Welded Tanks for Oil Storage

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Notice

Instructions for Submitting a Proposed Revision to this Standard Under Continuous Maintenance

The American Petroleum Institute maintains this standard under continuous maintenance procedures. These procedures establish a documented program for regular publication of addenda or revisions, including timely and documented consensus action on requests for revisions to any part of the standard. See Annex D for additional information. Proposed revisions shall be submitted to the Director, Standards Department, American Petroleum Institute, 200 Massachusetts Avenue, NW, Suite 1100, Washington, DC 20001, standards@api.org.

Foreword

This Standard is based on the accumulated knowledge and experience of Purchasers and Manufacturers of welded oil storage tanks of various sizes and capacities for internal pressures not more than 17.2 kPa ($2^1/_2$ pounds per square inch) gauge. This Standard is meant to be a purchase specification to facilitate the manufacture and procurement of storage tanks for the petroleum industry.

If the tanks are purchased in accordance with this Standard, the Purchaser is required to specify certain basic requirements. The Purchaser may want to modify, delete, or amplify sections of this Standard, but reference to this Standard shall not be made on the nameplates of or on the Manufacturer's certification for tanks that do not fulfill the minimum requirements of this Standard or that exceed its limitations. It is strongly recommended that any modifications, deletions, or amplifications be made by supplementing this Standard rather than by rewriting or incorporating sections of it into another complete standard.

The design rules given in this Standard are minimum requirements. More stringent design rules specified by the Purchaser or furnished by the Manufacturer are acceptable when mutually agreed upon by the Purchaser and the Manufacturer. This Standard is not to be interpreted as approving, recommending, or endorsing any specific design or as limiting the method of design or construction.

The verbal forms used to express the provisions in this document are as follows.

Shall: As used in a standard, "shall" denotes a minimum requirement in order to conform to the standard.

Should: As used in a standard, "should" denotes a recommendation or that which is advised but not required in order to conform to the standard.

May: As used in a standard, "may" denotes a course of action permissible within the limits of a standard.

Can: As used in a standard, "can" denotes a statement of possibility or capability.

- This Standard is not intended to cover storage tanks that are to be erected in areas subject to regulations more stringent than the specifications in this Standard. When this Standard is specified for such tanks, it should be followed insofar as it does not conflict with local requirements. The Purchaser is responsible for specifying any jurisdictional requirements applicable to the design and construction of the tank.

  After revisions to this Standard have been issued, they may be applied to tanks that are to be completed after the date of issue. The tank nameplate shall state the date of the edition of the Standard and any revision to that edition to which the tank has been designed and constructed.

- Each edition, revision, or addenda to this API Standard may be used beginning with the date of issuance shown on the cover page for that edition, revision, or addenda. Each edition, revision, or addenda to this API Standard becomes effective six months after the date of issuance for equipment that is certified as being constructed, and inspected per this Standard. During the six-month time between the date of issuance of the edition, revision, or addenda and the effective date, the Purchaser and the Manufacturer shall specify to which edition, revision, or addenda the equipment is to be constructed and inspected.

Important Information Concerning Use of Asbestos or Alternative Materials

Asbestos is specified or referenced for certain components of the equipment described in some API standards. It has been of extreme usefulness in minimizing fire hazards associated with petroleum processing. It has also been a universal sealing material, compatible with most refining fluid services.

Certain serious adverse health effects are associated with asbestos, among them the serious and often fatal diseases of lung cancer, asbestosis, and mesothelioma (a cancer of the chest and abdominal linings). The degree of exposure to asbestos varies with the product and the work practices involved.

Consult the most recent edition of the Occupational Safety and Health Administration (OSHA), U.S. Department of Labor, Occupational Safety and Health Standard for Asbestos, Tremolite, Anthophyllite, and Actinolite, 29 *Code of Federal Regulations* Section 1910.1001; the U.S. Environmental Protection Agency, National Emission Standard for Asbestos, 40 *Code of Federal Regulations* Sections 61.140 through 61.156; and the U.S. Environmental Protection Agency (EPA) rule on labeling requirements and phased banning of asbestos products (Sections 763.160-179).

There are currently in use and under development a number of substitute materials to replace asbestos in certain applications. Manufacturers and users are encouraged to develop and use effective substitute materials that can meet the specifications for, and operating requirements of, the equipment to which they would apply.

