

API Ballot Summary Sheet

3/22/2005

Ballot: 14-05: 650-587, Joining Narrow Plates to Form Wide Ones

AMS ID: 616

Start Date: 1/24/05

Closing Date: 3/14/05

Associate: Roland Goodman

Coordinator: Valeen Young

Proposal:

<u>Voter</u>	<u>Company</u>	<u>Comments</u>	<u>Vote Results</u>			
			<u>Affirmative</u>	<u>Negative</u>	<u>Abstain</u>	<u>Did Not Vote</u>
134629	Nelson Acosta	HMT Inspection	Yes	X		
131617	Joel Andreani	Equity Engineering Group, Inc., The	No	X		
38921	Robert Annett	Alyeska Pipeline	No			X
73074	Ronald Bailey	American Tank & Vessel, Inc.	Yes		X	
136219	Mark Baker	Baker Consulting Group, Inc.	No	X		
142888	Chris Bashor	Minnesota Pollution Control Agency	No	X		
134681	Ernie Blanchard	IMC-Phosphates	No	X		
109375	Jerry Boldra		No			X
22200	Dan Boley	DJA Inspection Services	No	X		
134782	Steve Caruthers	Tank Consultants, Inc.	No	X		
7127	Earl Crochet	Kinder Morgan	No	X		
142685	Domingo de Para	ExxonMobil	No	X		
133403	Jeffrey DeArmond	BP p.l.c. Whiting Refinery	Yes		X	
146748	Terry Delong	Terasen Pipelines (USA) Inc.	No			X
135965	Kenneth Erdmann	Matrix Service Company	No	X		
105011	David Flight	Dow Chemical Company	No			X
134870	Laurence Foster	Marathon Ashland Petroleum LLC	Yes	X		
134880	John Fumbanks	Pond and Company Inc.	No			X
115033	Alan Geis	Colonial Pipeline Company	No	X		
83689	Ty Hagen	Hagen Engineering International, Inc.	Yes		X	
136619	Robert Hendrix	Voridian Engineering & Construction	Yes		X	
70596	Marty Herlevic	James Machine Works, Inc.	No	X		
93133	Randy Kissell	TGB Partnership	No	X		
81918	Manfred Lengsfeld		No			X
135014	John Lieb	Tank Industry Consultants, Inc.	No	X		
136274	Thomas Lorentz	AEC Engineering, Inc.	No	X		
135072	Francis Maitland	Quense LLC	No	X		

API Ballot Summary Sheet

3/22/2005

Ballot: 14-05: 650-587, Joining Narrow Plates to Form Wide Ones

AMS ID: 616

Start Date: 1/24/05

Closing Date: 3/14/05

Associate: Roland Goodman

Coordinator: Valeen Young

Proposal:

78399	David Martin	Conservatek Industries, Inc.	No	X		
113545	James McBride	Petrex, Inc.	No	X		
139045	Craig Meier	ConocoPhillips	No			X
137255	Carl Mikkola	Enbridge Energy Partners. L.P.	No	X		
131185	Douglas Miller	Chicago Bridge & Iron Company(CB&I)	Yes	X		
69609	Bhana Mistry	TIW Steel Platework	No	X		
83736	John Mooney		No	X		
92212	George Morovich	TEMCOR	No	X		
136286	Philip Myers	ChevronTexaco Corporation	Yes		X	
132210	David Nasab	Kellogg Brown & Root	No			X
82544	John Oleyar	HMT, Inc.	No	X		
5193	Richard Pinegar	Cargill Inc.	No	X		
102412	Roy Ralph	Petro-Canada	No			X
135169	Michael Richardson	International Paper	Yes		X	
73744	Bruce Roberts		Yes		X	
101360	Marilyn Shores	Sunoco Logistics	Yes		X	
126019	Larry Speaks	Mass Technology Corporation	No	X		
134314	Tearle Taylor	Flint Hills Resources	No	X		
134325	Donald Thain	Shell Global Solutions (US) Inc.	No			X
145034	Leith Watkins	Explorer Pipeline Company	No	X		
145896	Alan Watson	A.R. Watson, USA	No	X		
132209	Richard Whipple	Fluor, Inc.	No			X

