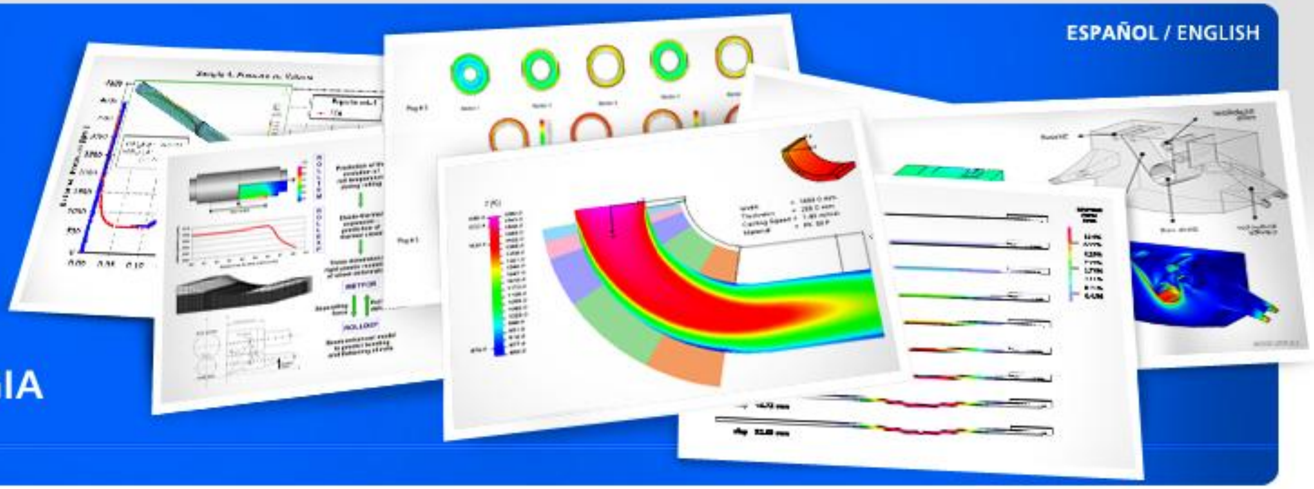
SIM&TEC

Simulación y Tecnología

Simulation and Technology

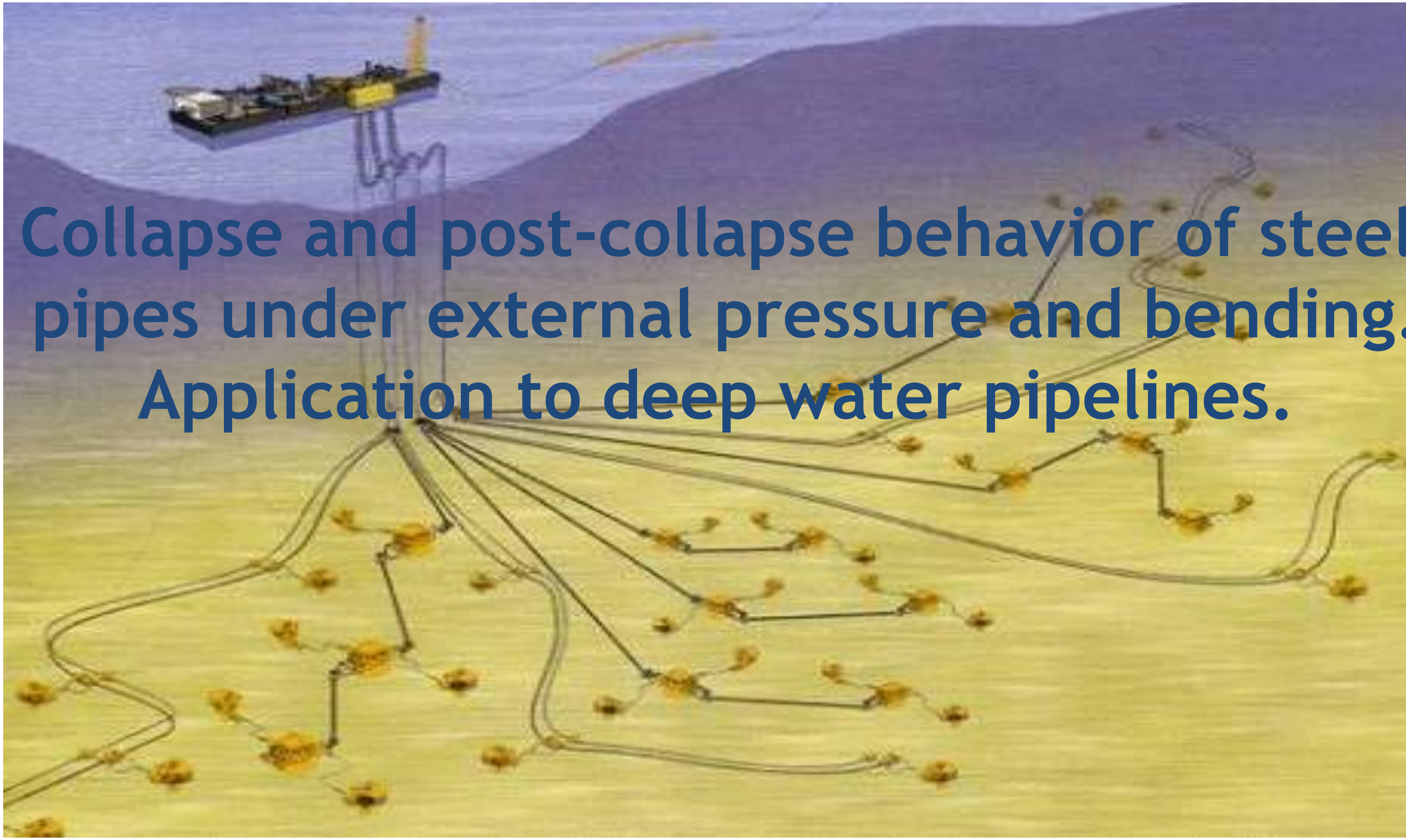
ESPAÑOL / ENGLISH



DE LA CIENCIA

A LA TECNOLOGIA

Collapse and post-collapse behavior of steel pipes under external pressure and bending. Application to deep water pipelines.



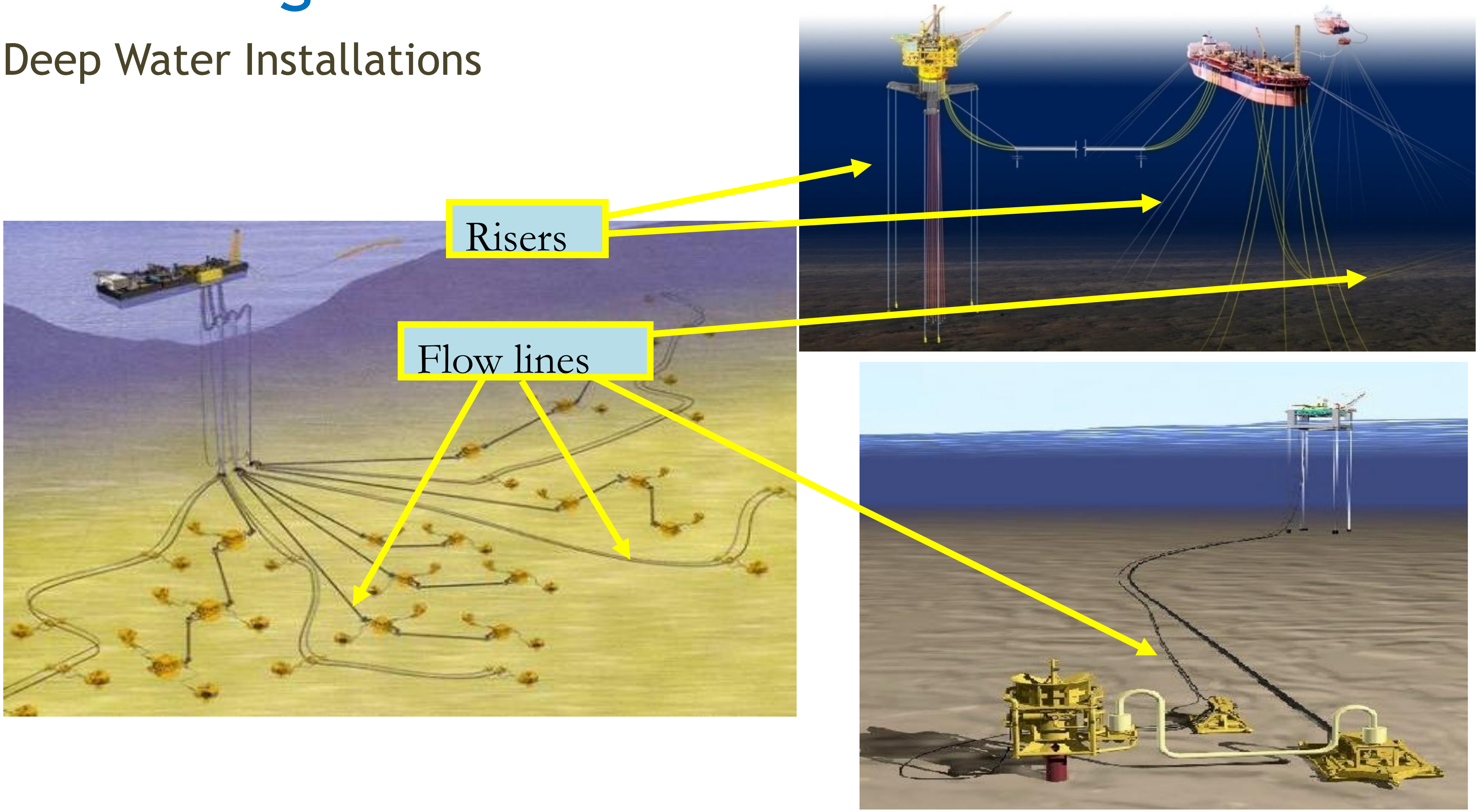
Agenda

Introduction: the technological problem

- Collapse and post-collapse behavior of steel pipes: Finite Element Models
- Collapse of deepwater pipelines under external pressure plus bending. Validation: numerical vs. experimental results
- Collapse of deepwater pipelines with buckle arrestors. Validation: numerical vs. experimental results
- UOE pipe manufacturing process

