

# Specification for Shop-welded Tanks for Storage of Production Liquids

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# Specification for Shop-welded Tanks for Storage of Production Liquids

## 1 Scope

### 1.1 General

**1.1.1** This specification covers material, design, fabrication, and testing requirements for new shop-fabricated vertical, cylindrical, aboveground, welded steel storage tanks in the standard sizes and capacities, and for internal pressures approximately atmospheric, given in Table 1.

**1.1.2** 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.

**1.1.3** Only tanks built to the requirements stated in this specification may be identified as 15LF tanks. Tanks built to dimensions other than listed in Table 1 are outside the scope of this specification.

**1.1.4** This specification has requirements given in two alternate systems of units. The manufacturer shall comply with the US Customary (USC) units. The SI unit equivalent is provided for convenience.

NOTE Per API document style, SI unit values appear first, followed by their USC equivalents in parentheses.

### 1.2 Compliance

**1.2.1** The manufacturer is responsible for complying with all the provisions of this specification. The purchaser may make any investigation necessary to satisfy himself or herself of manufacturer compliance and may reject any material that does not comply with this specification. The purchaser may wish to avail himself or herself of this right and furnish their own inspection independently or by supervisory inspection furnished by the manufacturer.

**1.2.2** This specification is not intended to cover storage tanks that are to be erected in areas subject to regulations more stringent than the requirements contained in this specification. When this document is specified for such tanks, it should be followed insofar as it does not conflict with regulatory requirements.

**1.2.3** Once the tank has been placed into service, it should be maintained according to API 12R1, API 653, or an owner program specifically designed for tank maintenance.

## 2 Normative References

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any addenda) applies.

AISC<sup>1</sup> *American Institute of Steel Construction Manual*, 15<sup>th</sup> Edition

API Specification 5L, *Specification for Line Pipe*

API 12R1, *Recommended Practice for Setting, Maintenance, Inspection, Operation, and Repair of Tanks in Production Service*

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<sup>1</sup> American Institute of Steel Construction, 130 East Randolph, Suite 2000, Chicago, Illinois 60601, [www.aisc.org](http://www.aisc.org)