



API 650

1	Standard applied only atmospheric storage Pr – up to 2 ½ psi, temp - 200°F	API 650	1.1.1	Temp <200°F P – 2 ½ psi
2	Appendix M – operating temp.	API 650	1.1.17	> 200°F
3	Material under tolerance	API 650	4.2.1.2.3	0.25mm/ 0.01inch
4	Shell plate maximum thick	API 650	4.2.1.4	45mm
5	Thicker plates normalized, Q&T killed & impact testing	API 650	4.2.1.4	40mm
6	Minimum permissible material design temp. with out impact testing	API 650		Fig. 41
7	Insert plate thickness can be used up to	API 650	4.2.1.4	100mm
8	Impact test size	API 650	4.2.8.5	10x10mm
9	Sub size specimen	API 650	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.	API 650	3.4	15°F/8°C above one day mean temp.
11	Nominal pipe sizes greater than 24" flanges shall confirm	API 650	4.6.2	ASNI B16.47
12	Welding electrodes E60V 7	API 650	4.8.1	AWS 5.1
13	Welding electrodes E80	API 650	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	API 650	5.1.3.3	1/3 rd of thinner plate or 5mm (atleast)
15	Lap welded overlap for double welded	API 650	5.1.3.5	< 2"
16	Single welded lap joint over lap	API 650	5.1.3.5	< 1"
17	Vertical joints offset from each other	API 650	5.1.5.2	5t min, t is thicker course thick
18	3 plate lap joints	API 650	5.1.5.4	12" distance each other
19	Bottom annular plate radial width	API 650	5.1.5.4	24"
20	Bottom weld root opening for butt welds	API 650	5.1.5.5	¼"
21	Shell to bottom fillet weld	API 650	5.1.5.7	Minimum 5mm(3/16") or table 3.1.5.7
22	Bottom plate projection beyond corner weld	API 650	5.1.5.7.d	1/2"
23	Annular plate projection beyond shell out side	API 650	5.1.5.7.d	1/2"
24	Shell to bottom fillet fillet for Gr I V to VI	API 650	3.1.5.7e	Minimum 2 pass
25	Annular to bottom fillet & groove	API 650	Fig.5-3C	Up to 1" Annular plate A=B
26	Design internal pr.(design consideration)	API 650	5.2.1.c	2.5lb/in ²
27	Design external pr. Min.(design consideration)	API 650	5.2.1b	1" of water, 0.25kpa

Api 650 Manual Appendix

United States Department of the Army

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