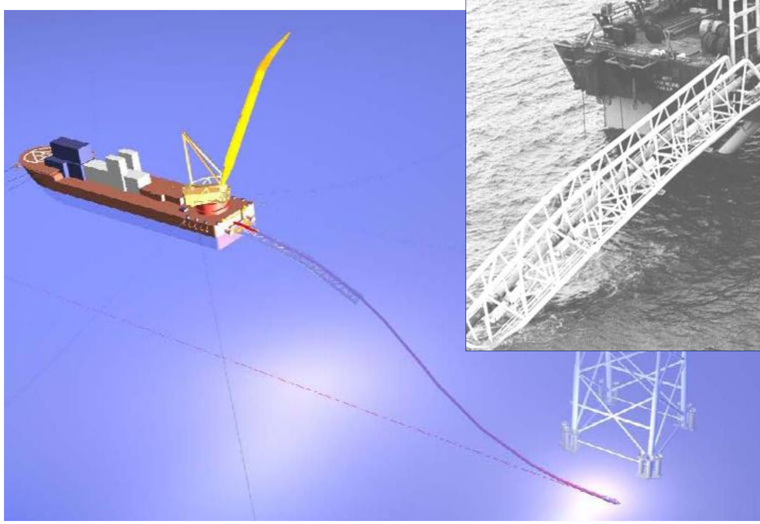
Technological Problem

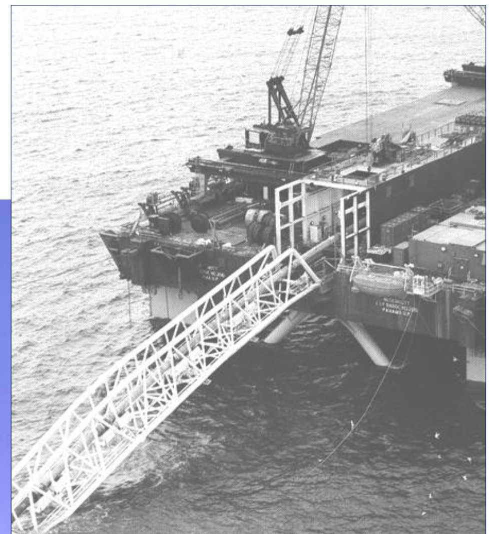
Deep Water Installations



Construction Techniques

S-lay barge pipeling



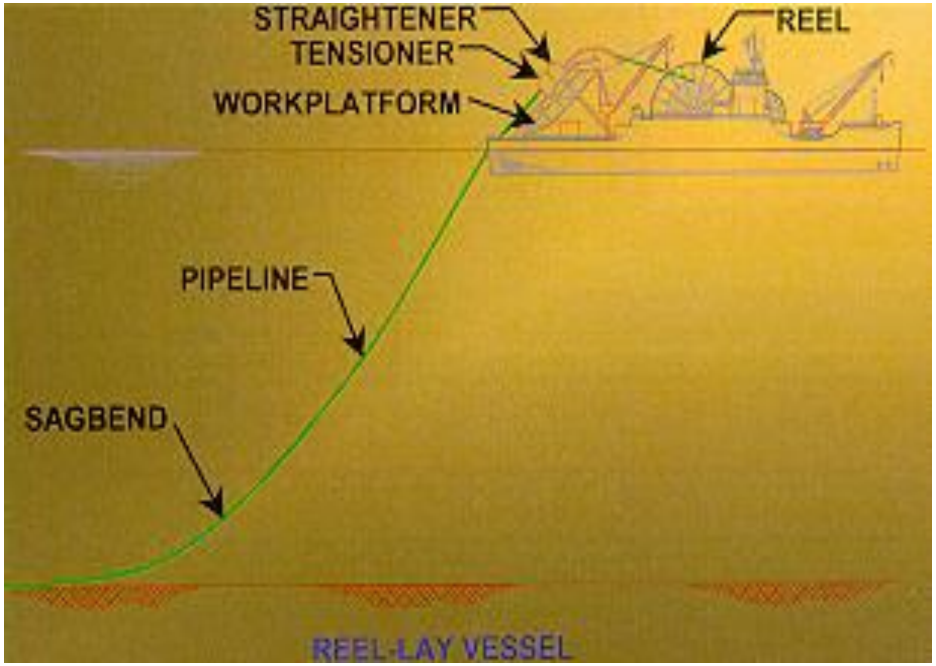


J-lay barge pipeling

- S-lay takes its name from the suspended shape of the pipe at the end of the barge, which lays in an elongated "S" from the stringer to the seabed.
- For the J-lay, the suspended pipe forms a "J" from the vessel to the seabed.

Construction Techniques

Reel-lay barge pipeling

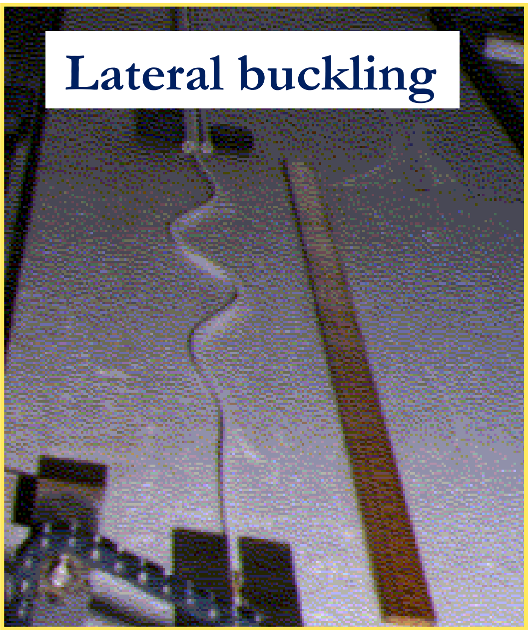


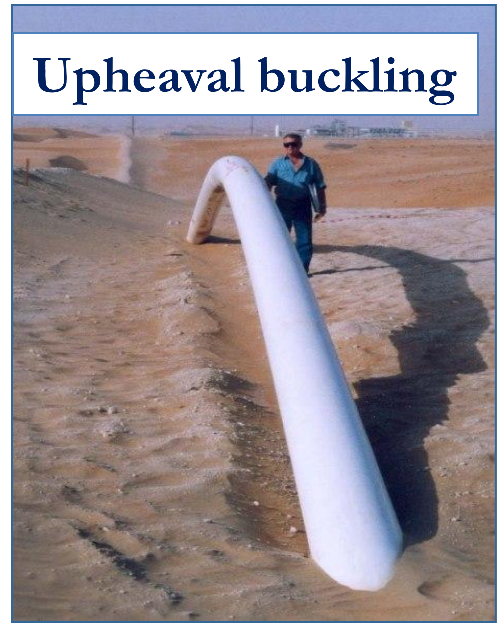
Reel-lay method: the pipe is assembled onshore and wound onto a large reel on the vessel; before to be J-laid on its final location it has to be unwound and straightened.

Failure Modes

- Global buckling

(buckling of the pipe as a bar in compression → column mode)





Internal pressure → Destabilizing effect

Palmer A.C. (1974), "Lateral Buckling of Axially Constrained Pipelines"
Dvorkin E.N. and Toscano R.G. (2001), "Effects of external/internal pressure on the global buckling of pipelines“.

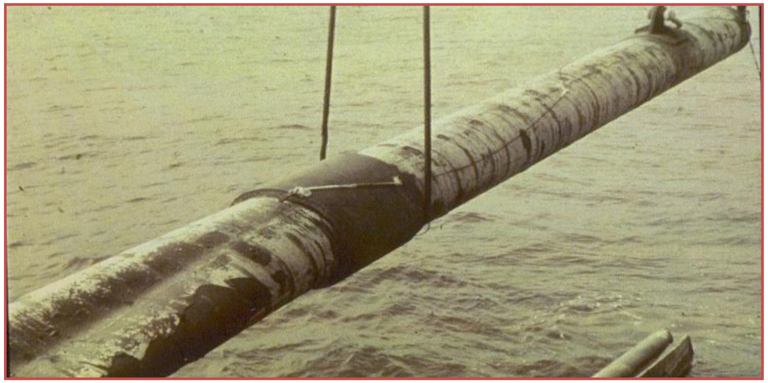
Failure Modes

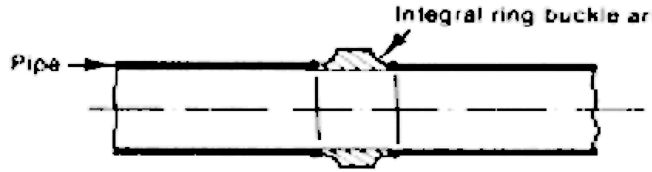
- Local buckling

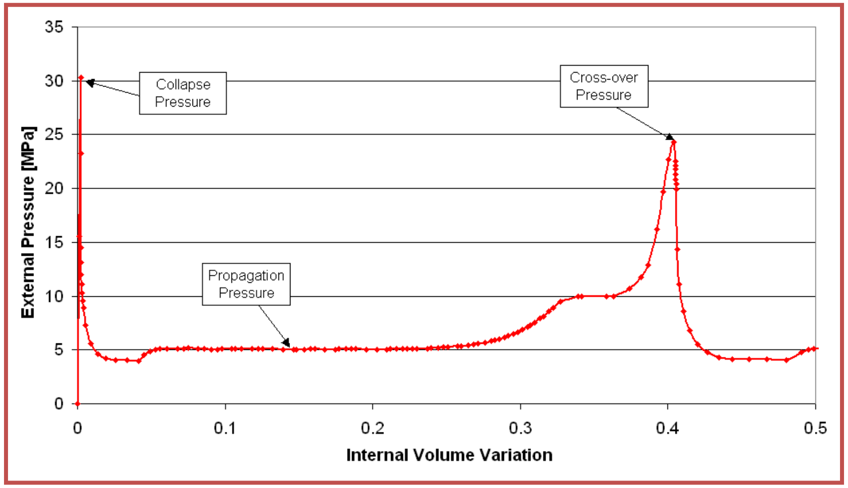
Physical phenomenon to be studied in this course using numerical models

Structural collapse of steel tubes under external pressure

Buckle Arrestor







Collapse propagation pressure: The lowest pressure which can sustain a propagation buckle ***(Andrew Palmer)***

Crossover pressure : The minimum pressure value at which the buckle crosses over the arrestor

