

(19) World Intellectual Property Organization
International Bureau



(43) International Publication Date
27 December 2007 (27.12.2007)

PCT

(10) International Publication Number
WO 2007/149673 A1

- (51) International Patent Classification:
F16L 33/02 (2006.01) *F16L 33/035* (2006.01)
- (21) International Application Number:
PCT/US2007/069574
- (22) International Filing Date: 23 May 2007 (23.05.2007)
- (25) Filing Language: English
- (26) Publication Language: English
- (30) Priority Data:
11/424,783 16 June 2006 (16.06.2006) US
- (71) Applicant (for all designated States except US): **HYDRIL COMPANY LP** [US/US]; 3300 North Sam Houston Parkway East, Houston, TX 77032 (US).
- (72) Inventors; and
- (75) Inventors/Applicants (for US only): **REYNOLDS, Harris, A.** [US/US]; 1706 Cranway, Houston, TX 77055 (US). **MALLIS, David, Llewellyn** [US/US]; 10 Lucky Leaf Court, The Woodlands, TX 77381 (US).
- (74) Agents: **BERGMAN, Jeffrey, S.** et al.; Osha. Liang LLP, 1221 McKinney St., Suite 2800, Houston, TX 77010 (US).
- (81) Designated States (unless otherwise indicated, for every kind of national protection available): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BH, BR, BW, BY, BZ, CA, CH,

CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, GT, HN, HR, HU, ID, IL, IN, IS, JP, KE, KG, KM, KN, KP, KR, KZ, LA, LC, LK, LR, LS, LT, LU, LY, MA, MD, ME, MG, MK, MN, MW, MX, MY, MZ, NA, NG, NI, NO, NZ, OM, PG, PH, PL, PT, RO, RS, RU, SC, SD, SE, SG, SK, SL, SM, SV, SY, 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, LS, MW, MZ, NA, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HU, IE, IS, IT, LT, LU, LV, MC, MT, NL, PL, PT, RO, SE, SI, SK, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

Declarations under Rule 4.17:

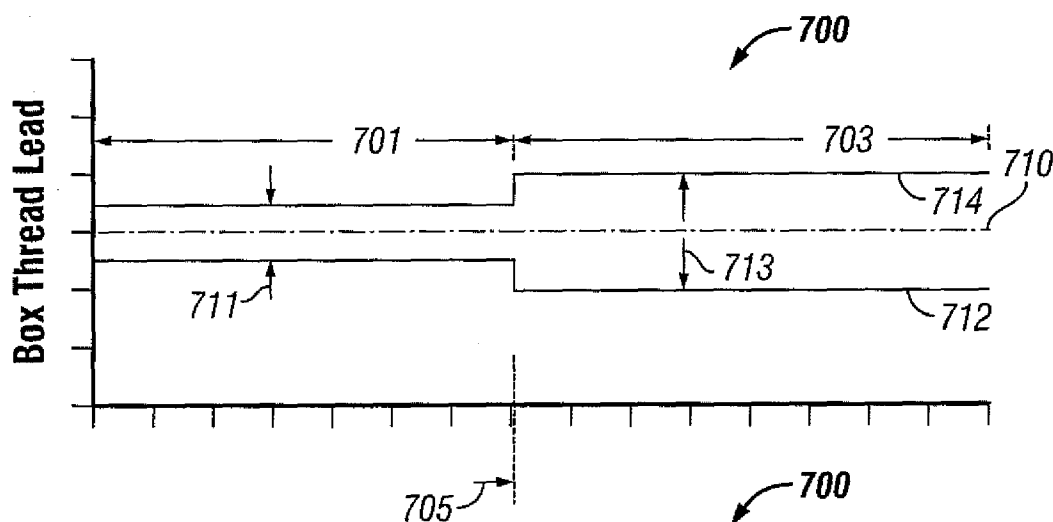
- as to applicant's entitlement to apply for and be granted a patent (Rule 4.17(ii))
- as to the applicant's entitlement to claim the priority of the earlier application (Rule 4.17(iii))

Published:

- with international search report
- before the expiration of the time limit for amending the claims and to be republished in the event of receipt of amendments

For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

(54) Title: WEDGE THREAD WITH HIGH-METAL SEAL



(57) Abstract: A threaded connection includes a pin member providing a single external thread comprising a first external portion and a second external portion, a box member providing a single internal thread comprising a first internal portion and a second internal portion, and a radial metal-to-metal seal to seal between the pin member and the box member, wherein the first and second internal portions threadably correspond with the first and second external portions, and wherein the first internal and external portions are characterized by a first wedge ratio and the second internal and external portions are characterized by a second wedge ratio, wherein the first wedge ratio is less than the second wedge ratio.

WO 2007/149673 A1

WEDGE THREAD WITH HIGH-ANGLE METAL SEAL

Background of Invention

Field of the Invention

[0001] The present invention generally relates to wedge-threaded components of tubular connections. More particularly, the present invention relates to wedge-threaded components of tubular connections incorporating a metal-to-metal seal therebetween. More particularly still, the present invention relates to single-step multi-portion wedge-threaded tubular connections incorporating high-angle metal-to-metal seals.

Background Art

[0002] Casing joints, liners, and other oilfield tubulars are frequently used to drill, complete, and produce wells. For example, casing joints may be placed in a wellbore to stabilize and protect a formation against high wellbore pressures (*e.g.*, wellbore pressures that exceed a formation pressure) that could otherwise damage the formation. Casing joints are sections of pipe (*e.g.*, steel or titanium), which may be coupled in an end-to-end manner by threaded connections, welded connections, or any other connection mechanisms known in the art. As such, connections are usually designed so that at least one seal is formed between an interior of the coupled casing joints and the annulus formed between exterior walls of the casing joints and the interior walls of the wellbore (*i.e.*, the formation). The seals may be elastomeric (*e.g.*, an o-ring seal), thread seals, metal-to-metal seals, or any other seals known to one of ordinary skill in the art.

[0003] It should be understood that certain terms are used herein as they would be conventionally understood, particularly where threaded tubular joints are connected in a vertical position along their central axes such as when making up a pipe string for lowering into a well bore. Typically, in a male-female threaded tubular connection, the male component of the connection is referred to as a “pin” member and the female component is called a “box” member. As used herein, “make-up” refers to engaging a pin member into a box member and threading the members

together through torque and rotation. Further, the term "selected make-up" refers to the threading of a pin member and a box member together with a desired amount of torque or based on a relative position (axial or circumferential) of the pin member with respect to the box member. Furthermore, the term "box face" is understood to be the end of the box member facing outward from the box threads and the term "pin nose" is understood to be the end of the pin member facing outward from the threads of the connection. As such, upon make-up of a connection, the nose of the pin is stabbed or inserted into and past the face of the box.

[0004] Referring to the geometry of threads, the term "load flank" designates the side wall surface of a thread that faces away from the outer end of the respective pin or box member on which the thread is formed and supports the weight (*i.e.*, tensile load) of the lower tubular member hanging in the well bore. Similarly, the term "stab flank" designates the side wall surface of the thread that faces toward the outer end of the respective pin or box member and supports forces compressing the joints toward each other such as the weight of the upper tubular member during the initial make-up of the joint or such as a force applied to push a lower tubular member against the bottom of a bore hole (*i.e.*, compressive force).

[0005] One type of threaded connection commonly used oil country tubular goods is a wedge thread. Referring initially to Figures 1A and 1B, a prior art tubular connection **100** having a wedge thread is shown. As used herein, "wedge threads" are threads, regardless of a particular thread form, that increase in width (*i.e.*, axial distance between load flanks **225** and **226** and stab flanks **232** and **231**) in opposite directions on a pin member **101** and a box member **102**. The rate at which the threads change in width along the connection is defined by a variable known as the "wedge ratio." As used herein, "wedge ratio," although technically not a ratio, refers to the difference between the stab flank lead and the load flank lead, which causes the width of the threads to vary along the connection. Furthermore, as used herein, a thread "lead" refers to the differential distance between a component of a thread on consecutive threads. As such, the "stab lead" is the distance between stab flanks of consecutive thread pitches along the axial length of the connection. A detailed discussion of wedge ratios is provided in U.S. Patent No. 6,206,436, issued to Mallis, assigned to the assignee of the present invention, and incorporated by reference in its entirety herein. Furthermore, wedge threads are extensively

disclosed in U.S. Patent No. RE 30,647 issued to Blose, U.S. Pat. No. RE 34,467 issued to Reeves, U.S. Pat. No. 4,703,954 issued to Ortloff, and U.S. Pat. No. 5,454,605 issued to Mott, all assigned to the assignee of the present invention and incorporated herein by reference in their entirety.

[0006] Referring still to Figures 1A and 1B, a pin thread crest **222** in a wedge thread coupling is narrow towards a distal end **108** of pin member **101** while a box thread crest **291** is wide. Moving along an axis **105** (from right to left), pin thread crest **222** widens while box thread crest **291** narrows as it approaches a distal end **110** of box member **102**. As shown in Figure 1A, the threads are tapered, meaning that a pin thread **106** increases in diameter from beginning to end while a box thread **107** decreases in diameter in a complimentary manner. Having a thread taper may improve the ability to stab pin member **101** into box member **102** and distribute stress throughout the connection.

