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(54) COMMUNICATION CONNECTIONS FOR WIRED DRILL PIPE JOINTS

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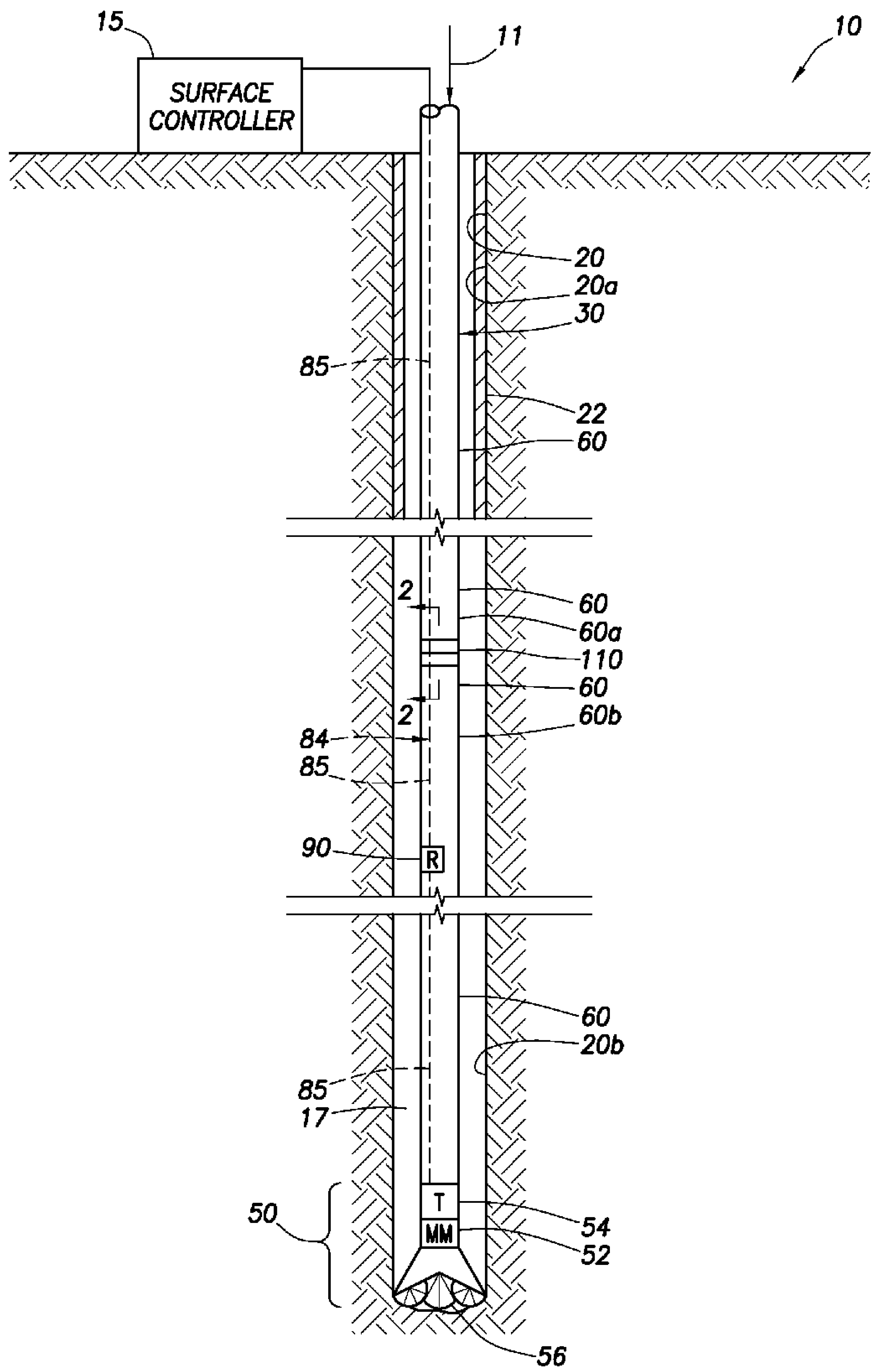
(57) **ABSTRACT**

A drill pipe includes a pin end connector, a box end connector, a first communication connector and a second communication connector. The pin end connector includes a first region to form a threaded connection to join sections of the drill pipe together, and the first region includes at least one thread that begins at one end of the first region and ends at the other end of the first region. The box end connector receives the pin end connector, and the box end connector includes a second region to mate with the first region to form the threaded connection. The first communication connector is attached to the pin end connector and is located in the first region; and the second communication connector is attached to the box end connector and located in the second region to form a communication connection with the first communication connector.