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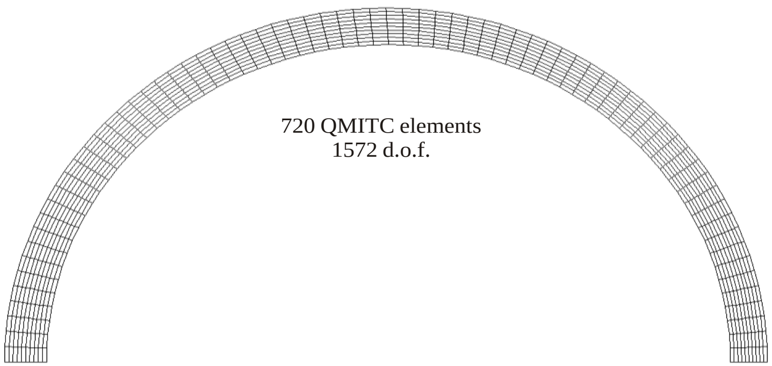
- **UOE pipe manufacturing process**

2D Continuum Mesh

Two dimensional finite element model of very long pipes



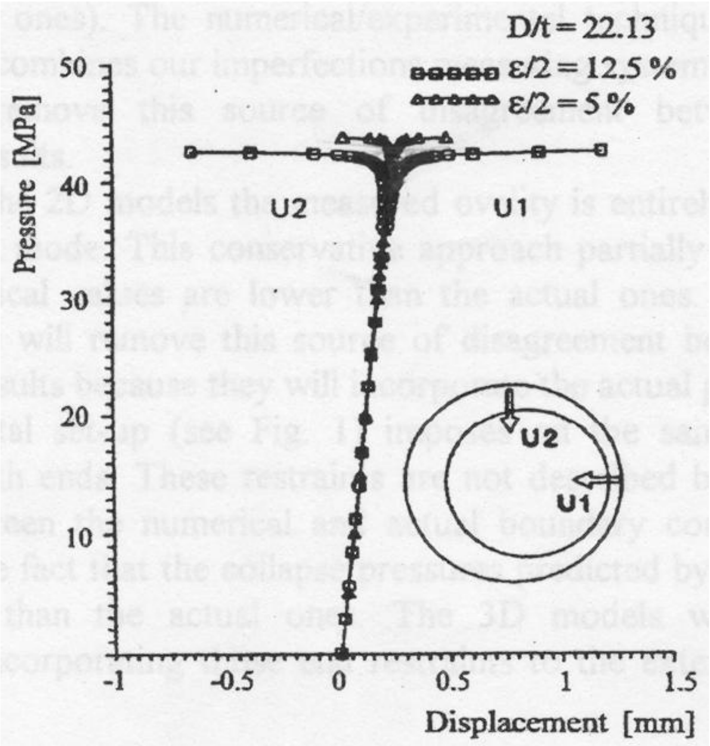
OD	245.42 mm
Wall thickness	12.61 mm
Ovality	0.18%
Yield stress	890 MPa
Theoretical p_{cr}	64.36 MPa
$\dfrac{[p_{cr}]_{theoretical}}{[p_{cr}]_{2D}}$	0.992

Qualification of 2D continuum elements model , Rs=0. (*Timoshenko*)

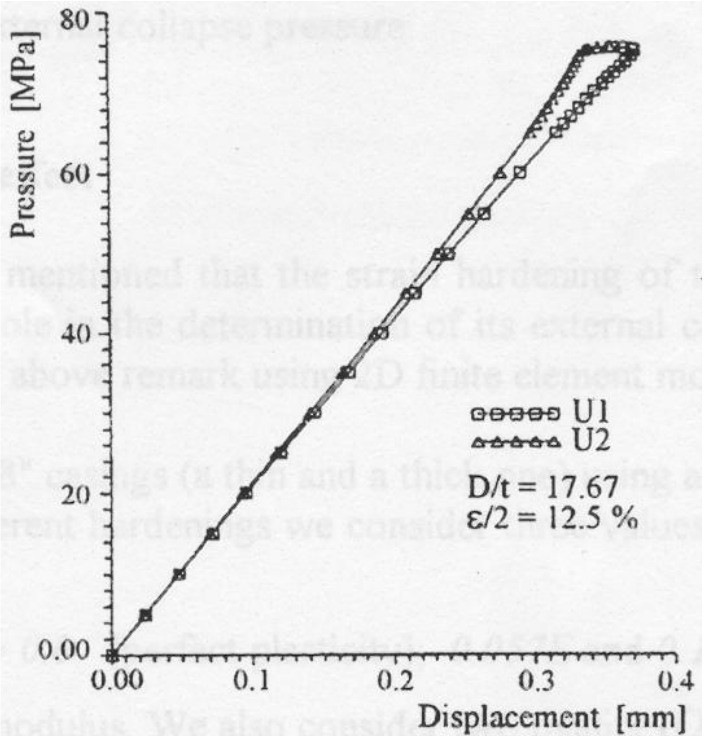
- ➢Total Lagrangian formulation.
- ➢QMITC plane strain element (4-noded element) *(Dvorkin-Vassolo)*
- ➢Automatic solution of the incremental nonlinear finite element equations (Riks method).
- ➢ Elasto-plastic material model: von Mises associated plasticity with isotropic hardening.
- ➢ Geometrical nonlinearity: large displacements / rotations but small strains.
- ➢ ADINA code (special version)
- ➢Follower loads
- ➢Residual stresses: linear distribution trough the thickness

2D Continuum Mesh

Eccentric pipes



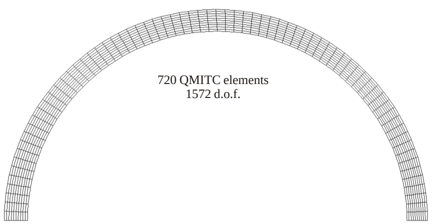
Direct collapse behavior



Inverse collapse behavior

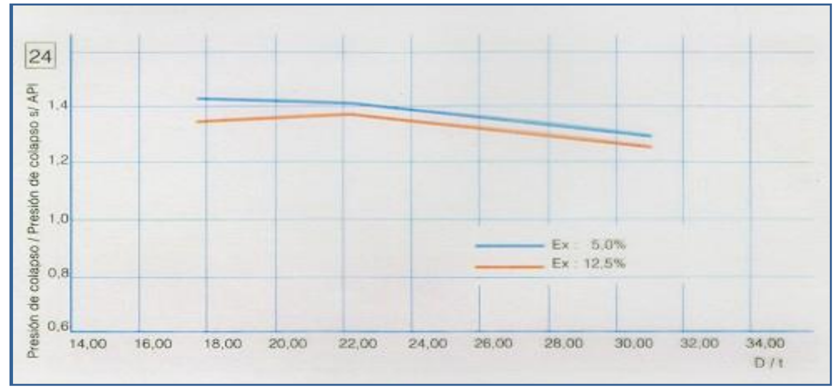
2D Continuum Mesh

Parametric analyses

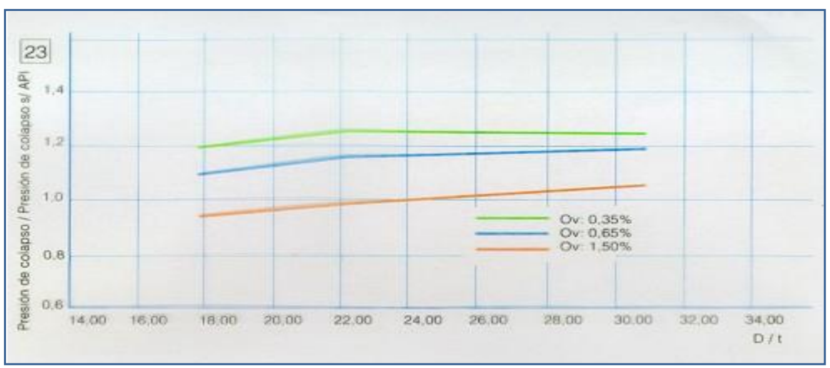


$$Ov(\%) = \frac{(D_{max} - D_{min})}{D_{average}} \cdot 100$$

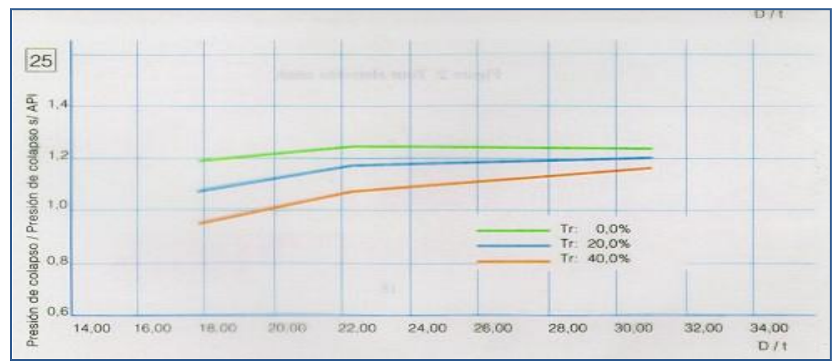
$$Ecc(\%) = \frac{(t_{max} - t_{min})}{t_{average}} \cdot 100$$