[0007] Generally, thread seals are difficult to achieve in non-wedge (*i.e.*, free-running) threads. However, thread forms that are unable to form a wedge seal in a free-running configuration may create thread seals when used in a wedge thread configuration. As should be understood by one of ordinary skill, as wedge threads do not require any particular type or geometry of thread form, a variety of thread forms may be used. One example of a suitable thread form is a semi-dovetailed thread form disclosed in U.S. Patent No. 5,360,239, issued to Klementich and incorporated herein by reference in its entirety. Another thread form includes a multi-faceted load flank or stab flank, as disclosed in U.S. Patent No. 6,722,706, issued to Church and incorporated herein by reference in its entirety. Each of the above thread forms is considered to be a "trapped" thread form, meaning that at least a portion of the corresponding load flanks and/or corresponding stab flanks axially overlap. An open (*i.e.*, not trapped) thread form with a generally rectangular shape is disclosed in U.S. Patent No. 6,578,880, issued to Watts and incorporated herein by reference in its entirety. As such, the above thread forms (*i.e.*, those of Klementich, Church, and Watts) are examples of thread forms that may be used with embodiments of the invention. Generally, open thread forms such as buttress or stub are not suitable for wedge threads, as they would impart a large radial force on the box member. However, a generally square thread form, such as that disclosed by Watts, or a trapped thread form, may be used, as they do not impart an outward

radial force on the box member. As such, those having ordinary skill in the art will appreciate that the teachings contained herein are not limited to particular thread forms.

[0008] Referring again to Figures 1A and 1B, in wedge threads, a thread seal may be accomplished through contact pressure caused by interference that occurs at make-up over at least a portion of connection 100 between pin load flank 226 and box load flank 225 and between pin stab flank 232 and box stab flank 231. Close proximity or interference between roots 292 and 221 and crests 222 and 291 complete the thread seal when occurring proximate to such flank interference. Generally, higher pressures may be contained either by increasing interference between the roots and crests ("root/crest interference") on pin member 101 and box member 102 or by increasing the aforementioned flank interference.

[0009] Although various wedge thread connections exist having positive-stop torque shoulders (*e.g.*, Klementich, referenced above), wedge threads typically do not have torque shoulders, so their make-up is "indeterminate," and, as a result, the relative position of the pin member and box member may vary more during make-up for a given torque range to be applied than for connections having a positive-stop torque shoulder. For wedge threads designed to have flank interference and root/crest interference at a selected make-up, the connection is designed such that both the flank interference and root/crest interference increase as the connection is made-up (*i.e.*, an increase in torque increases flank interference and root/crest interference). For tapered wedge threads having root/crest clearance, the clearance decreases as the connection is made-up. Regardless of the design of the wedge thread, corresponding flanks come closer to each other (*i.e.*, clearance decreases or interference increases) during make-up. Indeterminate make-up allows for the flank interference and root/crest interference to be increased by increasing the make-up torque on the connection. Thus, a wedge thread may be able to thread-seal higher pressures of gas and/or liquid by designing the connection to have more flank interference and/or root/crest interference or by increasing the make-up torque on the connection. However, increased interference and make-up torque may increase stress on the connection during make-up, which may lead to premature failure of the connection.

[0010] Furthermore, as shown, connection 100 includes a metal-to-metal seal 112 created by contact between corresponding seal surfaces 103 and 104, respectively

located on pin member **101** and box member **102**. Metal-to-metal seal **112** provides an additional measure of seal integrity (*i.e.*, when a wedge thread seal is not sufficient) for threaded connection **100**, and is particularly useful where connection **100** is intended to contain high-pressure gases. While the metal-to-metal seal is shown located proximate to the distal end **108** of pin member **102**, it should be understood by one of ordinary skill in the art that metal-to-metal seal **112** may be positioned anywhere along the length of connection **100**, including, but not limited to, a location proximate to the distal end of box member **102**.

[0011] Nonetheless, seal surfaces **103** and **104** of metal-to-metal seal **112** are usually constructed as corresponding frusta-conical surfaces characterized by a low angle (*e.g.*, an angle less than about 4 or 5 degrees) of intersection with their corresponding remaining pin **101** and box **102** surfaces. Typically, low-angle metal-to-metal seal surfaces **103** and **104** are used in conjunction with wedge thread connections (*e.g.*, **100**) because the indeterminate make-up thereof necessitates a seal capable of less precise axial alignment. As wedge threads make-up indeterminately, the relative axial position of pin member **101** and box member **102** will vary over successive make-up and breakout cycles. However, one disadvantage of a low-angle metal-to-metal seal is that seal surfaces **103** and **104** have friction contact areas than higher-angle seals, and as such, have less resistance to galling upon make-up. Furthermore, as low-angle metal-to-metal seals engage slowly (*i.e.*, low radial displacement per revolution), the seals must be in contact for several revolutions. As such, in a wedge thread connection including a metal-to-metal seal, the seal is typically the first thing to “make-up,” such that the initial engagement of the seal marks the “hand tight” state of such a threaded connection. Therefore, while low-angle seals are beneficial in that they accommodate the indeterminate make-up characteristics of wedge threads, they may become ineffective over repeated make-up and break-out cycles as seal surfaces **103** and **104** are deformed and/or are cold-worked out of specification.

[0012] In contrast, free-running threads used in oilfield tubular connections typically do not form thread seals when the connection is made-up. Referring now to Figure 2, a prior art connection **200** having free-running threads is shown. The free-running threads include load flanks **254** and **255**, stab flanks **257** and **258**, crests **259** and **262**, and roots **260** and **261**. As is typical of a connection with free-running threads,

connection 200 relies on a positive-stop torque shoulder formed by the contact of surfaces 252 and 251 disposed on a pin member 201 and a box member 202, respectively. The positive-stop torque shoulder shown in Figure 2 is commonly referred to as a "pin nose shoulder." In other connections, the positive-stop torque shoulder may instead be formed by a box face 263 and a mating shoulder (not shown) on pin member 201. The positive-stop torque shoulder also provides a seal. Unlike wedge threads (*e.g.*, those shown in Figure 1B), which make-up by the wedging of the pin thread 106 and the box thread 107, free-running threads rely on the positive-stop torque shoulder to load connection 200 during make-up. To make-up connection 200, pin member 201 and box member 202 are screwed together until surfaces 251 and 252 are brought into abutment, at which point pin load flank 254 and box load flank 255 are also in abutment. Additional torque is applied to pin member 201 and box member 202 to load surfaces 252 and 251 and pin load flank 254 and box load flank 255 until the desired amount of make-up torque (*i.e.*, the selected make-up) has been applied to connection 200.

[0013] Because a large gap 253 exists between pin stab flank 257 and box stab flank 258, connection 200 does not accomplish a thread seal. Gap 253 occurs as a result of how free-running threads with positive-stop torque shoulders are loaded. Applying torque to connection 200 during make-up against the positive-stop torque shoulder causes pin member 201 to be compressed while box member 202 is stretched in tension. Note that when a box face shoulder is used, box member 202 is compressed while pin member 201 is stretched in tension. The force between pin member 201 and box member 202 is applied through pin load flank 254 and box load flank 255. Notably pin stab flank 257 and box stab flank 258 are not loaded during make-up. This results in contact pressure between load flanks 254 and 255 and gap 253 between stab flanks 257 and 258. As discussed above, a wedge thread (*e.g.*, Figure 1) forms a thread seal in part because of the interference between load flanks 225 and 226 and stab flanks 232 and 231. In wedge threads, this occurs near the end of the make-up of the connection because of the varying width of pin thread 106 and box thread 107. To have similar interference between load flanks 254 and 255 and stab flanks 257 and 258 on a cylindrical (*i.e.*, non-tapered) free-running thread, the interference would exist substantially throughout the make-up of the connection because pin thread 206 and box thread 207 have a continuous width.

Furthermore, root/crest interference, if any, would exist substantially throughout the make-up of the connection. This could lead to galling of the threads and difficulty in making-up the connection.

[0014] The variance in thread width for a wedge thread occurs as a result of the load flanks having different leads than the stab flanks. A thread lead may be quantified in inches per revolution or by the commonly used inverse term “thread pitch,” (*i.e.*, threads per inch). A graph of the leads for a prior art wedge thread is shown in Figure 3A. For this connection, the load lead **14** is constant over the length of the connection and greater than the stab lead **12**, which is also constant. The nominal lead is shown as item **10**. As used herein, “nominal lead” refers to the average of load lead **14** and stab lead **12**. The thread will widen with each revolution by the difference in load lead **14** and stab lead **12**. As described above, the difference in the load lead **14** and the stab lead **12** is the “wedge ratio.” For a free-running thread (*i.e.*, non-wedge thread), load lead **14** and stab lead **12** would be substantially equal, thus causing the free-running thread to have a substantially constant thread width (*i.e.*, a zero wedge ratio).

[0015] Intentional variances in thread leads have been disclosed in the prior art for the purposes of load distribution. One example of a varied thread lead for stress distribution is disclosed in U.S. Patent No. 4,582,348 issued to Dearden, hereby incorporated by reference in its entirety. Dearden discloses a connection with free-running threads that has the pin thread and box thread divided into three sections, each with different leads (note that Dearden refers to thread pitch, which is quantified as threads per inch). In Figure 3B, a graph of the thread leads for the box member and the pin member of Dearden is shown. As shown in the graph, at one end of the connection, a pin thread lead **21** is larger than the box thread lead **22**. In the intermediate section **23**, the pin thread lead **21** and box thread lead **22** are substantially equal. Then, at the other end of the connection, box thread lead **22** is larger than pin thread lead **21**. In Dearden, the changes in pin thread lead **21** and box thread lead **22** are step changes (*i.e.*, substantially instantaneous changes in the lead). The varied thread leads disclosed by Dearden are intended to distribute loading across a greater portion of the connection, and have no effect on the ability of the free-running threads to form a thread seal. Dearden does not disclose varying a load lead or stab lead independent of one another.

[0016] Another connection is disclosed in U.S. Patent No. 6,976,711, issued to Sivley, assigned to the assignee of the present invention, and hereby incorporated by reference in its entirety. Sivley discloses connections having a variance in load lead and/or stab lead on one or both of the pin member and the box member. A graph of an embodiment disclosed by Sivley is shown in Figure 3C. Sivley discloses varying load lead **14** relative to stab lead **12** at a selected rate over at least a portion of the pin thread and/or box thread. In Figure 3C, the connection is a wedge thread as shown by the difference between load lead **14** and stab lead **12**. Load lead **14** and stab lead **12** converge at a linear rate towards the end of the thread. Sivley discloses various other embodiments having load leads **14** and stab leads **12** that vary at linear rates relative to each other. The variance in the thread leads distributes the loads experienced by the connection over the length of the connection.

