

# Contents

## Preface ix

## Chapter 1. Origin, Development, and Jurisdiction of the ASME Code 1

|                                                             |    |
|-------------------------------------------------------------|----|
| History of the ASME Code                                    | 1  |
| Additions to the Code                                       | 3  |
| ASME Boiler and Pressure Vessel Committee                   | 4  |
| Procedure for Obtaining the Code Symbol and Certificate     | 5  |
| The National Board of Boiler and Pressure Vessel Inspectors | 6  |
| Shop Reviews by the National Board                          | 7  |
| National Board Requirements                                 | 8  |
| Code Case Interpretations                                   | 9  |
| The Uniform Boiler and Pressure Vessel Laws Society         | 10 |
| Canadian Pressure Vessel Requirements                       | 10 |
| Department of Transportation Regulations                    | 16 |
| Welded Repair or Alteration Procedure                       | 17 |
| Managerial Factors in Handling Code Work                    | 20 |
| Work-Flow Schedules                                         | 24 |
| Mill Orders                                                 | 25 |
| Warehouse Orders                                            | 25 |
| Shop Organization                                           | 26 |

## Chapter 2. Descriptive Guide to the ASME Code Section VIII, Division 1, Pressure Vessels 27

|                                                                                                            |    |
|------------------------------------------------------------------------------------------------------------|----|
| Requirements for Establishing Design Thickness Based on Degree of Radiography (Code Pars. UW-11 and UW-12) | 27 |
| Use of Internal-Pressure Cylindrical Shell Thickness Tables                                                | 38 |
| Use of Simplified External-Pressure Cylindrical Shell Thickness Charts                                     | 47 |
| Use of Internal-Pressure-Thickness Tables for Ellipsoidal and Torispherical Heads                          | 53 |

|                                                                                                                                                      |                |
|------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|
| Elements of Joint Design for Heads                                                                                                                   | 67             |
| Use of Pressure–Thickness Charts for Flat Heads and Bolted Flat Cover Plates                                                                         | 69             |
| Various Other Designs for Heads                                                                                                                      | 70             |
| Allowable Pressure, Pitch, and Thickness                                                                                                             | 75             |
| Simplified Calculations for Reinforcement of Openings                                                                                                | 80             |
| Cryogenic and Low-Temperature Vessels                                                                                                                | 83             |
| Impact-Test Exemptions                                                                                                                               | 85             |
| Service Restrictions and Welded Joint Category                                                                                                       | 92             |
| Noncircular Cross-Section Type Pressure Vessels                                                                                                      | 94             |
| Jacketed Vessels                                                                                                                                     | 96             |
| Pressure Vessels Stamped with the UM Symbol                                                                                                          | 97             |
| Stamping Requirements                                                                                                                                | 98             |
| <br><b>Chapter 3. Design for Safety</b>                                                                                                              | <br><b>101</b> |
| Basic Causes of Pressure Vessel Accidents                                                                                                            | 101            |
| Corrosion Failures                                                                                                                                   | 101            |
| Stress Failures                                                                                                                                      | 101            |
| Other Failures                                                                                                                                       | 102            |
| Design Precautions                                                                                                                                   | 103            |
| Inspection Openings                                                                                                                                  | 106            |
| Quick-Opening Closures                                                                                                                               | 107            |
| Pressure Relief Devices                                                                                                                              | 109            |
| <br><b>Chapter 4. Guide to Quality Control Systems for ASME Code Vessels: A Practical Guide to Writing and Implementing a Quality Control Manual</b> | <br><b>113</b> |
| <br><b>Chapter 5. Inspection and Quality Control of ASME Code Vessels</b>                                                                            | <br><b>139</b> |
| Shop Inspection                                                                                                                                      | 139            |
| Tests                                                                                                                                                | 142            |
| ASME Manufacturer's Data Reports                                                                                                                     | 146            |
| Field Assembly Inspection                                                                                                                            | 147            |
| Responsibility for Field Assembly                                                                                                                    | 147            |
| Inspection Procedure                                                                                                                                 | 148            |
| Radiography                                                                                                                                          | 149            |
| Conditions Requiring Radiography                                                                                                                     | 149            |
| Interpretation of Welding Radiographs                                                                                                                | 151            |
| Sectioning                                                                                                                                           | 157            |
| Hydrostatic Testing                                                                                                                                  | 159            |
| Test Gage Requirements                                                                                                                               | 161            |
| Seven Simplified Steps to Efficient Weld Inspection                                                                                                  | 161            |
| <br><b>Chapter 6. Welding, Welding Procedure, and Operator Qualification</b>                                                                         | <br><b>165</b> |
| Examination of Procedure and Operator                                                                                                                | 165            |