Eccentricity effect

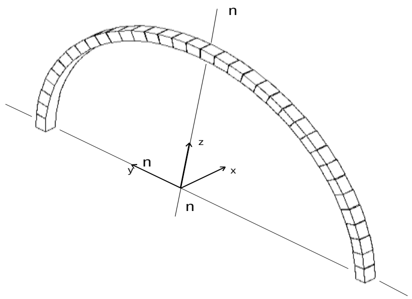


Ovality effect

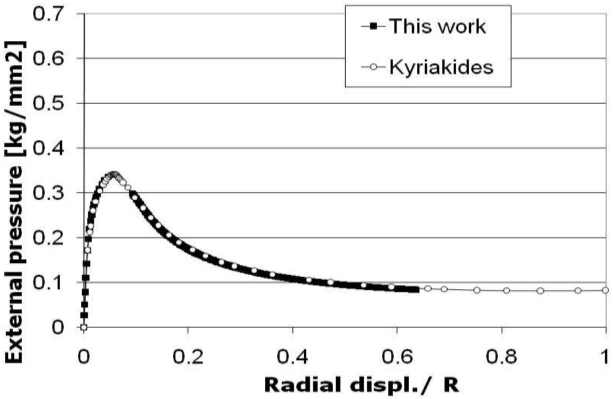


Residual stress effect

3D Finite Element of the Collapse and Post-collapse of very long pipes under Bending + external Pressure



pipe central slice

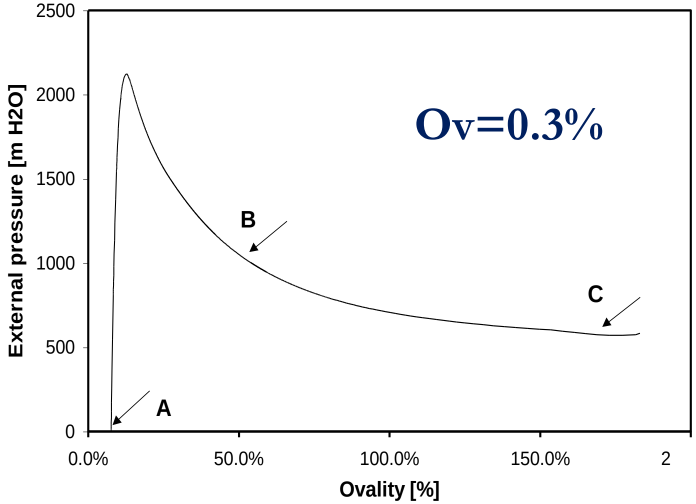


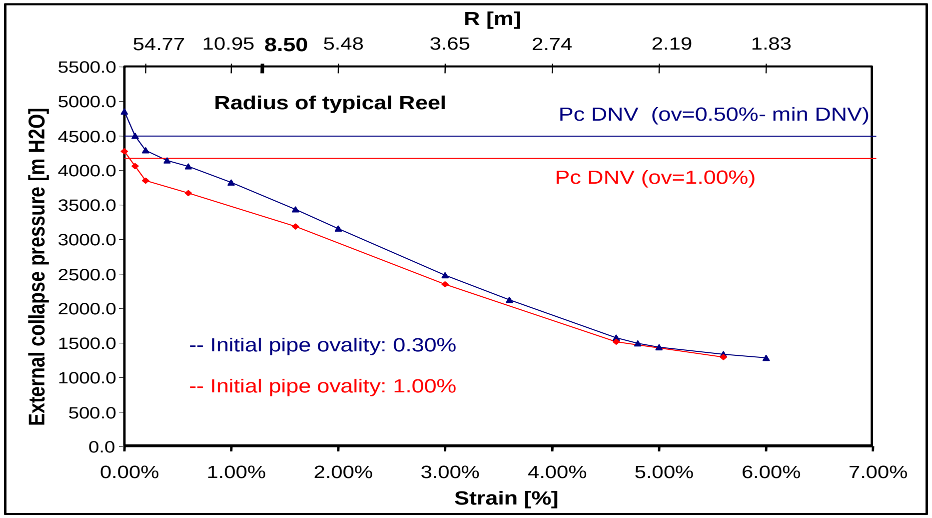
D=1.2522”
D/t=35
Sy=31.5 kg/mm2
E/Sy=225
E/Et = 86.5
Ov = 1.6%

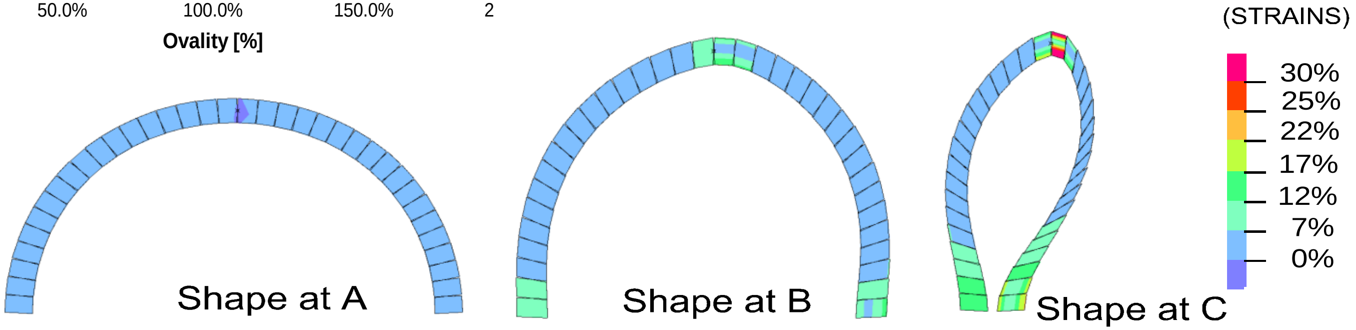
- MITC4 shell element (4-noded element that includes shear deformation) *(Dvorkin and Bathe)*
- Automatic solution of the incremental nonlinear finite element equations. .
- Elasto-plastic material model: von Mises associated plasticity with isotropic hardening.
- Geometrical nonlinearity: large displacements / rotations but small strains.
- ADINA code
- Follower loads
- Residual stresses: linear distribution trough the thickness

3D Finite Element Model of very pipes

8 5/8" OD 12.7# X60







Initial, intermediate and final shapes of the pipe cross section
Equivalent logarithmic strains

3D Finite Element Simulation of the Slit-ring Test (industrial standard test)

9 5/8" OD 47 lb/ft P110

$\sigma_R = 0.2\ \sigma_y$

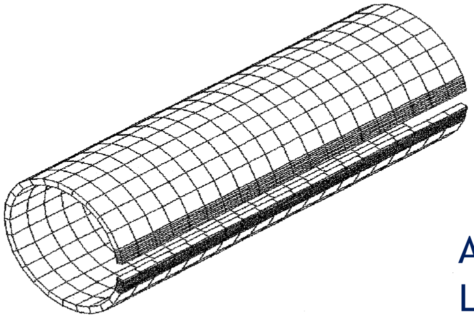
$$\sigma_R = \frac{a \cdot t \cdot E}{4 \cdot \pi \cdot R^2 \cdot (1-\nu^2)}$$

Long samples

$$\sigma_R = \frac{a \cdot t \cdot E}{4 \cdot \pi \cdot R^2}$$

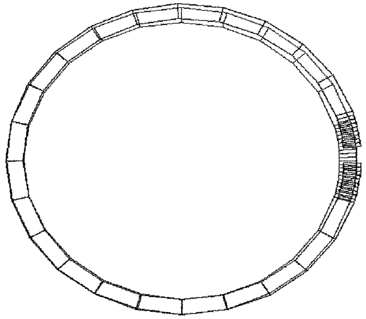
Short samples

Sample length	$a_{FEA}/a_{analytical}$
25 mm	1.02
3D	0.99



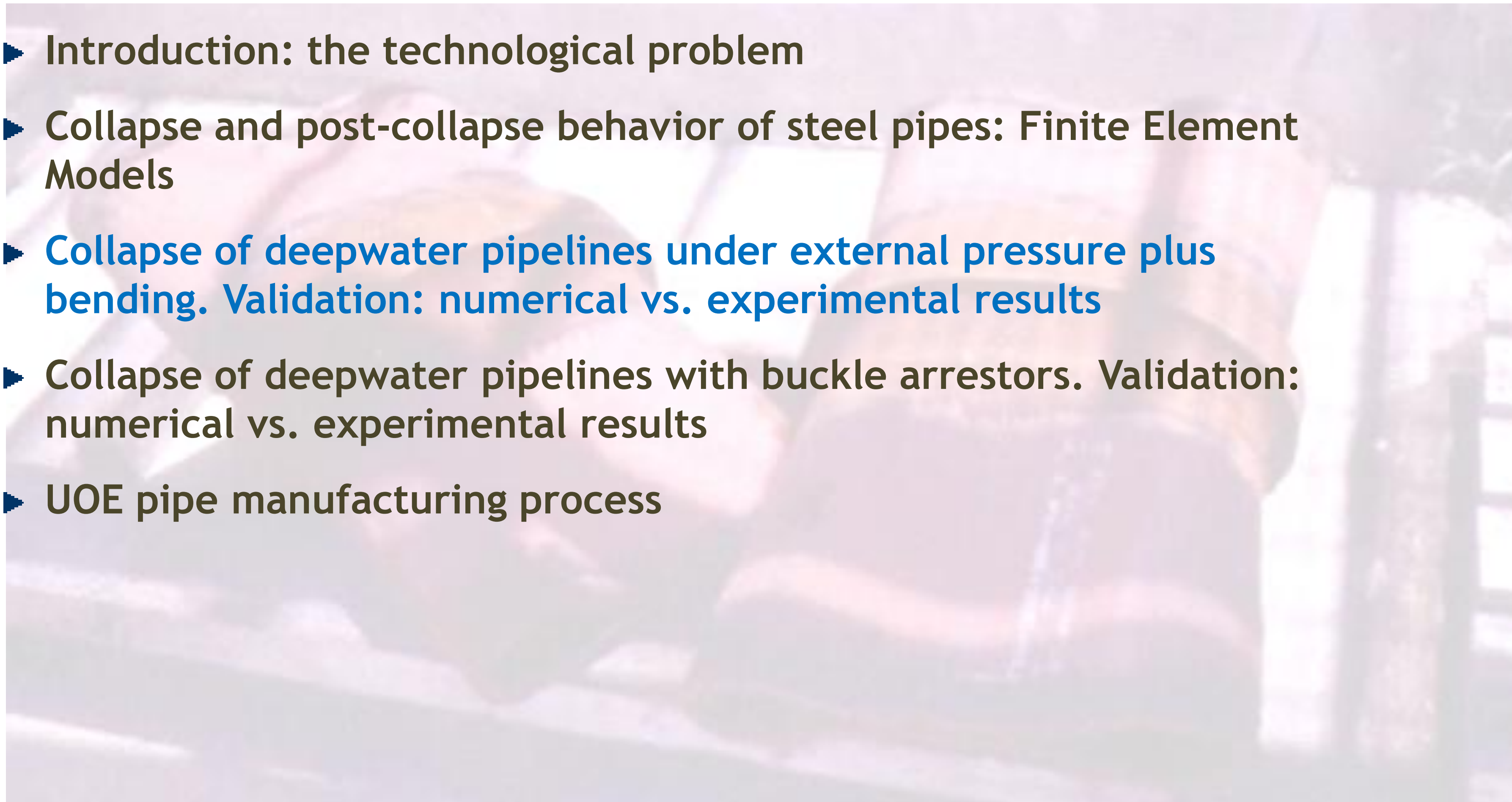
a (opening)

After slitting. Lateral view.