[0017] Referring now to Figure 4, a prior art two-step connection is shown. The threads that form the connection are separated across multiple "steps," a large step, indicated by a bracket **31**, and a small step, indicated by a bracket **32**. The portion between large step **31** and small step **32** is commonly referred to as a mid-step **33**. In some connections, mid-step **33** may be used as a metal-to-metal seal. Preferably, a pin thread crest (often referred to as a major diameter in a non-tapered threaded connection) on small step **32** of pin member **401**, at its full design height, does not interfere with a box thread crest (often referred to as a minor diameter in a non-tapered threaded connection) on large step **31** of box member **402** when pin member **401** is stabbed into box member **402**. The diameter of small step **32** of pin member **401** is smaller than the smallest crest-to-crest thread diameter on large step **31** of box member **402** so a pin thread **406** on small step **32** may be stabbed past a box thread **407** on large step **31**. The threads on both small step **32** and large step **31**, which have substantially the same nominal lead, engage with each revolution to make-up the connection. Thus, the number of revolutions during which the threads slide or rub against each other is reduced for the same number of engaged threads. A multi-step connection allows for each of the steps to have threads with different characteristics as long there is little or no variance in the nominal lead of the threads on the steps.

[0018] A two-step wedge thread connection is disclosed in U.S. Patent No. 6,206,436, issued to Mallis, and hereby incorporated by reference herein. Mallis

discloses a two-step wedge thread connection having different wedge ratios, one of which is considered to be an aggressive wedge ratio and the other a conservative wedge ratio, wherein "aggressive" refers to a larger wedge ratio, and "conservative" refers to a smaller wedge ratio. With all other thread characteristics held constant, a greater wedge ratio will exhibit a more determinate make-up. However, too large of a wedge ratio may have an inadequate wedging effect, which may allow the connection to back off during use. Conversely, smaller wedge ratios are better able to resist backing-off of the connection, but may have such an indeterminate make-up that galling may occur over the lengthened make-up distance. Mallis discloses that one of the steps in a multi-step thread may have a wedge ratio optimized for a more determinate make-up (aggressive), while another step may have a wedge ratio optimized to prevent backing-off of the connection (conservative).

[0019] United States Patent Nos. 6,174,001 and 6,270,127 issued to Enderle, assigned to the assignee of the present invention, and incorporated by reference herein, disclose two-step, low torque wedge threads for tubular connections. In the references, one step is provided so that there is interference at make-up along at least one of the complementary stab flanks, load flanks, roots, and crests while clearance is provided along another step along at least one of the complementary stab flanks, load flanks, roots, and/or crests. This configuration reduces the amount of torque required for make-up of the connection while retaining torque sensitivity, sealing capability, and threads necessary for structural purposes.

[0020] One problem with two-step connections is that the connection must be thick to reach 100 percent pipe body efficiency. As used herein, "pipe body efficiency" is the tensile strength of the connection relative to the tensile strength of the tubular. The primary reason for needing a thicker connection is the unengaged space of the mid-step, which is required so that the threads on the large step may clear the threads on the small step during stabbing. The mid-step, due to the lack of thread engagement, does not contribute to the overall strength of the connection. The advantages of having two separate threads often makes up for the decreased pipe body efficiency, however, it is desirable to have a single-step thread that may exhibit the advantages of two-step connections.

Summary of Invention

[0021] In one aspect, the present invention relates to a threaded connection including a pin member providing a single external wedge thread having a first external portion and a second external portion. Further, the threaded connection includes a box member providing a single internal wedge thread having a first internal portion and a second internal portion, wherein the first and second internal portions threadably correspond with the first and second external portions. Furthermore, the first internal and external portions are preferably characterized by a first wedge ratio and the second internal and external portions are preferably characterized by a second wedge ratio, wherein the first wedge ratio is less than the second wedge ratio and a radial metal-to-metal seal seals between the pin member and the box member and wherein the radial metal-to-metal seal comprises a seal angle between about 4 degrees and about 15 degrees.

[0022] In another aspect, the present invention relates to a threaded connection having a pin member providing a single external wedge thread comprising a first external portion and a second external portion. Further, the threaded connection has a box member providing a single internal wedge thread comprising a first internal portion and a second internal portion, wherein the first and second internal portions threadably correspond with the first and second external portions. Furthermore, the first internal and external portions are preferably characterized by a first wedge ratio and the second internal and external portions are preferably characterized by a second wedge ratio. Further still, a radial metal-to-metal seal seals between the pin member and the box member, and the pin and box members are configured such that, during make-up, the first external and internal portions reach a first specified make-up before engagement of the radial metal-to-metal seal and a second specified make-up of the second external and internal portions.

[0023] In another aspect, the present invention relates to a method to couple a threaded connection including engaging a pin end of the connection into a box end of the connection, wherein the pin end comprises an external wedge thread and the box end comprises an internal wedge thread. Further, the method includes rotating the connection to a first position to make-up a first portion of the pin end wedge thread with a first portion of the box end wedge thread at a first wedge ratio and

rotating the connection to a second position to engage a radial metal-to-metal seal of the threaded connection. Further still, the method includes rotating the connection to a third position to make-up a second portion of the pin end wedge thread and a second portion of the box end wedge thread at a second wedge ratio.

[0024] In another aspect, the present invention relates to a threaded connection having wedge threads, the threaded connection includes a pin member comprising a pin thread having a pin thread crest, a pin thread root, a pin load flank, and a pin stab flank, wherein the pin thread comprises at least a first portion, a transition region, and a second portion formed sequentially thereon. Further, the threaded connection includes a box member comprising a box thread having a box thread crest, a box thread root, a box load flank, and a box stab flank, wherein the box thread comprises at least a first portion, a transition region, and a second portion formed sequentially thereon, the portions on the box thread corresponding generally in axial position with the portions on the pin thread. Preferably, the first portion has a first wedge ratio, the transition region has a transition wedge ratio, and the second portion has a second wedge ratio, wherein thread leads are substantially constant within each of the portions. Furthermore, the threaded connection includes a radial metal-to-metal seal to seal between the pin member and the box member, wherein the pin and box members are configured such that during make-up, the first portions reach a first specified make-up before engagement of the radial metal-to-metal seal and a second specified make-up of the second portions.

Brief Description of Drawings

[0025] Figures 1A and 1B depict cross-sectional views of a prior art tubular connection having wedge threads.

[0026] Figure 2 is a cross-sectional view of a prior art tubular connection having free-running threads.

[0027] Figures 3A, 3B, and 3C show graphical representations of thread leads for various prior art tubular connections.

[0028] Figure 4 is a cross-sectional view of a prior-art two-step tubular connection having free-running threads.

- [0029] Figures 5A, 5B, and 5C schematically depict a two-portion wedge threaded connection.
- [0030] Figures 6A, 6B, and 6C schematically depict a two-portion wedge threaded connection.
- [0031] Figures 7A and 7B schematically depict a two-portion wedge threaded connection.

Detailed Description

- [0032] Some embodiments of the present invention include single-step wedge-threaded connections having variances in the wedge ratio so that a high-angle metal-to-metal seal may be used therewith. Furthermore, some embodiments are characterized by a multiple stage make-up of a wedge threaded connection, such that a first portion of the wedge thread may make-up at a conservative wedge ratio before a metal-to-metal seal engages and before a second portion of the wedge thread makes-up at an aggressive wedge ratio. Further still, in some embodiments, the metal-to-metal seal may engage simultaneously with the second portion make-up while, in other embodiments, the metal-to-metal seal may engage prior to the second portion make-up.
- [0033] Referring now to Figures 5A–5C, a three-portion wedge-threaded connection **500** is shown. Particularly, Figure 5A depicts connection **500** schematically as having a pin threaded member **506** and a box threaded member **507**. Next, Figure 5B is a graphical representation of the box thread lead of box member **507**. Furthermore, Figure 5C is a graphical representation of the pin thread lead of pin member **506**. As such, Figures 5B and 5C depict their respective thread lead length (*e.g.*, in inches) as a function of axial position (*e.g.*, the thread number).
- [0034] Nonetheless, for the sake of clarity, connection **500** is shown in Figure 5A partially made-up, rather than at a selected final make-up. Referring to Figure 5A, pin threaded member **506** corresponding to the graph of Figure 5C is shown partially made-up with a box threaded member **507** corresponding to the graph shown in Figure 5B. The partially made-up thread shown in Figure 5A has three thread portions, **501A**, **503**, and **501B**. Thread portion **503** is defined by the distal ends of

box thread portion **503A** and pin thread portion **503B**, as shown in Figures 5B and 5C, when the box and pin are partially made-up.

[0035] Referring now to Figures 5B and 5C, the lengths of various thread leads as a function of axial position are depicted, wherein each unit of the axial position axis represents about a 360 degree turn of a thread pitch. For example, thread portions **501A** and **501B** are about seven thread pitches each, while another thread portion **503** is about one thread pitch. In Figure 5A, pin thread **506** includes pin stab flanks **531** and pin load flanks **526** and box thread **507** includes box stab flanks **532** and box load flanks **525**. Both pin and box threads are divided into three thread portions, **501A**, **503A**, and **501B**. While wedge-thread connection **500** is shown as a three-portion connection, it should be understood that other configurations (*e.g.*, two or greater than three portions) may be used to create wedge-threaded connections in accordance with embodiments of the present invention.

[0036] Referring still to Figures 5B and 5C, thread portions **501A** have a wedge ratio **511A** and thread portions **501B** have a wedge ratio **511B**, wherein wedge ratios **511A** and **511B** are substantially the same. Thread portion **503A** of box member **507** and pin member **506** exhibit a wedge ratio **513** larger than wedge ratios **511A** and **511B**. As shown, box thread portion **503A** and pin thread portion **503B** are the same axial length, but as will be demonstrated later, thread portions **503A** and **503B** may be of different axial lengths. As thread portions **501A** and **501B** may have the same characteristics, together, they may be considered as a single, discontinuous thread **501**, which is “interrupted” or “perturbed” by thread portions **503A** and **503B**.

