A_1 = Specified minimum percentage elongation of the steel used—percent times 100 (i.e., if 20% use 20.0).

NOTE: For paragraphs (c) and (d) of this section the actual values for the tensile strength and percent elongation for the steel, as determined through tests on specimens from the group of plates to be used in the fabrication of the tank, may be substituted for the specified minimum values in the calculation prescribed in this paragraph (See § 178.270–3 of this part). Test records or certification of test results by the material producer or tank manufacturer must be retained by the tank manufacturer for a period not less than 15 years and must be made available to the Department or the owner of the tank.

[Amdt. 178–65, 46 FR 9896, Jan. 29, 1981, as amended by Amdt. 178–97, 56 FR 66284, Dec. 20, 1991; 57 FR 45465, Oct. 1, 1992; Amdt. 178–99, 58 FR 51534, Oct. 1, 1993; 66 FR 45387, 45389, Aug. 28, 2001]

§ 178.270–6 Tank supports, frameworks and lifting attachments.

(a) Each portable tank must be constructed with a permanent support structure that provides a secure base in transport. Skids, frameworks, cradles, or similar devices are acceptable. The calculated stress in tank supports, frameworks, and lifting attachments must not exceed 80 percent of the specified minimum yield strength of the material of construction under the applicable loading conditions specified in § 178.270–4(b).

(b) An IM portable tank that meets the definition of ''container'' in § 450.3(a)(3) must meet the requirements of parts 450 through 453 of this title, in addition to the requirements of this subchapter.

[Amdt. 178–65, 46 FR 9896, Jan. 29, 1981]

§ 178.270–7 Joints in tank shells.

Joints in tank shells must be made by fusion welding. Such joints and their efficiencies must be as required by the ASME Code. Weld procedures and welder performance must be ASME Code qualified or must be qualified by the approval agency in accordance with the procedures in the ASME Code, Section IX, Welding and Brazing Qualifications. A record of each qualification must be retained by the manufacturer for the period prescribed in ASME Code, Section VIII, Pressure Vessels, and must be made available to any duly identified representative of the Department and the owner of the tank.

[Amdt. 178–65, 46 FR 9896, Jan. 29, 1981; 46 FR 24184, Apr. 30, 1981]

§ 178.270–8 Protection of valves and accessories.

Each valve, fitting, accessory, safety device, gauging device, and other appurtenance shall be adequately protected against mechanical damage.

[Amdt. 178–65, 46 FR 9896, Jan. 29, 1981]

§ 178.270–9 Inspection openings.

Each portable tank must be fitted with a manhole or other inspection opening sited above the maximum liquid level to allow for complete internal inspection and adequate access for maintenance and repair of the interior. Each portable tank with a capacity of more than 1894 L (500 gallons) must be fitted with an elliptical or round manhole at least 279 × 381 mm (11 × 15 inches), or 254 × 405 mm (10 × 16 inches), or with a circular manhole at least 381 mm (15 inches) in diameter. Any inspection opening and closure must be designed and reinforced as required by the ASME Code.

[Amdt. 178–65, 46 FR 9896, Jan. 29, 1981, as amended by Amdt. 178–104, 59 FR 49135, Sept. 26, 1994; 66 FR 45387, Aug. 28, 2001]

§ 178.270–10 External design pressure.

(a) Each portable tank not fitted with vacuum relief devices must be designed to withstand a positive external pressure differential of at least 0.4 bar (6 psig).

(b) Each portable tank fitted with vacuum relief devices must be designed to withstand a positive external pressure differential not less than the set pressure of the vacuum relief device and in any case at least 0.21 bar (3 psig).

[Amdt. 178–65, 46 FR 9896, Jan. 29, 1981, as amended at 66 FR 45387, Aug. 28, 2001]

§ 178.270–11 Pressure and vacuum relief devices.

(a) *Relief devices required.* Each portable tank, or each independent compartment of a portable tank, must be fitted with pressure relief devices in accordance with the following:

(1) Each portable tank, or each independent compartment of a portable tank, with a capacity of more than 1893 L (500 gallons), must be provided with a primary spring-loaded pressure relief device, and, in addition, may have one or more emergency pressure relief devices that may be a spring-loaded pressure relief valve, a rupture disc or fusible element in parallel with the primary pressure relief device.

(2) Each portable tank, or each independent compartment of a portable tank, with a capacity of 1893 L (500 gallons) or less, must be fitted with a primary pressure relief device that may either be a non-reclosing device or a spring-loaded pressure relief valve.

(3) If a non-reclosing device is inserted in series with a required pressure relief valve, the space between them must have a suitable tell-tale indicator to permit detection, prior to and during shipment, of disc rupture, pinholing, or leakage which could cause a malfunction of the pressure relief system. The frangible disc must rupture at a tank pressure within the range specified in paragraph (c)(1) of this section.