Before and after slitting. Front view.

Agenda



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Test specimens

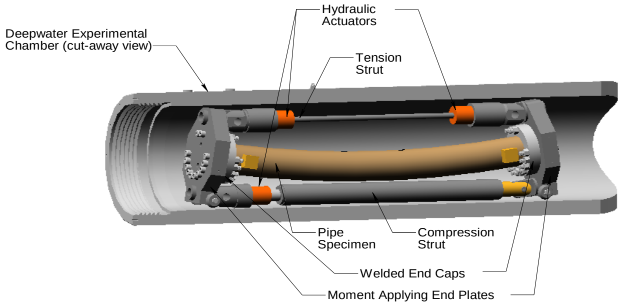
Sample Number	Specimen Number	Average Measured OD (mm)	Average Measured t (mm)	OD/t	Maximum Ovality *	Maximum Eccentricity *	Test Type
1	7782	353.1	22.07	16.0	0.39	0.053	Collapse
2	7784	352.9	22.04	16.0	0.40	0.050	P→B
3	7871	353.0	21.84	16.2	0.41	0.069	P→B
4	7549	325.0	18.37	17.7	0.20	0.097	Collapse
5	7673	325.0	18.32	17.7	0.17	0.067	P→B
6	7548	325.2	18.18	17.9	0.21	0.051	P→B
7	7550	323.4	21.17	15.3	0.23	0.066	Collapse
8	7672	323.7	21.11	15.3	0.25	0.088	P→B
9	7547	323.8	21.14	15.3	0.20	0.081	B→P

Ovality=(OD_max.-OD_min.)/OD_av.

Eccentricity=(t_max.-t_min.)/t_nominal

Collapse and Propagation Tests

Combined Pressure and Bending Set-up

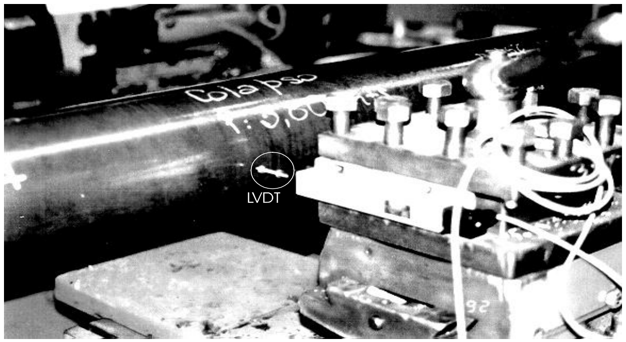


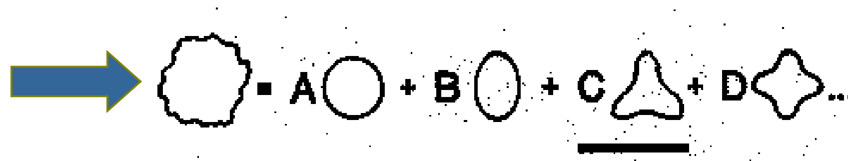
C-FER Technologies

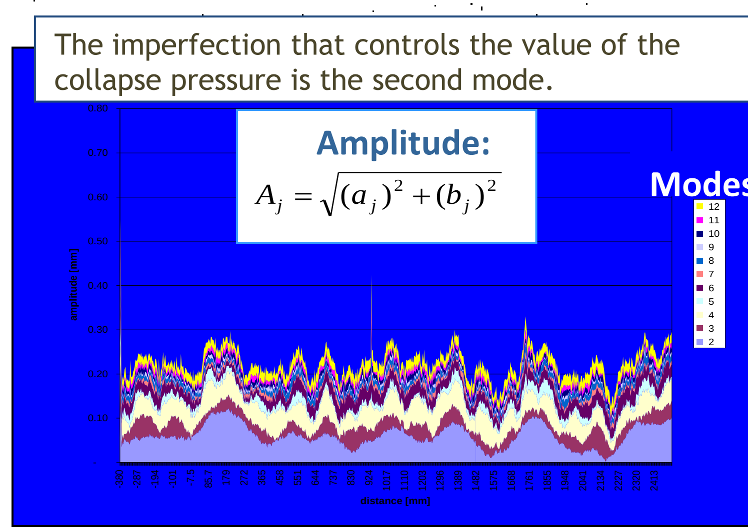
Acquisition of the OD “shape”

(IMS, Imperfection Measuring System or “ shapemeter”)

(Fourier decomposition)







Algorithm to process the data acquired with the LVDT

Each specimen was divided in sections located a few millimeters apart. For each section, the circle that best fits the section’s outer surface was determined. Using the best-fit circle center, any point on the outer surface can be located with a radius and an angle,

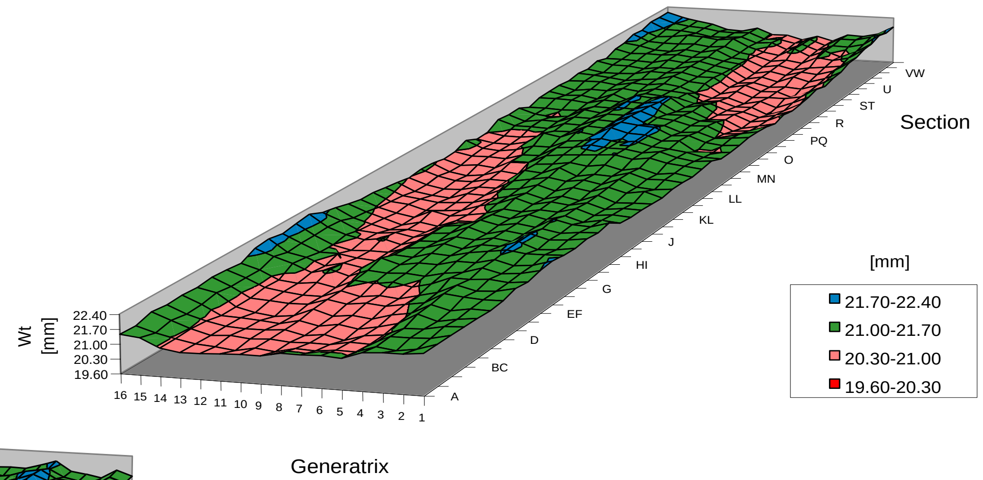
$$r(\theta) = R_o + \sum_{j=1}^{N} \left[a_j \cos(j\theta) + b_j \sin(j\theta) \right]$$

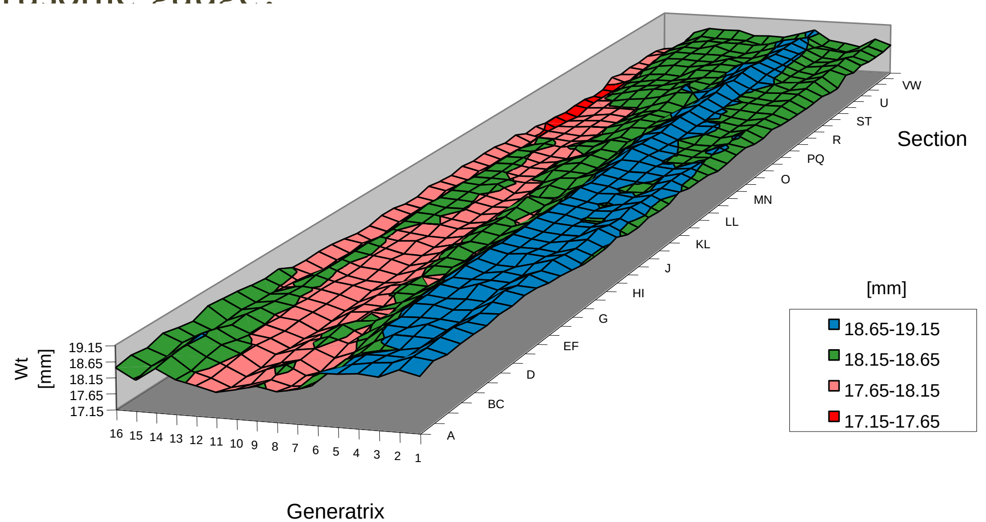
(R_o is the best-fit circle radius)

* Assanelli A.P., Toscano R.G., Johnson D. and Dvorkin E.N. (2000), "Experimental / numerical analysis of the collapse behavior of steel pipes“
Yeh and Kyriakides S ; Arbocz, J. and Babcock, C.D. ; Arbocz, J. and Williams, J.G.

Mapping of the wall thickness

The thickness of the samples was mapped using a standard ultrasonic gauge.

