

PRODUCT: AUTOMATED CATWALKS

DATE: May 26, 2009

SUBJECT: Repair of Cracks in Carrier Sides (Reference PB Bulletin Catwalk 010 This Product Bulletin Supersedes Catwalk PB 011)

SERIAL NUMBERS: PM3000-1001 to PM3000-1160 / 300158 to 300177

DISCUSSION: There's been occurrences of cracking in the Carrier Beam web at the kicker cylinder mount locations nearest to the lightening holes. This seems to be happening mostly when handling tubulars in excess of 6000 lbs. Pictures below show examples of cracks on the "Off Driller Side" and Driller Side" of the Carrier Beam.



Figure 1- Example of cracks on the "Off Driller Side"

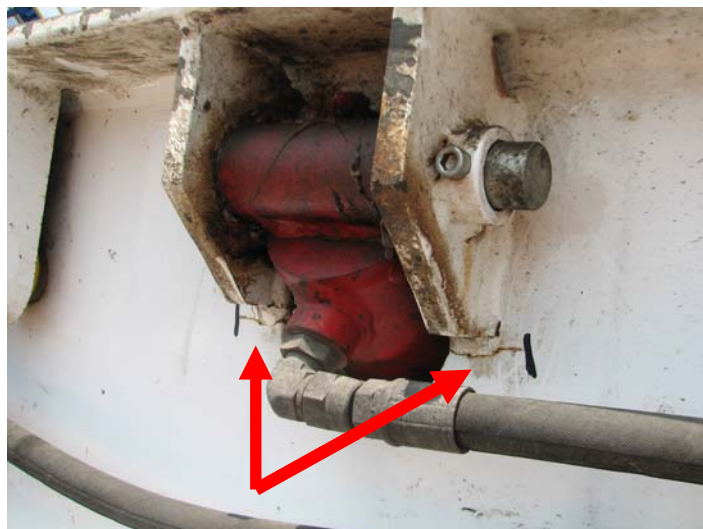


Figure 2 - Example of cracks on the "Driller Side"

RECOMMENDATION: A. Inspection Procedure if the cracks are not obvious:

1. Remove paint from the areas where the cracks are expected to be as shown in the pictures of Figures 1 and 2.
2. Perform an NDE (MPI or Dye Penetrant Analysis) in the areas where the paint was removed to ensure there are no cracks present.
3. If cracks were found, proceed to Section B below to repair the cracks and install the Stiffener package AY50649.
4. If cracks were not found, proceed to section C to install the stiffener package AY50649-1.

B. If cracks are present:

1. Remove paint a minimum of 1" in all directions around the crack on both sides of the Carrier beam web.
2. Perform a ¼" V-prep along the crack on the outside of the Carrier beam web. Ensure the weld prep extends ¼" beyond the end of the crack.
3. Perform an NDE (MPI or Dye Penetrant Analysis) to ensure extent of V-prep is beyond crack.
4. Cautiously apply preheat, weld at temperature of 70 degrees Fahrenheit.
5. Using an E7018 Low Hydrogen rod, perform a ¼" backing weld on the side opposite the V-prep.
6. Using an E7018 Low Hydrogen rod, weld the V-groove fully.
7. Allow to air cool; do not quench.
8. Grind the weld flush with the Carrier beam web.
9. Install stiffener package AY50649 according to the instructions on the drawings. Drawings and bill of material are attached.
10. Ensure all bare metal is painted.

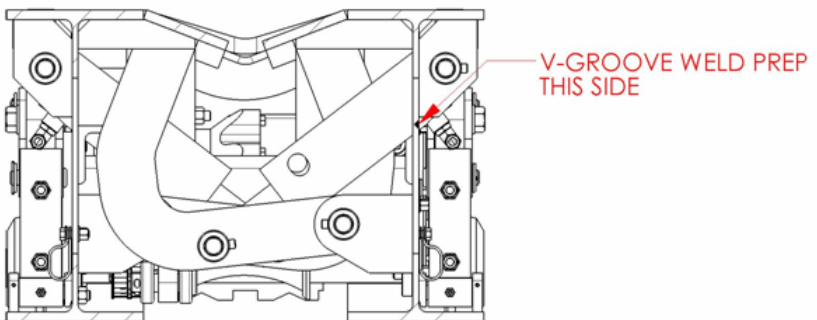


Figure 3 – V-Groove Weld prep

C. If cracks are not present:

1. Install stiffener package AY50649-1 according to the instructions on the drawings. Drawings and bill of material are attached.
2. Ensure all bare metal is painted.



