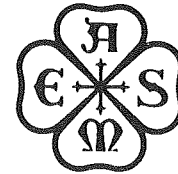


**ASME
BOILER AND
PRESSURE VESSEL
CODE**

**1980
EDITION**



**THE AMERICAN SOCIETY OF
MECHANICAL ENGINEERS**

SECTION

VIII

**AN AMERICAN
NATIONAL STANDARD**

**ANSI/ASME
BPV-VIII-1**

Division 1

Pressure Vessels

627P

ASME BOILER AND PRESSURE VESSEL CODE
AN AMERICAN NATIONAL STANDARD

ANSI/ASME BPV-VIII-1

SECTION VIII
Rules for Construction of
Pressure Vessels

Division 1

1980 EDITION

JULY 1, 1980



ASME BOILER AND PRESSURE VESSEL COMMITTEE
SUBCOMMITTEE ON PRESSURE VESSELS

THE AMERICAN SOCIETY OF MECHANICAL ENGINEERS
United Engineering Center 345 East 47th Street New York, N.Y. 10017

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1980 ASME BOILER AND PRESSURE VESSEL CODE

An American National Standard

Sections*

- I Power Boilers
- II Material Specifications
 - Part A — Ferrous Materials
 - Part B — Nonferrous Materials
 - Part C — Welding Rods, Electrodes and Filler Metals
- III Subsection NCA — General Requirements for Division 1 and Division 2
- III Division 1
 - Subsection NB — Class 1 Components
 - Subsection NC — Class 2 Components
 - Subsection ND — Class 3 Components
 - Subsection NE — Class MC Components
 - Subsection NF — Component Supports
 - Subsection NG — Core Support Structures
- III Appendices
- III Division 2 — Code for Concrete Reactor Vessels and Containments
- IV Heating Boilers
- V Nondestructive Examination
- VI Recommended Rules for Care and Operation of Heating Boilers
- VII Recommended Rules for Care of Power Boilers
- VIII Pressure Vessels
 - Division 1
 - Division 2 — Alternative Rules
- IX Welding and Brazing Qualifications
- X Fiberglass-Reinforced Plastic Pressure Vessels
- XI Rules for Inservice Inspection of Nuclear Power Plant Components — Division 1

*Available in bound and loose-leaf versions. Either version may be used for ASME Certification.

Code Cases

The Boiler and Pressure Vessel Committee meets regularly to consider proposed additions and revisions to the Code, and to formulate Cases to clarify the intent of existing requirements or provide, when the need is urgent, rules for materials or constructions not covered by existing Code rules. Those Cases which have been adopted appear in one or both of the 1980 Code Cases books—(1) Boilers and Pressure Vessels and (2) Nuclear Components. Supplements will be sent automatically to the purchasers of one or both of the Code Cases books up to the publication of the 1983 Edition.

Interpretations

Each issue of the Interpretations includes all of the written replies issued during successive 6-month intervals by the Secretarial Staff, speaking on behalf of the ASME Boiler and Pressure Vessel Committee, to inquiries concerning interpretations of technical aspects of the Code. The inquiries and replies are presented chronologically in groupings determined by the Code Sections to which they apply. Issues are published twice a year. Purchasers of the Interpretations will receive the six issues (Nos. 6-11) that will be published up to the publication of the 1983 Code.

Addenda

Colored-sheet Addenda, which include additions and revisions to individual Sections of the Code, are published twice a year and will be sent automatically to purchasers of the applicable Sections up to the publication of the 1983 Code. Purchasers of the bound versions of the Sections will receive bound Addenda. Purchasers of the loose-leaf versions of the Sections will receive replacement pages.

FOREWORD

The American Society of Mechanical Engineers set up a committee in 1911 for the purpose of formulating standard rules for the construction of steam boilers and other pressure vessels. This committee is now called the Boiler and Pressure Vessel Committee.

The Committee's function is to establish rules of safety governing the design, fabrication, and inspection during construction of boilers and pressure vessels, and to interpret these rules when questions arise regarding their intent. In formulating the rules, the Committee considers the needs of users, manufacturers, and inspectors of pressure vessels. The objective of the rules is to afford reasonably certain protection of life and property and to provide a margin for deterioration in service so as to give a reasonably long safe period of usefulness. Advancements in design and material and the evidence of experience have been recognized.