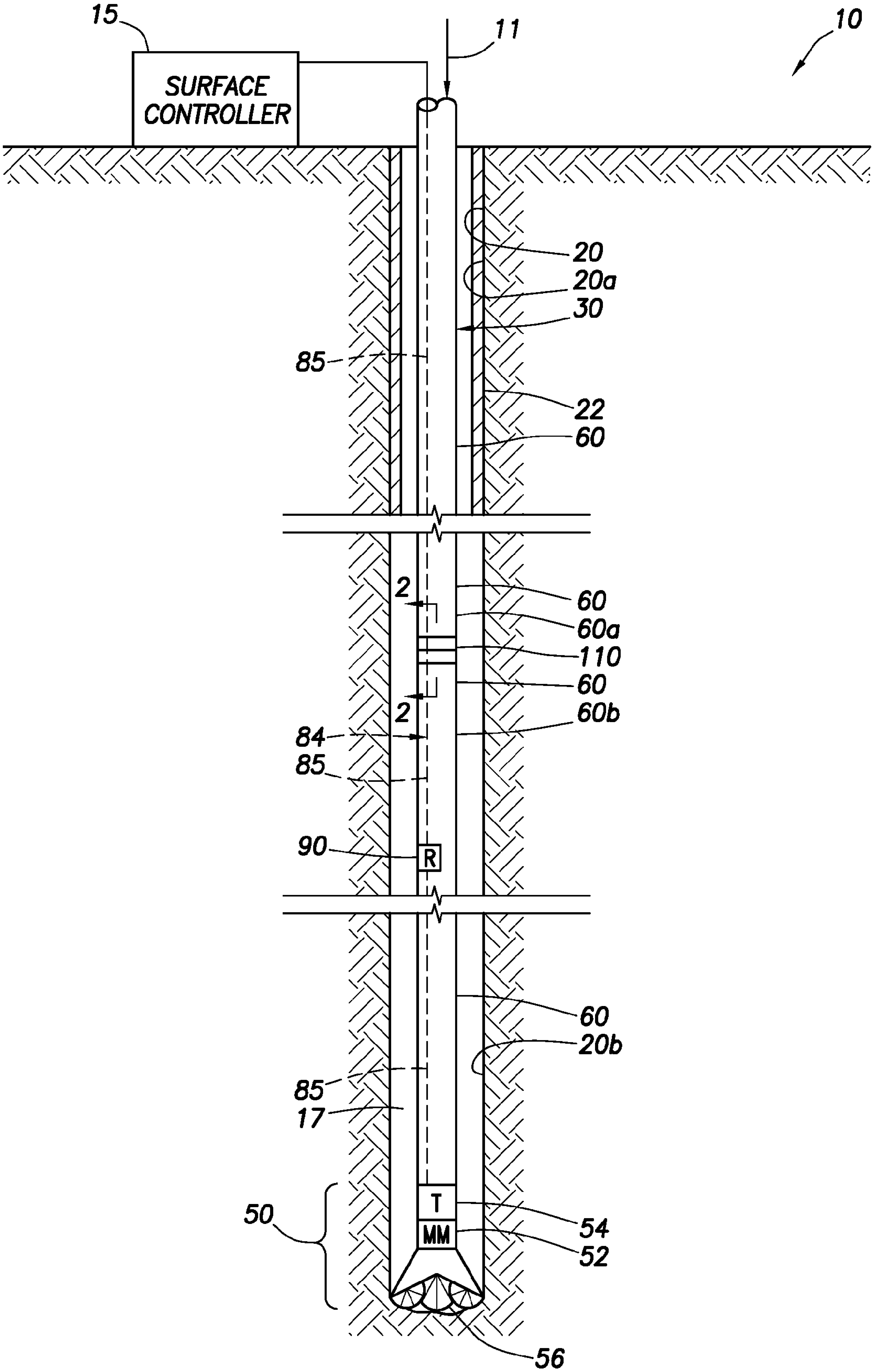

15
SURFACE CONTROLLER
11
10
20
20a
30
85
22
60
2
60
60a
110
60
2
60b
84
85
90
R
60
20b
85
17
50
T
MM
54
52
56

FIG. 1

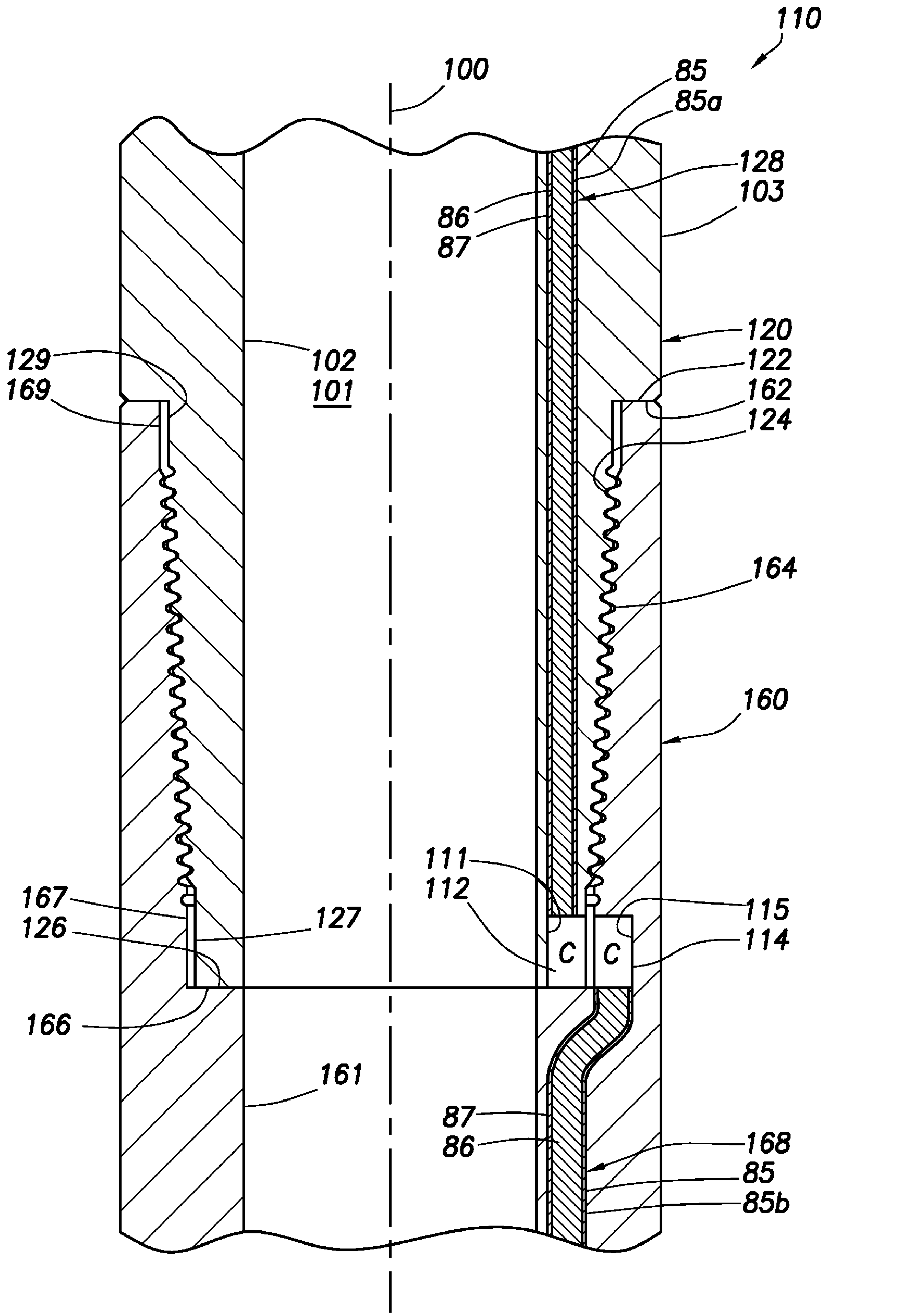

110
100
85
85a
128
103
86
87
120
122
162
124
129
169
102
101
164
160
111
112
115
114
167
126
127
166
161
168
87
86
85
85b
C
C

FIG.2

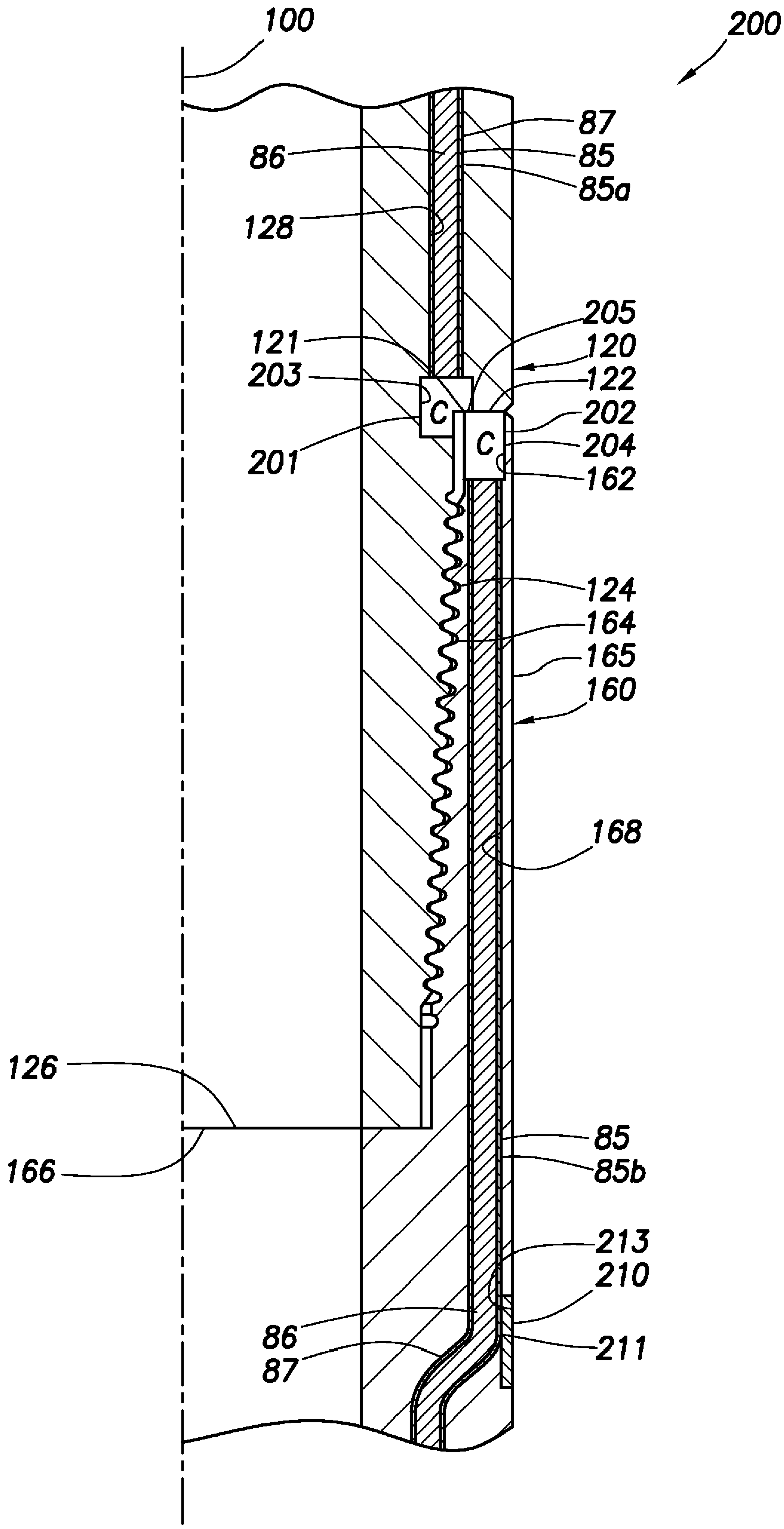

100
200
87
86
85
85a
128
205
121
120
203
122
202
201
204
162
124
164
165
160
168
126
166
85
85b
213
210
86
211
87