API Ballot Summary Sheet

3/22/2005

Ballot: 14-05: 650-587, Joining Narrow Plates to Form Wide Ones

AMS ID: 616

Start Date: 1/24/05

Closing Date: 3/14/05

Associate: Roland Goodman

Coordinator: Valeen Young

Proposal:

	<u>Affirmative</u>	<u>Negative</u>	<u>Abstain</u>	<u>Did Not Vote</u>
Balloting Totals:	30	8	1	10

Total Responses:	39			
Total Ballots:	49			
Response Rate :	61%	Must be > 50%		
Approval Rate:	79%	Must be > 67%		
Consensus:	YES			

API Template for Ballot Comments and Resolution

Ballot ID: 616	Date: March 22, 2005	Document: Ballot 14-05: 650-587
----------------	----------------------	--

#	(1)	(2)	(3)	(4)	(5)	(6)	(7)
	Voter/ Commenter	Company	Section No. (e.g. 3.1)	Type of comment	Comment (justification for change)	Proposed Change	Comment Resolution
1	Bruce Roberts			Technical	In addition to the stated 24" minimum plate width, there should be a maximum plate width stated to prevent using this change to pre-assemble normal width plates. And there should be a prohibition on using this to weld more than 2 plates together on the ground.		
2	Ronald Bailey	American Tank & Vessel, Inc.		Technical	FIGURE S-4 SHOWS TWO VERTICAL SHELL JOINTS INTERSECTING ONE ANOTHER. THIS VIOLATES THE 5t RULE IN API-650.		
3	Philip Myers	ChevronTexaco Corporation		Technical	I do not believe the figure is necessary nor does it fit with the format of the standard. Words should be used to describe this relatively simple problem. Also, there are no tolerances listed for the as welded shell course material. I believe we need to add some dimensional tolerance limitations. With these changes I will change my vote as I agree with the concept.		
4	Douglas Miller	Chicago Bridge & Iron Company(CB&I)		Editorial	These new provisions don't have much to do with forming. They are mostly about the right way to weld shop subassemblies. Therefore, this probably does not belong in the forming section (S.4.4).	Put this in the welding section (S.4.11). Make it new section S.4.11.3.	
5	Marilyn Shores	Sunoco Logistics	Entire	Technical	I know some penny pinching companies may be looking for every way to save a buck, but I don't feel it is prudent to offer this option. This does not provide the 5t offset required on vertical welds and, with all this welding, is going to produce an "ugly" tank.		
6	Jeffrey DeArmond	BP p.l.c. Whiting Refinery	Figure S-4	Technical	The proposed plate configuration and subsequent vertical field weld in Figure S-4 does not meet the requirements of Para. 3.1.5.2 b., the intent of which is to prevent the "intersections" of four-plate corners.	Change the plate configuration in the Figure S-4 to meet Para. 3.1.5.2 b.	

NOTE Columns 1, 2, 4, 6 are compulsory.

API electronic balloting commenting template/version 2002-12

API Template for Ballot Comments and Resolution

Ballot ID: 616	Date: March 22, 2005	Document: Ballot 14-05: 650-587
----------------	----------------------	--

