# ASME Sec.VIII Div.1 Cheat Sheet

# **Internal Pressure**

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

Created by : Vishal Tailor Gujarat-INDIA

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**Alexander Belov** 

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web mar 30 2020 according to kotler and keller marketing is the art and science of choosing target markets and getting keeping and growing customers through creating