FIG.3

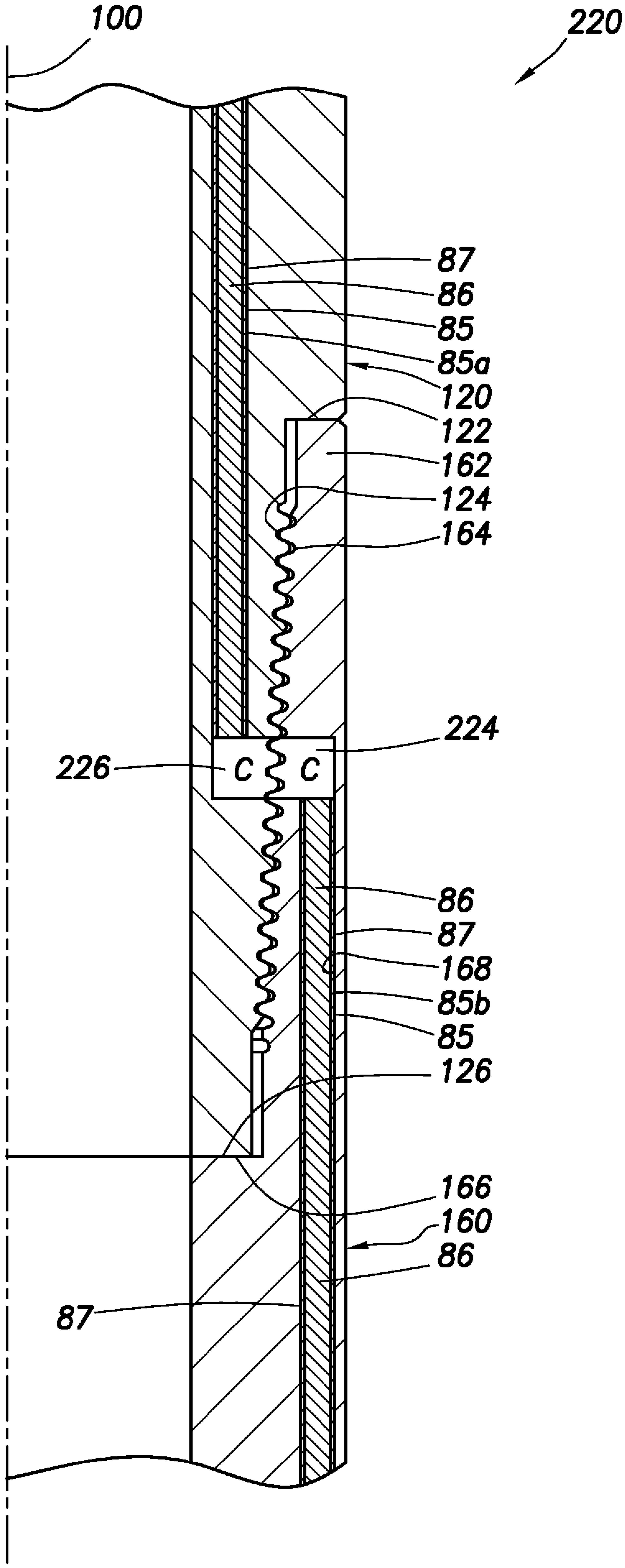

100
220
87
86
85
85a
120
122
162
124
164
224
226
C
C
86
87
168
85b
85
126
166
160
86
87

