

Welded Tanks for Oil Storage

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Notice

Instructions for Submitting a Proposed Revision to this Standard Under Continuous Maintenance

The American Petroleum Institute maintains this standard under continuous maintenance procedures. These procedures establish a documented program for regular publication of addenda or revisions, including timely and documented consensus action on requests for revisions to any part of the standard. See Annex D for additional information. Proposed revisions shall be submitted to the Director, Standards Department, American Petroleum Institute, 1220 L Street, NW, Washington, D.C. 20005-4070, standards@api.org.

Foreword

This Standard is based on the accumulated knowledge and experience of Purchasers and Manufacturers of welded oil storage tanks of various sizes and capacities for internal pressures not more than 17.2 kPa (2¹/₂ pounds per square inch) gauge. This Standard is meant to be a purchase specification to facilitate the manufacture and procurement of storage tanks for the petroleum industry.

If the tanks are purchased in accordance with this Standard, the Purchaser is required to specify certain basic requirements. The Purchaser may want to modify, delete, or amplify sections of this Standard, but reference to this Standard shall not be made on the nameplates of or on the Manufacturer's certification for tanks that do not fulfill the minimum requirements of this Standard or that exceed its limitations. It is strongly recommended that any modifications, deletions, or amplifications be made by supplementing this Standard rather than by rewriting or incorporating sections of it into another complete standard.

The design rules given in this Standard are minimum requirements. More stringent design rules specified by the Purchaser or furnished by the Manufacturer are acceptable when mutually agreed upon by the Purchaser and the Manufacturer. This Standard is not to be interpreted as approving, recommending, or endorsing any specific design or as limiting the method of design or construction.

Shall: As used in a standard, "shall" denotes a minimum requirement in order to conform to the specification.

Should: As used in a standard, "should" denotes a recommendation or that which is advised but not required in order to conform to the specification.

- This Standard is not intended to cover storage tanks that are to be erected in areas subject to regulations more stringent than the specifications in this Standard. When this Standard is specified for such tanks, it should be followed insofar as it does not conflict with local requirements. The Purchaser is responsible for specifying any jurisdictional requirements applicable to the design and construction of the tank.

After revisions to this Standard have been issued, they may be applied to tanks that are to be completed after the date of issue. The tank nameplate shall state the date of the edition of the Standard and any revision to that edition to which the tank has been designed and constructed.

- Each edition, revision, or addenda to this API Standard may be used beginning with the date of issuance shown on the cover page for that edition, revision, or addenda. Each edition, revision, or addenda to this API Standard becomes effective six months after the date of issuance for equipment that is certified as being constructed, and inspected per this Standard. During the six-month time between the date of issuance of the edition, revision, or addenda and the effective date, the Purchaser and the Manufacturer shall specify to which edition, revision, or addenda the equipment is to be constructed and inspected.

Important Information Concerning Use of Asbestos or Alternative Materials

Asbestos is specified or referenced for certain components of the equipment described in some API standards. It has been of extreme usefulness in minimizing fire hazards associated with petroleum processing. It has also been a universal sealing material, compatible with most refining fluid services.

Certain serious adverse health effects are associated with asbestos, among them the serious and often fatal diseases of lung cancer, asbestosis, and mesothelioma (a cancer of the chest and abdominal linings). The degree of exposure to asbestos varies with the product and the work practices involved.

Consult the most recent edition of the Occupational Safety and Health Administration (OSHA), U.S. Department of Labor, Occupational Safety and Health Standard for Asbestos, Tremolite, Anthophyllite, and Actinolite, 29 *Code of Federal Regulations* Section 1910.1001; the U.S. Environmental Protection Agency, National Emission Standard for Asbestos, 40 *Code of Federal Regulations* Sections 61.140 through 61.156; and the U.S. Environmental Protection Agency (EPA) rule on labeling requirements and phased banning of asbestos products (Sections 763.160-179).