[0037] Since a load lead **514** and a stab lead **516** are varied in a complementary manner on both pin member **506** and box member **507**, a nominal lead **510** is substantially constant over the length of both pin member **506** and box member **507**. At the end of first thread portion **501A**, wedge ratio **511A** increases to a second wedge ratio **513** by increasing a load lead **514** while proportionally decreasing a stab lead **516**, so that nominal lead **510** is maintained substantially constant. As mentioned earlier, second wedge ratio **513** is larger than both wedge ratio **511A** of thread portion **501A** and wedge ratio **511B** of thread portion **501B**. Furthermore, in some embodiments, a helical length of made-up thread portion **503** may be in increments of about 360 degrees to prevent eccentric loading of connection **500**.

After portion **503**, wedge ratio **513** decreases to wedge ratio **511B** characteristic of thread portion **501B**, which, as shown in Figures 5A–5C, is substantially equal to wedge ratio **511A** of thread portion **501A**.

[0038] At the partially made-up condition shown in Figure 5A, there may be contact between the pin stab flank **531** and box stab flank **532**, and between pin load flank **526** and box load flank **525** in both thread portion **501A** and thread portion **501B**, but clearance **504** between the stab and load flanks in made-up thread portion **503**.

[0039] Additionally, Figures 5B–5C disclose an offset **505** between the start of thread portion **503B** on pin thread **506** (Figure 5C) and the start of thread segment **503A** on box thread **507** (Figure 5B). As shown, thread portion **503A** begins at a slightly earlier selected axial position on box member **507** than thread portion **503B** on pin member **506**. This offset allows the threads of box member **507** to “open up” or widen slightly earlier than pin thread **506**, resulting in a clearance between flanks in thread portion **503** when the connection is partially made-up as shown in Figure 5A. To return to flank contact (or interference), thread portion **501B** may begin at an earlier axial position on box member **507**, thus allowing threads of pin member **506** to “catch up.” Thus, the size of offset **505** may dictate the relative flank contact in thread segments **501A**, **503**, and **501B**. For example, assuming connection **500** shown in Figures 5A–5C (wherein, at a selected partial make-up, the thread flanks in thread portions **501A** and **501B** are in contact and the thread flanks in thread portion **505** are in clearance), increasing offset **505** without changing any other thread characteristics would increase the flank clearance in thread portion **503** and reduce or eliminate the flank contact in thread portion **501B**.

[0040] Similarly, relative flank contact in thread segments **501A**, **503**, and **501B** at a selected make-up may be changed by altering the relative axial lengths of box thread portion **503A** and pin thread portion **503B**. For example, assuming connection **500** shown in Figures 5A–5C, increasing the axial length of pin thread portion **503B** in Figure 5C would result in increased contact stress in thread portion **501B**, reduced contact stress in thread portion **501A**, and an increased clearance at thread portion **503**. Therefore, connection **500** would tend to make-up first on the flanks of thread portion **501B**.

[0041] By varying the size of offset **505** and the relative widths of thread portions **503A** and **503B** on the box and pin threads respectively, a thread designer may tailor the relationship between the flanks in all three thread portions **501A**, **503**, and **501B** at a selected final make-up. For example, in one embodiment, the thread flanks in at least one of the three thread portions **501A**, **503**, and **501B** may be in clearance at a selected make-up. Similarly, in other embodiments the flank interference in thread portion **503** at a selected final make-up may be less than, equal to, or greater than the flank interference in thread portions **501A** or **501B**. In another embodiment, there may be flank interferences in all thread portions **501A**, **503**, and **501B** at a selected make-up which are all different from one another. In such an embodiment, flank contact may occur on one thread portion of the wedge thread before another thread portion at a preliminary make-up, but with both portions having flank interference at a selected make-up. Further, one or more thread portions may have interference between only the load flanks or the stab flanks instead of both.

[0042] Because wedge ratios **511A** and **511B** are conservative relative to wedge ratio **513** of portion **503**, contact stress between mating flanks in thread portions **501A** and **501B** will rise slowly with increased make-up, while the flank contact stresses in portion **503** will rise more quickly. In the embodiment represented by Figures 5A-5C, at a partial make-up, the flanks of thread portions **501A** and **501B** may be in contact while the flanks of thread portion **503** may be in clearance. Subsequently, at a selected final make-up, the flank interference may be the same in all three thread portions **501A**, **503**, and **501B**.

[0043] In another embodiment, at a selected final make-up the flank interference in thread portions **501A** and **503** may be the same while the flank interference in thread portion **501B** may be lower. This embodiment may be useful, for example, in high-torque applications where thread portion **501B**, having a lower flank interference at a selected final make-up, may act as a "back-up" torque shoulder.

[0044] Referring now to Figures 6A-6C, a three-portion wedge-threaded connection **600** is shown. In Figure 6A, a pin member **606** corresponding to the graph of Figure 6C is shown at a selected final make-up with a box member **607** corresponding to the graph of Figure 6B. In this embodiment, threads of pin member **606** and box member **607** exhibit interference between load flanks **625** and **626** and stab flanks

631 and **632** on a first portion **601** and a second portion **603**, on both a first portion **601** (analogous to the small step **32** of Figure 4) and a second portion **603** (analogous to the large step **31** of Figure 4) of the wedge-threaded connection **600** at selected make-up. Furthermore, a transition region **602** between first portion **601** and second portion **603** is shown. Thus, Figures 6A–6C represent a first portion **601** of approximately seven thread pitches, a transition region **602** of approximately one pitch, and a second portion **603** of approximately seven pitches.

[0045] In contrast, two-step connections having differential wedge ratios are disclosed in U.S. Patent No. 6,206,436 issued to Mallis, discussed above. Mallis' teachings (including all of the advantages), as they apply to two-step connections having two different wedge ratios, are generally applicable to the multiple thread-portion single step connections disclosed herein. Using terminology from Mallis, in the embodiment shown in Figures 6A–6C, second portion **603** exhibits an “aggressive” wedge ratio **613**, while first portion **601** exhibits a “conservative” wedge ratio **611**. However, unlike the disclosure of Mallis and Figures 5A–C discussed above, Figures 6A–6C depict continuous, single-step threads without interruptions between portions.

[0046] While transition region **602** is shown having clearance between load flanks **625**, **626** and stab flanks **631**, **632**, it should be understood by one of ordinary skill that transition region **602** may have load flank **625**, **626** or stab flank **631**, **621** interference. Furthermore, while transition region **602** is shown as extending over only one thread pitch, it should be understood that a larger or smaller transition region **602** may be used. Additionally, in one embodiment, flank interference may occur on one portion of the wedge thread before the other at make-up, with both first portion **601** and second portion **603** having interference at selected make-up. Further, one or more of thread portions **601**, **602**, and **603** may have interference between only the load flanks or the stab flanks instead of both.

[0047] To achieve the three-portion configuration shown in Figure 6A, a load lead **614** and a stab lead **616** may be varied in a complementary manner on both pin member **606** and box member **607** as shown in Figures 6B and 6C. As depicted, the nominal lead **610** is held substantially constant over the length threads on of both pin member **606** and box member **607**. Along first portion **601**, the difference between load lead **614** and stab lead **616** (i.e., the wedge ratio **611**) is substantially constant.

At the end of first portion **601**, wedge ratio **611** increases to a transition wedge ratio **612** by increasing load lead **614** a selected amount while proportionally decreasing stab lead **616**, substantially maintaining nominal lead **610**. As may be seen, transition wedge ratio **612** is larger than both wedge ratio **611** of first portion **601** and wedge ratio **613** of second portion **603**. The length of the threads at transition region **602** allows transition between first portion **601** and second portion **603**, and is relatively small in helical length compared to first portion **601** and second portion **603**. In some embodiments, the helical length of transition region **602** may be in increments of about 360 degrees to prevent eccentric loading of the connection. Following transition region **602**, transition wedge ratio **612** decreases to wedge ratio **613** characteristic of second portion **603**, which, in Figures 6A–6C, is shown greater than wedge ratio **611** of first portion **601**.

[0048] Additionally, Figures 6A–6C also disclose an offset **605** in transition thread portion **602** of pin member **606** and box member **607**. As shown, transition thread portion **602** begins at a slightly earlier selected axial position on box member **607** than on pin member **606**. This offset allows the threads of box member **607** to “open up” or widen slightly earlier than those of pin member **606**, resulting in a selected clearance between flanks on the transition region **602**. To return to flank interference, second portion **603** may begin at an earlier selected axial position on box member **607**, thus allowing threads of pin member **606** to “catch up.” Alternatively, second portion **603** of box member **607** and pin member **606** may begin simultaneously to further delay a selected make-up of second portion **603** following a selected make-up of first portion **601**. Thus, variations in load lead **614** and stab lead **616** over the length of the threads allows for a connection to exhibit different make-up characteristics in each portion of the connection. Those having ordinary skill in the art will appreciate that various combinations of portions (*e.g.*, **601**, **602**, **603**) may be used in accordance with embodiments of the present invention.

[0049] Referring now to Figures 7A–7B, a two-portion wedge-threaded connection **700** is shown schematically. Connection **700** is distinct from connection **600** of Figures 6A–6B in that connection **700** does not include a transition thread portion (*e.g.*, **602**) between a first portion **701** and a second portion **703**. As such, connection **700** is characterized by a wedge ratio **711** of first portion **701** that

instantaneously expands to a larger wedge ratio **713** of second portion **703**. Similar to the connections shown in Figures 5 and 6, the second portion of the pin thread may lag the box thread lead by an offset **705** to allow the box thread to open up or widen slightly earlier than pin thread. While change in wedge ratio from **711** to **713** is shown as a substantially instantaneous step change, a smoother graduated change may be used.