FIG.4

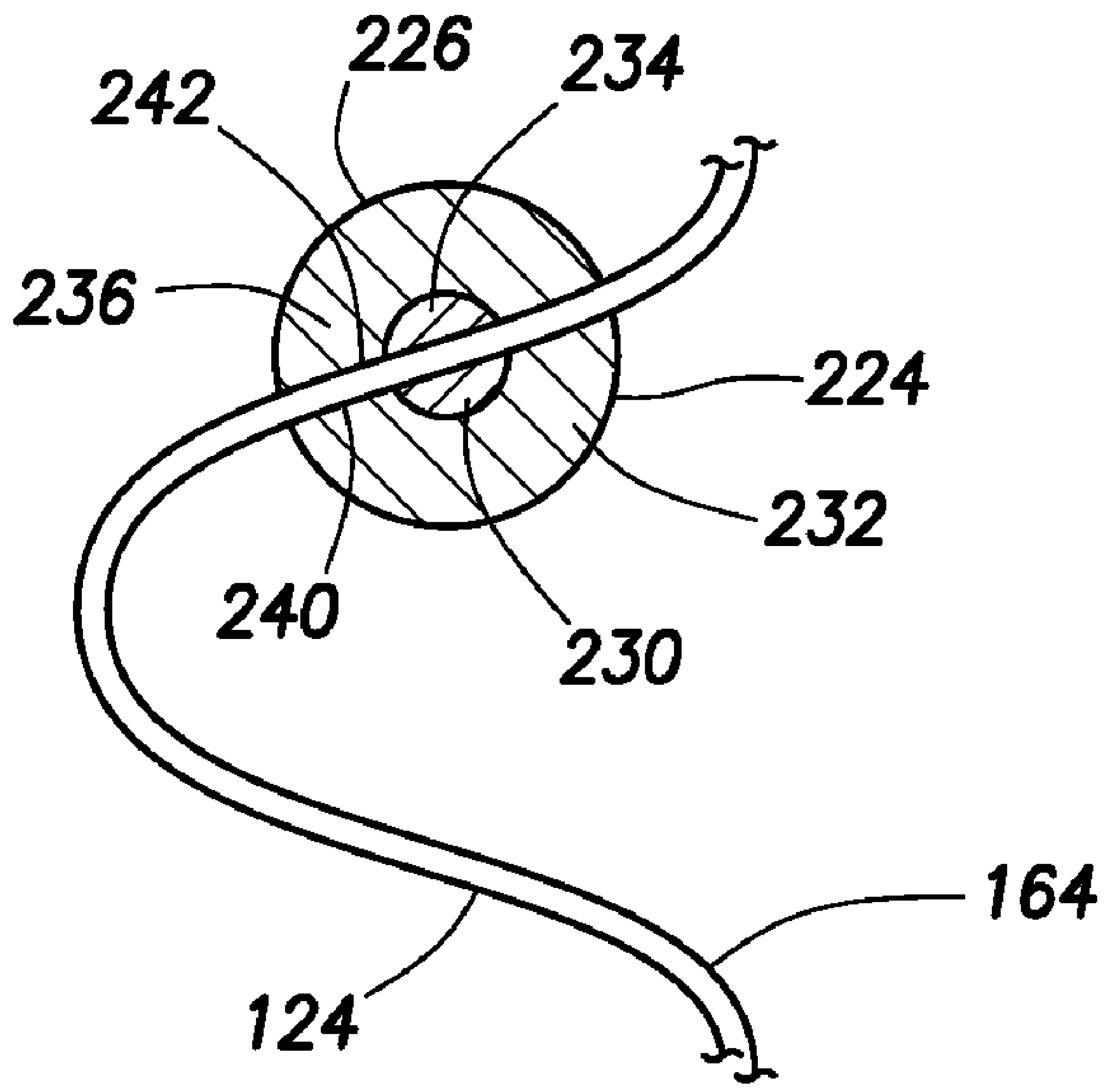

226
234
242
236
224
232
240
230
164
124

FIG.5

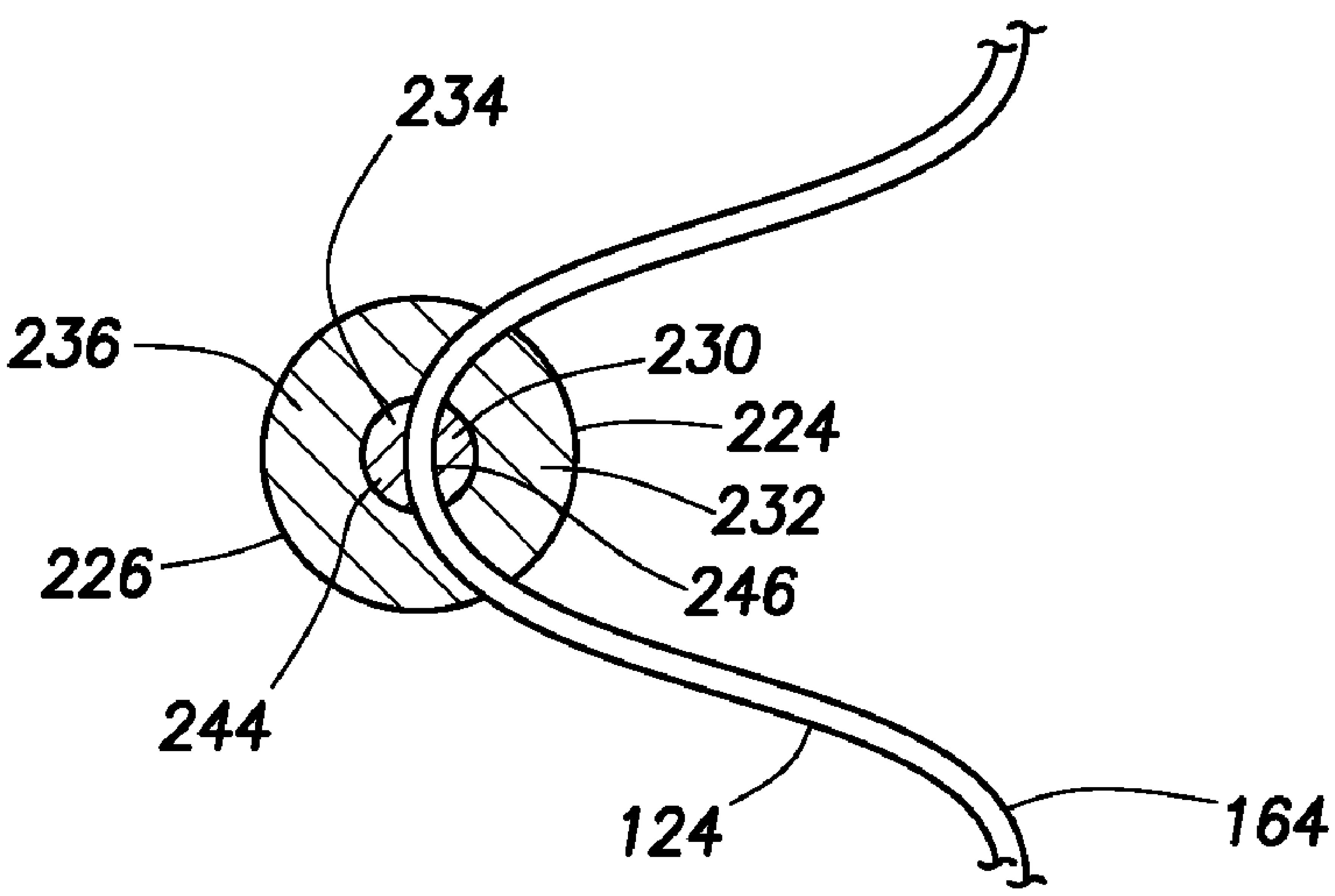

234
236
230
224
232
226
246
244
124
164

FIG.6

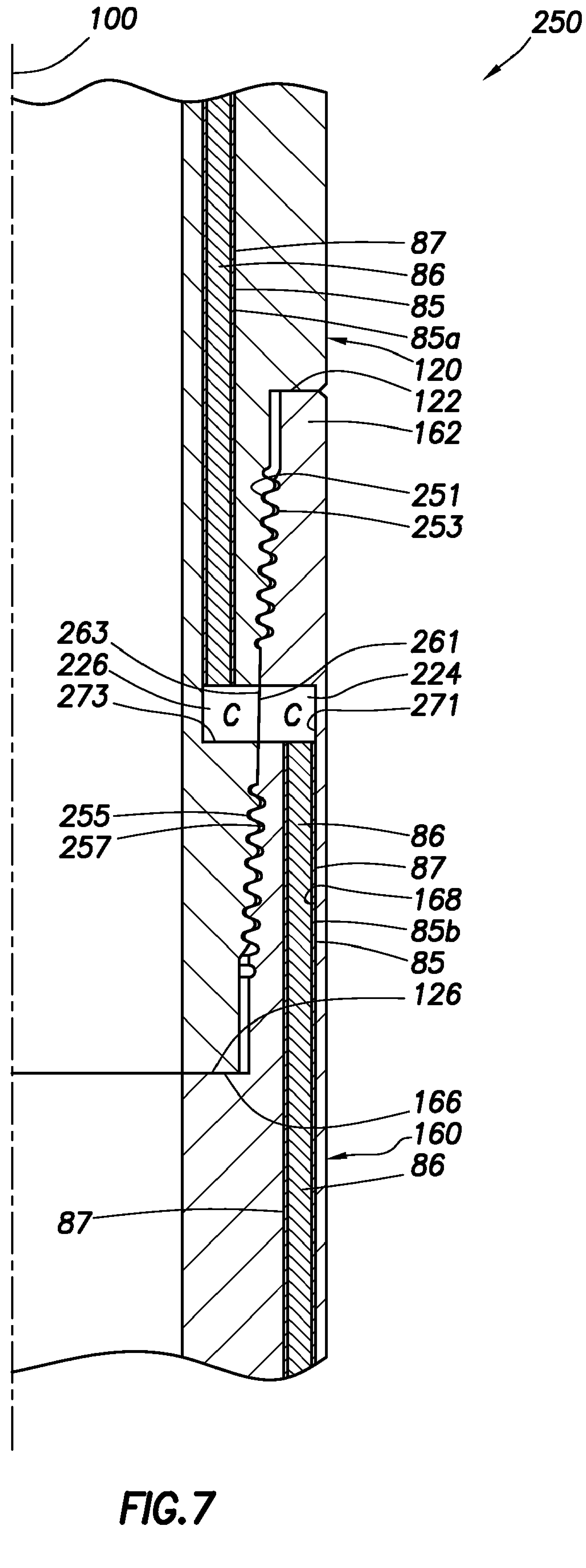

100
250
87
86
85
85a
120
122
162
251
253
263
226
273
261
224
271
C
C
255
257
86
87
168
85b
85
126
166
160
86
87

