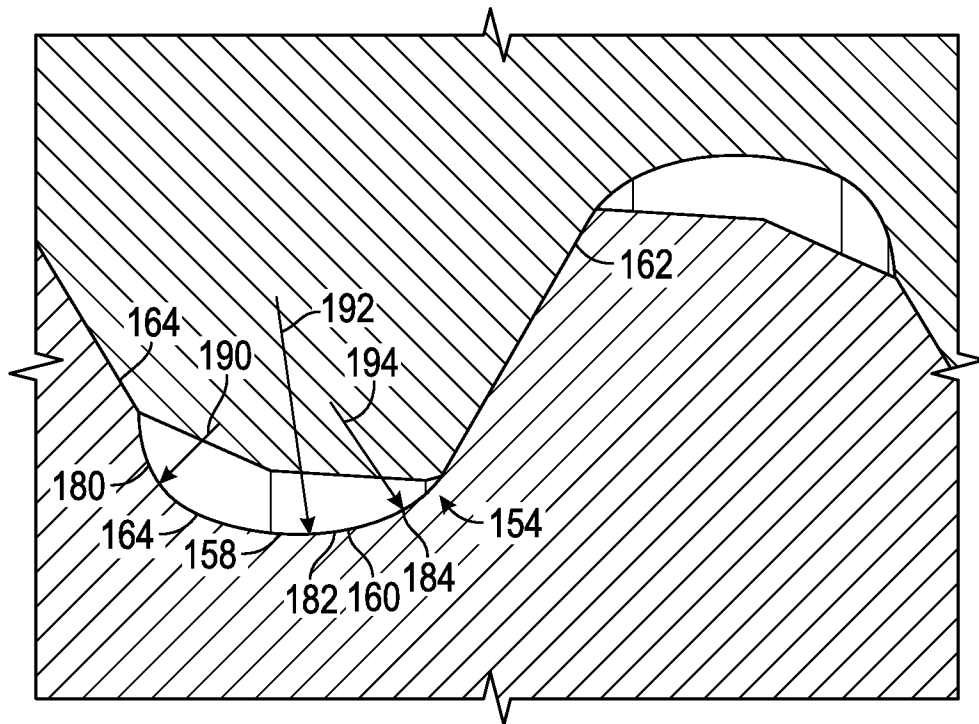


FIG. 3

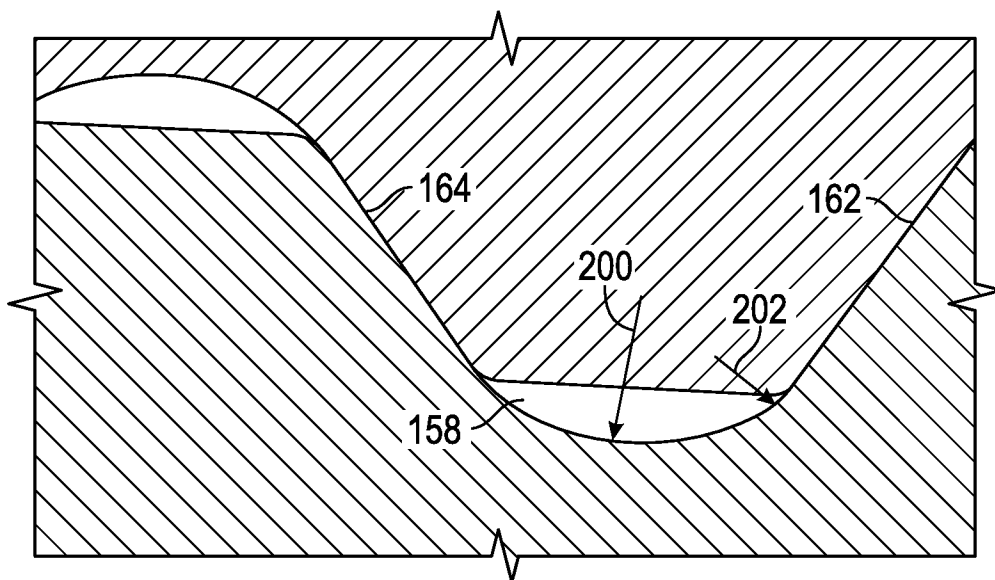


FIG. 4

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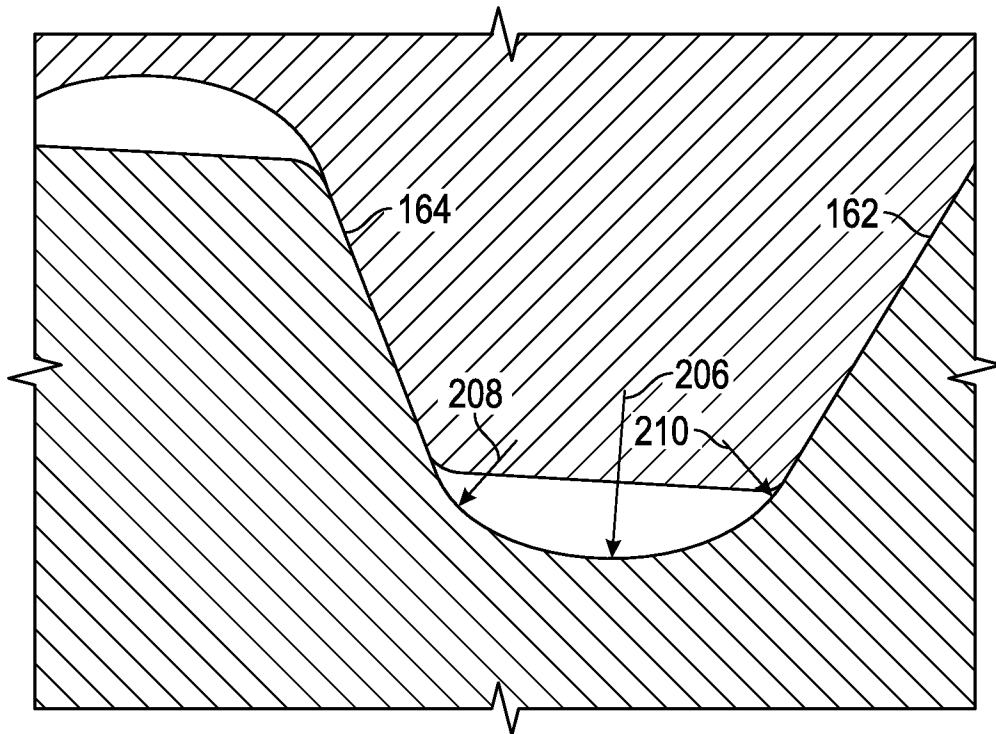


