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AN INTERNATIONAL CODE

2017 ASME Boiler & Pressure Vessel Code

2017 Edition

July 1, 2017

VIII RULES FOR CONSTRUCTION OF PRESSURE VESSELS

Division 2

Alternative Rules

ASME Boiler and Pressure Vessel Committee
on Pressure Vessels



The American Society of
Mechanical Engineers

Two Park Avenue • New York, NY • 10016 USA

ASME B16.34-2013
(Revision of ASME B16.34-2009)

Valves — Flanged, Threaded, and Welding End



AN AMERICAN NATIONAL STANDARD

The American Society of
Mechanical Engineers

Two Park Avenue • New York, NY • 10016 USA

ACCEPTANCE CRITERIA NON DESTRUCTIVE TEST	
1. SURFACE CRACKS The maximum length of any surface crack shall not exceed 1/16 in. (1.6 mm) for any one crack and 1/8 in. (3.2 mm) for any two cracks in any 6 in. (152 mm) length of weld.	2. SURFACE CRACKS The maximum length of any surface crack shall not exceed 1/16 in. (1.6 mm) for any one crack and 1/8 in. (3.2 mm) for any two cracks in any 6 in. (152 mm) length of weld.
2. DISCONTINUITIES The maximum length of any surface discontinuity shall not exceed 1/16 in. (1.6 mm) for any one discontinuity and 1/8 in. (3.2 mm) for any two discontinuities in any 6 in. (152 mm) length of weld.	3. DISCONTINUITIES The maximum length of any surface discontinuity shall not exceed 1/16 in. (1.6 mm) for any one discontinuity and 1/8 in. (3.2 mm) for any two discontinuities in any 6 in. (152 mm) length of weld.
3. DISCONTINUITIES The maximum length of any surface discontinuity shall not exceed 1/16 in. (1.6 mm) for any one discontinuity and 1/8 in. (3.2 mm) for any two discontinuities in any 6 in. (152 mm) length of weld.	4. DISCONTINUITIES The maximum length of any surface discontinuity shall not exceed 1/16 in. (1.6 mm) for any one discontinuity and 1/8 in. (3.2 mm) for any two discontinuities in any 6 in. (152 mm) length of weld.

Examples provided are only for illustration purposes. When a skirt is supplied, its thickness will be at least necessary for a seamless shell of the same inner dial, (50 mm), as long as the connections do not form ligaments that require an increase in the thickness of the shell or the head, and the prohibition of a mothers of 200 ° F (95 ° C) © applied, (2) For groove welds, more than 1st, 2 in. Page 14 of 27 asme sec viii div. A • ES Service (a) When the vessels should contain lethal substances, wool or gaseous, all welded joints should be fully radiographed except (13 mm) size and a throat no. (32 mm); (4) For nails soldiers to pressure from pressure provided for a motive at a mothers of 200 ° F (95 ° C) is applied when the thickness of the pressure exceeds 11â .4. When separate equations are supplied to U.S. units. Customary and SI, these equations must be executed using variables in the associated units in the specific equation. UCS-66 for P-NO. 1 materials. (19 mm) to 21st, 4 in. Page 10 of 27 ASME SEC VIII DIV 1st © "Basic & ©" NRS (Rev.5 A © "12 Mar 2010) iJC = P DI / 2 T (Circumferential Stress of the hole acting in sewing weld Long iJL = p di / 4 t (oitudinal stress acting in sewing weld Cir) Conclusion: The sewing weld circus stronger than long sewing weld when subjected to pressure. (57 mm) (c) 3â .4 in. 3 mm 1, 4t more than 19 to 38, incl. (3) For groove welds more than 1, 2 in. > 5.0 mm Relevant: NOTED & NOTABLE (rejection / repair) 1.5 & © "5.0 mm Relevant: Noticed & Acceptable

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