FIG. 7

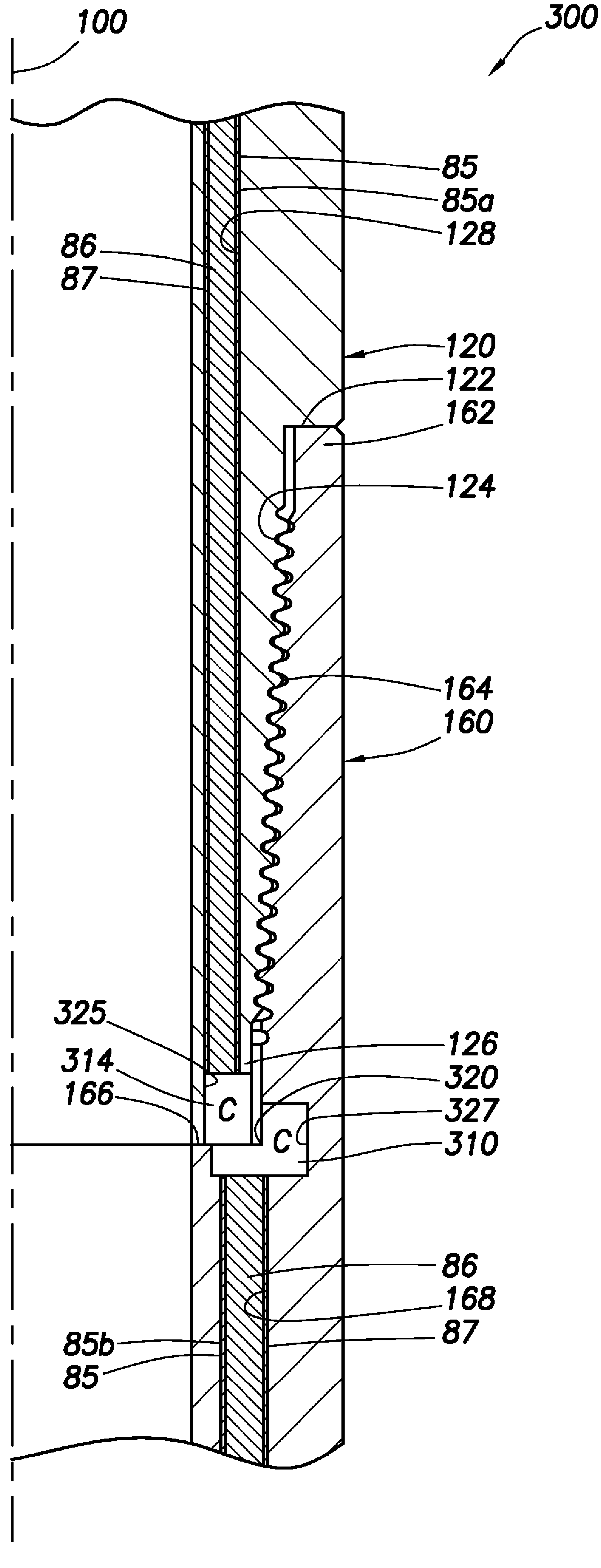

100
300
85
85a
128
86
87
120
122
162
124
164
160
325
126
314
320
166
327
C
C
310
86
168
85b
87
85

FIG.8

COMMUNICATION CONNECTIONS FOR WIRED DRILL PIPE JOINTS

BACKGROUND

[0001] The invention generally relates to communication connections for wired drill pipe joints.

[0002] A typical system for drilling an oil or gas well includes a tubular drill pipe, also called a "drill string," and a drill bit that is located at the lower end of the drill string. During drilling, the drill bit is rotated to remove formation rock, and a drilling fluid called "mud" is circulated through the drill pipe and returns up the annulus for such purposes as cooling the drill bit and removing debris that is generated by the drilling. A surface pumping system typically generates the circulating mud flow by delivering the mud to the central passageway of the drill pipe and receiving mud from the annulus of the well. More specifically, the circulating mud flow typically propagates downhole through the central passageway of the drill pipe, exits the drill pipe at nozzles that are located near or in the drill bit and returns to the surface pumping system via the annulus between the pipe and the wellbore.

[0003] One technique to rotate the drill bit involves applying a rotational force (through a rotary table and kelly arrangement or through a motorized swivel, as examples) to the drill pipe at the surface of the well to rotate the drill bit at the bottom of the string. Another conventional technique to rotate the drill bit takes advantage of the mud flow through the drill pipe by using the flow to drive a downhole mud motor, which is located near the drill bit. The mud motor responds to the mud flow to produce a rotational force that turns the drill bit.

[0004] The drilling of the well may be aided by communication between the surface of the well and tools at the bottom of the drill pipe. In this regard, the bottom end of a conventional drill pipe may include tools that measure various downhole parameters (pressures, temperatures and formation parameters, as examples) and characteristics of the drilling (direction and inclination of the drill bit, for example), which are communicated uphole. The uphole communication from a downhole location to the surface may involve the use of a mud pulse telemetry tool to modulate the circulating mud flow so that at the surface of the well, the modulated mud flow may be decoded to extract data relating to downhole measurements. Additionally, downhole communication may be established from the surface of the well to downhole tools of the drill pipe through one of a number of different conventional telemetry techniques. This downhole communication may involve, as examples, acoustic or electromagnetic signaling.

[0005] A more recent innovation in drill pipe telemetry involves the use of a wired drill pipe (WDP) infrastructure, such as the WDP infrastructure that is described in U.S. Patent Application Publication No. US 2006/0225926 A1, entitled, "METHOD AND CONDUIT FOR TRANSMITTING SIGNALS," which published on Oct. 12, 2006 and is owned by the same assignee as the present application. The WDP infrastructure typically includes communication lines that are embedded in the housing of the drill pipe. Because a conventional drill pipe may be formed from jointed tubing sections, communication connections for the WDP infrastructure may be made at each joint of the drill string. Due to the repeated use of the jointed tubing sections in numerous drilling jobs, the drill pipe joints typically are often re-faced and re-cut. Challenges typically arise in designing the communication connections for the WDP infrastructure in order to accommodate the re-facing and re-cutting of the drill pipe joints.

SUMMARY

[0006] In one aspect, a drill pipe includes a pin end connector, a box end connector, a first communication connector and a second communication connector. The pin end connector includes a first region to form a threaded connection to join sections of the drill pipe together, and the first region includes at least one thread that begins at one end of the first region and ends at the other end of the first region. The box end connector receives the pin end connector, and the box end connector includes a second region to mate with the first region to form the threaded connection. The first communication connector is attached to the pin end connector and is located in the first region; and the second communication connector is attached to the box end connector and is located in the second region to form a communication connection with the first communication connector.

[0007] In another aspect, a drill pipe includes a pin end connector, a box end connector to receive the pin end connector, a first communication connector and a second communication connector. One of the pin end and box end connectors includes a shoulder that defines a corner and is located near an end of the other of the pin end and box end connectors when the box end connector is received the pin end connector. One of the first and second communication connectors is located in a pocket that is formed in the corner.

[0008] In another aspect, a drill pipe includes a pin end connector, a box end connector to receive the pin end connector, a first communication connector and a second communication connector. The box end connector includes an inner shoulder to be in close proximity to an end of the pin end connector when the box end connector receives the pin end connector, and the first communication connector is attached to the pin end connector near the end of the pin end connector. The second communication connector is attached to the box end connector near the inner shoulder of the box end connector and is located radially outside of the first communication connector. The second communication connector is adapted to form a communication connection with the first communication connector.

[0009] In another aspect, a technique includes connecting drill pipe sections together, including threadably engaging a first region of a pin end connector with a second region of a box end connector. The technique includes communicating a signal through a communication connection that spans between the first and second regions.

[0010] In yet another aspect, a technique includes connecting drill pipe sections together, including engaging a pin end connector with a box end connector. The technique includes communicating a signal through a communication connection that spans between a first region of the pin end connector, which is located near an end of the pin end connector and a second region of the box end connector, which is located near an inner shoulder of the box end connector and radially outside of the first region.

[0011] Advantages and other features of the invention will become apparent from the following drawing, description and claims.

BRIEF DESCRIPTION OF THE DRAWING

[0012] FIG. **1** is a schematic diagram of a drilling system according to an example.

[0013] FIG. **2** is a cross-sectional view of a wired drill pipe joint taken along line **2-2** of FIG. **1** according to an example.

[0014] FIGS. **3**, **4**, **7** and **8** are partial cross-sectional views of other wired drill pipe joints according to other examples.

[0015] FIG. **5** is a schematic diagram illustrating a communication connection that spans across two thread flanks of a wired drill pipe joint according to an example.

[0016] FIG. **6** is a schematic diagram illustrating a communication connection that spans across the root of one thread of a wired drill pipe joint and the crest of another thread of the joint according to an example.

DETAILED DESCRIPTION

[0017] According to one example, FIG. **1** schematically depicts a drilling system **10** that includes a drill string, or pipe **30**. During drilling of a wellbore **20**, a surface pumping system (not shown) delivers a mud flow **11** to the central passageway of the drill pipe **30**, and the mud flow **11** propagates downhole through the pipe **30**. Near the bottom end of the drill pipe **30**, the mud flow **11** exits the pipe **30** at nozzles (not shown) and returns uphole to the surface pumping system via an annulus **17** of the well. As an example, the circulating mud flow may actuate a downhole mud motor **52** that, in turn, rotates a drill bit **56** of the drill pipe **30**.

