

Tank Inspection, Repair, Alteration, and Reconstruction

API STANDARD 653
THIRD EDITION, DECEMBER 2001
ADDENDUM 1, SEPTEMBER 2003
ADDENDUM 2, NOVEMBER 2005
ADDENDUM 3, FEBRUARY 2008
ERRATA, APRIL 2008



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Downstream Segment

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FOREWORD

This standard is based on the accumulated knowledge and experience of owners, operators, manufacturers, and repairers of steel storage tanks. The object of this publication is to provide guidance in the inspection, repair, alteration, and reconstruction of steel storage tanks used in the petroleum and chemical industries.

If tanks are inspected, repaired, altered, or reconstructed in accordance with this standard, the owner/operator may elect to modify, delete, or amplify sections of this standard. It is strongly recommended that such modifications, deletions, or amplifications be made by supplementing this standard rather than by rewriting or incorporating sections into another complete standard.

The rules given in this standard are minimum requirements. This standard is not to be interpreted as approving, recommending, or endorsing any specific design nor limiting the methods of inspection, repair, alteration, or reconstruction.

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Suggested revisions are invited and should be submitted to the Standards and Publications Department, API, 1220 L Street, NW, Washington, DC 20005, standards@api.org.

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CONTENTS

		Page
1	SCOPE	1-1
	1.1 Introduction	1-1
	1.2 Compliance with this Standard	1-1
	1.3 Jurisdiction	1-1
	1.4 Safe Working Practices	1-1
2	REFERENCES	2-1
	2.1 Referenced Publications	2-1
	2.2 Other References	2-1
3	DEFINITIONS	3-1
4	SUITABILITY FOR SERVICE	4-1
	4.1 General	4-1
	4.2 Tank Roof Evaluation	4-1
	4.3 Tank Shell Evaluation	4-2
	4.4 Tank Bottom Evaluation	4-7
	4.5 Tank Foundation Evaluation	4-9
5	BRITTLE FRACTURE CONSIDERATIONS	5-1
	5.1 General	5-1
	5.2 Basic Considerations	5-1
	5.3 Assessment Procedure	5-1
6	INSPECTION	6-1
	6.1 General	6-1
	6.2 Inspection Frequency Considerations	6-1
	6.3 Inspections from the Outside of the Tank	6-1
	6.4 Internal Inspection	6-2
	6.5 Alternative to Internal Inspection to Determine Bottom Thickness	6-3
	6.6 Preparatory Work for Internal Inspection	6-3
	6.7 Inspection Checklists	6-3
	6.8 Records	6-3
	6.9 Reports	6-4
	6.10 Non-Destructive Examinations	6-4
7	MATERIALS	7-1
	7.1 General	7-1
	7.2 New Materials	7-1
	7.3 Original Materials for Reconstructed Tanks	7-1
	7.4 Welding Consumables	7-1
8	DESIGN CONSIDERATIONS FOR RECONSTRUCTED TANKS	8-1
	8.1 General	8-1
	8.2 New Weld Joints	8-1
	8.3 Existing Weld Joints	8-1
	8.4 Shell Design	8-1
	8.5 Shell Penetrations	8-1
	8.6 Windgirders and Shell Stability	8-1