SAFETY AND HEALTH INFORMATION WITH RESPECT TO PARTICULAR PRODUCTS OR MATERIALS CAN BE OBTAINED FROM THE EMPLOYER, THE MANUFACTURER OR SUPPLIER OF THAT PRODUCT OR MATERIAL, OR THE MATERIAL SAFETY DATASHEET.

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Introduction

The 14th edition of API Standard 650 represents a significant update, introducing both major substantive and clarifying technical changes to the document.

Key Changes

This edition introduces a new annex dedicated to lightning protection. It also expands approved welding processes to include low-power density laser beam welding and adds new acceptance testing and weld qualification requirements for duplex stainless materials. New requirements have been added to allow for studded outlets under certain conditions. The requirements for manway handles have been changed, and new rules for nozzle and weld spacing on small stainless steel tanks allow for fittings to be placed closer to the tank bottoms.

The standard now allows for the use of liquid penetrant testing as a substitute for the vacuum box test under certain gas-tight roof requirements. It also revises examination requirements for bottom welds and provides more flexibility in using ultrasonic testing (UT) as an alternative to radiography. Additionally, new acceptance criteria for weld undercut have been added.

Other Notable Technical Changes and Clarifications

Clarifications and revisions: The document now clarifies membrane stress limits, notching requirements for concrete foundations, and the definition of design thickness with respect to corrosion allowance. It also provides clearer guidance on wind girder design, seismic freeboard, and the calculation of dynamic hoop stress.

Procedural and testing updates: This edition revises effective attachment length requirements for peripheral welds on reinforcing plates and updates radiographic testing requirements for annular joints welded with removable backup bars. It also clarifies requirements for procedure qualification records (PQRs) when welding over protective coatings and adds dye penetrant as an option for testing the shell-to-bottom joint weld.

Other revisions include an updated requirement for the lowest one-day mean ambient temperature and a clarification on the procedure for removing coatings from areas to be welded. Qualification of brazing procedures for attaching tank name plates has also been added.

Welded Tanks for Oil Storage

SECTION 1—SCOPE

1.1 General

1.1.1 This standard establishes minimum requirements for material, design, fabrication, erection, and inspection for vertical, cylindrical, aboveground, closed- and open-top, welded storage tanks in various sizes and capacities for internal pressures approximating atmospheric pressure (internal pressures not exceeding the weight of the roof plates), but a higher internal pressure is permitted when additional requirements are met (see 1.1.13). This standard applies only to tanks whose entire bottom is uniformly supported and to tanks in non-refrigerated service that have a maximum design temperature of 93 °C (200 °F) or less (see 1.1.20).

• **1.1.2** This standard provides industry with tanks of adequate safety and reasonable economy for use in the storage of petroleum, petroleum products, and other liquid products. This standard does not present or establish a fixed series of allowable tank sizes; instead, it is intended to permit the Purchaser to select whatever size tank may best meet his or her needs. This standard is intended to help Purchasers and Manufacturers in ordering, fabricating, and erecting tanks; it is not intended to prohibit Purchasers and Manufacturers from purchasing or fabricating tanks that meet specifications other than those contained in this standard.

NOTE A bullet (•) at the beginning of a paragraph indicates that there is an expressed decision or action required of the Purchaser. The Purchaser's responsibility is not limited to these decisions or actions alone. When such decisions and actions are taken, they are to be specified in documents such as requisitions, change orders, data sheets, and drawings.

• **1.1.3** This standard has requirements given in two alternate systems of units. The Manufacturer shall comply with either:

1) all of the requirements given in this standard in SI units; or

2) all of the requirements given in this standard in US Customary units.

The selection of which set of requirements (SI or US Customary) to apply shall be a matter of mutual agreement between the Manufacturer and Purchaser and indicated on the Data Sheet, Page 1.

1.1.4 All tanks and appurtenances shall comply with the Data Sheet and all attachments.

• **1.1.5** Field-erected tanks shall be furnished completely erected, inspected, and ready for service connections, unless specified otherwise. Shop-fabricated tanks shall be furnished inspected and ready for installation.

• **1.1.6** The annexes of this standard provide a number of design options requiring decisions by the Purchaser, standard requirements, recommendations, and information that supplements the basic standard. Except for Annex L, an Annex becomes a requirement only when the Purchaser specifies an option covered by that Annex or specifies the entire Annex. The designation "Normative" shall be understood to mean mandatory. The designation "informative" shall be understood to mean non-mandatory (i.e. informational data, recommendations, suggestions, commentary, samples, and examples).

The contents of the annexes to this standard are either "normative" or "informative."

"Normative" is further divided into the following.

— Always required (L).