[0018] FIG. **1** depicts a particular stage of the well during its drilling and completion. In this stage, an upper segment **20***a* of the wellbore **20** has been formed through the operation of the drill pipe **30**, and the wellbore segment **20***a* is lined with and supported by a casing string **22** that has been installed in the segment **20***a*. For this example, the wellbore **20** extends below the cased segment **20***a* into a lower, uncased segment **20***b*.

[0019] Thus, for the example that is depicted in FIG. **1**, drilling operations may be interlaced with casing installation operations. However, the drill pipe **30** may alternatively be used as part of the well completion, in another example. In this manner, called "casing drilling," the drill pipe **30** may be constructed to line and support the wellbore **20** so that at the conclusion of the drilling operation, the drill pipe **30** is left in the well to perform the traditional function of the casing.

[0020] The drilling operation and/or the downhole formations through which the wellbore **20** extends may be monitored at the surface of the well via measurements that are acquired downhole. For this purpose, the drill pipe **30** has a wired drill pipe (WDP) infrastructure **84** for purposes of establishing one or more communication link(s) between the surface of the well and downhole tools that acquire the measurements, such as tools that are part of a bottom hole assembly (BHA) **50** of the pipe **30**. As non-limiting examples, the WDP infrastructure **84** may provide electrical and/or optical communication link(s).

[0021] The communication through the WDP infrastructure **84** may be bidirectional, in that the communication may be from the surface of the well to the BHA **50** and/or from the BHA **50** to the surface of the well. Furthermore, the communication may involve the communication of power from the surface of the well to the BHA **50**. Thus, many variations and uses of the WDP infrastructure **84** are contemplated and are within the scope of the appended claims.

[0022] The WDP infrastructure **84** includes communication line segments **85** (fiber optic line segments or electrical cable segments, as just a few examples) that are embedded in the housing of the drill pipe **30**, and the WDP infrastructure **84** may include various repeaters **90** (one repeater **90** being depicted in FIG. **1**) along the drill pipe's length to boost the communicated signals.

[0023] In general, the drill pipe **30** is formed from jointed tubing sections **60** (specific jointed tubing sections **60***a* and **60***b* being labeled in FIG. **1** and described herein as examples) that are joined together at WDP joints **110** (one WDP joint **110** between the jointed tubing sections **60***a* and **60***b* being depicted in FIG. **1** as an example). As an example, each WDP joint **110** may be part of a drill pipe connection sub.

[0024] A given jointed tubing section **60** may have one or more communication line segments **85**, possibly one or more repeaters **90** and communication connectors (not shown in FIG. **1**) on either end of each communication line segment **85**. As described below, the communication connectors are disposed in the WDP joints **110** for purposes of connecting the communication line segments **85** of different jointed tubing sections **60** together. Pursuant to the WDP infrastructure, the drill pipe **30** may contain multiple communication lines that extend between the surface and downhole, with each communication line being formed from serially connected communication line segments **85**, repeaters **90** and WDP joint communication connectors.

[0025] Among the other features of the drill pipe **30**, the BHA **50** may include a communication tool **54** that communicates with a surface controller **15** via signals that are communicated over the WDP infrastructure **84**. As examples, the tool **54** may receive power, control and/or data signals from the WDP infrastructure **84**. Furthermore, the tool **54** may transmit signals (signals indicative of acquired measurements, for example) uphole to the surface controller **15** via the WDP infrastructure **84**.

[0026] The tool **54** may be constructed to acquire downhole measurements, and in addition to using the WDP infrastructure **84**, the tool **54** may use alternative paths (such as mud pulse telemetry, for example) for communicating with the surface. As non-limiting examples, the tool **54** may be a measurement while drilling (MWD) tool, a logging while drilling (LWD) tool, a formation tester, an acoustic-based imager, a resistivity tool, etc. Furthermore, the drill pipe **30** may contain a plurality of such tools that communicate with the surface via the WDP infrastructure **84**. It is noted that the drill pipe **30** may include various other features, such as a drill collars, an under-reamer, etc., as the depiction of the drill pipe **30** in FIG. **1** is simplified for purposes of illustrating certain aspects of the pipe **30** related to the WDP infrastructure **84** and the WDP joints **110**.

[0027] It is noted that the WDP infrastructure **84** may be used for purposes of performing tests in the well, such as a leak off test, as described in co-pending U.S. patent application Ser. No. ______, entitled, "TECHNIQUE AND APPARATUS TO PERFORM A LEAK OFF TEST IN A WELL," filed on ______, which is owned by the same assignee as the present application. Additionally, the WDP infrastructure **84** may be used for purposes of monitoring a plug cementing operation, as described in co-pending U.S. patent application Ser. No. ______, entitled, "TECHNIQUE AND APPARATUS TO DEPLOY A CEMENT PLUG IN A WELL," which is owned by the same assignee as the present application.

[0028] FIG. **2** depicts a cross-sectional view of the WDP joint **110** when fully assembled. Referring to FIG. **2** in conjunction with FIG. **1**, in general, the WDP joint **110** includes two main components for purposes of mechanically connecting the upper jointed tubing section **60***a* to tile lower jointed tubing section **60***b:* a pin end connector **120** and a box end connector **160**. Before the pin end **120** and box end **160** connectors are mated together, the pin end connector **120** is secured to (threaded to, for example) the lower end of the upper jointed tubing section **60***a,* and the box end connector **160** is secured to (threaded to, for example) the upper end of the lower jointed tubing section **60***b,* in connections that are not depicted. In general, the pin end **120** and box end **160** connectors are concentric about a longitudinal axis **100**, which is coaxial with the drill pipe **30** near the WDP joint **110**. Additionally, the pin end **120** and box end **160** connectors have respective central passageways that concentrically align to form a corresponding section **101** of a central passageway of the drill pipe **30** when the WDP joint **110** is fully assembled.

[0029] As a more specific example, the WDP joint **110** may be a double shoulder, rotary connection, in that the upper jointed tubing section **60***a* and the attached pin end connector **120** are rotated about the longitudinal axis **100** with respect to the box end connector **160** and the attached lower jointed tubing section **60***b* for purposes of threadably connecting the pin end **120** and box end **160** connectors together. In this regard, for this example, the pin end connector **120** has an external tapered thread **124** that helically circumscribes the longitudinal axis **100** and is constructed to engage a mating, internal tapered thread **164** (of the box end connector **160**), which also helically circumscribes the longitudinal axis **100**.

[0030] When the WDP joint **110** is fully assembled, a downwardly directed annular face **126** of the pin end connector **120** contacts or at least comes in close proximity, to an upwardly directed, inner annular shoulder **166** (herein called the "internal shoulder **166**") of the box end connector **160**. Also, when the WDP joint **110** is fully assembled, an upwardly directed annular face **162** of the box end connector **160** contacts or at least comes in close proximity to a downwardly facing external annular shoulder **122** (herein called the "external shoulder **122**") of the pin end connector **120**.

[0031] The external thread **124** of the pin end connector **120** longitudinally and continuously (as one example) extends between two relatively smooth external cylindrical surfaces **127** and **129** of the connector **120**. More specifically, the external thread **124** longitudinally extends from the external surface **129**, which is located near the external shoulder **122** to the external surface **127**, which is located near the lower end of the pin end connector **120**. The internal thread **164** of the box end connector **160** longitudinally and continuously (as one example) extends between two relatively smooth internal cylindrical surfaces **167** and **169** of the connector **160**. More specifically, the internal thread **164** extends from the internal surface **169**, which is located near upper end of the box end connector **160** to the internal surface **167**, which is located near the internal shoulder **166** of the box end connector **160**.

[0032] As depicted in FIG. **2**, when the WDP joint **110** is fully assembled, the internal surface **169** of the box end connector **160** is adjacent to and located radially outside of the external surface **129** of the pin end connector **120**. Also, for the fully assembled WDJ joint **110**, the internal surface **167** of the box end connector **160** is adjacent to and located radially outside of the external surface **127** of the pin end connector **120**.

[0033] In accordance with examples that are described herein, communication connectors are disposed in the pin end **120** and box end **160** connectors for purposes of establishing one or more communication connections (for the WDP infrastructure **84**), which span across the WDP joint **110**.