[0050] As described above, wedge threads are characterized by indeterminate make-up. However, the amount of indeterminateness of a wedge-threaded connection may be varied by changing the underlying wedge ratio. For example, wedge-threaded connections having a more conservative (*i.e.*, lower) wedge ratio, make-up to a selected amount of flank interference more indeterminately than those having more aggressive wedge ratios. As such, a connection having a more conservative wedge ratio will require more rotation (and torque) to reach a selected make-up, and thus be more indeterminate than a connection having an aggressive wedge ratio. In contrast, connections exhibiting more aggressive wedge ratios will make-up more determinately, but will be less resistant to backing off than connections having conservative wedge ratios.

[0051] As such, single-step wedge-threaded connections with at least two threaded portions at differing wedge ratios are highly beneficial in connections having a metal-to-metal seal (*e.g.*, **103** and **104** of Figure 1A) to reduce the amount of wear and galling experienced by such seals. Particularly, a continuous, wedge-threaded connection, in which a first thread portion has a conservative wedge thread, and a second thread portion has an aggressive wedge thread, may be used to allow a more determinate engagement of such a seal.

[0052] For example, in an embodiment in accordance with the present invention, a continuous, single-step wedge-threaded connection may be constructed having two (or more) portions, a first portion having a conventional (less aggressive) wedge ratio, and a second portion having a higher (more aggressive) wedge ratio. Because of the high wedge ratio of the second portion, the connection could include a radial metal-to-metal seal having a seal angle between about 4 and about 15 degrees. Further, in some embodiments, seal angles of about 7 degrees, about 14 degrees, or anywhere therebetween may be used. As described above, the metal-to-metal seal

may be a pin-nose seal, box face seal, or any other seal known to one of ordinary skill in the art.

[0053] Furthermore, for a two-portion wedge-threaded connection, the more aggressive second portion may comprise a smaller percentage of the total number of thread pitches than the more conservative first portion. For example, if a conventional standard wedge thread has ten pitches and a wedge ratio of 0.015"/pitch (*i.e.*, the thread width grows by 10 pitches $\cdot$ 0.015"/pitch = 0.150" over the length of the thread), a two-portion wedge thread of the same axial length may have two pitches at a wedge ratio of 0.030 in the second portion and the remaining eight pitches at 0.01125"/pitch wedge ratio (*i.e.*, $[0.150" - 2 \cdot 0.030"]/8$) in the first portion and still maintain the same growth in thread width over the length of the thread. Alternatively, the first and second portions may be of substantially equal number of pitches or length. Alternatively still, a multi-portion wedge-threaded connection may have several alternating conservative and aggressive portions, wherein each conservative/aggressive couple acts to selectively make-up the connection in parallel.

[0054] The make-up sequence for a continuous two-portion wedge-threaded connection in accordance with embodiments of the present invention may include the first portion making-up (*e.g.*, a preliminary rotation) before the engagement of the metal-to-metal seal (*e.g.*, a secondary rotation) and the making-up of the second portion (*e.g.*, a tertiary rotation). Preferably, the wedge ratio of the second portion could be related to the angle of the metal-to-metal seal, such that the second portion reaches its selected make-up at the same time the metal-to-metal seal becomes fully engaged. Generally, to achieve this goal, a steeper seal angle will require a higher wedge ratio in the second thread portion. For example, as the metal-to-metal seal having a seal angle of about 14 degrees will fully engage within 1/4 turn of a typical wedge thread, the axial position and wedge ratio of the second portion may be chosen such that the second portion reaches desired flank interference in about 1/4 turn, at essentially the same selected make-up that the metal-to-metal seal reaches full engagement.

[0055] It should be understood that wedge thread connections in accordance with embodiments of the present invention are advantageous over those in the prior art in

that the metal-to-metal seals contained therewith may be more durable and less susceptible to damage in service and during make-up and break-out cycles.

[0056] High-angle metal-to-metal seals in accordance with embodiments of the present invention are less susceptible to damage from eccentric contact during make-up and break-out as they are engaged after a first portion of a continuous multi-portioned wedge-threaded connection is made up. As such, make-up of the first portion prior to the engagement of the metal-to-metal seals may act to “pilot” the seal components into engagement with reduced likelihood of eccentric contact. Similarly, during break out, the seals may be disengaged prior to break-out of the first portion, thus again allowing the first portion to “pilot” the seal components apart axially, thus protecting seal surfaces from eccentric contact. Thus early engagement/late disengagement of the first portion of a continuous multi-portioned wedge-threaded connection may protect seal surfaces by piloting components of a metal-to-metal seal into and out of engagement along the an axis of the connection.

[0057] Furthermore, as described above, the reduced contact area of a high-angle seal in accordance with embodiments of the present invention translates to less metal-to-metal seal area, thereby reducing the likelihood and magnitude of galling therebetween. Furthermore, as the high-angle seals engage under less rotational displacement than low-angle seals, there is less metal-to-metal frictional displacement through that seal area.

[0058] While the invention has been described with respect to a limited number of embodiments, those skilled in the art, having benefit of this disclosure, will appreciate that other embodiments can be devised which do not depart from the scope of the invention as disclosed herein. Accordingly, the scope of the invention should be limited only by the attached claims.

Claims

What is claimed:

1. A threaded connection, comprising:
 - a pin member providing a single external wedge thread comprising a first external portion and a second external portion;
 - a box member providing a single internal wedge thread comprising a first internal portion and a second internal portion, wherein the first and second internal portions threadably correspond with the first and second external portions;
 - wherein the first internal and external portions are characterized by a first wedge ratio and the second internal and external portions are characterized by a second wedge ratio, wherein the first wedge ratio is less than the second wedge ratio;
 - a radial metal-to-metal seal to seal between the pin member and the box member;
 - and
 - wherein the radial metal-to-metal seal comprises a seal angle between about 4 degrees and about 15 degrees.
2. The threaded connection of claim 1, wherein the pin and box members are configured such that, during make-up, the first external and internal portions reach a first specified make-up before engagement of the radial metal-to-metal seal and a second specified make-up of the second external and internal portions.
3. The threaded connection of claim 1, wherein the radial metal-to-metal seal is selected from the group consisting of pin-nose seals, box-face seals, and mid-thread seals.
4. The threaded connection of claim 1, wherein the radial metal-to-metal seal comprises a seal angle between about 7 degrees and about 14 degrees.
5. The threaded connection of claim 1, further comprising a transition region between the first internal and external portions and the second internal and external portions.
6. The threaded connection of claim 1, further comprising an offset between the second internal portion and the second external portion.

7. The threaded connection of claim 1, further comprising a third portion on each of the box member and the pin member, wherein the third portions are characterized by a third wedge ratio substantially equal to the first wedge ratio.
8. A threaded connection, comprising:
 - a pin member providing a single external wedge thread comprising a first external portion and a second external portion;
 - a box member providing a single internal wedge thread comprising a first internal portion and a second internal portion, wherein the first and second internal portions threadably correspond with the first and second external portions;wherein the first internal and external portions are characterized by a first wedge ratio and the second internal and external portions are characterized by a second wedge ratio; and
 - a radial metal-to-metal seal to seal between the pin member and the box member;wherein, the pin and box members are configured such that, during make-up, the first external and internal portions reach a first specified make-up before engagement of the radial metal-to-metal seal and a second specified make-up of the second external and internal portions.
9. The threaded connection of claim 8, wherein the radial metal-to-metal seal is selected from the group consisting of pin-nose seals, box-shoulder seals, and mid-shoulder seals.
10. The threaded connection of claim 8, wherein the radial metal-to-metal seal comprises a seal angle between about 4 degrees and about 15 degrees.
11. The threaded connection of claim 8, wherein the first wedge ratio is less than the second wedge ratio.
12. The threaded connection of claim 8, further comprising a transition region between the first internal and external portions and the second internal and external portions.
13. The threaded connection of claim 8, further comprising an offset between the second internal portion and the second external portion.

14. The threaded connection of claim 13, wherein the first wedge ratio and the second wedge ratio are substantially equal.
15. The threaded connection of claim 8, wherein the radial metal-to-metal seal engages before the second specified make-up of the second internal and external portions.
16. The threaded connection of claim 8, wherein the radial metal-to-metal seal engages simultaneously with the second specified make-up of the second external and internal portions.
17. The threaded connection of claim 8, wherein the first specified make-up occurs when load and stab flanks of the first internal and external portions reach a specified amount of interference.
18. The threaded connection of claim 8, wherein the second specified make-up occurs when load and stab flanks of the second internal and external portions reach a specified amount of interference.
19. A method to couple a threaded connection, the method comprising:
 - engaging a pin end of the connection into a box end of the connection, wherein the pin end comprises an external wedge thread and the box end comprises an internal wedge thread;
 - rotating the connection to a first position to make-up a first portion of the pin end wedge thread with a first portion of the box end wedge thread at a first wedge ratio;
 - rotating the connection to a second position to engage a radial metal-to-metal seal of the threaded connection; and
 - rotating the connection to a third position to make-up a second portion of the pin end wedge thread and a second portion of the box end wedge thread at a second wedge ratio.
20. The method of claim 19, wherein rotating the connection to the second and third positions is performed simultaneously.
21. The method of claim 19, wherein the radial metal-to-metal seal is selected from the group consisting of a pin nose seal, a box-shoulder seal, and a mid shoulder seal.