	Page	
8.7	Roofs	8-1 05
8.8	Seismic Design	8-1 08
9	TANK REPAIR AND ALTERATION	9-1
9.1	General	9-1 01
9.2	Removal and Replacement of Shell Plate Material	9-1 08
9.3	Shell Repairs Using Lap-Welded Patch Plates	9-2 05
9.4	Repair of Defects in Shell Plate Material	9-4
9.5	Alteration of Tank Shells to Change Shell Height	9-4 05
9.6	Repair of Defective Welds	9-4
9.7	Repair of Shell Penetrations	9-4
9.8	Addition or Replacement of Shell Penetrations	9-5
9.9	Alteration of Existing Shell Penetrations	9-5
9.10	Repair of Tank Bottoms	9-7 08
9.11	Repair of Fixed Roofs	9-11
9.12	Repair of Floating Roofs	9-11
9.13	Repair or Replacement of Floating Roof Perimeter Seals	9-11
9.14	Hot Taps	9-12 08
10	DISMANTLING AND RECONSTRUCTION	10-1
10.1	General	10-1 08
10.2	Cleaning and Gas Freeing	10-1
10.3	Dismantling Methods	10-1
10.4	Reconstruction	10-2 08
10.5	Dimensional Tolerances	10-3
11	WELDING	11-1
11.1	Welding Qualifications	11-1 05
11.2	Identification and Records	11-1
11.3	Preheat or Controlled Deposition Welding Methods as Alternatives to Postweld Heat Treatment	11-1 08
12	EXAMINATION AND TESTING	12-1
12.1	Nondestructive Examinations	12-1
12.2	Radiographs	12-2 08
12.3	Hydrostatic Testing	12-3
12.4	Leak Tests	12-5
12.5	Measured Settlement During Hydrostatic Testing	12-5
13	MARKING AND RECORDKEEPING	13-1
13.1	Nameplates	13-1 05
13.2	Recordkeeping	13-1
13.3	Certification	13-1
APPENDIX A	BACKGROUND ON PAST EDITIONS OF API WELDED STORAGE TANK STANDARDS	A-1 08
APPENDIX B	EVALUATION OF TANK BOTTOM SETTLEMENT	B-1 05
APPENDIX C	CHECKLISTS FOR TANK INSPECTION	C-1

	Page	
APPENDIX D	AUTHORIZED INSPECTOR CERTIFICATION	D-1 03
APPENDIX E	TECHNICAL INQUIRIES	E-1
APPENDIX F	NDE REQUIREMENTS SUMMARY	F-1
APPENDIX G	QUALIFICATION OF TANK BOTTOM EXAMINATION PROCEDURES AND PERSONNEL	G-1 08
APPENDIX H	SIMILAR SERVICE ASSESSMENT	H-1
APPENDIX S	AUSTENITIC STAINLESS STEEL STORAGE TANKS	S-1 05
Figures		
4-1	Inspection of Corrosion Areas	4-2
4-2	Pit Measurement	4-3
5-1	Brittle Fracture Considerations	5-2 08
5-2	Exemption Curve for Tanks Constructed from Carbon Steel of Unknown Toughness	5-3
9-1	Acceptable Details for Replacement of Shell Plate Material	9-2 05
9-2	Lapped Patch Repair Plates at the External Shell-to-Bottom Joint.	9-3
9-3A	Typical Details for Addition of Reinforcing Plate to Existing Shell Penetration	9-5
9-3B	Typical Details for Addition of “Tombstone” Shape Reinforcing Plate to Existing Shell Penetration	9-5
9-4	Method for Raising Shell Nozzles	9-6 01
9-5A	Details for Installing a New Bottom Through an Existing Tombstone Reinforcing Plate	9-7
9-5B	Details for Installing a New Bottom Through an Existing Tombstone Reinforcing Plate	9-7 08
9-6	Typical Welded-on Patch Plates on Tank Bottom Plates.	9-8
9-7	Hot Tap for Tanks	9-13
10-1	Tank Shell and Bottom Cut Locations	10-2
13-1	Nameplate	13-2
13-2	Certification Forms.	13-3
B-1	Measurements of Shell Settlement (External)	B-1 03
B-2	Measurements of Bottom Settlement (Internal) Tank Out-of-Service	B-2
B-3	Graphical Representation of Tank Shell Settlement	B-3
B-4	Out-of-Plane Settlement Measurement Points.	B-4
B-5	Edge Settlement	B-4
B-6	Correction for Measured Edge Settlement.	B-5
B-7	Bottom Settlement Near Shell	B-6
B-8	Localized Bottom Depressions or Bulges Remote from Shell	B-7
B-9	Localized Tank Bottom Settlement Limits for Single Pass Welds	B-8
B-10	Maximum Allowable Edge Settlement for Areas with Bottom Lap Welds Approximately Parallel to the Shell	B-9
B-11	Maximum Allowable Edge Settlement for Areas with Bottom Lap Welds Approximately Perpendicular to the Shell	B-10
B-12	Edge Settlement with a Lap Weld at an Arbitrary Angle to the Shell.	B-11
H-1	Steps in Conducting Similar Service Assessment	H-5 08
H-2	Example Corrosion Rate Curves for Bottom of Storage Tank.	H-6
H-3	Example Corrosion Rate Curves for Top Course of Storage Tank	H-7

