

API Ballot Comments Sheet

9/4/2007

Ballot: 131-07-653-212 New Bottom Through Existing Low Type Nozzle

Start Date: 9/4/07 **Reinforcing Plate Alternate Detail** **Close Date: 9/30/07**

AMS Ballot ID: 1,184

Associate: Gordon Robertson

Coordinator: Gordon Robertson

Proposal:

API Ballot Comments Sheet

9/4/2007

134629 Nelson Acosta

HMT Inspection

<u>Specification Section</u>	<u>Type</u>	<u>Comment</u>	<u>Suggested Change</u>
Para. 9.9.4.c	Editorial	The wording in the second sentence should be modified to delete "and tell tale" and include "with telltale". Also, in the third sentence, the term "bottom to shell" should be hyphenated.	9.9.4.cThe removed (or new) reinforcing plate shall be prepared for a full fusion splice weld with telltale hole added (see Fig. 9-5C). The removed (or new) reinforcing plate is re-installed after the bottom-to-shell weld has been completed, inspected and tested.....
Fig. 9-5C	Editorial	Change "tell tale" to "telltale" and replace "removed" with "re-installed" in lower portion of reinforcing plate.	Telltale
Fig. 9-5C, Note 1	Technical	Fig. 3-6 is being revised (ref. Agenda Item 650-552). Note 1 refers the user to that figure in API 650 for weld spacing requirements. Dimensions H and J as shown are essentially minimum weld spacings. Without further guidance regarding use of Fig. 3-6 from API 650, I am concerned about the user not having enough information to correctly interpret what the actual required minimum weld spacing is for a modified low-type reinforcing plate. I feel this item needs to be further coordinated with Fig. 3-6 (as revised) and Fig. 3-22 to make sure there are no conflicts in the minimum required weld spacing.	Re-installed Existing or New Reinforcing Plate
Fig. 9-5C	Technical	The title of this figure is "Details for Installing a New Bottom Through an Existing Tombstone Reinforcing Plate" yet the figure actually shows a new bottom plate or annular plate UNDER a tombstone detail (as do Figs. 9-5A / B). It would be helpful and clearer to all users to show a raised second bottom detail here (with the old and new bottom both shown in all details) so that we are correctly showing what we intend to deal with in modifying an existing tombstone reinforcing plate.	

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159879 Esmā Aldahir

Lyondell Chemical Company

Specification Section

Type

Comment

Suggested Change

Editorial

API 650 section references in this ballot are from the 10 Edition, as I am sure all are aware

Revise API 650 references to include appropriate Edition (e.g. from “New fillet weld sizes per API 650 3.1.5.7” to “New fillet weld sizes per API 650 10th Ed 3.1.5.7”) or revise to reflection appropriate section in API 650 11th Edition (e.g. from “New fillet weld sizes per API 650 3.1.5.7” to “New fillet weld sizes per 5.1.5.7 ”)

73074 Ronald Bailey

American Tank & Vessel, Inc.

Specification Section

Type

Comment

Suggested Change

Technical

I BELIEVE THAT IN CASES NO 2 AND 3 DIMENSIONS "J" AND "H" SHOULD BE TWICE WHAT IS SHOWN IN FIGUER 9-5C. IN DOING SO WE WOULD PARALLEL THE EXISTING WORDING OF PAR. 5.7.3.1. CONSIDERING THE BUTTWELD IN THE REPAD AS HAVING THE SAME IMPORTANCE AS A SHELL BUTTWELD. ALSO, WE SHOULD ADD A CORRESPONDING DETAIL OF THIS CONFIGURATION TO FIGURE 5-6.

157328 Doug Bayles

Inserv Integrated Service Company LLC

Specification Section

Type

Comment

Suggested Change

Figure 9-5C

Technical

A note should be added for testing of the full penetration weld of the existing reinforcing plate to the removed existing or new reinforcing plate.

Also, note 3. should be changed to reflect API 11th edition section 7.2.4.

On figure under full penetratiion weld (See note 4)

Note 4 - Root pass of full penetration weld shall be tested by MT or PT. Final pass shall be tested by MT or PT, and UT.

133403 Jeffrey DeArmond

BP p.l.c. Whiting Refinery

Specification Section

Type

Comment

Suggested Change

Table beneath Figure 9-5C

Editorial

Should define tw in column J of table.

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135965 Kenneth Erdmann

Matrix Service Company

Specification Section

Type

Comment

Suggested Change

Technical I do not agree with a seam below the opening in the highest stress location. The weld spacing alone is not enough.

I suggest some back up calcs for stress levels and also some extra NDE.

93133 Randy Kissell

TGB Partnership

Specification Section

Type

Comment

Suggested Change

9.9.4c

Editorial The wording of the 3rd sentence isn't expressed in mandatory language.

Change "The removed (or new) reinforcing plate is re-installed after the bottom to shell weld has been completed, inspected, and tested." to "The removed (or new) reinforcing plate shall be re-installed after the bottom to shell weld has been completed, inspected, and tested."

113545 James McBride

Petrex, Inc.

Specification Section

Type

Comment

Suggested Change

9.9.4.c

Technical It should be noted that when the reinforcing plate is replaced in more than one piece, then each piece needs to have a tell tale hole.

135169 Michael Richardson

International Paper, Georgetown Mill

Specification Section

Type

Comment

Suggested Change

Figure 9-5C

Technical Would it not be advisable to provide a tell-tale hole to both sections of the reinforcing plate above and below the full penetration weld for indication of a leak. This could be accomplished by drilling through the outer reinforcing plate to the interface.

Add an additional tell-tale hole above the full penetration weld.

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134314 Tearle Taylor

Flint Hills Resources

Specification Section

Type

Comment

Suggested Change

Para 9.94.c

Technical

The paragraph should include reinforcement that currently is not tombstoned and will not meet the spacing tolerances when the bottom is removed. This will save time and money in raising nozzles that meet the spacing requirements. This is more prevalent on older tanks built to early API 650 and API 12C. Numerous owner / operators and repair companies are performing this presently but there is no documentation in API 653.

Include the adding reinforcement that currently is not tombstoned and will not meet the spacing tolerances when the bottom is removed to this paragraph.

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