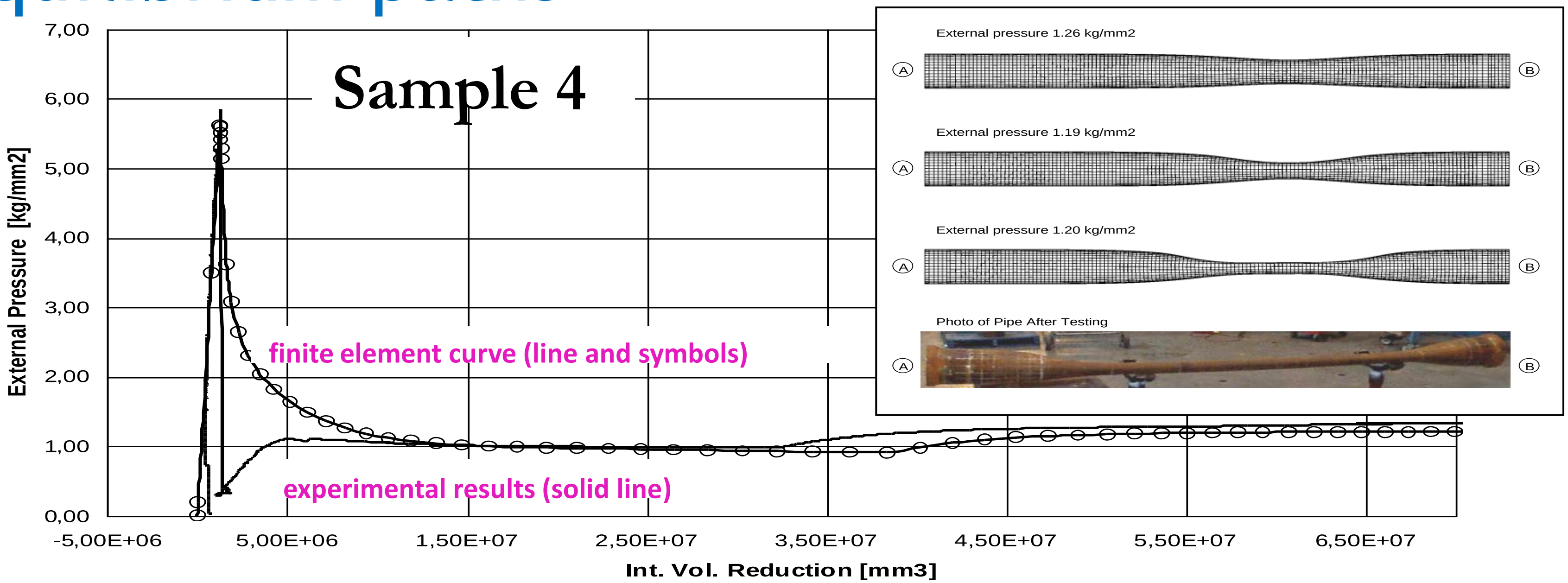




3D Finite Element Model

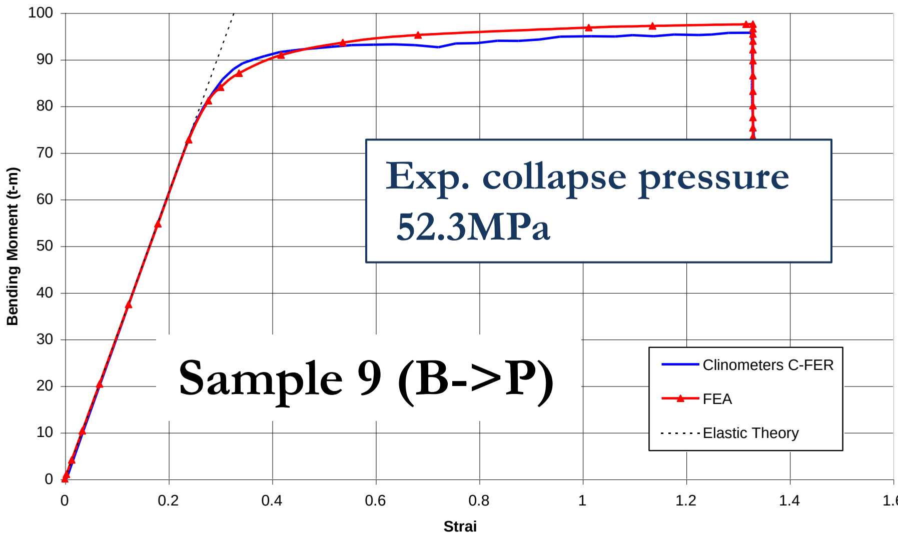
- MITC4 shell element (4-node element that includes shear deformation)
- ADINA code.
- Automatic solution of the incremental nonlinear finite element equations (Riks method).
- Elasto-plastic material model: von Mises associated plasticity with isotropic hardening, with <u>the yield stress corresponding to the samples hoop yield stress in compression</u>. In this model we neglect the plastic anisotropy of the material.
- Geometrical nonlinearity: large displacements / rotations but small strains.
- Contact elements on the pipe inner surface in order to prevent its inter-penetration in the post-collapse regime.
- Geometry described by the OD mapping and by the thickness distribution.
- Circumferential residual stresses obtained experimentally.

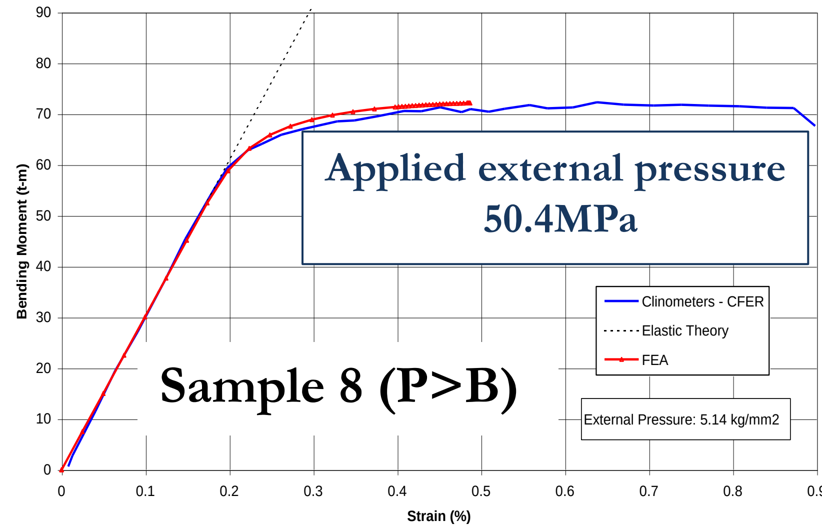
FST and FEA results for pipes under external pressure only. Pre and Post – collapse equilibrium paths



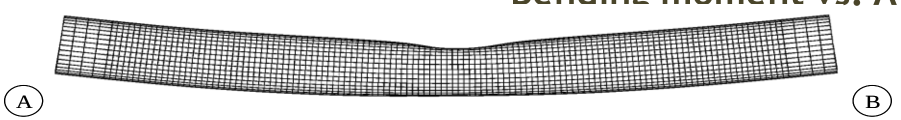
In the experimental test, after collapse the chamber is abruptly depressurized and water must be pumped to regain pressure. Hence, the experimental path is different from the numerical one, which better represents the undersea conditions.

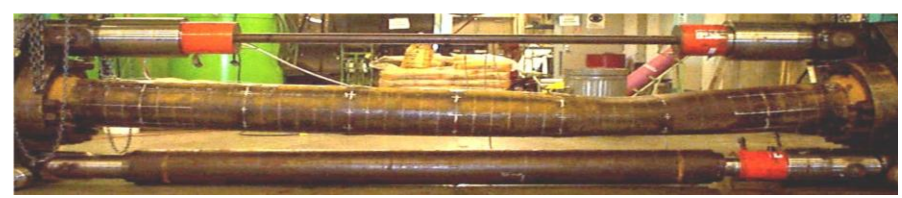
FST and FEA results for Pressure Bend Tests





Bending moment vs. Average bending strain





Pipe after collapse

Summary: Numerical vs. Experimental Results

Sample	1	2	3	4	5	6	7	8	9
P_c FEA / P_c exp	0.977	--	--	0.966	--	--	1.103	--	0.964
Pprop FEA / Pprop exp	0.87	--	--	0.89	--	--	0.99	--	--
M_c FEA / M_c exp	--	1.047	1.088	--	0.972	0.998	--	0.998	--

The agreement between the finite element predictions and the laboratory observations, both in the pre- and post-collapse regimes is excellent; hence, the finite element models can be used as a reliable engineering tool for analyzing the effect of different imperfections, and of residual stresses, on the collapse and collapse propagation pressure of steel pipes.

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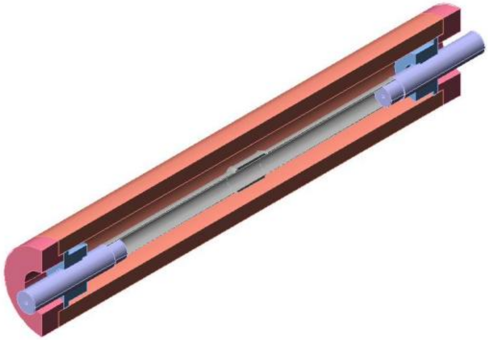
Tested Samples

h=arrestor thickness
t= pipe thickness
La=arrestor length
D=pipe external diameter



Tenaris
Siderca lab.

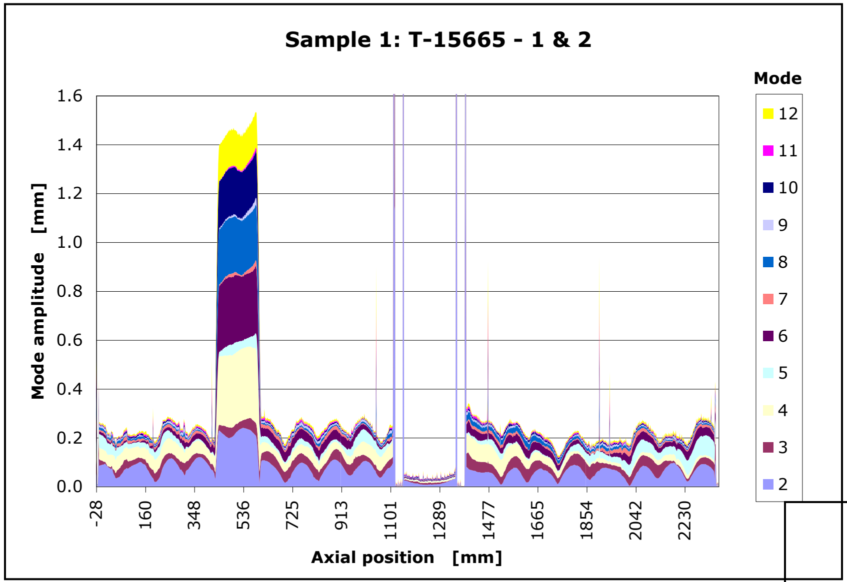
Sample	Pipe OD [mm]	Pipe thickness (t) [mm]	Pipe steel grade	Arrestor (h/t)	Arrestor (La/D)	Arrestor steel grade	Sample length [mm]	Expected cross-over mechanism
1	141.3	6.55	X42	3.0	0.50	6 (ASTM A-333)	2240	Flattening
2	141.3	6.55	X42	2.5	0.50	X42	2250	Flattening
3	141.3	6.55	X42	3.0	0.75	X42	2274	Flipping
4	141.3	6.55	X42	3.0	1.00	X42	2330	Flipping