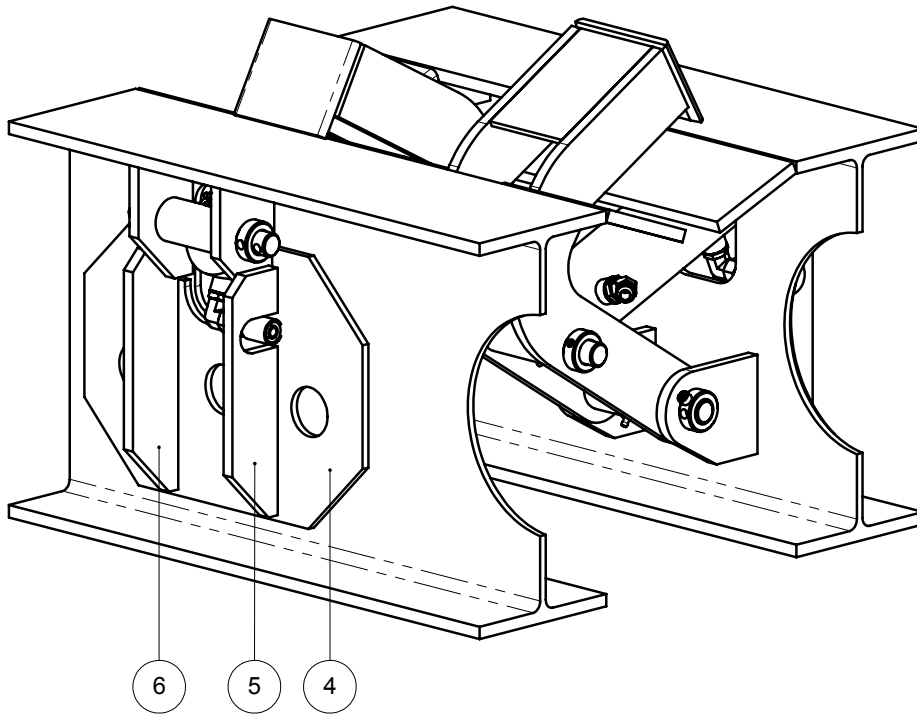
Engineering Bill of Material

Part: AY50649
Description: PC3000 CARRIER WEB STIFFENING
RETRO-FIT

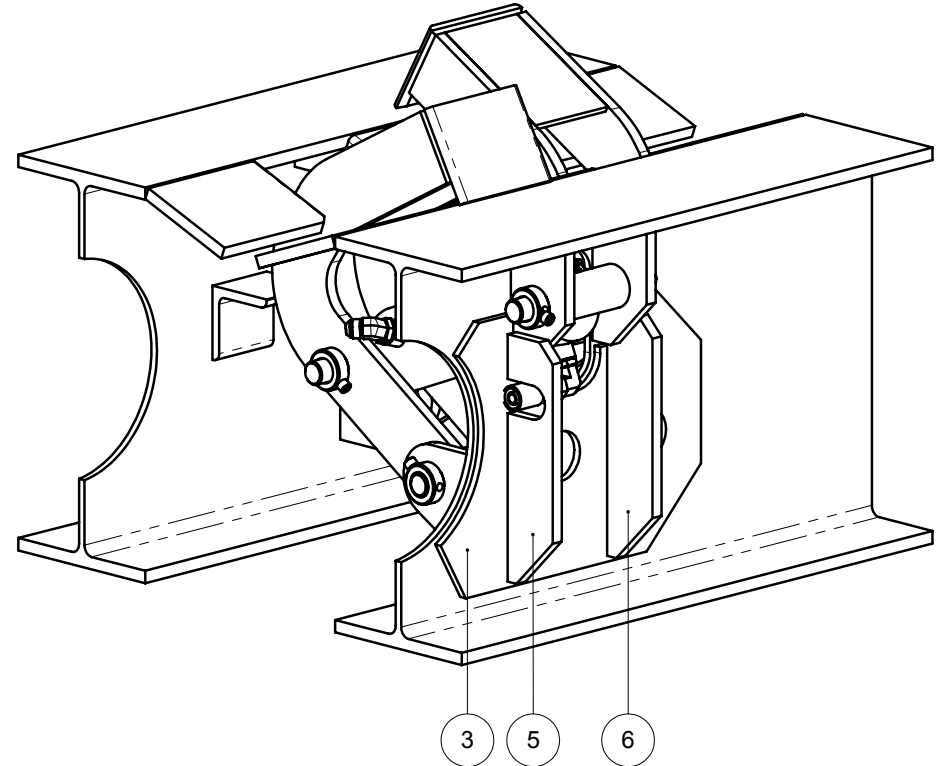
Eng ID: 1
Drawing ID: AY50649

Rev No: D

Item	Qty	Units	Part ID	Eng ID	Description
01	6.00	EA	H15-070112-08		CAP, 1/2 JIC
02	6.00	EA	H15-090109A-08		PLUG, HEX HD, 1/2 ORB
03	3.00	EA	141102594		PLATE,ODS CARRIER KICKER FISH
04	3.00	EA	141102595		PLATE,DS, CARRIER KICKER FISH
05	6.00	EA	156100269		NOTCHED WEB STIFFENER,PC3000 CARRIER
06	6.00	EA	156100268		WEB STIFFENER,PC3000 CARRIER



DRILLERS SIDE



OFF DRILLERS SIDE

NOTE:

- 1) THIS ILLUSTRATION IS A SIMPLIFIED REPRESENTATION OF THE PC3000 CARRIER AT THE MIDDLE KICKER CYLINDER LOCATIONS.
- 2) THE BALLOONED ITEMS ARE TO BE WELDED IN PLACE AS SHOWN AT ALL 6 KICKER CYLINDER LOCATIONS.
- 3) ITEMS 3 AND 4 ALIGN CONCENTRICALLY WITH THE EXISTING CUT-OUTS.

REV.	DESCRIPTION	DATE
D	ITEMS 3, 4, 5 AND 6 ARE NEW ADDITIONS, SEE ECN# CN1288.	22-May-2009
C	WELD SPECIFICATION NOTE ADDED, SEE ECN# CN1286.	20-May-2009
B	ITEM 1 AND 2 LENGTH CHANGE, SEE ECN# CN1284	06-May-2009

