ASME Sec.VIII Div.1 Cheat Sheet

Internal Pressure

Shell	200	
Longitudinal [1, Section UG-27(c)(2)]	$\sigma_{s} = \frac{PR_{m}}{0.2t}$	2SE + 0.4P
Circumferential [1, Section UG-27(c)(1); Section 1-1 (a)(1)]	$\sigma_{\phi} = \frac{PR_{ln}}{1}$	SE - 0.6P
Heads		
Hemisphere [1, Section 1-1 (a)(2):	$\sigma_{\sigma} = \sigma_{\sigma} = \frac{PR_m}{2t}$	PR, 2SE - 0.2P
Section UG-27(d) Ellipsoidal [1, Section 1-4(c)]	See Procedure 2-7	PD/K 2SE - 0.2P

External Pressure - Cylindrical shell

- 1. Assume thickness "t"
- 3. Determine Factor "A"
- 5. Determine Factor "B"

 $\frac{4B}{3(Do/t)}$

Nozzle Reinforcement

✓ Area Removed ≤ Area Available + Area Reinforced



Minimum Nozzle Neck Thickness

Nominal Stre	lin.	Triving .
NPS % (DN 6)	0.060	1.54
NPS 55 (DN 8)	0.077	1.96
NPS % (DN 10)	0.000	2.02
NPS 1/2 (DN 15)	0.095	2.42
NPS % (DN 20)	0.099	2:51
NPS 1 (DN 25)	0.116	2.96
NPS 1% (DN 32)	0.123	3.12
NPS 1% (DN 40)	0.127	3.22
NPS 2 (DN 50)	0.135	36.42
NPS 2% (DN 65)	40.117/8	4.52
NPS 3 (DN 80)	0.109	34390
NPS 3%, (DN 90)	0.198	5.02
MPS 4 (DM 100)	0.207	5.27
NPS 5 (DN 125)	0.226	5.73
NPS & (DN 150)	0.245	6.22
NPS 8 (DN 200)	0.282	77.166
NPS 10 (DN 250)	0.319	96,112
2 NPS 12 (DN 300)	05.18.2588	80.364

Forming Strain,

if Strain >=5 % Stress relieving Heat treatment to be done

Type of Part Being Formed	Forming Strain, %
Cylinders formed from plate	$\epsilon_f = \left(\frac{50t}{R_f}\right)\left(1 - \frac{R_f}{R_O}\right)$
For double curvature (e.g., heads)	$\epsilon_f = \left(\frac{75t}{R_f}\right)\left(1 - \frac{R_f}{R_o}\right)$

Hydro Test,

- √ 1.3*LSR*(Design Pressure or MAWP)
- ✓ Or 1.3*MAP

Pneumatic Test,

- Normally, not performed. To be done in special case only.
- ✓ 1.1 MAWP*LSR

Stamping of Vessel



Specific Marking

- "RT-1,2,3,4"
- "HT" or "PHT"

Different Stress and Allowable limit,

- ✓ Pm ≤ S
- ✓ Pm + Pb ≤ 1.5*S
- ✓ Pm + Pb + Q ≤ 3*S

Permissible Out-of-Roundness,

- ✓ 1 % of Nominal Diameter
- ✓ 2 % @ opening

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