|                                                                                            |         |
|--------------------------------------------------------------------------------------------|---------|
| Record of Qualifications                                                                   | 166     |
| Welding Procedures and Qualification Simplified                                            | 166     |
| Welding Procedure Specification Forms                                                      | 168     |
| Variables [Code Pars. QW-400, QW-250, and QW-350 and Tables QW-415 (WPS) and QW-416 (WPQ)] | 170     |
| Welder Qualifications                                                                      | 173     |
| Welding Details and Symbols                                                                | 180     |
| Joint Preparation and Fit-Up                                                               | 185     |
| Effects of Welding Heat                                                                    | 187     |
| Preheating                                                                                 | 192     |
| Postweld Heat Treatment                                                                    | 193     |
| Conditions Requiring Postweld Heat Treatment                                               | 194     |
| <br>Chapter 7. Nondestructive Examination                                                  | <br>197 |
| Leak Testing                                                                               | 206     |
| Acoustic Emission Testing                                                                  | 207     |
| <br>Chapter 8. ASME Code Section VIII, Division 2, Alternative Rules                       | <br>209 |
| <br>Chapter 9. Power Boilers: Guide to the ASME Code Section I, Power Boilers              | <br>215 |
| <br>Chapter 10. Nuclear Vessels and Required Quality Assurance Systems                     | <br>223 |
| Power Plant Cycles                                                                         | 223     |
| Pressurized Water Reactor Plants                                                           | 224     |
| Boiling Water Reactor Plants                                                               | 225     |
| Quality Assurance                                                                          | 229     |
| <br>Chapter 11. Department of Transportation Requirements for Cargo Tanks                  | <br>239 |
| History and Overview of 49 CFR§107 to §180                                                 | 239     |
| Specification Cargo Tanks—General Design Information (§178.340)                            | 240     |
| Specification Cargo Tank MC-306 (§178.341)                                                 | 241     |
| Specification Cargo Tank MC-307 (§178.342)                                                 | 243     |
| Specification Cargo Tank MC-312 (§178.343)                                                 | 244     |
| Specification Cargo Tank MC-331 (§178.337)                                                 | 246     |
| Certification of Cargo Tanks (§178.340-10)                                                 | 249     |
| Maintenance of Specification Cargo Tanks—General Information (§180)                        | 252     |
| Glossary of Terms                                                                          | 253     |
| Qualification and Maintenance of Specification Cargo Tanks §180 to §180.417)               | 255     |
| Purpose, Applicability, and General Requirements (§180.1 to §180.3)                        | 255     |
| Definitions (§180.403)                                                                     | 255     |
| Qualification of Cargo Tanks (§180.405)                                                    | 256     |

|                                                                                              |            |
|----------------------------------------------------------------------------------------------|------------|
| Upgrading Existing Specification MC-306, MC-307, and MC-312 Cargo Tanks [§180.405(c) to (g)] | 257        |
| Requirements for Tests and Inspections of Specification Cargo Tanks (§180.407)               | 258        |
| Minimum Qualifications for Inspectors and Testers (§180.409)                                 | 267        |
| Acceptable Results of Tests and Inspections (§180.411)                                       | 269        |
| Repair, Modification, Stretching, or Rebarreling of a Cargo Tank (§180.413)                  | 270        |
| Test and Inspection Markings (§180.415)                                                      | 271        |
| Reporting and Record Retention Requirements (§180.417)                                       | 273        |
| <b>Chapter 12. ISO 9000 Quality Assurance Systems</b>                                        | <b>275</b> |
| Introduction to ISO 9000 Standards                                                           | 275        |
| Assessment of the Quality Assurance Program                                                  | 278        |
| Notified Bodies and the CE Mark                                                              | 281        |
| <b>Appendix A. Cylinder Volume Tables and Diagrams</b>                                       | <b>283</b> |
| <b>Appendix B. Circumferences of Cylinders</b>                                               | <b>289</b> |
| <b>Appendix C. Decimal Equivalents and Theoretical Weights of Steel Plates</b>               | <b>301</b> |
| <b>Appendix D. Pipe Wall Thicknesses</b>                                                     | <b>303</b> |
| <b>Appendix E. Dry Saturated Steam Temperatures</b>                                          | <b>305</b> |
| <b>Appendix F. Metric (SI) Units; English and Metric Conversions</b>                         | <b>309</b> |
| <b>Bibliography</b>                                                                          | <b>315</b> |
| <b>Index</b>                                                                                 | <b>317</b> |