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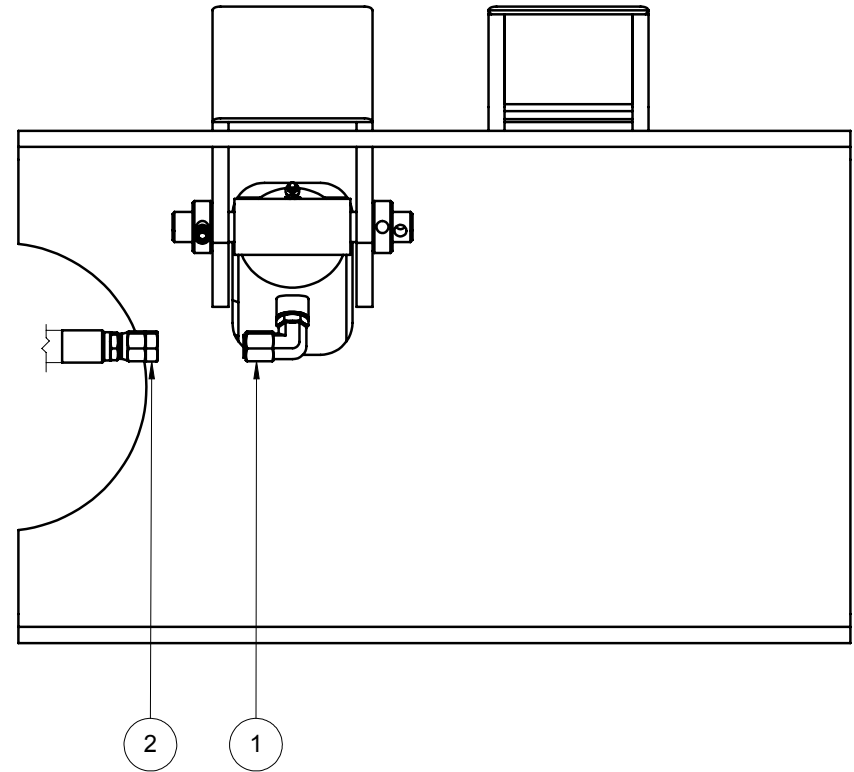
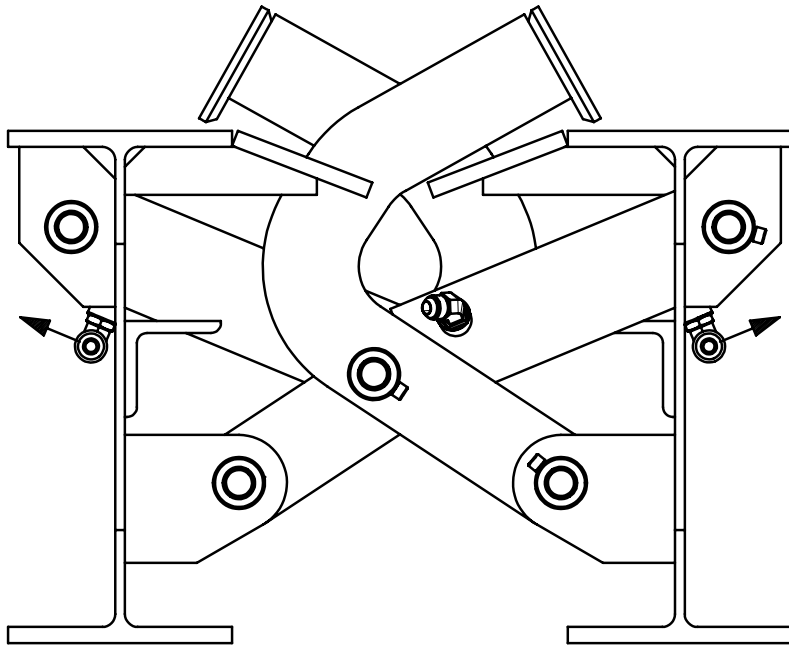


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TITLE:

PC3000 CARRIER WEB STIFFENING RETRO-FIT

DRAWN BY:	DATE:	DRAWING NO:	SHEET:	REV:
TLK	15-Apr-2009	AY50649	1 OF 3	D



PRE-WELD PREPARATION

- 1) REMOVE HOSE FITTING FROM CYLINDER
- 2) ROTATE CYLINDER FITTING SLIGHTLY (5°) IN THE DIRECTION DISPLAYED BY THE ARROWS.
- 3) PLUG THE HOSE FITTING WITH ITEM 2 AND CAP THE CYLINDER FITTING WITH ITEM 1 PRIOR TO ANY GRINDING.
- 4) EXISTING PAINT AND WELDS MUST BE GROUND OFF AT ANY LOCATION WHERE NEW ITEMS ARE TO BE WELDED IN PLACE.

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TITLE:

PC3000 CARRIER WEB STIFFENING RETRO-FIT

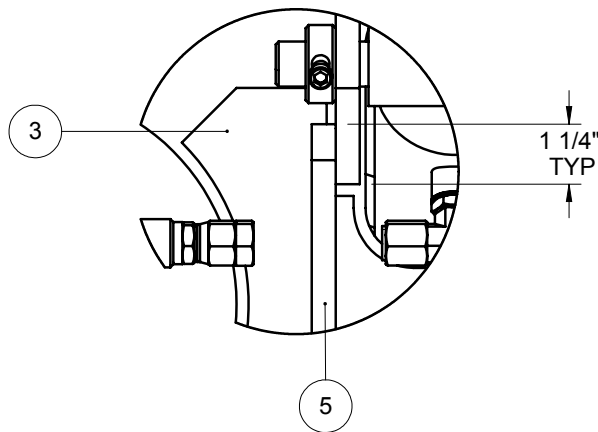
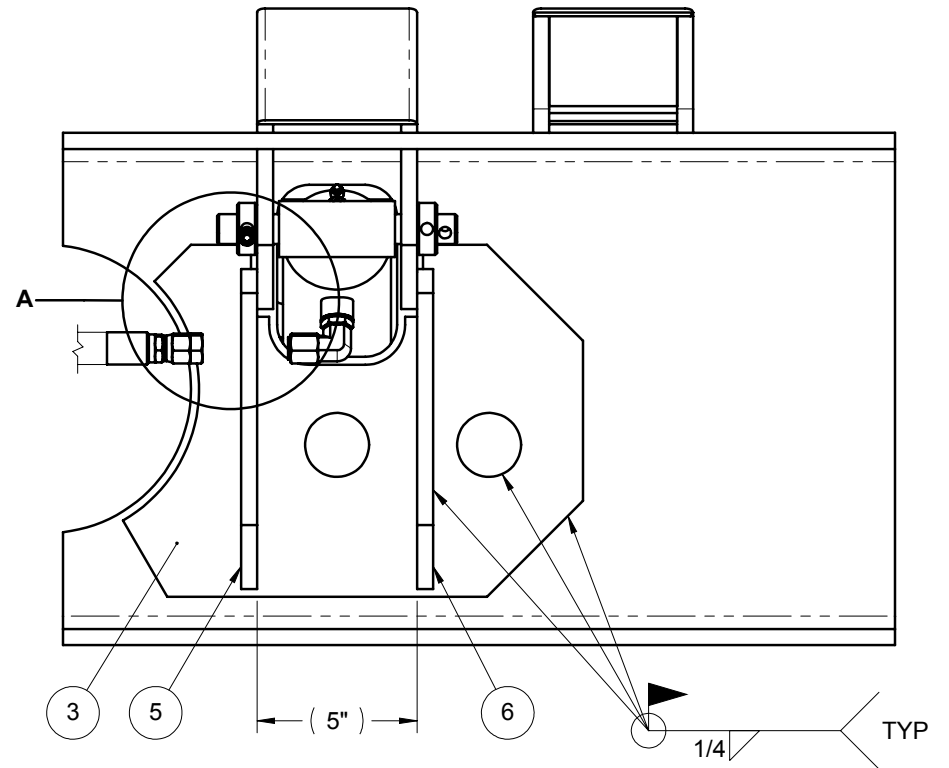
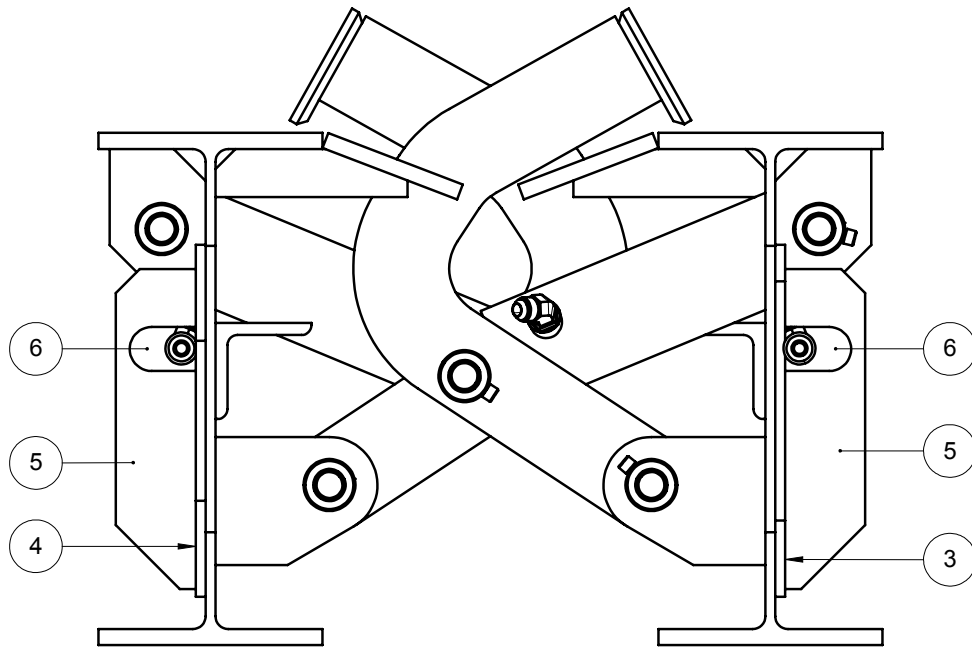
DRAWN BY:
TLK

DATE:
15-Apr-2009

DRAWING NO:
AY50649

SHEET:
2 OF 3

REV:
D



DETAIL A

NOTE:

- 1) ALL WELDING CARRIED OUT TO THE REQUIREMENTS OF CWB-W59 (LATEST EDITION) OR DYNAMICALLY LOADED STRUCTURES. ALL WELDING CARRIED OUT TO THE REQUIREMENTS OF CANRIG DOCUMENT ENG704 AS SUPPLIED.
- 2) ITEMS 3 AND 4 ARE TO BE WELDED IN PLACE PRIOR TO WELDING ITEMS 5 AND 6 IN PLACE.
- 3) ALL BARE METAL MUST BE PAINTED UPON COMPLETION OF WELDING.
- 4) KEEP HOSE PLUG AND CYLINDER FITTING CAP IN PLACE UNTIL WELDING AND PAINTING HAS BEEN COMPLETED.

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TITLE:

PC3000 CARRIER WEB STIFFENING RETRO-FIT

DRAWN BY:

TLK

DATE:

15-Apr-2009

DRAWING NO:

AY50649

SHEET:

3 OF 3

REV:

D



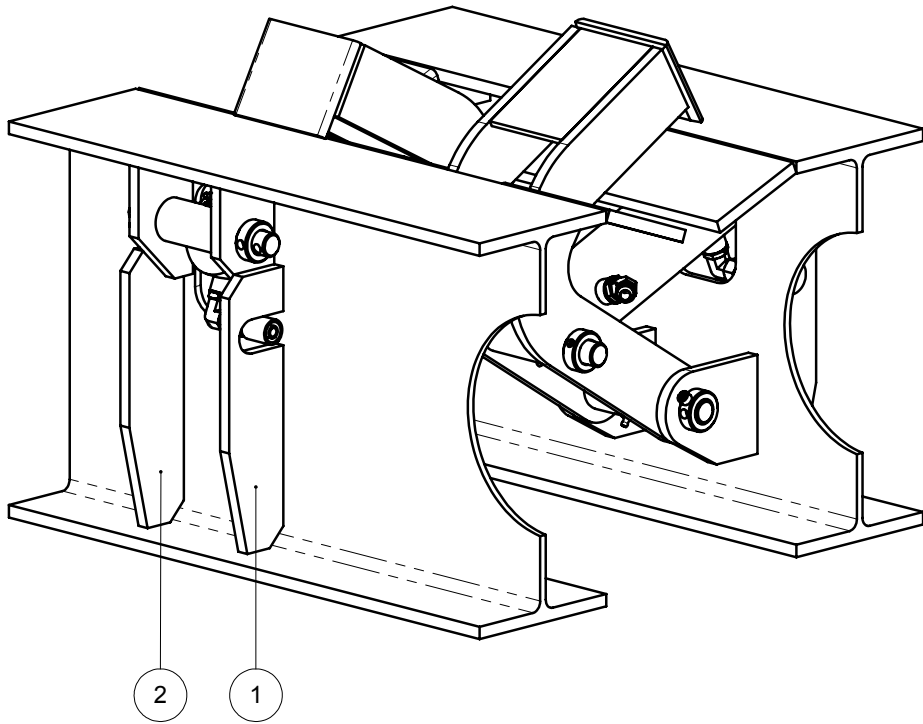
Engineering Bill of Material

Part: AY50649-1
Description: PC3000 CARRIER WEB STIFFENING
RETRO FIT2

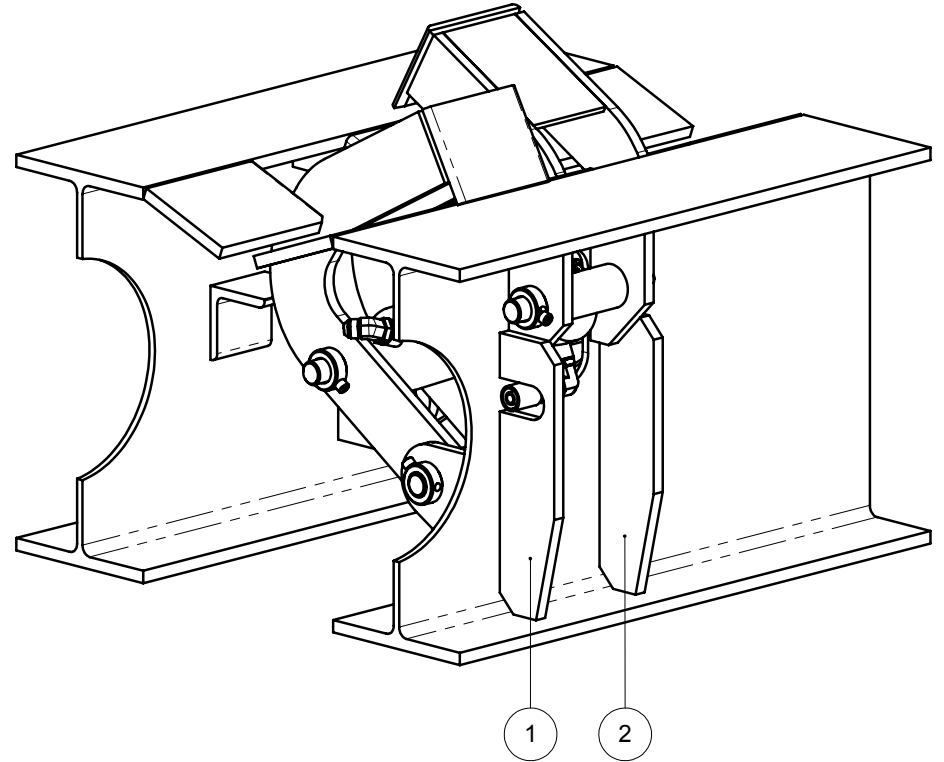
Eng ID: 0
Drawing ID: AY50649-1

Rev No: A

Item	Qty	Units	Part ID	Eng ID	Description
01	6.00	EA	156100273		NOTCHED WEB STIFFENER #2,PC3000 CARRIER
02	6.00	EA	156100272		WEB STIFFENER #2, PC3000 CARRIER



DRILLERS SIDE



OFF DRILLERS SIDE

NOTE:

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- 2) THE BALLOONED ITEMS ARE TO BE WELDED IN PLACE AS SHOWN AT ALL 6 KICKER CYLINDER LOCATIONS.