There are currently in use and under development a number of substitute materials to replace asbestos in certain applications. Manufacturers and users are encouraged to develop and use effective substitute materials that can meet the specifications for, and operating requirements of, the equipment to which they would apply.

SAFETY AND HEALTH INFORMATION WITH RESPECT TO PARTICULAR PRODUCTS OR MATERIALS CAN BE OBTAINED FROM THE EMPLOYER, THE MANUFACTURER OR SUPPLIER OF THAT PRODUCT OR MATERIAL, OR THE MATERIAL SAFETY DATASHEET.

Contents

	Page	
1 Scope	1-1	
1.1 General	1-1	15
1.2 Limitations	1-3	
1.3 Responsibilities	1-4	
1.4 Documentation Requirements	1-4	
1.5 Formulas	1-4	
2 Normative References	2-1	15
3 Terms and Definitions	3-1	
4 Materials	4-1	
4.1 General	4-1	15
4.2 Plates	4-2	
4.3 Sheets	4-9	
4.4 Structural Shapes	4-9	
4.5 Piping and Forgings	4-14	
4.6 Flanges	4-17	15
4.7 Bolting	4-17	
4.8 Welding Electrodes	4-17	
4.9 Gaskets	4-18	
5 Design	5-1	
5.1 Joints	5-1	15
5.2 Design Considerations	5-9	
5.3 Special Considerations	5-12	
5.4 Bottom Plates	5-14	
5.5 Annular Bottom Plates	5-15	
5.6 Shell Design	5-17	15
5.7 Shell Openings	5-27	
5.8 Shell Attachments and Tank Appurtenances	5-67	
5.9 Top and Intermediate Stiffening Rings	5-80	
5.10 Roofs	5-91	
5.11 Wind Load on Tanks (Overturning Stability)	5-98	
5.12 Tank Anchorage	5-100	
5.13 Downward Reactions on Foundations	5-107	
6 Fabrication	6-1	
6.1 General	6-1	15
6.2 Shop Inspection	6-2	
7 Erection	7-1	
7.1 General	7-1	15
7.2 Details of Welding	7-1	
7.3 Examination, Inspection, and Repairs	7-5	
7.4 Repairs to Welds	7-11	
7.5 Dimensional Tolerances	7-11	
8 Methods of Examining Joints	8-1	
8.1 Radiographic Method	8-1	15
8.2 Magnetic Particle Examination	8-5	
8.3 Ultrasonic Examination	8-5	
8.4 Liquid Penetrant Examination	8-5	

	Page	
8.5	Visual Examination	8-6
8.6	Vacuum Testing	8-7
9	Welding Procedure and Welder Qualifications	9-1
9.1	Definitions	9-1
9.2	Qualification of Welding Procedures	9-1
9.3	Qualification of Welders	9-2
9.4	Identification of Welded Joints	9-3
10	Marking	10-1
10.1	Nameplates	10-1
10.2	Division of Responsibility	10-3
10.3	Certification	10-3
Annex A	(normative) Optional Design Basis for Small Tanks	A-1
Annex AL	(normative) Aluminum Storage Tanks	AL-1
Annex B	(informative) Recommendations for Design and Construction of Foundations for Aboveground Oil Storage Tanks	B-1
Annex C	(normative) External Floating Roofs	C-1
Annex D	(informative) Inquiries and Suggestions for Change	D-1
Annex E	(normative) Seismic Design of Storage Tanks	E-1
Annex EC	(informative) Commentary on Annex E	EC-1
Annex F	(normative) Design of Tanks for Small Internal Pressures	F-1
Annex G	(normative) Structurally-Supported Aluminum Dome Roofs	G-1
Annex H	(normative) Internal Floating Roofs	H-1
Annex I	(normative) Undertank Leak Detection and Subgrade Protection	I-1
Annex J	(normative) Shop-assembled Storage Tanks	J-1
Annex K	(informative) Sample Applications of the Variable-Design-Point Method to Determine Shell-Plate Thickness	K-1
Annex L	(normative) API Standard 650 Storage Tank Data Sheet	L-1
Annex M	(normative) Requirements for Tanks Operating at Elevated Temperatures	M-1
Annex N	(normative) Use of New Materials That Are Not Identified	N-1
Annex O	(normative) Under-bottom Connections	O-1
Annex P	(normative) Allowable External Loads on Tank Shell Openings	P-1
Annex R	(informative) References for Tanks in Non-petroleum Product Service	R-1
Annex S	(normative) Austenitic Stainless Steel Storage Tanks	S-1
Annex SC	(normative) Stainless and Carbon Steel Mixed Materials Storage Tanks	SC-1
Annex T	(informative) NDE Requirements Summary	T-1
Annex U	(normative) Ultrasonic Examination in Lieu of Radiography	U-1
Annex V	(normative) Design of Storage Tanks for External Pressure	V-1
Annex W	(normative) Commercial and Documentation Recommendations	W-1
Annex X	(normative) Duplex Stainless Steel Storage Tanks	X-1
Annex Y	(normative) API Monogram	Y-1