(b) *Location and construction of relief devices.* (1) Pressure relief devices must be spring-loaded valves, rupture discs, or fusible elements. Vacuum relief devices must be capable of reclosing in any attitude. Each pressure relief device inlet must be situated in the vapor space of the tank. The discharge from any device must be unrestricted and directed to prevent impingement upon the tank shell or structural framework. Protective devices which deflect the flow of vapor are permissible provided the required vent capacity is maintained. Pressure and vacuum relief devices including their inlets must be sited on the top of the tank in a position as near as possible to the longitudinal and transversal center of the tank within the following limitation:

(i) Longitudinally on the tank within 107 cm (3½ feet) or ⅙ the tank length, whichever is less, from the top center of the tank; and

(ii) Transversally within 12 degrees of the tank top.

(2) Except for a relief device installed in a piping system, each relief device must provide unrestricted venting under all conditions. Each pressure relief system, including any piping, must provide a venting capacity at least equal to the venting capacity specified in § 178.270–11(d) for the tank on which the system is installed.

(3) Fusible elements, when installed, must not be protected from direct communication with external heat sources.

(4) Spring-loaded pressure relief valves must be constructed in a manner to prevent unauthorized adjustment of the relief setting.

(c) *Pressure settings of relief devices*—(1) *Primary pressure relief devices.* The primary relief device required by paragraph (a) of this section must be set to function in the range of—

(i) No less than 67 percent and no greater than 83 percent of test pressure for tanks hydrostatically tested under § 178.270–13(a) of this subpart at a gauge pressure below 455 kPa (66 psig). Spring-loaded pressure relief valves must close after discharge at a pressure not less than 80 percent of start-to-discharge pressure.

(ii) No less than 67 percent and no greater than 74 percent of test pressure for tanks hydrostatically tested under § 178.270–13(a) of this subpart at a gauge pressure of 455 kPa (66 psig) or higher. Spring-loaded pressure relief valves must close after discharge at a pressure not less than 90 percent of start-to-discharge pressure.

(2) *Emergency pressure relief devices.* Each rupture disc, other than one used as a primary relief device in accordance with paragraph (b)(2) of this section, must be designed to burst at a pressure greater than 83 percent of and less than or equal to tank hydrostatic test pressure. Each spring-loaded pressure relief device must be set to operate at no less than 83 percent of hydrostatic test pressure and be fully open at test pressure.

(3) *Fusible elements.* Fusible elements must have a nominal yield temperature greater than the highest tank operating temperature and less than or equal to 121 °C (250 °F). The pressure developed in the tank at the fusible element yield temperature must be below the test pressure of the tank.

(4) *Vacuum relief devices.* Vacuum relief devices, when used, must be designed to provide total containment of

product under normal and accident conditions and must be set to open at a nominal external overpressure of not less than 0.21 bar (3 psig) but not greater than the external pressure for which the tank is designed. Each vacuum relief device must have a minimum cross sectional flow area of 2.84 cm^2 (0.44 square inches).

(d) *Venting capacity of pressure relief devices*—(1) *Pressure relief valves (spring-loaded)*. Each pressure relief valve must have a minimum vent capacity of at least 170 standard cubic meters per hour (SCMH) (6,000 standard cubic feet per hour (SCFH)). The minimum total pressure relief valve vent capacity for each tank shall be 340 SCMH (12,000 SCFH) per 32.5m^2 (350 square feet) of exposed tank area, but in any case at least 340 SCMH (12,000 SCFH).

(2) *Total tank vent capacity*. The total vent capacity of all pressure relief devices installed on each portable tank must be sufficient with all devices operating to limit the pressure in the tank to less than or equal to the test pressure. Except as provided in paragraph (d)(3) or (d)(4) of this section, the total vent capacity must be at least equal to that shown in the following table:

TABLE I—MINIMUM TOTAL VENT CAPACITY

[Metric units table in cubic meters of air per hour at atmospheric pressure and 15 °C]

Exposed area square meters	Cubic meters free air per hour	Exposed area square meters	Cubic meters free air per hour
2	841	37.5	9.306
3	1,172	40	9,810
4	1,485	42.5	10,308
5	1,783	45	10,806
6	2,069	47.5	11,392
7	2,348	50	11,778
8	2,621	52.5	12,258
9	2,821	55	12,732
10	3,146	57.5	13,206
12	3,655	60	13,674
14	4,146	62.5	14,142
16	4,625	65	14,604
18	5,092	67.5	15,066
20	5,556	70	15,516
22.5	6,120	75	16,422
25	6,672	80	17,316
27.5	7,212	85	18,198
30	7,746	90	19,074
32.5	8,268	95	19,938
35	8,790	100	20,790

[Nonmetric units in cubic feet of air per hour at atmospheric pressure and 59 °F]

Exposed area square feet	Cubic feet free air per hour	Exposed area square feet	Cubic feet free air per hour
20.	27,600	275	237,000
30	38,500	300	256,000
40	48,600	350	289,500
50	58,600	400	322,100
60	67,700	450	355,900
70	77,000	500	391,000
80	85,500	550	417,500
90	94,800	600	450,000
100	104,000	650	479,000
120	121,000	700	512,000
140	136,200	750	540,000
160	152,100	800	569,000
180	168,200	850	597,000
200	184,000	900	621,000
225	199,000	950	656,000
250	219,500	1,000	686,000

Note: Interpolate for intermediate sizes.