22. The method of claim 19, wherein the radial metal-to-metal seal comprises a seal angle between about 4 degrees and about 15 degrees.
23. The method of claim 19, wherein the first wedge ratio is lower than the second wedge ratio.
24. The method of claim 19, wherein components of the radial metal-to-metal seal do not engage until the connection is rotated to the second position.
25. A threaded connection having wedge threads, the threaded connection comprising:
a pin member comprising a pin thread having a pin thread crest, a pin thread root, a pin load flank, and a pin stab flank, wherein the pin thread comprises at least a first portion, a transition region, and a second portion formed sequentially thereon;
a box member comprising a box thread having a box thread crest, a box thread root, a box load flank, and a box stab flank, wherein the box thread comprises at least a first portion, a transition region, and a second portion formed sequentially thereon, the portions on the box thread corresponding generally in axial position with the portions on the pin thread;
wherein the first portion has a first wedge ratio, the transition region has a transition wedge ratio, and the second portion has a second wedge ratio;
wherein thread leads are substantially constant within each of the portions;
a radial metal-to-metal seal to seal between the pin member and the box member;
and
wherein the pin and box members are configured such that during make-up, the first portions reach a first specified make-up before engagement of the radial metal-to-metal seal and a second specified make-up of the second portions.

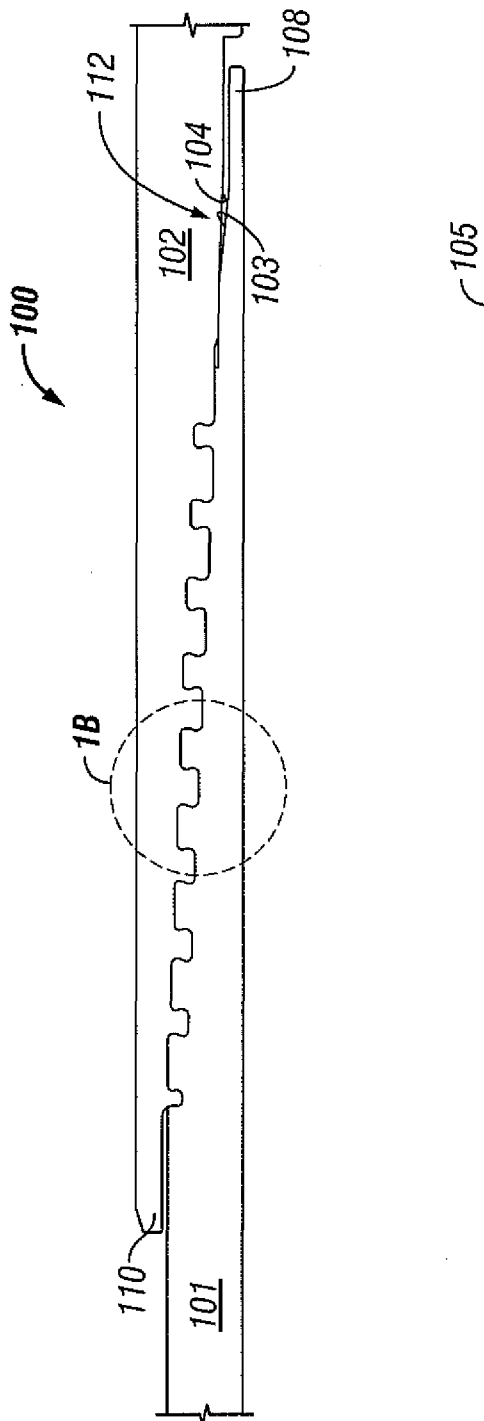


FIG. 1A
(Prior Art)

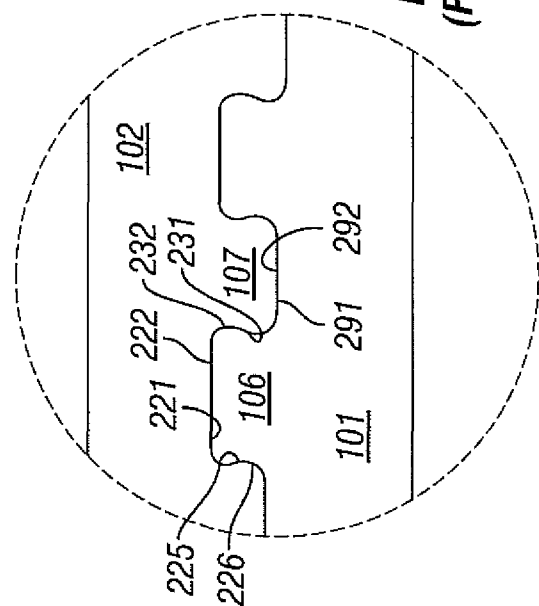


FIG. 1B
(Prior Art)

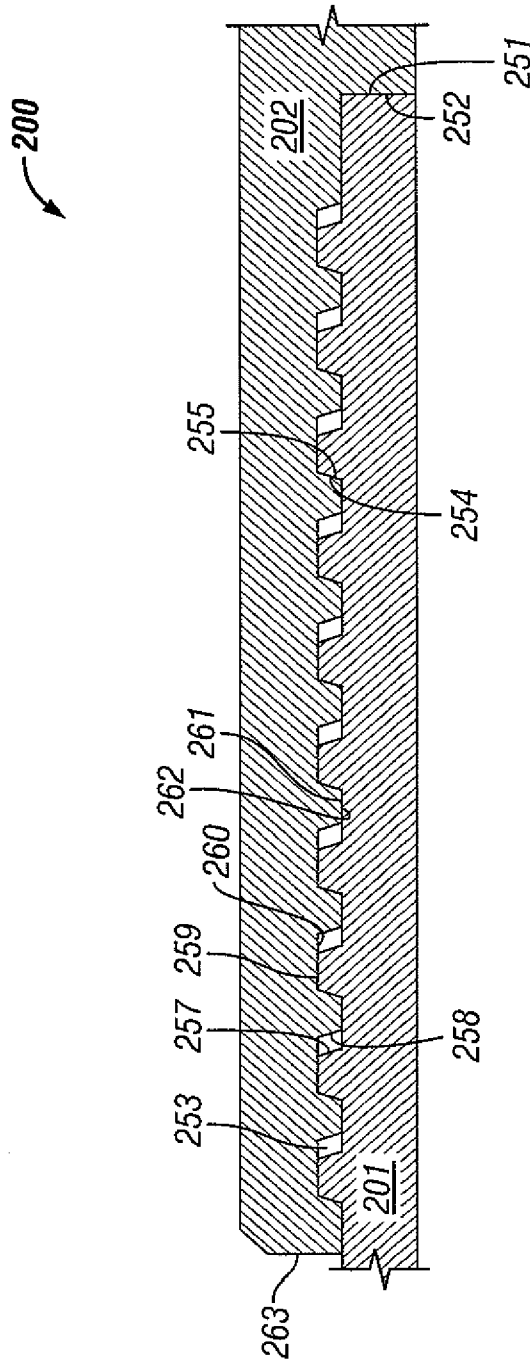


FIG. 2
(Prior Art)

3/7

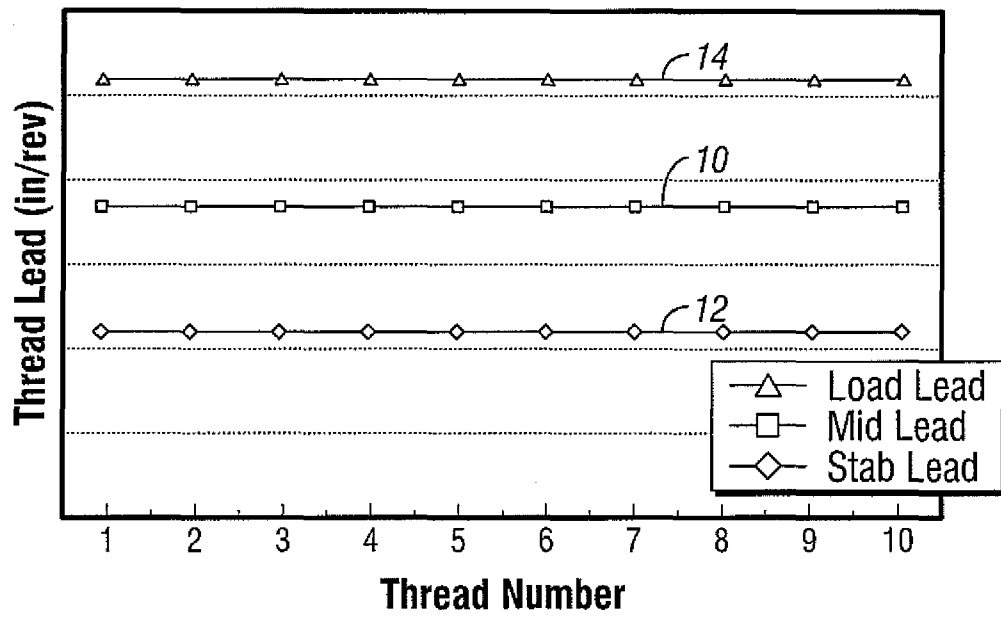


FIG. 3A
(Prior Art)

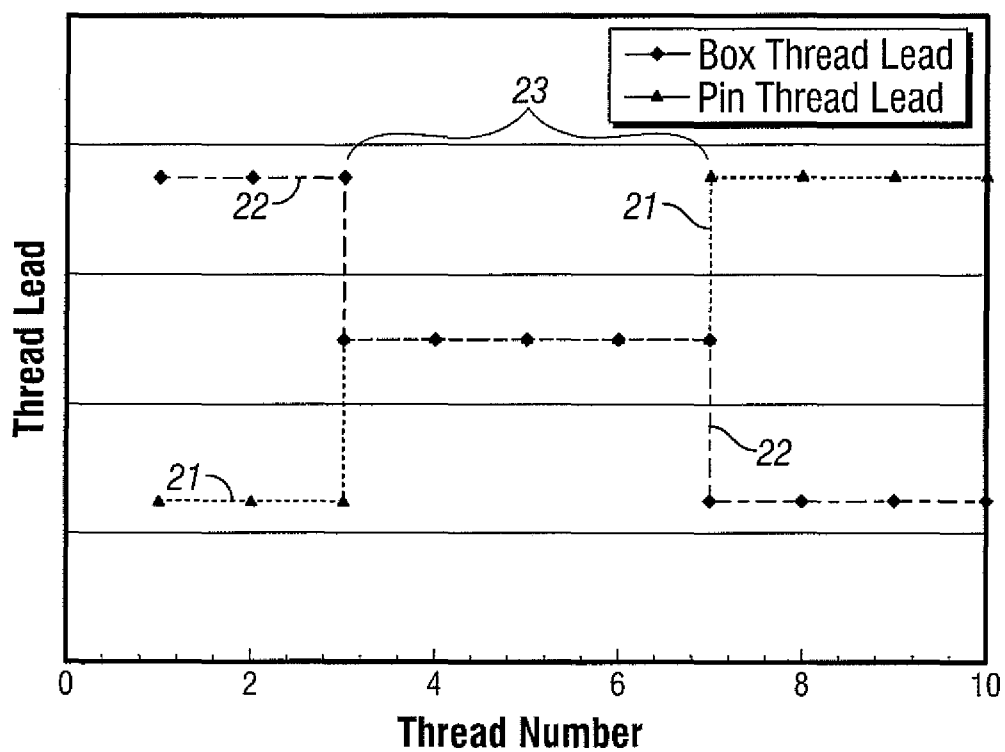


FIG. 3B
(Prior Art)

