

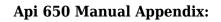
# Southern Inspection Services

# API 650

| 1   | Standard applied only atmospheric storage<br>Pr – up to 2 ½ psi, temp - 200°F                   | AP1650 | 1.1.1     | Temp < 200°F<br>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  |
| -41 | 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.<br>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<br>thick                                 |
| 10  | The design metal temp, shall be considered<br>15°F above the lowest one day mean temp.          | AP1650 | 3.4       | 15°F/8°C above<br>one day mean<br>temp.                   |
| 11  | Nominal pipe sizes greater than 24" flanges<br>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<br>plate or 5mm<br>(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<br>course thick                      |
| 18  | 3 plate lap joints  | AP1650 | 5.1.5.4   | 12" distance each<br>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   | Y4"   |
| 21  | Shell to bottom fillet weld   | AP1650 | 5.1.5.7   | Minimum<br>5mm(3/16") or table<br>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 GrIV to VI   | API650 | 3.1.5.7e  | Minimum 2 pass  |
| 25  | Annular to bottom filet & groove  | AP1650 | Fig.5-3C  | Up to 1" Annular<br>plate A=B                             |
| 26  | Design internal pr.(design consideration)   | AP1650 | 5.2.1.c   | 2.5/bt/in2  |
| 27  | Design external pr. Min (design consideration)  | AP1650 | 5.2.1b    | 1" of water,<br>0.25kpa                                   |

# **Api 650 Manual Appendix**

**United States Department of the Army** 



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