

API Ballot Comments Sheet

9/4/2007

Ballot: 138-07-650-642 APP S Fillet Weld Size

Start Date: 7/19/07

Closing Date: 8/30/07

AMS Ballot ID: 1,191

Associate: Gordon Robertson

Coordinator: Gordon Robertson

Proposal:

159879 Esma Aldahir

Lyondell Chemical Company

Specification Section

Type

Comment

Suggested Change

Technical

The fillet weld size ranges given in API 650 11th Ed Section 5.1.5.7 is adequate, this ballot does not provide sufficient technical justification for change. Distortion can be controlled by design and welding processes. Some practical ways to control distortion includes but is not limited to the use of fewer weld passes, use of a well-planned welding sequence, use of clamps and jigs, removing shrinkage forces after welding via peening or stress relieving, and minimizing welding time.

131185 Douglas Miller

Chicago Bridge & Iron Company(CB&I)

Specification Section

Type

Comment

Suggested Change

Technical

I agree with item. Parallel change should be done in 620-S.

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134314 Tearle Taylor

Flint Hills Resources

Specification Section

Type

Comment

Suggested Change

The table of the revision

Editorial

The table is based on millimeters and decimal (in inches) on shell plate nominal thickness but on the minimum size of the fillet weld it is base on millimeter and fractions (in inches). Stay consistent on the measurements

Change the minimum size of fillet weld to the decimal (in inches) .

Nominal Thickness of Shell Plate		Minimum Size of Fillet Weld	
(mm)	(in.)	(mm)	(in.)
5	0.1875	5	0.187
> 5 to 25	> 0.1875 to 1.0	6	0.25
> 25 to 45	> 1.0 to 1.75	8	0.3125

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