4/7

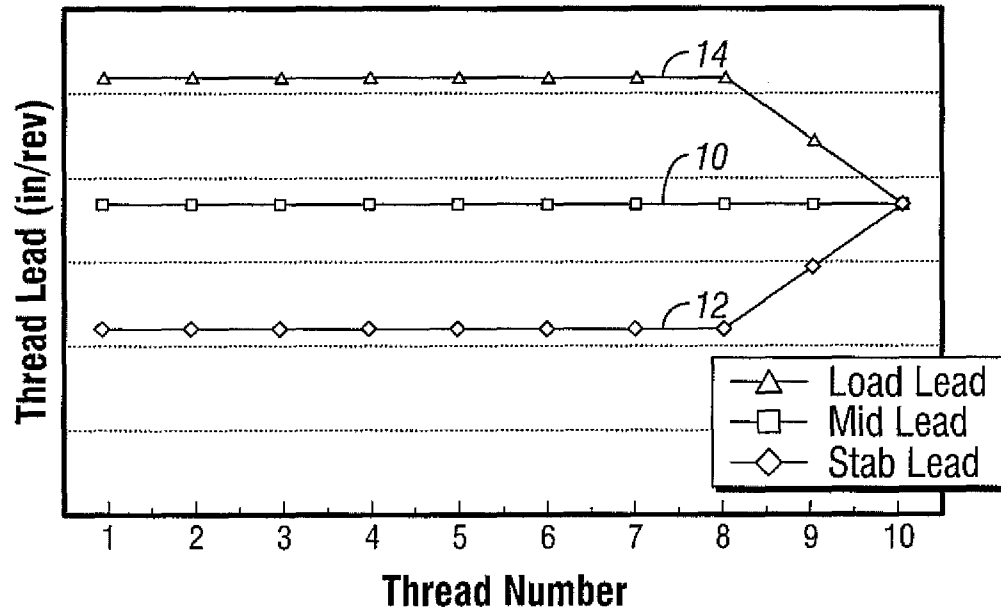


FIG. 3C
(Prior Art)

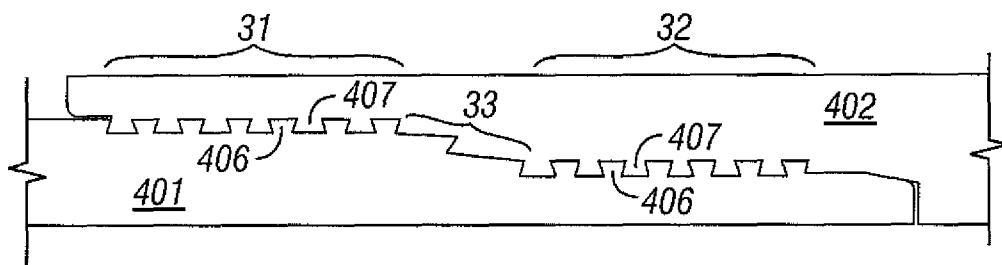


FIG. 4
(Prior Art)