[0034] As a more specific example, FIG. **2** depicts communication connectors **112** and **114**, which connect respective communication line segments in the jointed tubing sections **60***a* and **60***b* together. For this example, the communication connectors **112** and **114** are arranged to establish a communication connection that spans between the surfaces **127** and **167**. The communication connector **112** is disposed in a pocket **111** of the pin end connector **120** near the bottom end of the connector **120** and is generally oriented to form a connection at the outer surface **127**. The communication connector **114** is disposed in a pocket **115** of the box end connector **160**, located near the inner shoulder **166** and is oriented to form a connection at the surface **167**. Thus, when the WDP joint **110** is fully assembled, the communication connectors **112** and **114** are in proximity to each other, with the connector **114** being located radially outside of the connector **112**; and in these positions, the connectors **112** and **114** form a communication connection that spans across the WDP joint **110**.

[0035] As examples, the communication connectors **112** and **114** may be constructed to communicate any of a number of different signals across the communication connection, such as electrical signals, optical signals and electromagnetic flux signals, as just a few examples. Thus, the connectors **112** and **114** may be, as examples, direct contact electrical connectors, inductive connectors, resistive couplers, toroid-type connectors, fiber optic connectors, etc. Additionally, the communication connection that is established by the connectors **112** and **114** may be a connection to communicate a data signal, a power signal and/or a control signal.

[0036] Although one pair of connectors **112** and **114** is depicted in FIG. **2**, it is understood that the WDP joint **110** may have additional sets of connector pairs for purposes of forming additional communication connections across the WDP joint **110**. Thus, many variations are contemplated and are within the scope of the appended claims.

[0037] As depicted in FIG. **2**, the communication connectors **112** and **114** may be connected to communication line segments **85***a* and **85***b* (specific examples of the communication line segments **85**), respectively, of the WDP infrastructure **84**. For this example, the communication line segments **85***a* and **85***b* are electrical wire segments, where each segment **85***a*, **85***b* is formed from an inner conductor **86** that is surrounded by an outer insulative, or dielectric, layer **87**. However, it is understood that the communication line segments **85** of the WDP infrastructure **84** may be formed from other types of communication lines, such as fiber optic segments, in accordance with other examples. Thus, many variations are contemplated and are within the scope of the appended claims.

[0038] The communication line segment **85***a* extends longitudinally upwardly from the communication connector **112** and is routed through a longitudinal passageway **128** that is formed in the pin end connector **120**. For this example, the passageway **128** is located near the pin end connector's inner cylindrical surface **102** that forms part of the central passageway section **101** of the drill pipe **30**. However, the passageway **128** may be located closer to an outer surface **103** of the pin end connector **120**, as another example. As examples, the passageway **128** may be formed by gun drilling, drilling, electrical discharge machining (EDM) or any other material removal process that forms a hole, whether the cross-section of the hole is round or otherwise. As another example, the passageway **128** may be formed using plunge EDM and cut into almost any shape desired for the cross-section of the passageway **128**. The cross-section may be, as examples, round or as another example, oval to reduce stress concentrations.

[0039] The box end connector **160** includes a longitudinal passageway **168** through which the communication line segment **85***b* is run to form a connection to the communication connector **114**. The passageway **168** may be formed by any of the techniques described above and may have one of a variety of different cross-sectional shapes. As shown, the passageway **168** generally extends downhole from the communication connector **114** and may (as an example) be close to the box end connector's **160** inner surface **161** that forms part of the central passageway section **101** of the drill pipe **30**.

[0040] As an example, the connectors **112** and **114** may be relatively shallow and long. The connectors **112** and **114** may be "snap and groove" connectors, in that one of the connectors **112** and **114** snaps into a groove of the other connector **112**, **114**. As another example, the connectors **112** and **114** may be designed so that one connector **112**, **114** forms a groove into which the other connector **112**, **114** slides into. As an example, protective caps may be used to protect the connectors **112** and **114** during stabbing of the pin end connector **120** into the box end connector **160**. It is noted that the positioning of the communication connectors **112** and **114** permits re-cuts while maintaining the connection-to-assembly-to-hole alignment.

[0041] Referring to FIG. **3**, as another example, the WDP joint **110** may be replaced with a WDP joint **200**. Although FIG. **3**, along with FIGS. **4**, **7** and **8**, depicts only the right hand portion (and not the left hand portion) of a WDP joint, it is understood that the pin end **120** and box end **160** connectors of each WDP joint is generally symmetrical about the longitudinal axis **100** and thus, the cross-section may be assumed to include the omitted left hand cross-sectional portion. Features of the WDP joint **200** that are similar to the WDP joint **110** are denoted by similar reference numerals.

[0042] The WDP joint **200** includes communication connectors **201** and **202** that are disposed in pockets **203** (in the pin end connector **120**) and **204** (in the box end connector **160**), respectively. In general, the communication connectors **201** and **202** may be connectors similar to any of the examples given above for the communication connectors **112** and **114**. The pocket **203** is formed in a corner **121** that is defined by the external shoulder **122** of the pin end connector **120**. Thus, for this arrangement, a portion of the corner **121** is removed, or hollowed out, to form the pocket **203**. The connector **201** has a shape that preserves the corner **121** so that when the WDP joint **200** is fully assembled, the connector **202** (which is located in the upper end of the box end connector **160**) fits against a portion **205** of the corner **201** that is formed by the connector **201**, as shown in FIG. **3**.

[0043] As also depicted in FIG. **3**, respective communication segments **85*a*** and **85*b*** (wire segments for this example) extend away from the connectors **201** and **202**, respectively. Because the communication line segment **85*b*** is located near an outer surface **165** of the box end connector **160**, however, (as depicted in FIG. **3**) at a point **211**, the communication line segment **85** begins extending-inwardly toward the inside of the box end connector **160**. For purposes of machining the corresponding passageway **168** to have this inclined characteristic, an external access port **213** may be created near the point, and the port **213** may be plugged via a plug **210** after the installation of the communication line segment **85*b*** in the passageway **168**.

[0044] A particular advantage of the WDP joint **200** is that the communication connector **201** is protected from being damaged during handling and mating of the pin end **120** and box end **160** connectors. Also, the connectors **201** and **202** are relatively easily accessed.

[0045] Referring to FIG. **4**, as another example, a WDP joint **220** (a right hand portion of which is depicted in FIG. **4**) may be used in place of the other WDP joints that are described herein. The WDP joint **220** has similar features to the WDP joints **110** and **200**, with like reference numerals being used to denote similar components. Furthermore, communication connectors **224** and **226** may, in general, have designs similar to any of the examples given above for the communication connectors **112** and **114**. Unlike the WDP joints **110** and **200**, the communication connectors **224** and **226** form a communication connection that spans across the threaded region of the joint **220**. Thus, as depicted in FIG. **4**, the communication connector **226** is located in the threaded region of the pin end connector **120** and is oriented to form a connection at the external thread **124**; and the communication connector **224** is located radially outside of the connector **226** in the threaded region of the box end connector **160** and is oriented to form the communication at the internal thread **164**.

[0046] As examples, the communication connectors **224** and **226** may form the communication connection that spans between the flanks of two engaging threads or may form the communication connection that spans between the root and crest of two engaging threads. More specifically, FIG. **5** depicts a non-limiting example in which the communication connectors **224** and **226** are electrical, direct contact-type connectors. For this example, the communication connector **224** includes an electrically conductive material **230** that is exposed on a flank **240** of the thread **164** and is disposed in an electrically insulative, or dielectric, well **232** of the connector **224**.

[0047] When the WDP joint **220** (see also FIG. **4**) is assembled, the electrically conductive material **230** of the communication connector **224** contacts an electrically conductive material **234** of the communication connector **226**. Similar to the communication connector **224**, electrically conductive material **234** of the connector **226** resides inside a dielectric well **236** of the connector **226**. For purposes of making the contact, the electrically conductive material **234** is exposed on a flank **242** of the thread **124** of the pin end connector **120**.

