

for a distance of at least two times the plate thickness, or a minimum of 1 inch, whichever is greater. The cylinder shall be joined to the head flange by a full fillet weld. Distance from head seam to cylinder shall not be less than 1½ inches or three times the plate thickness, whichever is greater. Voids created by the space between heads of tanks joined together to form a compartment tank shall be provided with a tapped drain hole at their lowest point and a tapped hole at top of tank. The top hole shall be closed and the bottom hole may be closed with solid pipe plugs not less than ¾ inch nor more than 1½ inches having NPT threads.

[29 FR 18995, Dec. 29, 1964. Redesignated at 32 FR 5606, Apr. 5, 1967, and amended by Amdt. 179-10, 36 FR 21350, Nov. 6, 1971; 66 FR 45186, Aug. 28, 2001]

§ 179.200-10 Welding.

(a) All joints shall be fusion-welded in compliance with the requirements of AAR Specifications for Tank Cars, appendix W. Welding procedures, welders and fabricators shall be approved.

(b) Welding is not permitted on or to ductile iron or malleable iron fittings.

[29 FR 18995, Dec. 29, 1964. Redesignated at 32 FR 5606, Apr. 5, 1967, and amended by Amdt. 179-10, 36 FR 21350, Nov. 6, 1971]

§ 179.200-11 Postweld heat treatment.

After welding is complete, postweld heat treatment must be in compliance with the requirements of AAR Specifications for Tank Cars, appendix W, when specified in § 179.201-1.

[Amdt. 179-10, 36 FR 21350, Nov. 6, 1971, as amended at 66 FR 45186, Aug. 28, 2001]

§ 179.200-13 Manway ring or flange, pressure relief device flange, bottom outlet nozzle flange, bottom washout nozzle flange and other attachments and openings.

(a) These attachments shall be fusion welded to the tank and reinforced in an approved manner in compliance with the requirements of appendix E, figure 10, of the AAR Specifications for Tank Cars.

(b) The opening in the manway ring must be at least 16 inches in diameter except that acid resistant lined manways must be at least 18 inches in diameter before lining.

(c) The manway ring or flange, shall be made of cast, forged or fabricated metal. The metal of the dome, tank, or nozzle must be compatible with the manway ring or flange, so that they may be welded together.

(d) The openings for the manway or other fittings shall be reinforced in an approved manner.

[Amdt. 179-40, 52 FR 13047, Apr. 20, 1987]

§ 179.200-14 Expansion capacity.

(a) Tanks shall have expansion capacity as prescribed in this subchapter. This capacity shall be provided in the tank for Class DOT-111A cars, or in a dome for Class DOT-103 and 104 type cars.

(b) For tank cars having an expansion dome, the expansion capacity is the total capacity of the tank and dome combined. The capacity of the dome shall be measured from the inside top of shell of tank to the inside top of dome or bottom of any vent pipe projecting inside of dome, except that when a pressure relief device is applied to side of dome, the effective capacity of the dome shall be measured from top of the pressure relief device opening inside of dome to inside top of shell of tank.

(c) The opening in the tank shell within the dome shall be at least 29 inches in diameter. When the opening in the tank shell exceeds 30 inches in diameter, the opening shall be reinforced in an approved manner. This additional reinforcement may be accomplished by the use of a dome opening of the flued-type as shown in appendix E, Figure E 10C of the AAR Specifications for Tank Cars or by the use of reinforcing as outlined in Appendix E, E3.04 and Figures E10K and E10L. When the opening in the tank shell is less than the inside diameter of the dome, and the dome pocket is not closed off in an approved manner, dome pocket drain holes shall be provided in the tank shell with nipples projecting inside the tank at least 1 inch.

(d) The dome head shall be of approved contour and shall be designed for pressure on concave side.

(e) Aluminum alloy domes: (1) The dome shell thickness shall be calculated by the formula in § 179.200-6(a).