Date of Issue: February 2019
Affected Publication: API Specification 7-1, *Specification for Rotary Drill Stem Elements*

Addendum 4

Section 7.10 shall be amended to the following:

7.10 Marking

Subs manufactured in conformance with this part of ISO 10424 shall be marked with the following information:

1) the manufacturer's name or identification mark;

2) "API 7-1";

3) the inside diameter;

4) the size and style of the connection at each end.

For subs of type A, B, and C, the marking shall be die-stamped on a marking recess located on the outside diameter of the sub. The marking identifying the size and style of the connection shall be placed on that end of the recess closest to the connection to which it applies. The marking recess location is shown in Figure 5.

EXAMPLE 1 A sub with 4 1/2 Reg LH box connection on each end and with a 57,2 mm (2 1/4 in) inside diameter, manufactured by A B Company, shall be marked in the recess as follows:

A B Co. (or mark)		ISO 10424-1
4 1/2 REG LH	57,2 (2 1/4)	4 1/2 REG LH

EXAMPLE 2 A sub with NC 31 pin connection on one end and NC 46 box connection on the other end and with a 50,8 mm (2 in) inside diameter, manufactured by A B Company, shall be marked in the recess as follows:

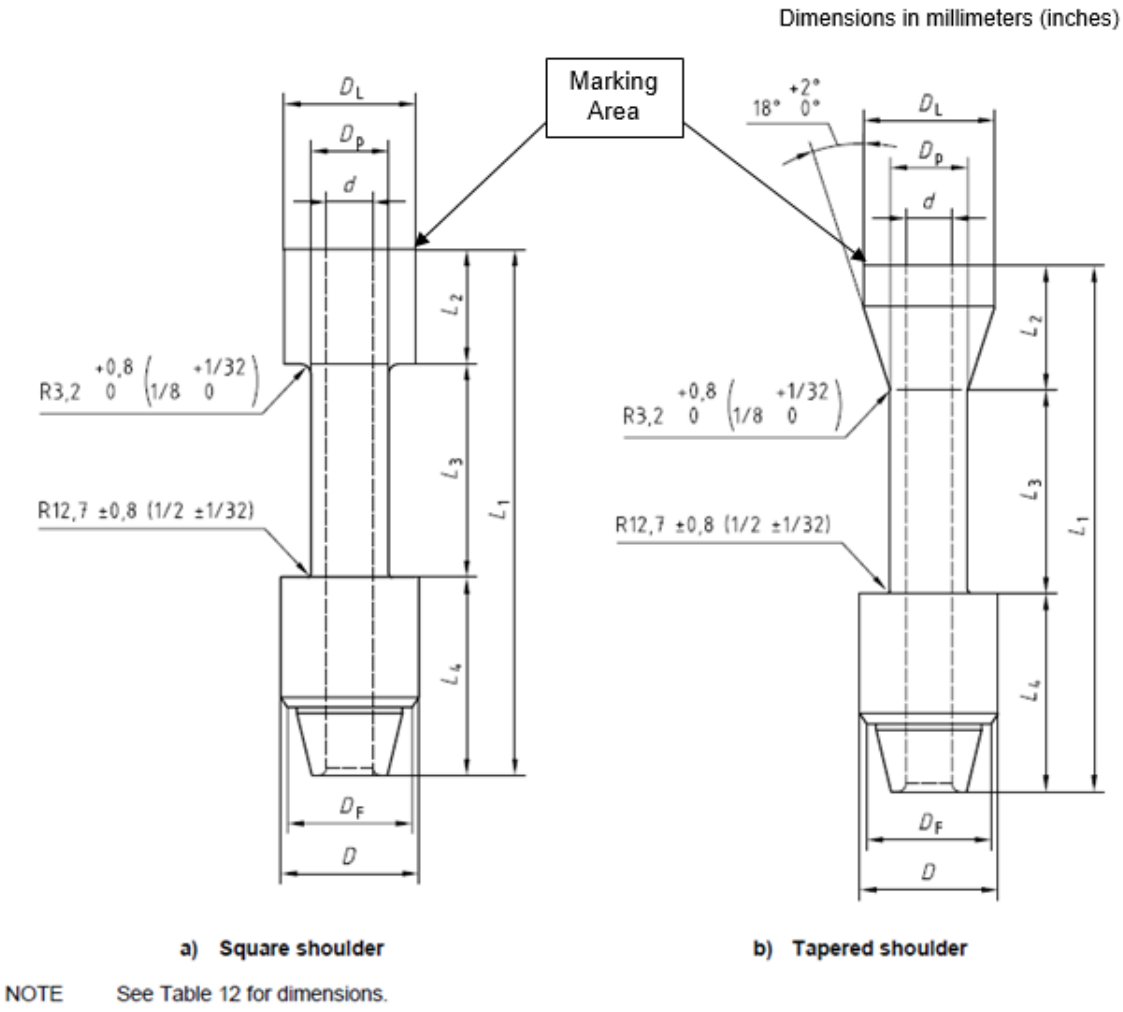
A B Co (or mark)		ISO 10424-1
NC 31	50,8 (2)	NC 46