Bibliography	Y-2
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Figures

4.1a	Minimum Permissible Design Metal Temperature for Materials Used in Tank Shells without Impact Testing (SI)	4-7	
4.1b	Minimum Permissible Design Metal Temperature for Materials Used in Tank Shells without Impact Testing (USC)	4-8	
4.2	Isothermal Lines of Lowest One-day Mean Temperatures (°F)	4-10	15
4.3	Governing Thickness for Impact Test Determination of Shell Nozzle and Manhole Materials	4-16	
5.1	Typical Vertical Shell Joints	5-3	
5.2	Typical Horizontal Shell Joints	5-4	
5.3a	Typical Roof and Bottom Joints	5-5	
5.3b	Method for Preparing Lap-welded Bottom Plates under Tank Shell	5-6	
5.3c	Detail of Double Fillet-groove Weld for Annular Bottom Plates with a Nominal Thickness Greater than 13 mm (1/2 in.)	5-6	
5.3d	Spacing of Three-plate Welds at Annular Plates	5-7	
5.4	Storage Tank	5-13	
5.5	Drip Ring (Suggested Detail)	5-14	15
5.6	Minimum Weld Requirements for Openings in Shells According to 5.7.3	5-28	
5.7a	Shell Manhole	5-34	
5.7b	Details of Shell Manholes and Nozzles	5-35	
5.8	Shell Nozzles	5-36	
5.9	Minimum Spacing of Welds and Extent of Related Radiographic Examination	5-50	
5.10	Shell Nozzle Flanges	5-52	15
5.11	Area Coefficient for Determining Minimum Reinforcement of Flush-type Cleanout Fittings	5-54	
5.12	Flush-type Cleanout Fittings	5-55	15
5.13	Flush-type Cleanout Fitting Supports	5-56	
5.14	Flush-type Shell Connection	5-63	
5.15	Rotation of Shell Connection	5-66	
5.16	Roof Manholes	5-70	15
5.17	Rectangular Roof Openings with Flanged Covers	5-74	
5.18	Rectangular Roof Openings with Hinged Cover	5-75	15
5.19	Flanged Roof Nozzles	5-76	
5.20	Threaded Roof Nozzles	5-76	
5.21	Drawoff Sump	5-76	
5.22	Scaffold Cable Support	5-77	
5.23	Grounding Lug	5-81	15
5.24	Typical Stiffening-ring Sections for Tank Shells	5-84	
5.25	Stairway Opening through Stiffening Ring	5-87	
5.26	Some Acceptable Column Base Details	5-95	
5.27	Overtipping Check for Unanchored Tanks	5-98	
5.28	Typical Anchor Chair	5-104	
5.29	Typical Anchor Strap Welded Attachment (for Carbon Steel Tank)	5-105	14
5.30	Typical Hold-Down Strap Configuration (for Carbon Steel Tank)	5-106	
5.31	Butt Weld Joint with Back-up Bar	5-107	15
6.1	Shaping of Plates	6-2	
8.1	Radiographic Requirements for Tank Shells	8-2	
10.1	Manufacturer's Nameplate	10-1	15
10.2	Manufacturer's Certification Letter	10-3	
AL.1	Cover Plate Thickness for Shell Manholes and Cleanout Fittings	AL-13	15
AL.2	Flange Plate Thickness for Shell Manholes and Cleanout Fittings	AL-14	
AL.3	Bottom Reinforcing Plate Thickness for Cleanout Fittings	AL-15	

