

# **Specification for Shop Welded Tanks for Storage of Production Liquids**

API SPECIFICATION 12F  
TWELFTH EDITION, OCTOBER 2008

EFFECTIVE DATE: APRIL 1, 2009



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**Upstream Segment**

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# Specification for Shop Welded Tanks for Storage of Production Liquids

## 1 Scope

### 1.1 General

This specification covers material, design, fabrication, and testing requirements for shop-fabricated vertical, cylindrical, aboveground, closed top, welded steel storage tanks in various standard sizes and capacities for internal pressures approximately atmospheric, not to exceed those listed in Table 1, Column 2.

This specification is designed to provide the oil production industry with tanks of adequate safety and reasonable economy for use in the storage of crude petroleum and other liquids commonly handled and stored by the production segment of the industry. This specification is for the convenience of purchasers and manufacturers in ordering and fabricating tanks.

### 1.2 Compliance

The manufacturer is responsible for complying with all of the provisions of this specification. The purchaser may make any investigation necessary to be satisfied of this compliance by the manufacturer and may reject any material that does not comply with this specification. It is urged that the purchaser avail him/herself of this right and furnish his/her own inspection independently of any supervisory inspection furnished by the manufacturer, and that the purchaser's inspector follow closely all the details of shop fabrication and/or field construction and testing herein specified which affect the integrity and safety of the completed structure.

## 2 References

API Specification 5L, *Specification for Line Pipe*

API Standard 2000, *Venting Atmospheric and Low-Pressure Storage Tanks: Nonrefrigerated and Refrigerated*

ASME B1.1<sup>1</sup>, *Unified Inch Screw Threads (UN and UNR Thread Form)*

ASME B16.5, *Pipe Flanges and Flanged Fittings*

ASME B16.11, *Forged Steel Fittings, Socket-Welding and Threaded*

ASME B18.2.1, *Square and Hex Bolts and Screws, Inch Series*

ASME B18.2.2, *Square and Hex Nuts*

ASME B31.1, *Process Piping*

ASME *Boiler and Pressure Vessel Code, Section IX—Welding and Brazing Qualifications*

ASTM A36<sup>2</sup>, *Standard Specification for Carbon Structural Steel*

ASTM A53, *Standard Specification for Pipe, Steel, Black and Hot-Dipped, Zinc-Coated, Welded and Seamless*

ASTM A106, *Standard Specification for Seamless Carbon Steel Pipe for High-Temperature Service*

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<sup>1</sup> ASME International, 3 Park Avenue, New York, New York 10016, [www.asme.org](http://www.asme.org).

<sup>2</sup> ASTM International, 100 Barr Harbor Drive, West Conshohocken, Pennsylvania 19428, [www.astm.org](http://www.astm.org).