#	(1)	(2)	(3)	(4)	(5)	(6)	(7)
	Voter/ Commenter	Company	Section No. (e.g. 3.1)	Type of comment	Comment (justification for change)	Proposed Change	Comment Resolution
7	Douglas Miller	Chicago Bridge & Iron Company(CB&I)	Figure S-4	Technical	The proposed rules show only two plates subassembled together. But the text does not put any limit on how many plates can go into a single subassembly. This should be addressed clearly.		
8	Michael Richardson	International Paper	General	Technical	What additional NDE will be performed to ensure the soundness of the four corner junction? Will very four corner junction be tested (RT or UT)? Why can't the verticals be off-set and than the horizontal be welded?		
9	Douglas Miller	Chicago Bridge & Iron Company(CB&I)	S.3.1	Technical	S.3.1 permits use of 48" wide bottom plates. But Appendix S is silent on shell plate width. Therefore it seems that 72" is the minimum width as covered in 3.4.1. It seems very inconsistent now to allow horizontal seams every 24 inches when subassembly is involved. Tank appearance will be affected significantly.	Require purchaser approval to use raw plate widths less than 72"	
10	Larry Hiner	Chicago Bridge & Iron Company(CB&I)	S.4.4.6	Technical	S.4.4.6 Affirmative Comment - Shell plate widths do not need to go down to 24". Usually only one ring would require a width different than a 48" multiple and in these cases a wider make up plate could be used.	Remove "Not less than 24" in Figure S-4 and replace with "Purchaser approval req'd for < 48" wide."	
11	Larry Hiner	Chicago Bridge & Iron Company(CB&I)	S.4.4.6	Technical	S.4.4.6 Some provision should be made for RT of these 4 way joints.	At least 25% of vertical spot welds shall be made at shop horizontal weld to field vertical weld intersections.	
12	Ty Hagen	Hagen Engineering International, Inc.	S.4.4.6	Technical	Allow plates within 1/16" of each other in thickness to be shop welded and place a maximum thickness of 3/8".	Change second sentence to read: Plates welded together shall have thicknesses within 1/16" of each other with the maximum thickness being 3/8".	

NOTE Columns 1, 2, 4, 6 are compulsory.

API *electronic balloting commenting template/version 2002-12*

API Template for Ballot Comments and Resolution

Ballot ID: 616	Date: March 22, 2005	Document: Ballot 14-05: 650-587
----------------	----------------------	--

#	(1)	(2)	(3)	(4)	(5)	(6)	(7)
	Voter/ Commenter	Company	Section No. (e.g. 3.1)	Type of comment	Comment (justification for change)	Proposed Change	Comment Resolution
13	Nelson Acosta	HMT Inspection	S.4.4.6	Technical	If it is the intent to maintain API 650 weld spacing / shell geometry for App. S shell layouts, it is probably appropriate to add reference in this wording to Para. 3.1.5.2 in this revised item to prevent users from stacking shell plates all the way up with the now allowable 4-way intersections for building up wider plates per Fig. S-4. I will leave how to do that to the Item handler.		
14	Laurence Foster	Marathon Ashland Petroleum LLC	S.4.4.6	Technical	As written, the manufacturer can do this without agreement from the purchaser. The purchaser should have to approve this option.	With the approval of the purchaser, stainless steel plates may be ...	
15	Robert Hendrix	Voridian Engineering & Construction	S.4.4.6	Technical	For some products it is desirable to minimize the number of weld seams. The purchaser needs to be able to accept or reject such options. In times past, I have used such fabrications where semi-automatic machine welding procedures were used for the shop welds and the radiographic examination of these welds exceeded that of the field welds. This need not always be the case, but the purchaser should not be forced to accept the provisions of this proposal without the possibility of modification. Note that as cast, a joint efficiency of 0.7 would still require radiographic examination of the shop welds per Section 6. I'll not try to address this below.	Add to the first sentence: "...shell course when specified or accepted by the purchaser. Change the fourth sentence as follows: ".....shall be subjected to inspection requirements no less stringent than those contained in Section 6 and as agreed to between the purchaser and the manufacturer."	
16	Larry Hiner	Chicago Bridge & Iron Company(CB&I)	S.4.4.6	Editorial	S.4.4.6 Affirmative comments. Changes are being made on the presumption material prices for narrow plates will benefit the Purchaser. Provide a representative savings.		

NOTE Columns 1, 2, 4, 6 are compulsory.

API electronic balloting commenting template/version 2002-12