AL.4	Stresses in Roof Plates	AL-18	
B.1	Example of Foundation with Concrete Ringwall	B-4	
B.2	Example of Foundation with Crushed Stone Ringwall	B-5	
E.1	Coefficient C_i	E-13	
EC.1	Maximum Earthquake Response Spectrum	EC-4	
EC.2	Earthquake Response Spectrum Notation	EC-4	
EC.3	Site Specific Response Spectrum	EC-5	
EC.4	Deterministic Lower Limit on MCE Response Spectrum	EC-5	
EC.5	Relationship of Probabilistic and Deterministic Response Spectra	EC-6	
EC.6	Sloshing Factor, K_s	EC-7	
EC.7	Design Response Spectra for Ground-Supported Liquid Storage Tanks	EC-8	
EC.8	Effective Weight of Liquid Ratio	EC-10	
EC.9	Center of Action of Effective Forces	EC-10	
EC.10	Overtopping Moment	EC-12	
F.1	Annex F Decision Tree	F-2	15
F.2	Permissible Details of Compression Rings	F-3	
G.1	Data Sheet for a Structurally-Supported Aluminum Dome Added to an Existing Tank	G-2	14
G.2	Typical Roof Nozzle	G-9	
I.1	Concrete Ringwall with Undertank Lead Detection at the Tank Perimeter (Typical Arrangement)	I-2	14
I.2	Crushed Stone Ringwall with Undertank Leak Detection at the Tank Perimeter (Typical Arrangement)	I-3	
I.3	Earthen Foundation with Undertank Leak Detection at the Tank Perimeter (Typical Arrangement)	I-3	
I.4	Double Steel Bottom with Leak Detection at the Tank Perimeter (Typical Arrangement)	I-3	
I.5	Double Steel Bottom with Leak Detection at the Tank Perimeter (Typical Arrangement)	I-5	
I.6	Reinforced Concrete Slab with Leak Detection at the Perimeter (Typical Arrangement)	I-5	
I.7	Reinforced Concrete Slab	I-6	
I.8	Typical Drawoff Sump	I-7	
I.9	Center Sump for Downward-Sloped Bottom	I-7	
I.10	Typical Leak Detection Wells	I-8	
I.11	Tanks Supported by Grillage Members (General Arrangement)	I-9	14
O.1	Example of Under-bottom Connection with Concrete Ringwall Foundation	O-3	15
O.2	Example of Under-bottom Connection with Concrete Ringwall Foundation and Improved Tank Bottom and Shell Support	O-4	
O.3	Example of Under-bottom Connection with Earth-type Foundation	O-5	
P.1	Nomenclature for Piping Loads and Deformation	P-4	
P.2a	Stiffness Coefficient for Radial Load: Reinforcement on Shell ($L/2a = 1.0$)	P-6	
P.2b	Stiffness Coefficient for Longitudinal Moment: Reinforcement on Shell ($L/2a = 1.0$)	P-6	
P.2c	Stiffness Coefficient for Circumferential Moment: Reinforcement on Shell ($L/2a = 1.0$)	P-7	
P.2d	Stiffness Coefficient for Radial Load: Reinforcement on Shell ($L/2a = 1.5$)	P-7	
P.2e	Stiffness Coefficient for Longitudinal Moment: Reinforcement on Shell ($L/2a = 1.5$)	P-8	
P.2f	Stiffness Coefficient for Circumferential Moment: Reinforcement on Shell ($L/2a = 1.5$)	P-8	
P.2g	Stiffness Coefficient for Radial Load: Reinforcement in Nozzle Neck Only ($L/2a = 1.0$)	P-9	
P.2h	Stiffness Coefficient for Longitudinal Moment: Reinforcement in Nozzle Neck Only ($L/2a = 1.0$)	P-9	
P.2i	Stiffness Coefficient for Circumferential Moment: Reinforcement in Nozzle Neck Only ($L/2a = 1.0$)	P-10	
P.2j	Stiffness Coefficient for Radial Load: Reinforcement in Nozzle Neck Only ($L/2a = 1.5$)	P-10	
P.2k	Stiffness Coefficient for Longitudinal Moment: Reinforcement in Nozzle Neck Only ($L/2a = 1.5$)	P-11	

