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**Affected Publication:** API Specification 8C, *Drilling and Production Hoisting Equipment (PSL 1 and PSL 2)*, Fifth Edition, April 2012

## ERRATA

*Page 3, Section 2 Normative References, remove:*

ISO 10422, Petroleum and natural gas industries—Threading, gauging and thread inspection of casing, tubing and line pipe threads—Specifications

*Page 7, Section 4.3.5.2 shall read:*

In the case of plastic analysis, the equivalent stress as defined in 4.3.4 shall not exceed the maximum allowable stress  $AS_{\max}$  as calculated by Equation (2).

*Page 9, Section 4.5, the first sentence shall read:*

Figure 8, Figure 9, Figure 10 and Table 6 show radii of hoisting-tool contact surfaces.

*Page 14, Section 6.3.4 shall read:*

For materials with a specified minimum yield strength of less than 310 MPa (45 ksi), the average impact toughness shall be 27 J (20 ft-lb) at  $-20\text{ }^{\circ}\text{C}$  ( $-4\text{ }^{\circ}\text{F}$ ) with no individual value less than 20 J (15 ft-lb).

*Page 17, Figure 6, the figure references in footnotes a and b shall read:*

Figure 5

*Page 18, Section 6.5.3, the annex reference in the NOTE shall read:*

Annex B

*Page 19, Section 7.7 shall read:*

In addition to the requirements specified in 7.2 to 7.6, weld-joint types and sizes shall meet the manufacturer's design requirements and shall be documented in the manufacturer's welding procedure specification.

*Page 20, Section 7.8.3, the first sentence in the fourth paragraph shall read:*

For PSL 2, for major weld repairs as defined in 8.4.9.3, the manufacturer shall also produce a dimensional sketch of the area to be repaired and the repair sequence.

Page 21, Section 8.3 shall read:

Equipment used to inspect, test or examine material or other equipment shall be identified, controlled, calibrated and adjusted at specified intervals in accordance with documented manufacturer instructions, and consistent with a recognized industry standard (e.g. MIL STD 120<sup>[3]</sup> or ISO 10012-1<sup>[1]</sup>), to maintain the required level of accuracy.

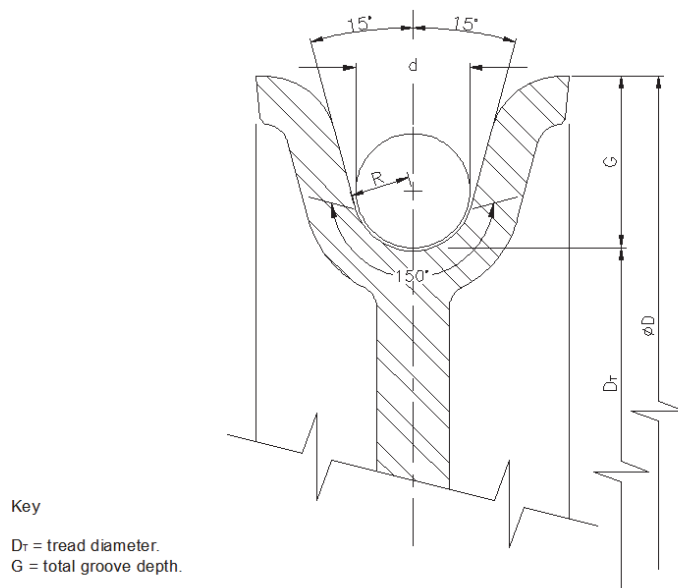
Page 25, Section 8.4.8.3.3, the first paragraph shall read:

The acceptance criteria for both straight beam and angle beam ultrasonic examination of castings are based on SA-609 in ASME BPVC, Section V, Subsection B, Article 23.

Page 28, Section 9.2.3, the first sentence of the first paragraph shall read:

The sheave diameter shall be the overall diameter ( $D$ ) shown in Figure 7.

Page 29, Figure 7 shall be replaced with the following:



**Figure 7—Sheave Grooves**

Page 29, Section 9.2.5, the first two sentences of the first paragraph shall read:

Grooves for sand-line sheaves shall be made for the selected rope size. The bottom of the groove shall have a radius of between  $R_{min}$  and  $R_{max}$  [see Equation (10) and Equation (11)] subtending an arc of 150 degrees.

Page 31, Table 6, the row under Elevator Link Lower Eye and Elevator Link Ear Radius shall read:

$G_1$ max.	$G_2$ min.	$H_1$ min.	$H_2$ max.
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Page 31, Table 6, footnote b shall read:

b See Figure 9.

Page 31, Table 6, the third footnote shall read:

c See Figure 10.