The Boiler and Pressure Vessel Committee deals with the care and inspection of boilers and pressure vessels in service only to the extent of providing suggested rules of good practice as an aid to owners and their inspectors.

The rules established by the Committee are not to be interpreted as approving, recommending, or endorsing any proprietary or specific design or as limiting in any way the manufacturer's freedom to choose any method of design or any form of construction that conforms to the Code rules.

The Boiler and Pressure Vessel Committee meets regularly to consider requests for interpretations and revisions of the rules, and to develop new rules as dictated by technological development. Inquiries must be addressed to the Secretary in writing and must give full particulars in order to receive consideration and a written interpretation. Proposed revisions to the Code resulting from inquiries will be presented to the Main Committee for appropriate action. The action of the Main Committee becomes effective only after confirmation by letter ballot of the Committee and approved by the Council of the Society.

Proposed revisions to the Code approved by the Committee are submitted to the American National

Standards Institute and published in *Mechanical Engineering* to invite comments from all interested persons. After the allotted time for public review and final approval by ASME Council, revisions are published semiannually in Addenda to the Code.

Code Cases may be used in the construction of components to be stamped with the ASME Code symbol beginning with the date of their approval by the ASME Council.

After Code revisions are approved by Council they may be used beginning with the date of issuance shown on the Addenda. Revisions become mandatory as minimum requirements six months after such date of issuance, except for boilers or pressure vessels contracted for prior to the end of the six-month period.

Manufacturers and users of components are cautioned against making use of revisions and Cases that are less restrictive than former requirements without having assurance that they have been accepted by the proper authorities in the jurisdiction where the component is to be installed.

Each state and municipality in the United States and each province in the Dominion of Canada that adopts or accepts one or more Sections of the Boiler and Pressure Vessel Code is invited to appoint a representative to act on the Conference Committee to the Boiler and Pressure Vessel Committee. Since the members of the Conference Committee are in active contact with the administration and enforcement of the rules, the requirements for inspection in this Code correspond with those in effect in their respective jurisdictions. The required qualifications for an Authorized Inspector or an Authorized Nuclear Inspector under these rules may be obtained from the administrative authority of any state, municipality, or province which has adopted these rules.

The Boiler and Pressure Vessel Committee in the formulation of its rules and in the establishment of maximum design and operating pressures considers materials, construction, methods of fabrication, inspection, and safety devices. Permission may be granted to regulatory bodies and organizations pub-

lishing safety standards to use a complete Section of the Code by reference. If usage of a Section, such as Section IX, involves exceptions, omissions, or changes in provisions, the intent of the Code might not be attained.

Where a state or other regulatory body, in the printing of any Section of the Boiler and Pressure Vessel Code, makes additions or omissions, it is recommended that such changes be clearly indicated.

The National Board of Boiler and Pressure Vessel Inspectors is composed of chief inspectors of states and municipalities in the United States and of provinces in the Dominion of Canada that have adopted the Boiler and Pressure Vessel Code. This Board, since its organization in 1919, has functioned to uniformly administer and enforce the rules of the Boiler and Pressure Vessel Code. The cooperation of that organization with the Boiler and Pressure Vessel Committee has been extremely helpful. Its function is clearly recognized and, as a result, inquiries received which bear on the administration or application of the rules are referred directly to the National Board. Such handling of this type of inquiry not only simplifies the work of the Boiler and Pressure Vessel Committee, but action on the problem for the inquirer is thereby expedited. Where an inquiry is neither clearly an interpretation of the rules nor a problem of application or administration, it may be considered both by the Boiler and Pressure Vessel Committee and the National Board.

It should be pointed out that the state or municipality where the Boiler and Pressure Vessel Code has been made effective has definite jurisdiction over any particular installation. Inquiries dealing with problems of local character should be directed to the proper authority of such state or municipality. Such authority may, if there is any question or doubt as to the proper interpretation, refer the question to the Boiler and Pressure Vessel Committee.