P.2I	Stiffness Coefficient for Circumferential Moment: Reinforcement in Nozzle Neck Only ($L/2a = 1.5$)	P-11	
P.3a	Construction of Nomogram for b_1, b_2, c_1, c_2 Boundary	P-12	
P.3b	Construction of Nomogram for b_1, c_3 Boundary	P-12	
P.4a	Obtaining Coefficients Y_F and Y_L	P-13	
P.4b	Obtaining Coefficient Y_C	P-14	
P.5a	Determination of Allowable Loads from Nomogram: F_R and M_L	P-15	
P.5b	Determination of Allowable Loads from Nomogram: F_R and M_C	P-15	
P.6	Low-type Nozzle with Reinforcement on Shell	P-16	
P.7	Allowable-load Nomograms for Sample Problem	P-21	
V.1a	Dimensions for Self-supporting Cone Roof	V-6	15
V.1b	Dimensions for Self-supporting Dome Roof	V-9	

Tables

1.1	Deleted		15
4.1	Maximum Permissible Alloy Content	4-5	
4.2	Acceptable Grades of Plate Material Produced to National Standards	4-5	
4.3a	Linear Equations for Figure 4.1a (SI)	4-9	
4.3b	Linear Equations for Figure 4.1b (USC)	4-9	
4.4a	Material Groups (SI)	4-11	15
4.4b	Material Groups (USC)	4-12	
4.5a	Minimum Impact Test Requirements for Plates (SI)	4-13	15
4.5b	Minimum Impact Test Requirements for Plates (USC)	4-13	
5.1a	Annular Bottom-plate Thicknesses (t_b) (SI)	5-16	14
5.1b	Annular Bottom-plate Thicknesses (t_b) (USC)	5-16	
5.2a	Permissible Plate Materials and Allowable Stresses (SI)	5-18	15
5.2b	Permissible Plate Materials and Allowable Stresses (USC)	5-20	
5.3a	Thickness of Shell Manhole Cover Plate and Bolting Flange (SI)	5-29	15
5.3b	Thickness of Shell Manhole Cover Plate and Bolting Flange (USC)	5-29	
5.4a	Dimensions for Shell Manhole Neck Thickness (SI)	5-30	15
5.4b	Dimensions for Shell Manhole Neck Thickness (USC)	5-31	
5.5a	Dimensions for Bolt Circle Diameter D_b and Cover Plate Diameter D_b for Shell Manholes (SI)	5-32	15
5.5b	Dimensions for Bolt Circle Diameter D_b and Cover Plate Diameter D_b for Shell Manholes (USC)	5-33	
5.6a	Dimensions for Shell Nozzles (SI)	5-37	15
5.6b	Dimensions for Shell Nozzles (USC)	5-39	
5.7a	Dimensions for Shell Nozzles: Pipe, Plate, and Welding Schedules (SI)	5-40	15
5.7b	Dimensions for Shell Nozzles: Pipe, Plate, and Welding Schedules (USC)	5-42	
5.8a	Dimensions for Shell Nozzle Flanges (SI)	5-43	15
5.8b	Dimensions for Shell Nozzle Flanges (USC)	5-44	
5.9a	Dimensions for Flush-type Cleanout Fittings (SI)	5-45	15
5.9b	Dimensions for Flush-type Cleanout Fittings (USC)	5-45	
5.10a	Minimum Thickness of Cover Plate, Bolting Flange, and Bottom Reinforcing Plate for Flush-Type Cleanout Fittings (SI)	5-46	15
5.10b	Minimum Thickness of Cover Plate, Bolting Flange, and Bottom Reinforcing Plate for Flush-Type Cleanout Fittings (USC)	5-46	
5.11a	Thicknesses and Heights of Shell Reinforcing Plates for Flush-type Cleanout Fittings (SI)	5-47	15
5.11b	Thicknesses and Heights of Shell Reinforcing Plates for Flush-type Cleanout Fittings (USC)	5-47	
5.12a	Dimensions for Flush-type Shell Connections (SI)	5-58	14
5.12b	Dimensions for Flush-type Shell Connections (USC)	5-59	
5.13a	Dimensions for Roof Manholes (SI)	5-69	14
5.13b	Dimensions for Roof Manholes (USC)	5-70	
5.14a	Dimensions for Flanged Roof Nozzles (SI)	5-72	