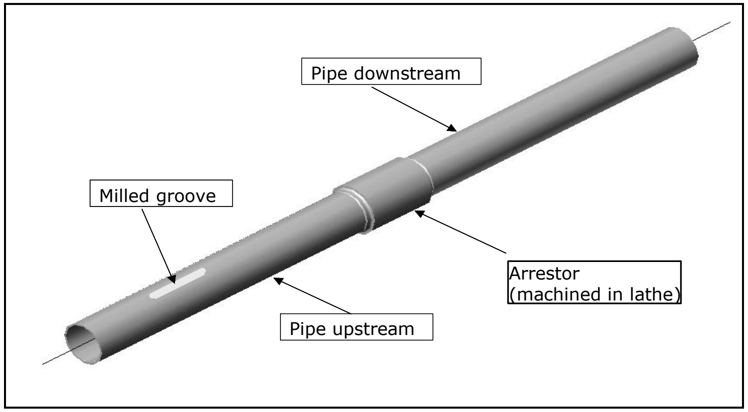
flattening mode

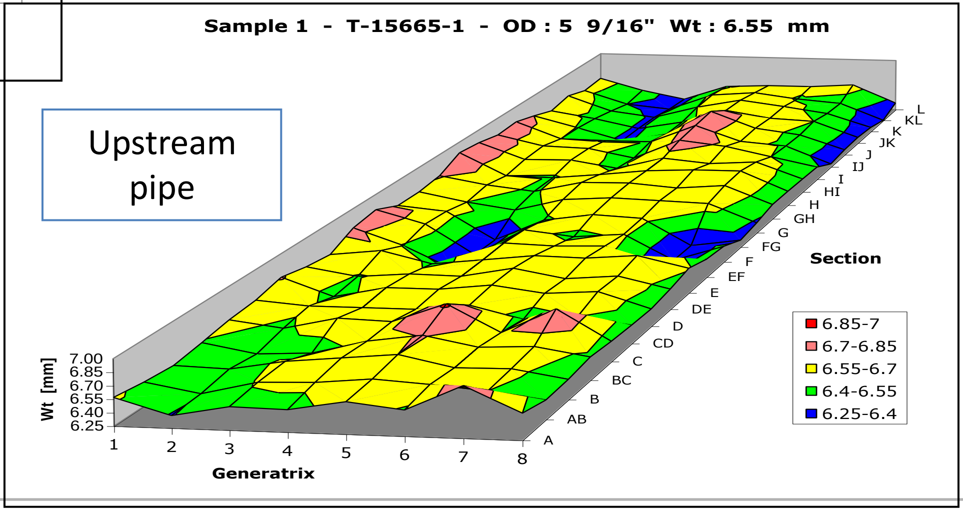
flipping mode

*Kyriakides S., Park T.D. and Netto T.A.

Geometrical Measurements





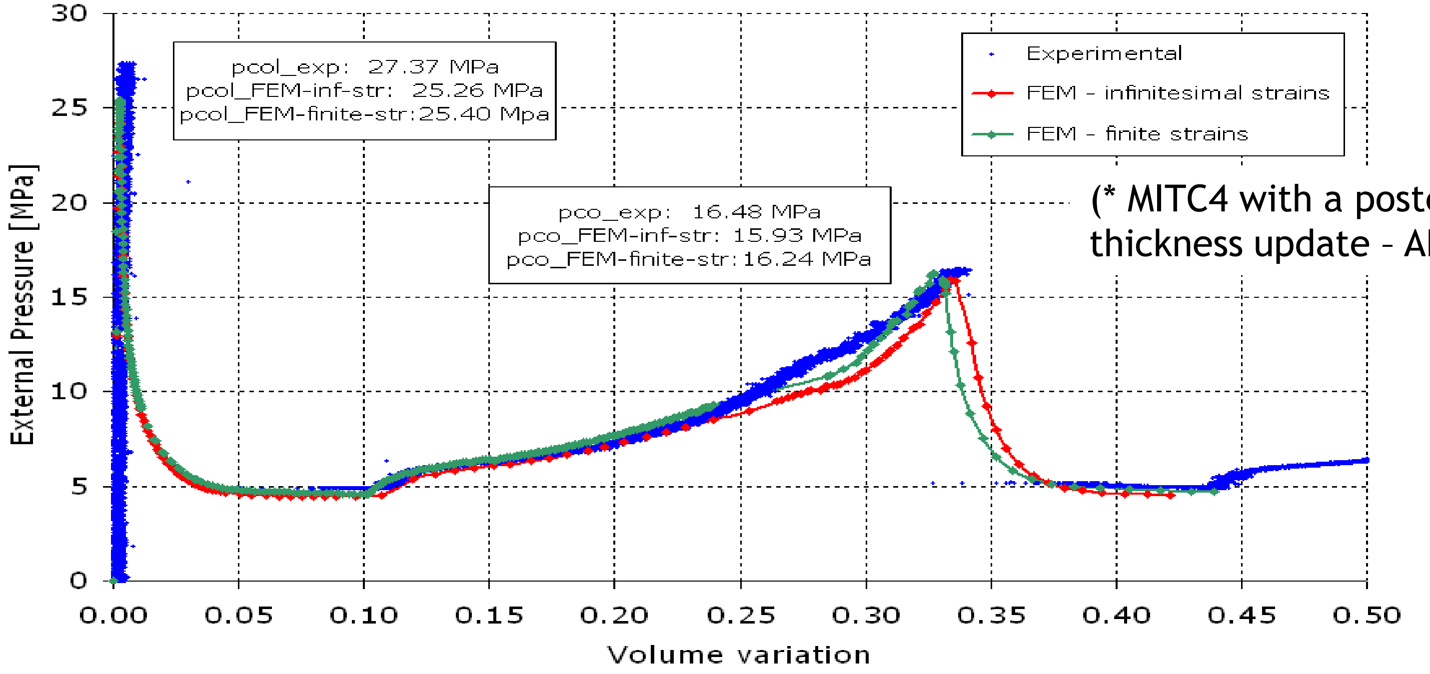


OD Fourier Decomposition of a Pipe Specimen:

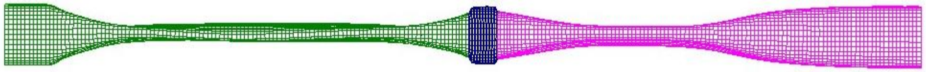
Mode amplitude distribution as a function of the axial position along the sample.

Thickness distribution (ultrasonic gauges)

Validation: Numerical vs. Experimental Response

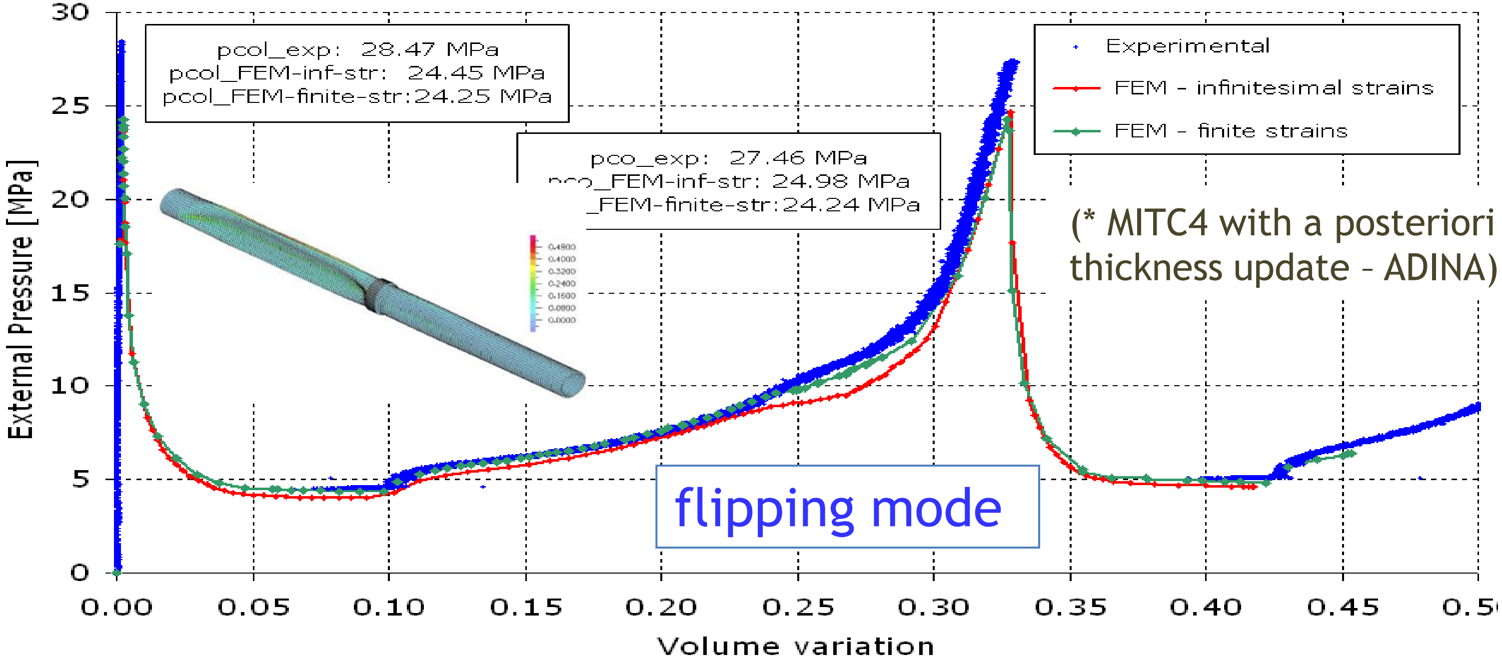


(* MITC4 with a posteriori thickness update – ADINA)

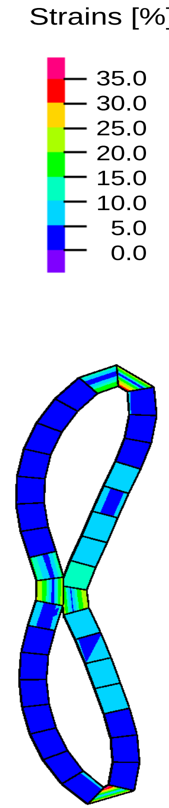


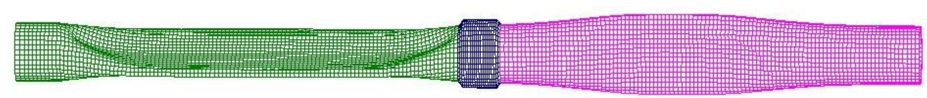
Validation: Numerical vs. Experimental Response

Infinitesimal or finite strains



(* MITC4 with a posteriori thickness update – ADINA)





Summary: Numerical vs. Experimental Response

Sample	Collapse pressure: FEA_finite strain/lab	Crossover pressure: FEA_finite strain/lab.	Mode
1	0.924	1.004	Flattening
2	0.928	0.985	Flattening
3	0.951	0.926	Flipping
4	0.852	0.883	Flipping

The two collapse modes reported in the literature, the flattening and the flipping mode, were identified in our simulations.