5/7

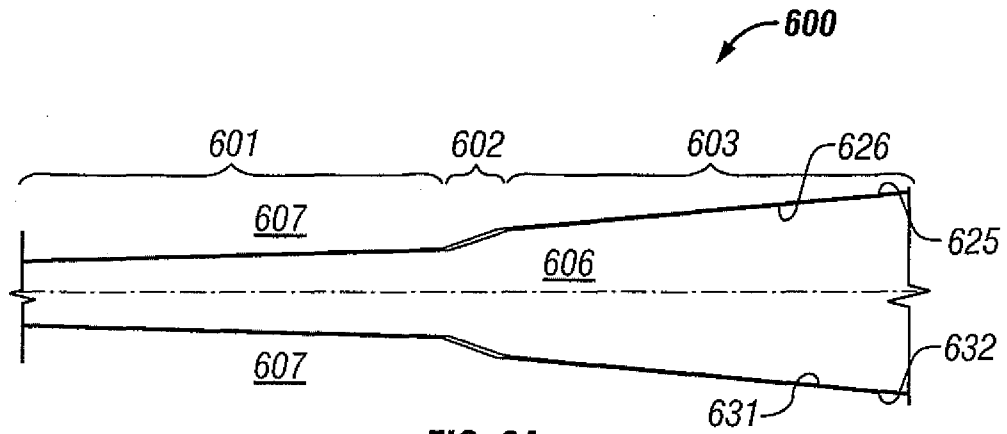


FIG. 6A

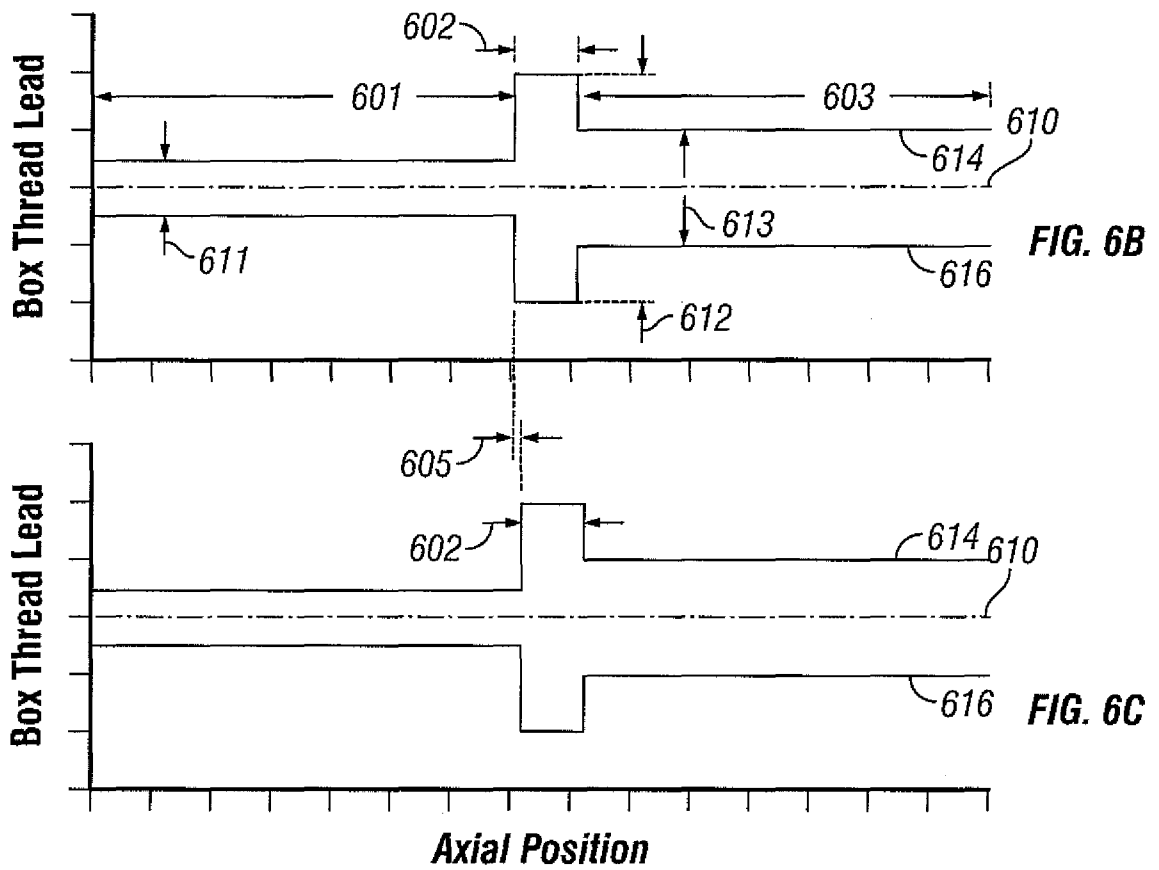


FIG. 6B

FIG. 6C

6/7

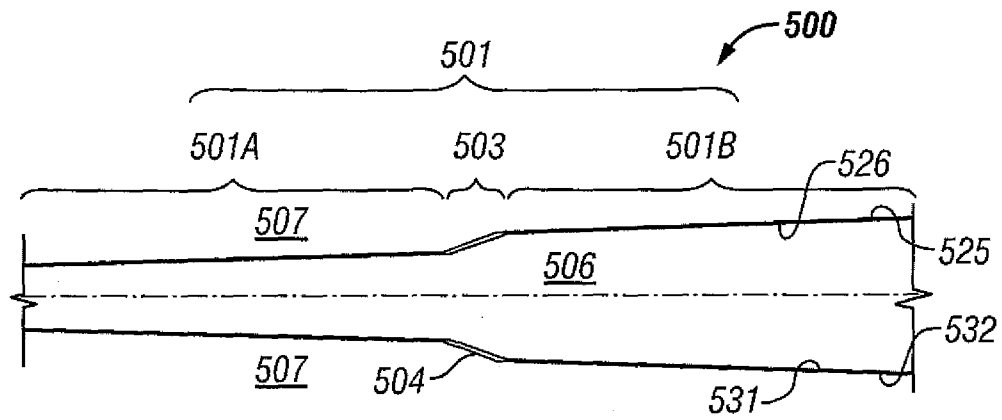


FIG. 5A

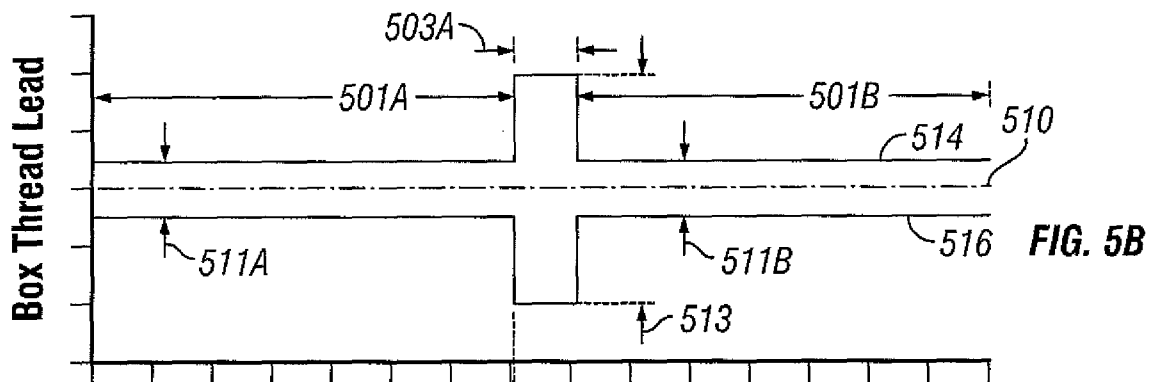


FIG. 5B

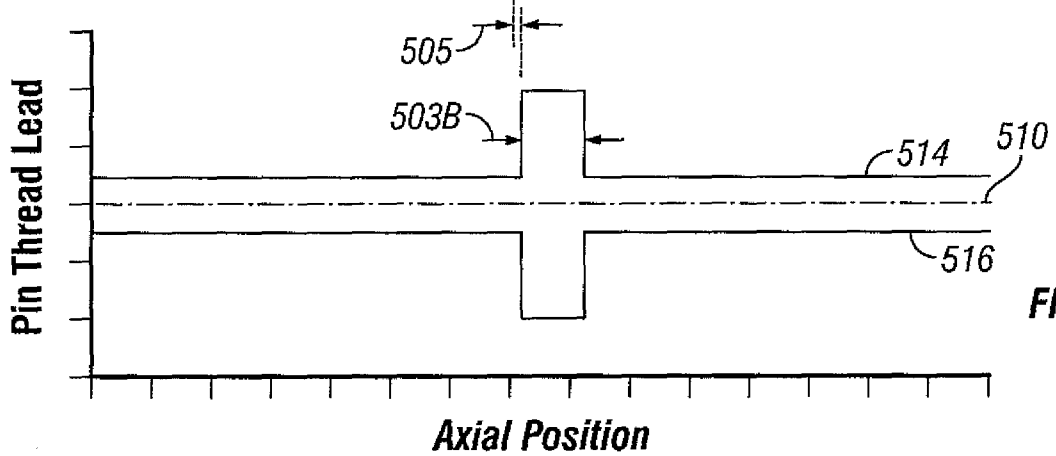
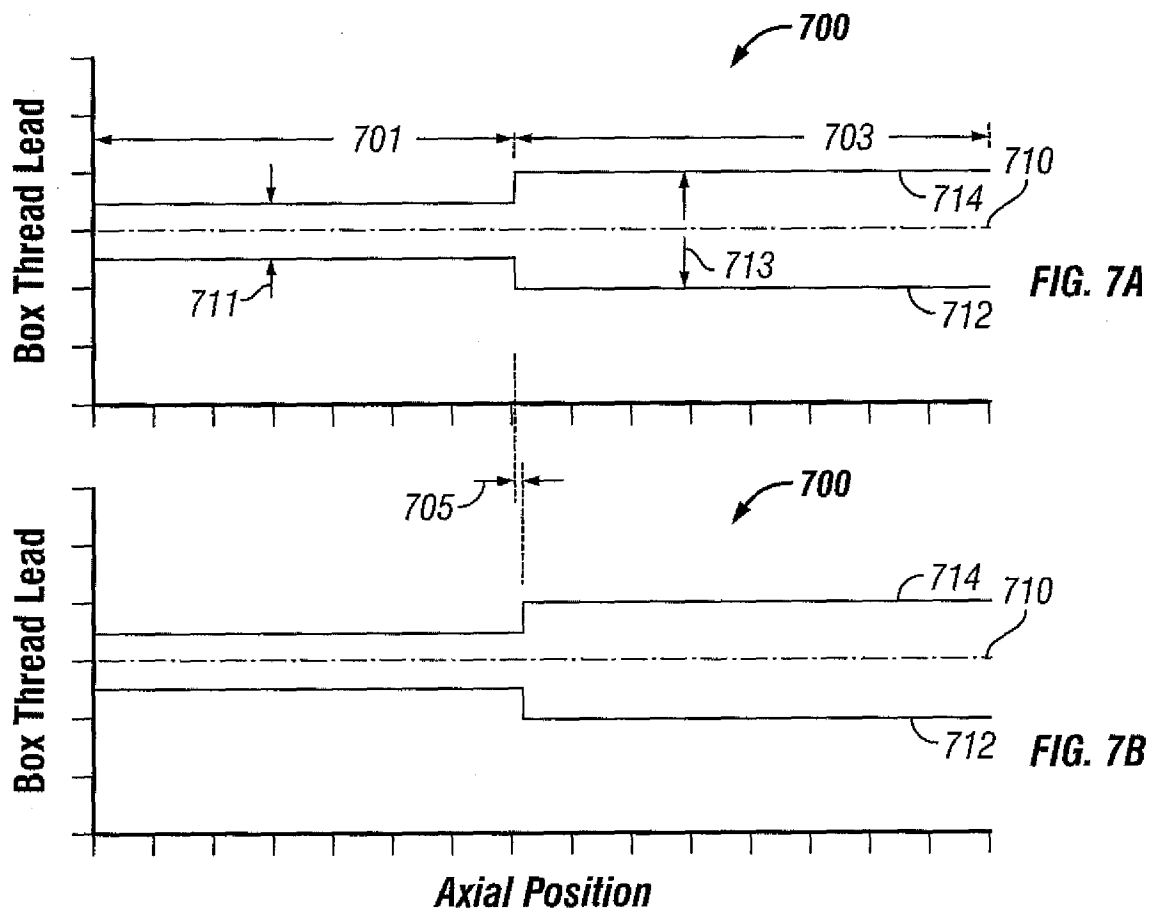


FIG. 5C

7/7



INTERNATIONAL SEARCH REPORT

International application No.
PCT/US2007/069574**A. CLASSIFICATION OF SUBJECT MATTER*****F16L 33/02(2006.01)i, F16L 33/035(2006.01)i***

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

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 8: F16L15/00, F16L25/00, F16L33/02

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

eKIPASS (KIPO internal) & keywords : "thread", "connection", "wedge", "seal", and "pipe"

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US 6,174,001 B1 (DOUG ENDERLE) 16 January 2001 See claim 1 and figure 4.	1 - 25
A	US 6,722,706 B2 (CRIS L. CHURCH) 20 April 2004 See claim 1 and figures 2, 3.	1 - 25
A	JP 2004-524483 A (SUMITOMO METAL INDUSTRIES, LTD.) 12 August 2004 See claim 1 and figures 2A, 4D, 6A, 6B.	1 - 25
A	US 6,578,880 B2 (JOHN D. WATTS) 17 June 2003 See claim 1 and figure 7.	1 - 25

☐ Further documents are listed in the continuation of Box C.☒ See patent family annex.

* Special categories of cited documents:

"A" document defining the general state of the art which is not considered to be of particular relevance

"E" earlier application or patent but published on or after the international filing date

"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of citation or other special reason (as specified)

"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"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

24 OCTOBER 2007 (24.10.2007)

Date of mailing of the international search report

24 OCTOBER 2007 (24.10.2007)

Name and mailing address of the ISA/KR

Korean Intellectual Property Office
920 Dunsan-dong, Seo-gu, Daejeon 302-701,
Republic of Korea

Facsimile No. 82-42-472-7140

Authorized officer

KIM, JAE CHUL

Telephone No. 82-42-481-5410



INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No.

PCT/US2007/069574

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
US6174001B1	16.01.2001	AU199930746A1	11.10.1999
		CA02324457A1	23.09.1999
		DE69912413T2	17.06.2004
		EP1070192A1	24.01.2001
		EP1070192B1	29.10.2003
		W09947785A1	23.09.1999
US6722706B2	20.04.2004	US20030067169A1	10.04.2003
JP2004524483A	12.08.2004	AR032421A1	05.11.2003
		AT280922E	15.11.2004
		BR200207086A	20.01.2004
		CA2437528A1	22.08.2002
		CN1254625C	03.05.2006
		CN1489680A	14.04.2004
		CZ20032444A3	17.12.2003
		DE60201731T2	24.11.2005
		EP1358421B1	27.10.2004
		EP1358421A1	05.11.2003
		ES2230465T3	01.05.2005
		FR2820806A1	16.08.2002
		FR2820806B1	20.02.2004
		MXPA03006962A	05.05.2004
		PL363612A1	29.11.2004
		RU2003127121A	10.03.2005
US6578880B2	17.06.2003	US20040195835A1	07.10.2004
		W002065012A1	22.08.2002
US6578880B2	17.06.2003	US2002117856A1	29.08.2002