5.14b	Dimensions for Flanged Roof Nozzles (USC)	5-72
5.15a	Dimensions for Threaded Roof Nozzles (SI)	5-73
5.15b	Dimensions for Threaded Roof Nozzles (USC)	5-73
5.16a	Dimensions for Drawoff Sumps (SI)	5-77
5.16b	Dimensions for Drawoff Sumps (USC)	5-77
5.17	Requirements for Platforms and Walkways	5-76
5.18	Requirements for Stairways	5-79
5.19a	Rise, Run, and Angle Relationships for Stairways (SI)	5-79
5.19b	Rise, Run, and Angle Relationships for Stairways (USC)	5-80
5.20a	Section Moduli (cm ³) of Stiffening-Ring Sections on Tank Shells (SI)	5-85
5.20b	Section Moduli (in. ³) of Stiffening-Ring Sections on Tank Shells (USC)	5-86
5.21a	Uplift Loads (SI)	5-101
5.21b	Uplift Loads (USC)	5-102
5.22	Unfactored (Working Stress) Downward Reactions on Foundations	5-108
7.1a	Minimum Preheat Temperatures (SI)	7-2
7.1b	Minimum Preheat Temperatures (USC)	7-2
A.1a	Typical Sizes and Corresponding Nominal Capacities (m ³) for Tanks with 1800-mm Courses (SI)	A-2
A.1b	Typical Sizes and Corresponding Nominal Capacities (Barrels) for Tanks with 72-in. Courses (USC)	A-3
A.2a	Shell-plate Thicknesses (mm) for Typical Sizes of Tanks with 1800-mm Courses (SI)	A-4
A.2b	Shell-plate Thicknesses (in.) for Typical Sizes of Tanks with 72-in. Courses (USC)	A-5
A.3a	Typical Sizes and Corresponding Nominal Capacities (m ³) for Tanks with 2400-mm Courses (SI)	A-6
A.3b	Typical Sizes and Corresponding Nominal Capacities (Barrels) for Tanks with 96-in. Courses (USC)	A-7
A.4a	Shell-plate Thicknesses (mm) for Typical Sizes of Tanks with 2400-mm Courses (SI)	A-8
A.4b	Shell-plate Thicknesses (in.) for Typical Sizes of Tanks with 96-in. Courses (USC)	A-9
AL.1	Material Specifications	AL-4
AL.2	Joint Efficiency	AL-4
AL.3a	Minimum Mechanical Properties (SI)	AL-5
AL.3b	Minimum Mechanical Properties (USC)	AL-6
AL.4a	Annular Bottom Plate Thickness (SI)	AL-8
AL.4b	Annular Bottom Plate Thickness (USC)	AL-9
AL.5a	Minimum Shell Thickness (SI)	AL-9
AL.5b	Minimum Shell Thickness (USC)	AL-9
AL.4b	Annular Bottom Plate Thickness (USC)	AL-9
AL.6a	Allowable Tensile Stresses for Tank Shell (for Design and Test) (SI)	AL-11
AL.6b	Allowable Tensile Stresses for Tank Shell (for Design and Test) (USC)	AL-12
AL.7a	Allowable Stresses for Roof Plates (SI)	AL-17
AL.7b	Allowable Stresses for Roof Plates (USC)	AL-17
AL.8a	Compressive Moduli of Elasticity E (MPa) at Temperature (°C) (SI)	AL-19
AL.8b	Compressive Moduli of Elasticity E (ksi) at Temperature (°F) (USC)	AL-19
AL.9a	Shell Nozzle Welding Schedule (SI)	AL-20
AL.9b	Shell Nozzle Welding Schedule (USC)	AL-21
E.1	Value of F_a as a Function of Site Class	E-9
E.2	Value of F_v as a Function of Site Class	E-9
E.3	Site Classification	E-12
E.4	Response Modification Factors for ASD Methods	E-15
E.5	Importance Factor (I) and Seismic Use Group Classification	E-16
E.6	Anchorage Ratio Criteria	E-22
E.7	Minimum Required Freeboard	E-26

