

Safety Bulletin			 Tesco Corporation 5616 – 80th Avenue SE Calgary, Alberta, Canada T2C 4N5 Tel: 1-877-TESCO-77 (North America) Tel: 1 (713) 359-7195 (AMSS 24-hour support) Tel: 1 (713) 359-7295 (International) Email: bulletins@tescocorp.com www.tescocorp.com www.tescoparts.com
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Weld Failure on F-Clamp Used to Stabilize TESCO Top Drives			

BACKGROUND INFORMATION:

A recent incident occurred where a plate on an F-Clamp (TESCO part number 3888) that stabilizes the torque track in the derrick broke off and fell approximately 60 feet onto the rig floor (Figure 2). No injuries were reported. Upon inspection it was discovered that the F-Clamp had a complete weld on only one side of the plate (Figure 1) where it should have been fully welded on both sides (Figure 4). Because only one side of the plate was welded, the stability of the F-Clamp was compromised during top drive operation, directly resulting in the plate breaking off from the assembly. The welds on the F-Clamp and plate were insufficient and did not conform to the minimum required weld requirements as stated on TESCO's F-Clamp drawing for the torque track (Figure 5).



Figure 1: F-Clamp weld with one side of plate not fully welded



Figure 2: Plate from F-Clamp that fell onto the rig floor

Further investigation revealed that although the F-Clamps underwent the TESCO quality control process for random inspection and passed with no issues found, some of the defective clamps (i.e., with no welds on the inside) may have bypassed inspection and shipped to the customer (see Figure 3).

An extensive quality control inspection of all F-Clamps currently in stock was subsequently carried out at all TESCO facilities to isolate and destroy any faulty F-Clamps. Currently all F-Clamps that TESCO is carrying in inventory have been inspected and are 100% conforming to TESCO requirements.

Steps have been taken to ensure that a more stringent inspection procedure is in place, whereby all F-Clamps and similar overhead weldment assemblies undergo a thorough 100% visual weld inspection to eliminate the future possibility of defective components slipping through the quality control process. Physical dimensions of assemblies will be randomly inspected as needed. TESCO has notified all suppliers regarding the welding issue and will work to ensure that all F-Clamps are properly welded to TESCO requirements.

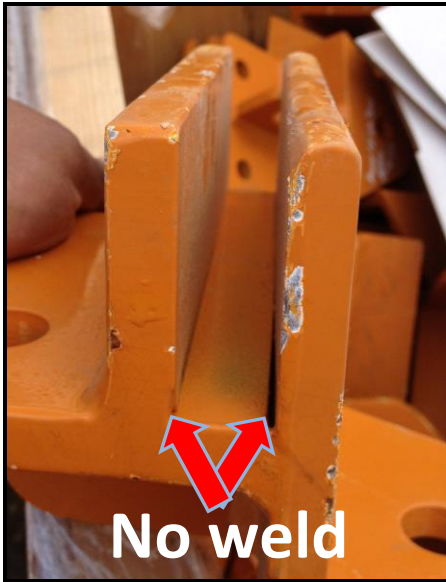


Figure 3: Welds not present on F-Clamp plate

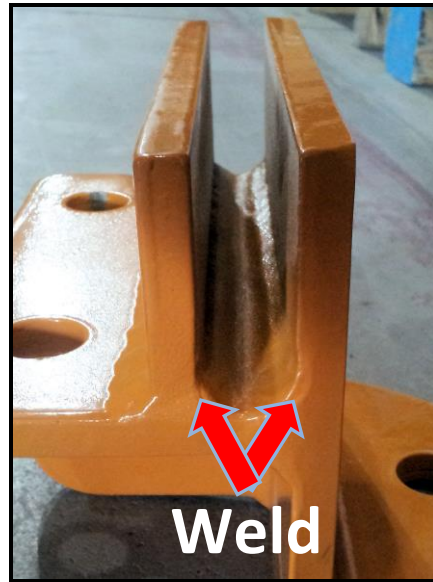


Figure 4: F-Clamp plate is fully welded on both sides

AFFECTED PRODUCTS:

F-Clamps (TESCO part number 3888) used on all TESCO Top Drives.

ACTION REQUIRED:

Customers should perform an immediate visual inspection of the F-Clamps and confirm that there is sufficient welds on both sides (Figure 4). Any defective F-Clamps found with insufficient or incomplete welds must be quarantined and fully welded to TESCO requirements (Figure 5) before being put to use.

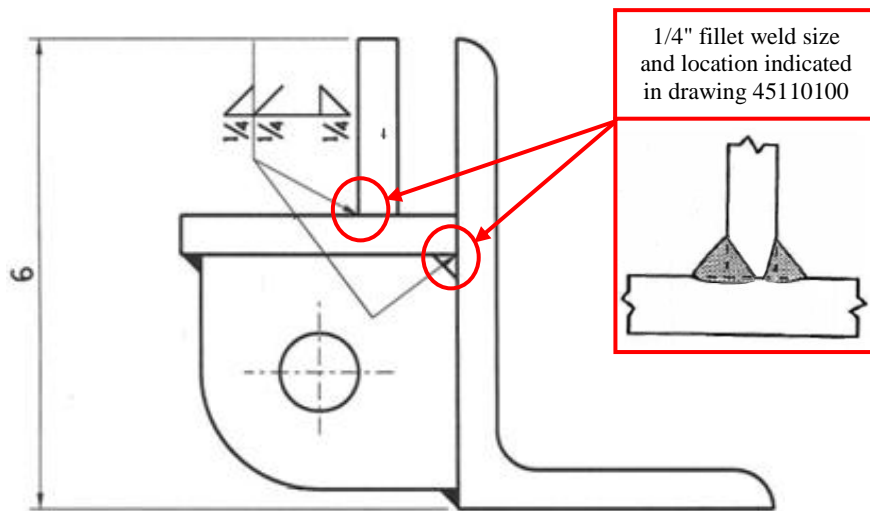


Figure 5: Size of weld on the F-Clamp

Version	Date (D/M/Y)	ECN	Description of changes
Rev 0	22/07/2013	157-0039	Initial release of document

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