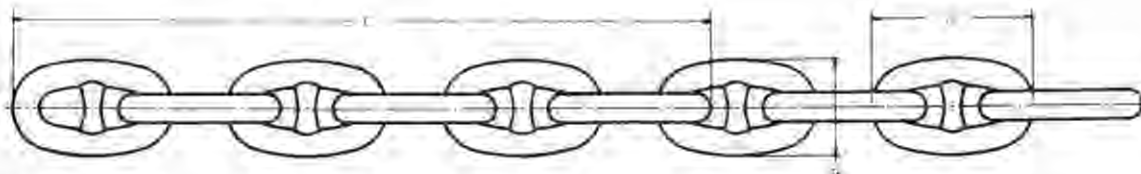




WELDED OIL RIG CHAIN



CHAIN SIZE	LINK LENGTH A	LINK WIDTH B	LENGTH OVER SIX LINKS C	OIL RIG QUALITY (API)		SPECIAL QUALITY		EXTRA STRENGTH	
				PROOF TEST POUNDS	BREAK TEST POUNDS	PROOF TEST POUNDS	BREAK TEST POUNDS	PROOF TEST POUNDS	BREAK TEST POUNDS
1	5	3-9/16	26	85,000	128,000	84,000	129,000	130,000	180,600
1-1/8	6-3/4	4	29-1/4	107,000	162,000	106,000	161,000	164,300	225,400
1-1/4	7-1/2	4-1/2	32-1/2	132,000	198,000	130,000	198,000	201,500	277,200
1-3/8	8-1/4	4-15/16	35-3/4	168,000	236,000	157,000	235,000	243,300	329,000
1-1/2	9	5-3/8	39	187,000	282,000	185,000	280,000	286,700	392,000
1-5/8	9-3/4	5-7/8	42-1/4	218,000	329,000	216,000	325,000	334,800	455,000
1-3/4	10-1/2	6-5/16	45-1/2	251,000	379,000	249,000	380,000	385,800	532,000
1-7/8	11-1/4	6-3/4	48-3/4	287,000	432,000	285,000	432,000	441,700	604,800
2	12	7-3/16	52	324,000	489,000	322,000	488,000	499,000	683,000
2-1/16	12-3/8	7-7/16	53-5/8	344,000	518,000	342,000	518,000	530,000	725,000
2-1/8	12-3/4	7-5/8	55-1/4	364,000	548,000	362,000	548,000	561,000	767,000
2-3/16	13-1/8	7-7/8	56-7/8	384,000	579,000	382,500	579,100	592,800	810,700
2-1/4	13-1/2	8-1/8	58-1/2	405,000	611,000	403,000	610,000	624,800	854,000
2-5/16	13-7/8	8-5/16	60-1/8	427,000	643,000	425,000	642,500	658,700	889,500
2-3/8	14-1/4	8-9/16	61-3/4	449,000	676,000	447,000	675,000	692,000	945,000
2-7/16	14-5/8	8-3/4	63-3/8	471,000	710,000	469,500	709,500	727,700	993,000
2-1/2	15	9	65	494,000	744,000	492,000	744,000	762,000	1,041,600
2-9/16	15-3/8	9-1/4	66-5/8	517,000	780,000	515,000	775,500	799,800	1,090,000
2-5/8	15-3/4	9-7/16	68-1/4	541,000	815,000	540,000	813,000	837,000	1,136,000
2-11/16	16-1/8	9-11/16	69-7/8	565,000	852,000	565,000	849,000	875,700	1,188,000
2-3/4	16-1/2	9-7/8	71-1/2	590,000	889,000	580,000	885,000	914,000	1,239,000
2-13/16	16-7/8	10-1/8	73-1/8	615,000	927,000	615,000	925,000	953,000	1,295,000
2-7/8	17-1/4	10-3/8	74-3/4	640,000	965,000	640,000	965,000	992,000	1,351,000
2-15/16	17-5/8	10-9/16	76-3/8	666,000	1,004,000	666,500	1,006,000	1,032,000	1,407,000
3	18	10-13/16	78	693,000	1,044,000	693,000	1,045,000	1,067,000	1,462,000
3-1/16	18-3/8	11	79-5/8	719,000	1,084,000	720,500	1,086,500	1,109,000	1,510,000
3-1/8	18-3/4	11-1/4	81-1/4	747,000	1,125,000	748,000	1,128,000	1,152,000	1,567,900
3-3/16	19-1/8	11-1/2	82-7/8	774,000	1,167,000	776,050	1,169,000	1,195,000	1,624,900
3-1/4	19-1/2	11-11/16	84-1/2	802,000	1,209,000	804,100	1,210,000	1,238,000	1,681,900
3-5/16	19-7/8	11-15/16	86-1/8	830,000	1,251,000	833,150	1,253,000	1,283,000	1,741,000
3-3/8	20-1/4	12-1/8	87-3/4	859,000	1,295,000	862,200	1,296,000	1,327,700	1,801,800
3-7/16	20-5/8	12-3/8	89-3/8	888,000	1,339,000	892,100	1,339,550	1,373,800	1,861,900
3-1/2	21	12-5/8	91	918,000	1,383,000	922,000	1,383,100	1,419,800	1,923,000
3-5/8	21-3/4	12-15/16	94-1/4	977,000	1,473,000	1,021,000	1,566,000	1,572,000	2,176,700
3-3/4	22-1/2	13-3/8	97-1/2	1,039,000	1,566,000	1,120,000	1,760,000	1,724,000	2,432,000
3-7/8	23-1/4	14	100-3/4	1,101,000	1,660,000	1,205,000	1,863,000	1,855,000	2,589,000
4	24	14-3/8	104	1,165,000	1,756,000	1,299,000	1,996,500	1,996,900	2,775,000

To supply the need of the Offshore Oil Industry, Hamamaka offers Oil Rig Quality, Special Quality and Extra Strength flash welded chain. Chain can be made in continuous lengths omitting the need for chain connecting links.

Material - Fine grain alloy steel is used to develop optimum mechanical properties and superior proof and break loads.

Heat Treatment - All chain is heat treated to refine welding and minimize any presence of Widmanstall structure.

Studs - The forged stud is pressed into the link and secured by welding all around one end opposite the link weld.

Test Specimens - Four extra links are manufactured with every

length of chain or with every heat of bar material. Three links are subjected to ultimate break load and one link is used to supply certified test specimens. These specimens are Charpy impact, mechanical property and photomicrographic; the specimens are taken opposite link weld at the 2/3R position.

Inspection - All testing and inspection is certified by regulating testing agencies.

Prior to painting, all chain is visually inspected for surface defects by qualified personnel and by customer's representative, if desired.

Ultrasonic inspection of chain can be conducted per customer's request.