(3) Notwithstanding the minimum total vent capacity shown in table I, of paragraph (d)(2), a tank in dedicated service may have a lesser total vent capacity provided the approval certificate required by §173.32a of this subchapter specifies the hazardous materials for which the tank is suitable. The lesser total vent capacity must be determined in accordance with the following formula:

Formula for metric units

$$Q = 5{,}660{,}000\ A^{0.82}\ (ZT)^{0.5} / (LC)(M^{0.5})$$

Formula for nonmetric units

$$Q = 37{,}980{,}000\ A^{0.82}\ (ZT)^{0.5} / (LC)(M^{0.5})$$

where:

Q = The total required venting capacity, in cubic meters of air per hour at standard conditions of 15.6 °C and 1 atm (cubic feet of air per hour at standard conditions of 60 °F and 14.7 psia);

T = The absolute temperature of the vapor at the venting conditions—degrees Kelvin (°C+273) [degrees Rankine (°F+460)];

A = The exposed surface area of tank shell—square meters (square feet);

L = The latent heat of vaporization of the lading—calories per gram (BTU/lb);

Z = The compressibiliy factor for the vapor (if this factor is unknown, let Z equal 1.0);

M = The molecular weight of vapor;

C = A constant derived from (K), the ratio of specific heats of the vapor. If (K) is unknown, let C = 315.

$$C = 520[K(2/(K+1))\ [^{(K+1)\ /\ (K-1)}]]^{1/2}$$

where:

$K = C_p / C_v$

C_p = The specific heat at constant pressure, in -calories per gram degree centigrade (BTU/lb °F.); and
C_v = The specific heat at constant volume, in -calories per gram degree centigrade (BTU/lb °F.).

(4) The required total venting capacity determined by using table I or paragraph (d)(3) of this section may be reduced for insulated tanks to Q_t by the following formula:

$$Q_t = FQ_1$$

where:

Q_t = The total required venting capacity of the insulated tank;

Q_1 = The total venting capacity required for an uninsulated tank according to table I or paragraph (d)(3) of this section;

F = A coefficient with a value greater than or equal to 0.25 according to the following formula:

Formula for metric units

$$F = 8U(649-t) / 93.5 \times 10^6$$

Formula for nonmetric units

$$F = 8U(1200-t) / 34{,}500$$

where:

U = The thermal conductance of the insulation system taken at 38 °C (100 °F), in gram calories per hour square meter °C (BTU per hour square feet °F); and
t = The actual temperature of the substance at loading, in °C (°F).

(5) Insulation systems, used for the purpose of reducing the venting capacity, must be approved by the approval agency. In all cases, insulation systems approved for this purpose must:

(i) Remain effective at all temperatures up to 649 °C (1200 °F); and

(ii) Be jacketed with a material having a melting point of 649 °C (1200 °F) or greater.

(6) The flow capacity rating of any pressure relief device must be certified by the manufacturer to be in accordance with the applicable provisions of the ASME Code with the following exceptions:

(i) The ASME Code stamp is not required; and

(ii) The flow capacity certification test for spring loaded pressure relief valves may be conducted at a pressure not to exceed 120% of the set pressure provided the stamped flow capacity rating is not greater than 83% of the average capacity of the valves tested.

(e) *Markings on pressure and vacuum relief devices.* The following information shall be plainly displayed on each pressure relief device:

(1) The pressure or, when appropriate, the temperature at which the device is set to function;

(2) Except for vacuum relief devices, the rated flow capacity of air discharged per minute at 15 °C (59 °F) and atmospheric pressure, at:

(i) The set pressure for rupture discs;

(ii) No greater than 20% above the start-to-discharge pressure for spring-loaded relief devices; or

(iii) The fusing temperature for fusible elements.

(3) The manufacturer's name and catalog number; and

(4) The allowable tolerances at the start-to-discharge pressure and the allowable tolerances at the discharge temperature.

[Amdt. 178–65, 46 FR 9897, Jan. 29, 1981; 46 FR 24184, Apr. 30, 1981, as amended by Amdt. 178–97, 55 FR 52716, Dec. 21, 1990; Amdt. 178–99, 58 FR 51534, Oct. 1, 1993; Amdt. 178–104, 59 FR 49135, Sept. 26, 1994; 66 FR 45386, 45389, Aug. 28, 2001]

§ 178.270–12 Valves, nozzles, piping, and gauging devices.

(a) All tank nozzles, except those provided for filling and discharge connections below the normal liquid level of the tank, relief devices, thermometer wells, and inspection openings, must be fitted with manually operated stop valves located as near the shell as practicable either internal or external to the shell. Each filling and discharge connection located below the normal liquid level of the tank must be equipped with an internal discharge valve. A tank nozzle installed in the vapor space to provide a filling or cleaning opening, which is closed by a blank flange or other suitable means, need not be provided with a manually operated stop valve. A tank nozzle installed for a thermometer well or inspection opening need not be provided with a manually operated stop valve.

(b) Each valve must be designed and constructed to a rated pressure not less than the MAWP of the tank. Each stop valve with a screwed spindle must be closed by a clockwise motion of the