The Specifications for base materials given in Section II, Parts A and B, are identical with or similar to those of The American Society for Testing and Materials. The Specifications for welding materials given in Section II, Part C, are identical with or similar to those of the American Welding Society. Use of the materials described in these Specifications is covered by the rules in one or more Sections of the Boiler and Pressure Vessel Code. All materials allowed by these various Sections and used for construction within the scope of their rules shall be furnished in accordance with ASME Material Specifications contained in Section II except where otherwise provided in Code Cases or in the applicable Section of the Code. Materials covered by these Specifications are acceptable for use in items covered by the Code Sections only to the degree indicated in the applicable Section. Materials for Code use should preferably be ordered, produced, and documented on this basis; however, material produced under an ASTM Specification may be used in lieu of the corresponding ASME Specification, provided that the requirements of the ASTM Specification are identical (excluding editorial differences) or more stringent than the ASME Specification for the Grade, Class, or Type produced and provided that the material is confirmed as complying with the ASTM Specification. Material produced to an ASTM specification with requirements different from the requirements of the corresponding ASME Specification may also be used in accordance with the above, provided the material manufacturer or vessel manufacturer certifies with evidence acceptable to the Authorized Inspector or Authorized Nuclear Inspector that the corresponding ASME Specification requirements have been met. Material produced to an ASME or ASTM Material Specification is not limited as to country of origin.

STATEMENT OF POLICY ON THE USE OF CODE SYMBOLS AND CODE AUTHORIZATION IN ADVERTISING

ASME has established procedures to authorize qualified organizations to perform various activities in accordance with the requirements of the ASME Boiler and Pressure Vessel Code. It is the aim of the Society to provide recognition of organizations so authorized. An organization holding authorization to perform various activities in accordance with the requirements of the Code may state this capability in its advertising literature.

Organizations that are authorized to use Code Symbols for marking items or constructions which have been constructed and inspected in compliance with the ASME Boiler and Pressure Vessel Code are issued Certificates of Authorization. It is the aim of the Society to maintain the standing of the Code Symbols for the benefit of the users, the enforcement jurisdictions, and the holders of the symbols who comply with all requirements.

Based on these objectives, the following policy has been established on the usage in advertising of facsimiles of the symbols, Certificates of Authorization, and reference to Code construction. The Ameri-

can Society of Mechanical Engineers does not "approve," "certify," "rate," or "endorse" any item, construction, or activity and there shall be no statements or implications which might so indicate. An organization holding a Code Symbol and/or a Certificate of Authorization may state in advertising literature that items, constructions, or activities "are built (produced or performed) or activities conducted in accordance with the requirements of the ASME Boiler and Pressure Vessel Code," or "meet the requirements of the ASME Boiler and Pressure Vessel Code."

The ASME Symbol shall be used only for stamping and nameplates as specifically provided in the Code. However, facsimiles may be used for the purpose of fostering the use of such construction. Such usage may be by an association or a society, or by a holder of a Code Symbol who may also use the facsimile in advertising to show that clearly specified items will carry the symbol. General usage is permitted only when all of a manufacturer's items are constructed under the Rules.

STATEMENT OF POLICY ON THE USE OF ASME MARKING TO IDENTIFY MANUFACTURED ITEMS

The ASME Boiler and Pressure Vessel Code provides rules for the construction of boilers, pressure vessels, and nuclear components. This includes requirements for materials, design, fabrication, examination, inspection, and stamping. Items constructed in accordance with all of the applicable rules of the Code are identified with the official Code Symbol Stamp described in the governing Section of the Code.

Markings such as "ASME," "ASME Standard," or any other marking including "ASME" or the various Code Symbols shall not be used on any item which is

not constructed in accordance with all of the applicable requirements of the Code.

Items shall not be described on ASME Data Report Forms nor on similar forms referring to ASME which tend to imply that all Code requirements have been met when in fact they have not been. Data Report Forms covering items not fully complying with ASME requirements should not refer to ASME or they should clearly identify all exceptions to the ASME requirements.