REV.	DESCRIPTION	DATE
A	RFM	01-Jun-2009

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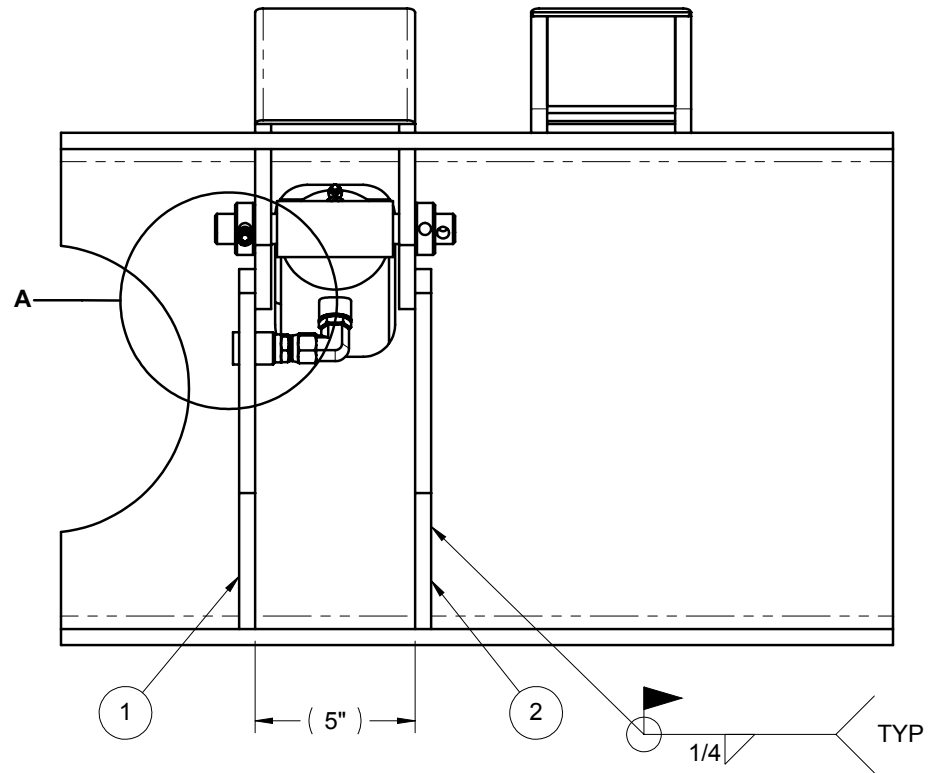
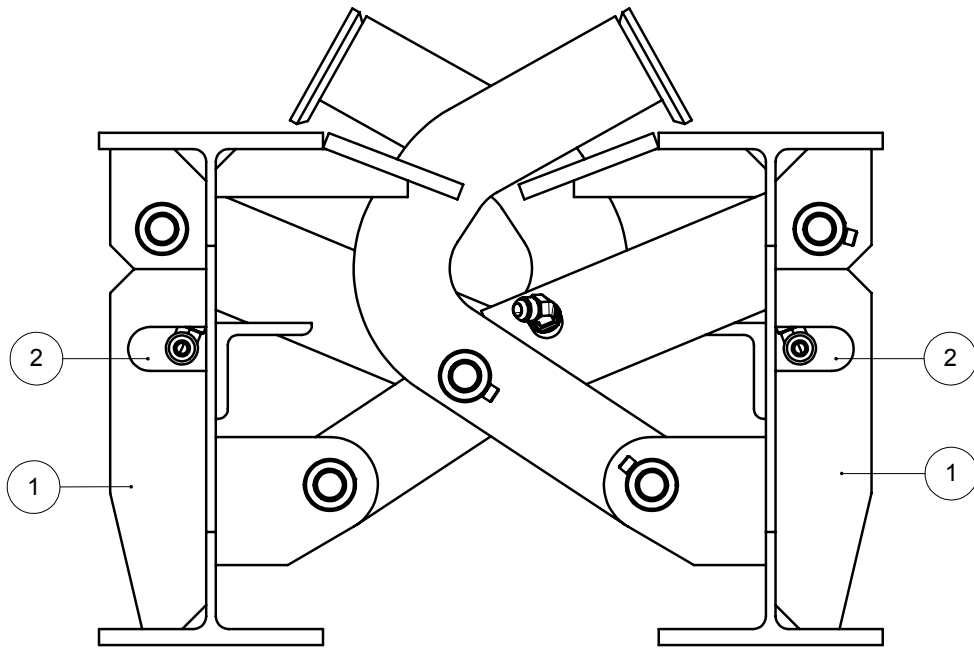
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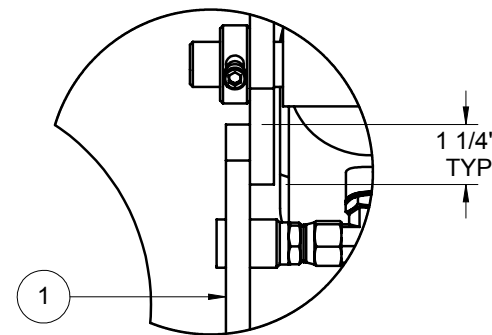
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PC3000 CARRIER WEB STIFFENING RETRO-FIT 2

DRAWN BY: TLK	DATE: 15-Apr-2009	DRAWING NO: AY50649-1	REV: A
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- 1) REMOVE THE HOSE FITTING FROM THE CYLINDER.
- 2) PLUG THE HOSE FITTING AND CAP THE CYLINDER FITTING. LEAVE THE PLUG AND CAP IN PLACE UNTIL FINAL PAINTING IS COMPLETE.
- 3) EXISTING PAINT AND WELDS MUST BE GROUND OFF AT THE LOCATIONS WHERE ITEMS 1 AND 2 ARE TO BE WELDED IN PLACE.
- 4) ALL WELDING CARRIED OUT TO THE REQUIREMENTS OF CWB-W59 (LATEST EDITION) OR DYNAMICALLY LOADED STRUCTURES. ALL WELDING CARRIED OUT TO THE REQUIREMENTS OF CANRIG DOCUMENT ENG704 AS SUPPLIED.
- 5) ALL BARE METAL MUST BE PAINTED UPON COMPLETION OF WELDING.



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PC3000 CARRIER WEB STIFFENING RETRO-FIT 2

DRAWN BY:
TLK

15-Apr-2009

DRAWING NO:
AY50649-1

REV:
A

INFORMATION:

For a complete list of all bulletins go to www.canrig.com

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