E.8	Design Displacements for Piping Attachments	E-27	
G.1a	Bolts and Fasteners (SI)	G-4	
G.1b	Bolts and Fasteners (USC)	G-5	
J.1a	Minimum Roof Depths for Shop-assembled Dome-roof Tanks (SI)	J-2	
J.1b	Minimum Roof Depths for Shop-assembled Dome-roof Tanks (USC)	J-3	
K.1a	Shell-plate Thicknesses Based on the Variable-design-point Method Using 2400-mm Courses and an Allowable Stress of 159 MPa for the Test Condition (SI)	K-11	
K.1b	Shell-plate Thicknesses Based on the Variable-design-point Method Using 96-in. Courses and an Allowable Stress of 23,000 lbf/in. ² for the Test Condition (USC)	K-12	
K.2a	Shell-plate Thicknesses Based on the Variable-design-point Method Using 2400-mm Courses and an Allowable Stress of 208 MPa for the Test Condition (SI)	K-13	
K.2b	Shell-plate Thicknesses Based on the Variable-design-point Method Using 96-in. Courses and an Allowable Stress of 30,000 lbf/in. ² for the Test Condition (USC)	K-14	
K.3a	Shell-plate Thicknesses Based on the Variable-design-point Method Using 2400-mm Courses and an Allowable Stress of 236 MPa for the Test Condition (SI)	K-15	
K.3b	Shell-plate Thicknesses Based on the Variable-design-point Method Using 96-in. Courses and an Allowable Stress of 34,300 lbf/in. ² for the Test Condition (USC)	K-16	
L.1	Index of Decisions or Actions Which may be Required of the Tank Purchaser	L-28	15
M.1a	Yield Strength Reduction Factors (SI)	M-3	
M.1b	Yield Strength Reduction Factors (USC)	M-3	
M.2a	Modulus of Elasticity at the Maximum Design Temperature (SI)	M-6	
M.2b	Modulus of Elasticity at the Maximum Design Temperature (USC)	M-7	
O.1a	Dimensions of Under-Bottom Connections (SI)	O-2	
O.1b	Dimensions of Under-Bottom Connections (USC)	O-2	
P.1a	Modulus of Elasticity and Thermal Expansion Coefficient at the Design Temperature (SI)	P-3	
P.1b	Modulus of Elasticity and Thermal Expansion Coefficient at the Design Temperature (USC)	P-3	
S.1a	ASTM Materials for Stainless Steel Components (SI)	S-2	14
S.1b	ASTM Materials for Stainless Steel Components (USC)	S-3	
S.2a	Allowable Stresses for Tank Shells (SI)	S-8	
S.2b	Allowable Stresses for Tank Shells (USC)	S-8	
S.3a	Allowable Stresses for Plate Ring Flanges (SI)	S-9	
S.3b	Allowable Stresses for Plate Ring Flanges (USC)	S-9	
S.4	Joint Efficiencies	S-10	
S.5a	Yield Strength Values in MPa (SI)	S-10	
S.5b	Yield Strength Values in psi (USC)	S-10	
S.6a	Modulus of Elasticity at the Maximum Design Temperature (SI)	S-11	
S.6b	Modulus of Elasticity at the Maximum Design Temperature (USC)	S-11	
U.1a	Flaw Acceptance Criteria for UT Indications May be Used for All Materials (SI)	U-5	
U.1b	Flaw Acceptance Criteria for UT Indications May be Used for All Materials (USC)	U-6	
X.1	ASTM Materials for Duplex Stainless Steel Components	X-2	
X.2a	Allowable Stresses for Tank Shells (SI)	X-5	14
X.2b	Allowable Stresses for Tank Shells (USC)	X-6	
X.3	Joint Efficiencies	X-6	
X.4a	Yield Strength Values in MPa	X-8	14
X.4b	Yield Strength Values in PSI	X-8	
X.5a	Modulus of Elasticity at the Maximum Design Temperature (SI)	X-9	
X.5b	Modulus of Elasticity at the Maximum Design Temperature (USC)	X-9	
X.6a	Hot Forming Temperatures (SI)	X-10	
X.6b	Hot Forming Temperatures (USC)	X-10	