FIG. 5A

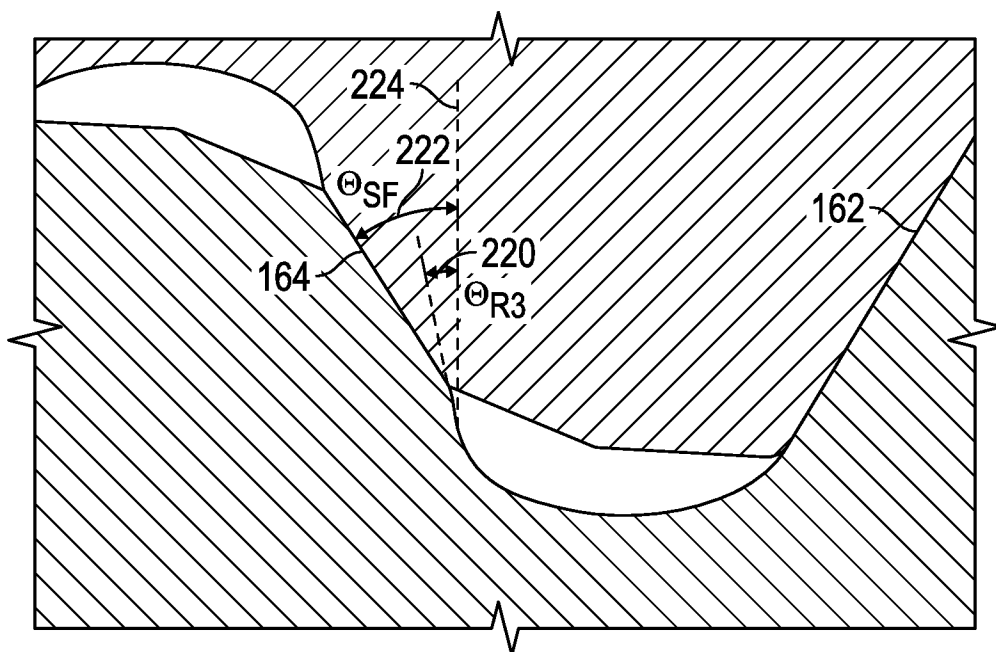


FIG. 5B

INTERNATIONAL SEARCH REPORT

International application No.
PCT/US2015/042629**A. CLASSIFICATION OF SUBJECT MATTER****E21B 17/042(2006.01)i, F16L 15/06(2006.01)i, E21B 19/16(2006.01)i**

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHEDMinimum documentation searched (classification system followed by classification symbols)
E21B 17/042; B23B 35/00; F16L 25/00; F16B 35/04; F16L 15/00; F16L 15/06; E21B 19/16Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched
Korean utility models and applications for utility models
Japanese utility models and applications for utility modelsElectronic data base consulted during the international search (name of data base and, where practicable, search terms used)
eKOMPASS(KIPO internal) & Keywords: wellbore, threaded connection, drill string, pin, box, profile, root, flank, radius and tangential**C. DOCUMENTS CONSIDERED TO BE RELEVANT**

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 2013-0147191 A1 (MAZZAFERRO, GASTN MAURO et al.) 13 June 2013 See paragraphs [0003], [0043]-[0045], [0051] and figures 1, 5.	1-17
A	US 2002-0113436 A1 (VERDILLON, LIONEL) 22 August 2002 See paragraphs [0117]-[0194] and figures 1-5B.	1-17
A	US 4004832 A (CONNELLY, EUGENE B.) 25 January 1977 See claims 1-4 and figures 1-2.	1-17
A	EP 1117897 B1 (BOART LONGYEAR GMBH & CO. KG HARTMETALLWERKZEUGFABRIK) 12 May 2004 See paragraphs [0023]-[0033] and figures 1a-3b.	1-17
A	US 6467818 B1 (SNAPP, DOUGLAS V. et al.) 22 October 2002 See column 2, line 66 - column 3, line 60 and figures 1-3.	1-17



Further documents are listed in the continuation of Box C.



See patent family annex.

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"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art

"&" document member of the same patent family

Date of the actual completion of the international search

19 October 2015 (19.10.2015)

Date of mailing of the international search report

19 October 2015 (19.10.2015)

Name and mailing address of the ISA/KR

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INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No.

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INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No.

PCT/US2015/042629Patent document
cited in search reportPublication
datePatent family
member(s)Publication
date

US 6467818 B1

22/10/2002

None