The agreement between the finite element predictions and the laboratory observations, both for the collapse and cross-over pressure, is very good; hence, finite element models can be used as a reliable engineering tool to assess the performance of integral ring buckle arrestors for steel pipes.

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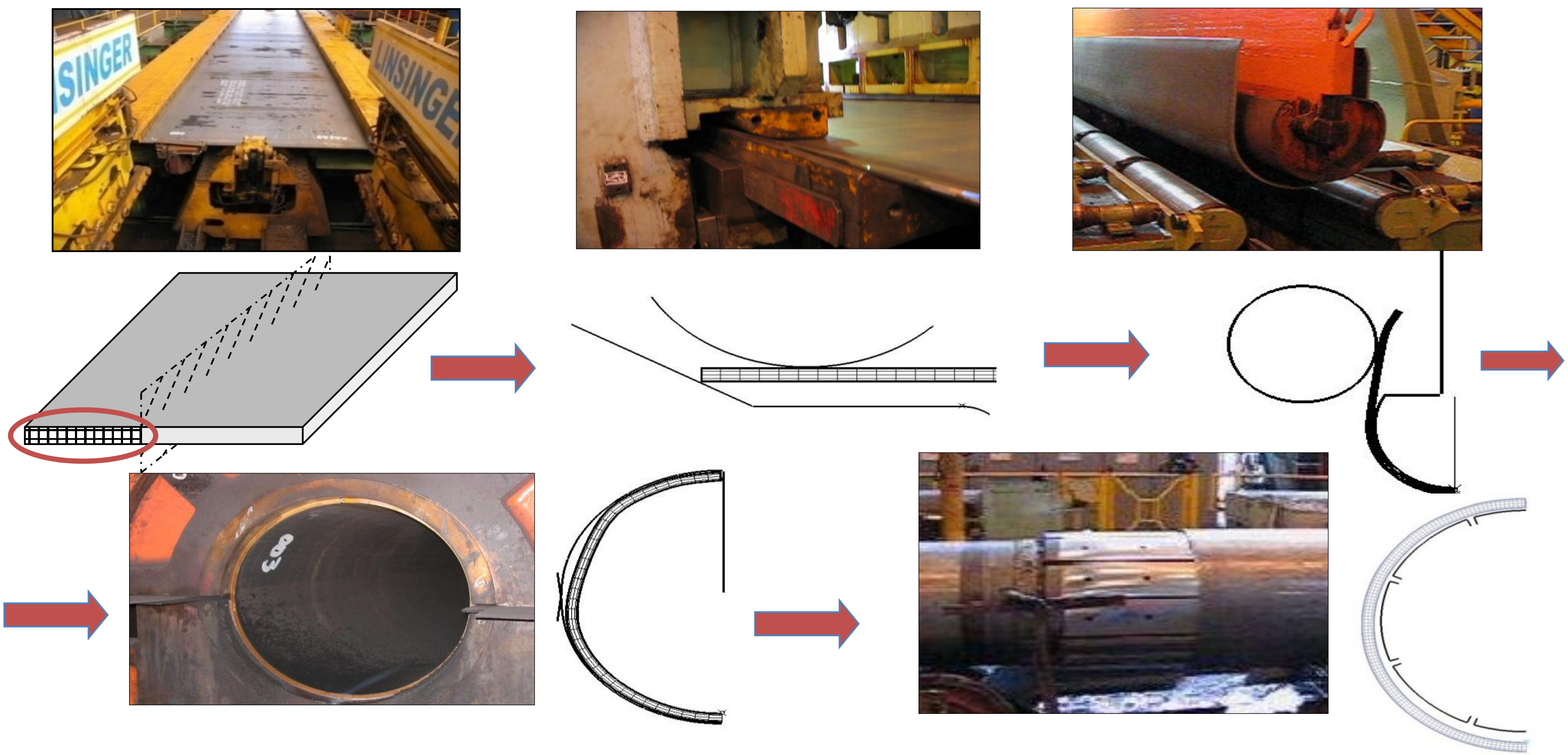
- UOE pipe manufacturing process

UOE pipe manufacturing process



(Tenaris Confab-Brazil)

UOE process: 2D numerical model

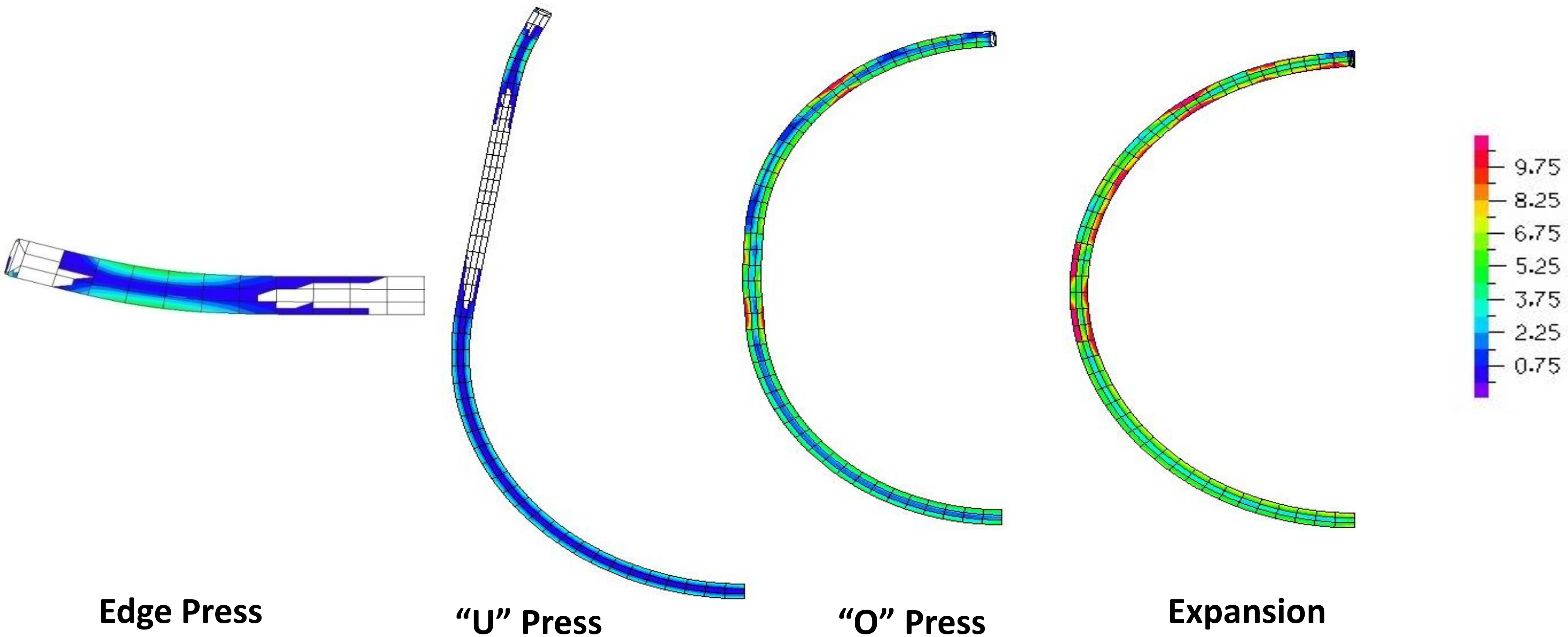
The described cold forming process introduces residual stresses and plastic deformations that, due to the Bauschinger effect, reduce the yielding stress of the steel for compressive loading → **the cold forming processes reduces pipe collapse strength.**

2D Finite element model

- **Q1-P0 plane strain element.**
- **ADINA code.**
- **Large displacements/rotations but small strains.**
- **Elasto-plastic bi-linear material model.**
- **Von Mises plasticity with kinematic hardening.**
- **The forming tools are modeled as rigid bodies.**
- **Sliding nodes contact algorithm to simulate the contact between the tools and the plates.**

Results

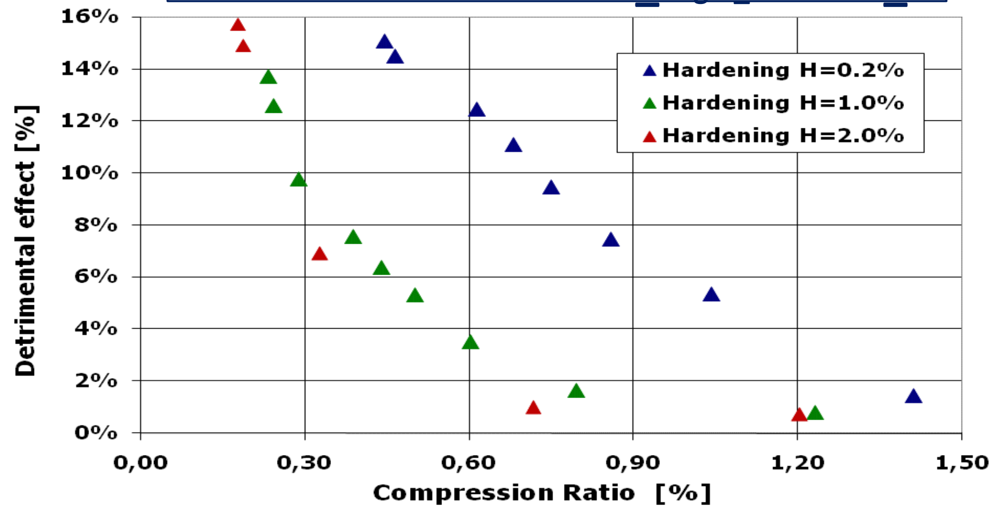
16" OD x 0.5" Wt X60
Hardening 1%



Accumulated effective plastic strains evolution [%]

Results

Detrimental Effect= $PC_{\_virgin\_mat}$ - $Pc_{\_UOE}$



20” OD x 0.75” WT X80

D/t=26.7

$$Compression\_Ratio\_\% = \frac{OP\_After\_Opress - OP\_Before\_Opress}{OP\_Before\_Opress} \cdot 100\%$$

***OP*: Outside Perimeter measured as the sum of node to node distances.**

One very important conclusion from this study is that the deterioration of the collapse pressure diminishes as the compression ratio increases.

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