[0048] As an alternative, the above-described direct contact communication connectors may be used to establish a communication connection that spans between the root and crest of two engaging threads. Referring to FIG. **6**, as an example, the communication connector **224** may be situated in the thread **164** such that the electrically conductive material **230** is exposed at a crest **246** of the thread **164**; and the communication connector **226** may be situated such that the electrically conductive material **234** is exposed at a root **244** of the thread **124** for purposes of establishing connection between the electrically conductive regions **224** and **236** when the WDP joint **220** is assembled.

[0049] It is noted that for purposes of FIGS. **5** and **6**, the disclosure of a direct contact-type connector is merely provided as an example of one out of many possible types of connectors that may be used. Other variations are contemplated (such as fiber optic or inductive coupling-based connectors, as non-limiting examples) and are within the scope of the appended claims.

[0050] Referring back to FIG. **4**, a particular advantage of placing a connection in the threaded region of the WDP joint **220**, such as the middle of the threaded region (as the example depicted in FIG. **4**) is generally that the stress levels in the middle of the threaded region, is generally lower than at the ends, i.e., the stress may be higher at the last engaged threads (LETs). It is noted that the connectors **224** and **226** may alternatively be disposed in the upper or lower portions of the threaded region.

[0051] Although the communication connectors **224** and **226** may be, in general, located in the threaded region of the pin end **120** and box end **160** connectors for purposes of forming a communication connection in the region, the communication connectors **224** and **226** may create a communication connection that does not directly span between two threads. For example, FIG. **7** depicts a WDP joint **250** (the right hand side of the joint being depicted in FIG. **7**) that is similar in design to the WDP joint **220** (see FIG. **4**), with similar reference numerals being used to denote similar components. However, unlike the WDP joint **220**, the threaded region between the pin end **120** and box end **160** connectors is not formed from a contiguous region of engaged threads.

[0052] Instead, the threaded region between the pin end **120** and box end **160** connectors includes, near its upper end, a first threaded region in which an interior thread **253** of the pin end connector **120** engages a corresponding exterior thread **251** of the box end connector **160**. Near the lower end of the WDP joint **250**, the threaded region includes an internal tapered thread **257** of the box end connector **160**, which engages a corresponding external thread **255** of the pin end connector **120**.

[0053] The threaded region also includes an intervening non-threaded region. In particular, the pin end connector **120** includes a relatively smooth and tapered external surface **263** that extends between the upper external thread **251** and the lower external thread **255**. Similarly, the box end connector **160** includes a mating relatively smooth and tapered internal surface **263** that extends between the upper **253** and lower **257** internal threads of the connector **160**. In general, when the WDP joint **250** is fully assembled, the surfaces **261** and **263** are opposed to and in close proximity to each other. As depicted in FIG. **7**, the communication connectors **224** and **226** are disposed in pockets **271** (in the box end connector **160**) and **273** (in the pin end connector **120**), respectively. The communication connectors **224** and **226** are oriented to form a communication connection that spans across the surfaces **261** and **263**.

[0054] Other variations are contemplated and are within the scope of the appended claims. For example, FIG. **8** depicts a WDP joint **300** that is a variation of the WDP joint **200** of FIG. **3**. Similar reference numerals are used to denote similar components. Furthermore, communication connectors **314** and **327** may, in general, have designs similar to any of the connector examples that are delivered herein. Instead of establishing the communication connection at the corner **121** (as depicted in FIG. **3**) that is defined by the external shoulder **122**, a communication connection may be established at a corner **320** that is defined by the internal shoulder **166**. In the WDP joint **300**, a pocket **325** is formed in the corner **320** to accept the communication connector **314**, which is shaped to preserve the corner **320**. A corresponding communication connector **310** is disposed in a pocket **327** of the pin end connector **120** and is located near its lower end such that when the WDP joint **300** is fully assembled, the communication connector **310** resides in the corner created by the communication connector **314**, as depicted in FIG. **8**.

[0055] While the present invention has been described with respect to a limited number of embodiments, those skilled in the art, having the benefit of this disclosure, will appreciate numerous modifications and variations therefrom. It is intended that the appended claims cover all such modifications and variations as fall within the true spirit and scope of this present invention.

What is claimed is:

1. A drill pipe comprising:

a pin end connector comprising a first region to form a threaded connection to join sections of the drill pipe together, the first region comprising at least one thread that begins at one end of the first region and ends at the other end of first region;

a box end connector to receive the pin end connector, the box end connector comprising a second region to mate with the first region to form the threaded connection;

a first communication connector attached to the pin end connector and located in the first region; and

a second communication connector attached to the box end connector and located in the second region to form a communication connection with the first communication connector.

2. The drill pipe of claim **1**, wherein the first communication connector is adapted to form the communication connection at a thread of the first region.

3. The drill pipe of claim **2**, wherein the first communication connector is adapted to form the communication connection at a thread flank of said thread of the first region.

4. The drill pipe of claim **2**, wherein the first communication connector is adapted to form the communication connection at a crest or root of said thread of the first region.

5. The drill pipe of claim **1**, wherein the first communication connector is adapted to form the communication connection at one of a crest and root of said thread of the first region, and the second communication connector is adapted to form the communication connection at the other of said crest and root of a thread of the second region.

6. The drill pipe of claim **1**, wherein the first region comprises a non-threaded region between two threads, and the first and second communication connectors are adapted to form the communication connection at said non-threaded region.

7. The drill pipe of claim **1**, wherein the first and second communication connectors comprise direct contact connectors, inductive connectors, resistive couplers, toroid-type connectors, or fiber optic connectors.

8. A drill pipe comprising:

a pin end connector;

a box end connector to receive the pin end connector;

a first communication connector; and

a second communication connector,

wherein one of the pin end connector and the box end connector includes a shoulder that defines a corner and is located near an end of the other of the pin end connector and the box end connector, when the box end connector receives the pin end connector and one of the first communication connector and the second communication connector is located in a pocket that is formed in the corner.

9. The drill pipe of claim **8**, wherein the corner comprises a corner formed in an external shoulder of the pin end connector.

10. The drill pipe of claim **8**, wherein the corner comprises a corner formed in an internal shoulder of the box end connector.

11. The drill pipe of claim **8**, wherein the first and second communication connectors are adapted to communicate a data signal, a power signal or a control signal.

12. The drill pipe of claim **8**, wherein the first and second communication connectors comprise direct contact connectors, inductive connectors, resistive couplers, toroid-type connectors, or fiber optic connectors.

13. A drill pipe comprising:

a pin end connector comprising an end;

a box end connector to receive the pin end connector, the box end connector comprising an inner shoulder to be in

close proximity to the end of the pin end connector when the box end connector receives the pin end connector;
a first communication connector attached to the pin end connector near the end of the pin end connector; and
a second communication connector attached to the box end connector near the inner shoulder of the box end connector and is located radially outside of the first communication connector to form a communication connection with the first communication connector.

14. The drill pipe of claim **13**, wherein the first and second communication connectors comprise direct contact connectors, inductive connectors, resistive couplers, toroid-type connectors, or fiber optic connectors.

15. The drill pipe of claim **13**, wherein the first and second communication connectors are adapted to communicate a data signal, a power signal or a control signal.

16. A method comprising:
connecting drill pipe sections together, comprising threadably engaging a first region of a pin end connector with a second region of a box end connector; and
communicating a signal through a communication connection that spans between the first and second regions.

17. The method of claim **16**, wherein the communicating comprises communicating across a thread of the first region.

18. The method of claim **17**, wherein the communicating comprises communicating across a thread flank of said thread of the first region.

19. The method of claim **17**, wherein the communicating comprises communicating across a crest or root of said thread of the first region.

20. The method of claim **17**, wherein the communicating comprises communicating, across a non-threaded region between two threads of the first region.

21. A method comprising:
connecting drill pipe sections together, comprising engaging a pin end connector with a box end connector, the pin end connector comprising an end and the box end connector comprising an inner shoulder; and
communicating a signal through a communication connection between a first region of the pin end connector located near the end of the pin end connector and a second region of the box end connector located near the inner shoulder of the box end connector and radially outside of the first region.

22. The method of claim **21**, wherein the act of communicating comprises communicating an electrical signal, an inductive flux signal, a resistive signal or a fiber optic signal.

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