Tables

4-1	Maximum Allowable Shell Stresses	4-4	08
4-2	Joint Efficiencies for Welded Joints	4-5	
4-3	Joint Efficiencies for Riveted Joints	4-7	
4-4	Annular Bottom Plate Thicknesses	4-9	
6-1	Bottom Plate Minimum Thickness	6-3	
9-1	Hot Tap Connection Sizes and Shell Plate Thicknesses	9-12	08
10-1	Maximum Thicknesses on New Welds	10-3	
10-2	Radii Tolerances	10-3	
11-1	Welding Methods as Alternatives to Postweld Heat Treatment Qualification Thicknesses for Test Plates and Repair Grooves	11-2	08
A-1	Editions of API Standard 650 and Its Precursor, Standard 12C	A-1	
G-1	Suggested Essential Variables for Qualification Tests	G-4	03
H-1	Similar Service Product Classification	H-4	08

Tank Inspection, Repair, Alteration, and Reconstruction

1 Scope

1.1 INTRODUCTION

05 1.1.1 This standard covers steel storage tanks built to API Standard 650 and its predecessor API 12C. It provides minimum requirements for maintaining the integrity of such tanks after they have been placed in service and addresses inspection, repair, alteration, relocation, and reconstruction.

1.1.2 The scope is limited to the tank foundation, bottom, shell, structure, roof, attached appurtenances, and nozzles to the face of the first flange, first threaded joint, or first welding-end connection. Many of the design, welding, examination, and material requirements of API Std 650 can be applied in the maintenance inspection, rating, repair, and alteration of in-service tanks. In the case of apparent conflicts between the requirements of this standard and API Std 650 or its predecessor API 12C, this standard shall govern for tanks that have been placed in service.

1.1.3 This standard employs the principles of API Std 650; however, storage tank owner/operators, based on consideration of specific construction and operating details, may apply this standard to any steel tank constructed in accordance with a tank specification.

1.1.4 This standard is intended for use by organizations that maintain or have access to engineering and inspection personnel technically trained and experienced in tank design, fabrication, repair, construction, and inspection.

05 1.1.5 This standard does not contain rules or guidelines to cover all the varied conditions which may occur in an existing tank. When design and construction details are not given, and are not available in the as-built standard, details that will provide a level of integrity equal to the level provided by the current edition of API Std 650 must be used.

03 1.1.6 This standard recognizes fitness-for-service assessment concepts for evaluating in-service degradation of pressure containing components. API RP 579, *Recommended Practice for Fitness-for-Service*, provides detailed assessment procedures or acceptance criteria for specific types of degradation referenced in this standard. When this standard does not provide specific evaluation procedures or accep-

tance criteria for a specific type of degradation or when this standard explicitly allows the use of fitness-for-service criteria, RP 579 may be used to evaluate the various types of degradation or test requirements addressed in this standard.

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1.2 COMPLIANCE WITH THIS STANDARD

The owner/operator has ultimate responsibility for complying with the provisions of this standard. The application of this standard is restricted to organizations that employ or have access to an authorized inspection agency as defined in 3.5. Should a party other than the owner/operator be assigned certain tasks, such as relocating and reconstructing a tank, the limits of responsibility for each party shall be defined by the owner/operator prior to commencing work.

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1.3 JURISDICTION

If any provision of this standard presents a direct or implied conflict with any statutory regulation, the regulation shall govern. However, if the requirements of this standard are more stringent than the requirements of the regulation, then the requirements of this standard shall govern.

1.4 SAFE WORKING PRACTICES

An assessment shall be made of the potential hazards to which personnel may be exposed when conducting internal tank inspections, making repairs, or dismantling tanks. Procedures shall be developed according to the guidelines given in API Standard 2015, Recommended Practice 2016, and Publication 2217A that will include safeguard for personnel health and safety, prevention of accidental fires and explosions, and the prevention of property damage.

Special procedures may need to be developed for certain activities described in this standard that are not fully covered by the referenced API publications; for example, safety precautions for personnel accessing floating roof tanks that are in service, or gas freeing the bottom side of a tank. Finally, procedures must comply with any federal or state safety regulations pertaining to “confined spaces” or any other relevant provisions.