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CONTENTS

A Detailed Contents Precedes Each Part and the Appendices

Foreword	v
Statements of Policy	vii
Personnel	ix
Introduction	1
Subsection A — General Requirements	
Part UG — General Requirements for All Methods of Construction and All Materials	7
Subsection B — Requirements Pertaining to Methods of Fabrication of Pressure Vessels	
Part UW — Requirements for Pressure Vessels Fabricated by Welding	89
Part UF — Requirements for Pressure Vessels Fabricated by Forging	121
Part UB — Requirements for Pressure Vessels Fabricated by Brazing	129
Subsection C — Requirements Pertaining to Classes of Materials	
Part UCS — Requirements for Pressure Vessels Constructed of Carbon and Low-Alloy Steels	141
Part UNF — Requirements for Pressure Vessels Constructed of Nonferrous Materials	155
Part UHA — Requirements for Pressure Vessels Constructed of High-Alloy Steel	169
Part UCI — Requirements for Pressure Vessels Constructed of Cast Iron	181
Part UCL — Requirements for Welded Pressure Vessels Constructed of Integrally Clad Plate or With Applied Corrosion Resistant Linings	187
Part UCD — Requirements for Pressure Vessels Constructed of Cast Ductile Iron	195
Part UHT — Requirements for Pressure Vessels Constructed by Ferritic Steels With Tensile Properties Enhanced by Heat Treatment	201
Part ULW — Requirements for Pressure Vessels Fabricated by Layered Construction	213
Part ULT — Requirements for Pressure Vessels Constructed of Materials Having Higher Allowable Stresses at Low Temperature	237

Tables	247
Mandatory Appendices	353
Nonmandatory Appendices	491
Index	603

INTRODUCTION

SCOPE

U-1 SCOPE¹

(a) For the scope of this Division, pressure vessels are containers for the containment of pressure, either internal or external. This pressure may be obtained from an external source, or by the application of heat from a direct or indirect source, or any combination thereof.

(b) This Division is divided into three Subsections. Subsection A consists of Part UG, covering the general requirements applicable to all pressure vessels. Subsection B covers the specific requirements that are applicable to the various methods used in the fabrication of pressure vessels. It consists of Parts UW, UF, and UB, dealing with welded, forged, and brazed methods, respectively. Subsection C covers specific requirements applicable to the several classes of materials used in pressure vessel construction. It consists of Parts UCS, UNF, UHA, UCI, UCL, UCD, and UHT, dealing with carbon and low-alloy steels, nonferrous metals, high-alloy steels, cast iron, clad and lined material, cast ductile iron, and ferritic steels with properties enhanced by heat treatment, respectively.

(c) The following classes of vessels are not considered to be within the scope of this Division:

- (1) those within the scope of other Sections
- (2) fired process tubular heaters
- (3) pressure containers which are integral parts or components of rotating or reciprocating mechanical devices, such as pumps, compressors, turbines, generators, engines, and hydraulic or pneumatic cylinders where the primary design considerations and/or stresses are derived from the functional requirements of the device

(4) except as covered in U-1(f), structures whose

primary function is the transport of fluids from one location to another within a system of which it is an integral part, that is, piping systems

(5) piping components, such as pipe, flanges, bolting, gaskets, valves, expansion joints, fittings, and the pressure-containing parts of other components, such as strainers and devices which serve such purposes as mixing, separating, snubbing, distributing, and metering or controlling flow, providing that pressure-containing parts of such components are generally recognized as piping components or accessories

(6) vessels with a nominal water-containing capacity of 120 gal (454 l) or less for containing water² under pressure, including those containing air, the compression of which serves only a cushion

(7) a hot water supply storage tank heated by steam or any other indirect means when none of the following limitations is exceeded:

- (a) a heat input of 200,000 Btu/hr (58.6 kW)
- (b) a water temperature of 210°F (99°C)
- (c) a nominal water-containing capacity of 120 gal (454 l)

(8) vessels having an internal or external operating pressure [see 3-1(f)] not exceeding 15 psi (103 kPa) with no limitation on size [see UG-28(e)]

(9) vessels having an inside diameter, width, height, or cross section diagonal not exceeding 6 in. (152 mm), with no limitation on length of vessel or pressure

(d) The rules of this Division have been formulated on the basis of design principles and construction practices applicable to vessels designed for pressures not exceeding 3,000 psi (20 670 kPa). For pressures above 3,000 psi (20 670 kPa), deviations from and additions to these rules usually are necessary to meet the requirements of design principles and construction practices for these higher pressures. Only in the event that after having applied these additional design principles and construction practices the vessel still

¹In those applications where there are laws or regulations issued by Municipal, State, Provincial or Federal Authorities covering pressure vessels, these laws or regulations should be reviewed to determine size or service limitations of the coverage which may be different or more restrictive than those given in this paragraph.

²The water may contain additives provided the flash point of the aqueous solution at atmospheric pressure is 185°F (85°C) or higher.