For subs of type D, the marking shall be on the top surface. The type D sub shall also be marked with the size of the recess diameter in characters at least 9.5 mm ($^3/_8$ in) high.

EXAMPLE 3 A lift sub with NC 38 pin connection, a 3 1/2-inch elevator recess, and a 50,8 mm (2 in) inside diameter, manufactured by A B Company, shall be marked on the top face as follows:

A B Co (or mark)	ISO 10424-1
NC 38	50,8 (2)
	3 1/2

Figure 6 shall be amended to the following:



NOTE See Table 12 for dimensions.

Figure 6—Lift Subs (Type D)

Table 11: The header shall be changed to the following (change indicated by red box):

Table 11—Minimum Surface Hardness of Dimension D_R of Type B Drill Stem Subs

Table 12 shall be amended as indicated in the red boxes:

Table 12—Dimensions for Lift-sub Upper Lift Diameters

Dimensions in millimeters

Elevator recess diameter D_p ± 0,8	Diameter of lift shoulder (tapered or square) D_L $^{+3,2}_{0}$	Overall length L_1 $^{+76}_{-25}$	Top length L_2 ± 3	Elevator recess length L_3 Ref.	Bottom length L_4 ± 12	Largest elevator [a]
60,3	88,9	915	102	457	356	2 7/8
73,0	108,0	915	102	457	356	3 1/2 or 4IU
88,9	127,0	915	102	457	356	4 1/2
101,6	152,4	915	102	457	356	5 1/2
114,3	158,8	915	102	457	356	5 1/2
127,0	165,1	915	102	457	356	5 1/2
139,7	184,2	915	102	457	356	6 5/8
168,3	203,2	915	102	457	356	6 5/8

[a] For the lift sub and elevator best fit, it is recommended to use the appropriate elevator size for the lift sub D_p value in accordance with Table 7 in API 8C, 5th Edition—where the data in this column is from.

Table A.12 shall be amended as indicated in the red boxes:

Table A.12—Dimensional Data for Lift Sub Upper Lift Diameters

Dimensions in inches

Elevator recess diameter D_P ± 1/32	Diameter of lift shoulder (tapered or square) D_L $^{+1/8}_{0}$	Overall length L_1 $^{+3}_{-1}$	Top length L_2 ± 1/8	Elevator recess length L_3 Ref.	Bottom length L_4 ± 1/2	Largest elevator [a]
2 3/8	3 1/2	36	4	18	14	2 7/8
2 7/8	4 1/4	36	4	18	14	3 1/2 or 4IU
3 1/2	5	36	4	18	14	4 1/2
4	6	36	4	18	14	5 1/2
4 1/2	6 1/4	36	4	18	14	5 1/2
5	6 1/2	36	4	18	14	5 1/2
5 1/2	7 1/4	36	4	18	14	6 5/8
6 5/8	8	36	4	18	14	6 5/8

[a] For the lift sub and elevator best fit, it is recommended to use the appropriate elevator size for the lift sub D_p value in accordance with Table 7 in API 8C, 5th Edition, where the data in this column is from.

Table C.1 shall be amended as indicated in the red boxes:

Table C.1—Mechanical Properties and Tests for Heavy Section Tools

Yield strength MPa (psi) min	Tensile strength MPa (psi) min	Elongation, with gauge length four times diameter % min	Impact strength Joules (ft-lbs)		Brinell Hardness HBW
			Average 3 specimens	Minimum single specimen	
689 (100 000)	931 (135 000)	13	54 J (40)	47 J (35)	277 – 352