Welded Tanks for Oil Storage

SECTION 1—SCOPE

1.1 General

1.1.1 This standard establishes minimum requirements for material, design, fabrication, erection, and inspection for vertical, cylindrical, aboveground, closed- and open-top, welded storage tanks in various sizes and capacities for internal pressures approximating atmospheric pressure (internal pressures not exceeding the weight of the roof plates), but a higher internal pressure is permitted when additional requirements are met (see 1.1.13). This standard applies only to tanks whose entire bottom is uniformly supported and to tanks in non-refrigerated service that have a maximum design temperature of 93 °C (200 °F) or less (see 1.1.20).

- **1.1.2** This standard provides industry with tanks of adequate safety and reasonable economy for use in the storage of petroleum, petroleum products, and other liquid products. This standard does not present or establish a fixed series of allowable tank sizes; instead, it is intended to permit the Purchaser to select whatever size tank may best meet his or her needs. This standard is intended to help Purchasers and Manufacturers in ordering, fabricating, and erecting tanks; it is not intended to prohibit Purchasers and Manufacturers from purchasing or fabricating tanks that meet specifications other than those contained in this standard.

NOTE A bullet (•) at the beginning of a paragraph indicates that there is an expressed decision or action required of the Purchaser. The Purchaser's responsibility is not limited to these decisions or actions alone. When such decisions and actions are taken, they are to be specified in documents such as requisitions, change orders, data sheets, and drawings.

- **1.1.3** This standard has requirements given in two alternate systems of units. The Manufacturer shall comply with either:
 - 1) all of the requirements given in this standard in SI units; or
 - 2) all of the requirements given in this standard in US Customary units.

The selection of which set of requirements (SI or US Customary) to apply shall be a matter of mutual agreement between the Manufacturer and Purchaser and indicated on the Data Sheet, Page 1.

1.1.4 All tanks and appurtenances shall comply with the Data Sheet and all attachments.

- **1.1.5** Field-erected tanks shall be furnished completely erected, inspected, and ready for service connections, unless specified otherwise. Shop-fabricated tanks shall be furnished inspected and ready for installation.
- **1.1.6** The annexes of this standard provide a number of design options requiring decisions by the Purchaser, standard requirements, recommendations, and information that supplements the basic standard. Except for Annex L, an Annex becomes a requirement only when the Purchaser specifies an option covered by that Annex or specifies the entire Annex. The designation "Normative" shall be understood to mean mandatory. The designation "informative" shall be understood to mean non-mandatory (i.e. informational data, recommendations, suggestions, commentary, samples, and examples).

The contents of the annexes to this standard are either "normative" or "informative."

"Normative" is further divided into the following.

- Always required (L).