

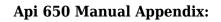
# Southern Inspection Services

## API 650

1	Standard applied only atmospheric storage Pr – up to 2 ½ psi, temp - 200°F	AP1650	1.1.1	Temp < 200°F P = 2 ½ psi
2	Appendix M – operating temp.	AP1650	1.1.17	> 200°F
3	Material under tolerance	AP1650	4.2.1.2.3	0.25mm/ 0.01inch
-4	Shell plate maximum thick	AP1650	4.2.1.4	45mm
5	Thicker plates normalized, Q&T killed &impact testing	AP1650	4.2.1.4	40mm
6	Minimum permissible material design temp. with out impact testing	AP1650		Fig. 41
7	Insert plate thickness can be used up to	AP1650	4.2.1.4	100mm
8	Impact test size	AP1650	4.2.8.5	10x10mm
9	Sub size specimen	AP1650	4.2.8.5	>80% of material thick
10	The design metal temp, shall be considered 15°F above the lowest one day mean temp.	AP1650	3.4	15°F/8°C above one day mean temp.
11	Nominal pipe sizes greater than 24" flanges shall confirm	AP1650	4.6.2	ASNI B16.47
12	Welding electrodes E60/ 7	AP1650	4.8.1	AWS 5.1
13	Welding electrodes E80	AP1650	4.8.2	AWS 5.5
14	Fillet weld size (minimum) ,1/3 of the thickness of thinner plate, but it should be minimum 5mm	AP1650	5.1.3.3	1/3 <sup>rd</sup> of thinner plate or 5mm (atleast)
15	Lap welded overlap for double welded	AP1650	5.1.3.5	< 2"
16	Single welded lap joint over lap	AP1650	5.1.3.5	< 1"
17	Vertical joints offset from each other	AP1650	5.1.5.2	5t min, t is thicker course thick
18	3 plate lap joints	AP1650	5.1.5.4	12" distance each other
19	Bottom annular plate radial width	AP1650	5.1.5.4	24*
20	Bottom weld root opening for butt welds	AP1650	5.1.5.5	1/4"
21	Shell to bottom fillet weld	AP1650	5.1.5.7	Minimum 5mm(3/16") or table 3.1.5.7
22	Bottom plate projection beyond comer weld	AP1650	5.1.5.7.d	1/2"
23	Annular plate projection beyond shell out side	AP1650	5.1.5.7.d	1/2"
24	Shell to bottom fillet filet for GrlV to VI	API650	3.1.5.7e	Minimum 2 pass
25	Annular to bottom filet & groove	AP1650	Fig.5-3C	Up to 1" Annular plate A=B
26	Design internal pr.(design consideration)	AP1650	5.2.1.c	2.5lbt/in2
27	Design external pr. Min.(design consideration)	AP1650	5.2.1b	1" of water, 0.25kpa

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**Emilie Sanchez** 



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