Page 35, Table 8, replace the table as follows:

Table 8—Elevator Bores for Non-upset Casing and Tubing

Nominal Casing or Tubing Size D	Formula for New Top Bore $T_B^{a,b}$ (see Figure 11)		
$D < 4\frac{1}{2}$ in.	$1.001 \times (D \times 25.4) + 1.88$ mm ( $1.001 \times D + 0.074$ in.)		
$4\frac{1}{2}$ in. $\leq D < 9\frac{5}{8}$ in.	$1.0125 \times (D \times 25.4) + 1.22$ mm ( $1.0125 \times D + 0.048$ in.)		
$9\frac{5}{8}$ in. $\leq D < 12\frac{7}{8}$ in.	$1.0125 \times (D \times 25.4) + 0.89$ mm ( $1.0125 \times D + 0.035$ in.)		
$12\frac{7}{8}$ in. $\leq D \leq 20$ in.	$1.0125 \times (D \times 25.4) + 0.56$ mm ( $1.0125 \times D + 0.022$ in.)		
20 in. $< D < 42$ in.	$1.010 \times (D \times 25.4) + 1.90$ mm ( $1.010 \times D + 0.075$ in.)		
$42$ in. $\leq D$	$1.010 \times (D \times 25.4) + 3.18$ mm ( $1.010 \times D + 0.125$ in.)		
Tolerances:			
$T_B \leq 254$ mm	$\pm 0.40$ mm	$B_B \leq 254$ mm	$+0.80$ $-0.40$ mm
$(T_B \leq 10$ in.	$\pm \frac{1}{64}$ in.)	$(B_B \leq 10$	$+\frac{1}{32}$ $-\frac{1}{64}$ in.)
$254$ mm $< T_B \leq 508$	$+0.80$ $-0.40$ mm	$254$ mm $< B_B \leq 508$	$+1.60$ $-0.40$ mm
$(10$ in. $< T_B \leq 20$	$+\frac{1}{32}$ $-\frac{1}{64}$ in.)	$(10$ in. $< B_B \leq 20$	$+\frac{1}{16}$ $-\frac{1}{64}$ in.)
$T_B > 508$	$+1.60$ $-0.80$ mm	$B_B > 508$	$+1.60$ $-0.80$ mm
$(T_B > 20$	$+\frac{1}{16}$ $-\frac{1}{32}$ in.)	$(B_B > 20$	$+\frac{1}{16}$ $-\frac{1}{32}$ in.)
NOTE 1 Refer to Figure 11 for the relationship of $T_B$ and $B_B$ .			
NOTE 2 Longitudinal, circumferential or spiral welds should be ground flush in the area of slip or elevator contact.			
NOTE 3 Bore sizes take in account a casing tolerance of $+1\%$ / $-0.5\%$ on the casing outside diameter. If the casing diameter including the circumferential weld is within the standard tolerance, these bores can be used. If the bottom bore may interfere with circumferential, longitudinal, or spiral welds, consideration should be given to grinding flush in the area of possible slip contact or elevator contact.			
NOTE 4 See API 8B, Annex A, for maximum allowable wear for square shouldered elevator bores in-service.			
a Bottom bore $B_B$ is optional; some elevator designs do not have a bottom bore.			
b New bottom bore, $B_B$ may be the same at manufacturer's option.			

Page 36, Table 9, the NOTE shall read:

NOTE Refer to Figure 11 for the relationship of  $T_B$  and  $B_B$ .

Page 39, Section 9.9.4.2, the first paragraph shall read:

If gooseneck connections are threaded, the threads shall comply with API 5B.

*Page 40, Table 10, the first row under the heading Load Rating shall read:*

$$R \leq 178 \text{ kN (40 Kips)}$$

*Page 40, Section 9.13, the second sentence shall read:*

Traveling drill-string motion compensators' contact-surface radii shall comply with the dimensions given in Table 6 and Figure 8.

*Page 43, Section 9.17.5 shall read:*

Surface NDE (welds only) – All welds shall be inspected using magnetic particle (MP) or liquid penetrate (LP) method in accordance with AWS D1.1.

Volumetric NDE (welds only) – All full or partial penetration welds loaded in tension to 70 % or greater of their allowable stress, as determined by design, shall be ultrasonic or radiograph inspected in accordance with AWS D1.1.

*Page 45, Section 11.3 c), the fifth line item shall read:*

- wear limits, including elevator bore wear limits (see API 8B, Table A.1, for method of computing and limitations on wear limits);

*Page 46, Annex A.4, the third line item shall read:*

- wear limits and nominal capacities and ratings<sup>9</sup>,

*Page 46, Annex A.4, the seventh and eighth line items shall read:*

- heat treatment records<sup>9</sup>,
- material test reports<sup>9</sup>,

*Page 47, Annex A.7, the second sentence shall read:*

The connection shall conform to the applicable requirements as specified in API 7-1 and API 7-2 for the drill collar boreback box stress-relief feature.

*Page 53, Bibliography, add:*

- [8] API Recommended Practice 8B, *Recommended Practice for Procedures for Inspections, Maintenance, Repair, and Remanufacture of Hoisting Equipment*.