

# Pressure-relieving and Depressuring Systems

API STANDARD 521  
SIXTH EDITION, JANUARY 2014



AMERICAN PETROLEUM INSTITUTE

## Special Notes

API publications necessarily address problems of a general nature. With respect to particular circumstances, local, state, and federal laws and regulations should be reviewed.

Neither API nor any of API's employees, subcontractors, consultants, committees, or other assignees make any warranty or representation, either express or implied, with respect to the accuracy, completeness, or usefulness of the information contained herein, or assume any liability or responsibility for any use, or the results of such use, of any information or process disclosed in this publication. Neither API nor any of API's employees, subcontractors, consultants, or other assignees represent that use of this publication would not infringe upon privately owned rights.

API publications may be used by anyone desiring to do so. Every effort has been made by the Institute to assure the accuracy and reliability of the data contained in them; however, the Institute makes no representation, warranty, or guarantee in connection with this publication and hereby expressly disclaims any liability or responsibility for loss or damage resulting from its use or for the violation of any authorities having jurisdiction with which this publication may conflict.

API publications are published to facilitate the broad availability of proven, sound engineering and operating practices. These publications are not intended to obviate the need for applying sound engineering judgment regarding when and where these publications should be utilized. The formulation and publication of API publications is not intended in any way to inhibit anyone from using any other practices.

Any manufacturer marking equipment or materials in conformance with the marking requirements of an API standard is solely responsible for complying with all the applicable requirements of that standard. API does not represent, warrant, or guarantee that such products do in fact conform to the applicable API standard.

Users of this standard should not rely exclusively on the information contained in this document. Sound business, scientific, engineering, and safety judgment should be used in employing the information contained herein.

Work sites and equipment operations may differ. Users are solely responsible for assessing their specific equipment and premises in determining the appropriateness of applying the standard. At all times users should employ sound business, scientific, engineering, and judgment safety when using this standard.

Copyright reserved. No part of this work may be reproduced, translated, stored in a retrieval system, or transmitted by any means, electronic, mechanical, photocopying, recording, or otherwise, without prior written permission from the publisher. Contact the Publisher, API Publishing Services, 1220 L Street, NW, Washington, DC 20005.

## Foreword

Nothing contained in any API publication is to be construed as granting any right, by implication or otherwise, for the manufacture, sale, or use of any method, apparatus, or product covered by letters patent. Neither should anything contained in the publication be construed as insuring anyone against liability for infringement of letters patent.

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 document was produced under API standardization procedures that ensure appropriate notification and participation in the developmental process and is designated as an API standard. Questions concerning the interpretation of the content of this publication or comments and questions concerning the procedures under which this publication was developed should be directed in writing to the Director of Standards, American Petroleum Institute, 1220 L Street, NW, Washington, DC 20005. Requests for permission to reproduce or translate all or any part of the material published herein should also be addressed to the director.

Generally, API standards are reviewed and revised, reaffirmed, or withdrawn at least every five years. A one-time extension of up to two years may be added to this review cycle. Status of the publication can be ascertained from the API Standards Department, telephone (202) 682-8000. A catalog of API publications and materials is published annually by API, 1220 L Street, NW, Washington, DC 20005.

Suggested revisions are invited and should be submitted to the Standards Department, API, 1220 L Street, NW, Washington, DC 20005, [standards@api.org](mailto:standards@api.org).

Currently in preview, click buy full version

## Contents

	Page
<b>1 Scope</b> .....	<b>1</b>
<b>2 Normative References</b> .....	<b>1</b>
<b>3 Terms, Definitions, Acronyms, and Abbreviations</b> .....	<b>1</b>
<b>3.1 Terms and Definitions</b> .....	<b>1</b>
<b>3.2 Acronyms and Abbreviations</b> .....	<b>10</b>
<b>4 Causes of Overpressure and Their Relieving Rates</b> .....	<b>11</b>
<b>4.1 General</b> .....	<b>11</b>
<b>4.2 Overpressure Protection Philosophy</b> .....	<b>12</b>
4.2.1 Hierarchy of Protective Measures .....	12
4.2.2 Use of Administrative Controls if Corrected Hydrotest Pressure Not Exceeded .....	12
4.2.3 Double Jeopardy .....	13
4.2.4 Latent Failures .....	13
4.2.5 Operator Error/Effect of Operator Response .....	13
4.2.6 Role of Instrumentation in Overpressure Protection .....	14
<b>4.3 Determination of Individual Relieving Rates</b> .....	<b>14</b>
4.3.1 General Philosophy .....	14
4.3.2 Effects of Pressure, Temperature, and Composition .....	15
4.3.3 Dynamic Simulation .....	15
<b>4.4 Individual Overpressure Causes and Their Relieving Rates</b> .....	<b>16</b>
4.4.1 General .....	16
4.4.2 Closed Outlets .....	16
4.4.3 Cooling or Reflux Failure .....	18
4.4.4 Absorbent Flow Failure .....	20
4.4.5 Accumulation of Noncondensables .....	20
4.4.6 Entrance of Volatile Material into the System .....	20
4.4.7 Overfilling .....	21
4.4.8 Failure of Automatic Controls .....	22
4.4.9 Abnormal Process Heat or Vapor Input .....	26
4.4.10 Internal Explosions or Transient Pressure Surges .....	29
4.4.11 Chemical Reaction .....	30
4.4.12 Hydraulic Expansion .....	31
4.4.13 Fires .....	36
4.4.14 Heat Transfer Equipment Failure .....	54
4.4.15 Utility Failure .....	58
4.4.16 Overpressure Prevention During Maintenance .....	60
<b>4.5 Guidance on Vacuum Relief</b> .....	<b>61</b>
4.5.1 General .....	61
4.5.2 Causes for Vacuum .....	61
4.5.3 Protection Against Vacuum .....	62
<b>4.6 Vapor Depressuring</b> .....	<b>62</b>
4.6.1 General .....	62
4.6.2 Initiation of Depressuring .....	63
4.6.3 Low Temperatures During Depressuring .....	63
4.6.4 Application Criteria .....	64
4.6.5 Acceptance and Design Criteria .....	64
4.6.6 Depressuring Rate .....	66
4.6.7 Vapor Flows .....	66

<b>4.7</b>	<b>Relief System Design Documentation</b>	<b>71</b>
4.7.1	General	71
4.7.2	Purpose of Documentation	71
4.7.3	Potential Elements of Relief System Design Documentation	71
<b>4.8</b>	<b>Flare Header Design Documentation</b>	<b>75</b>
<b>4.9</b>	<b>Special Considerations for Individual PRDs</b>	<b>6</b>
4.9.1	General	71
4.9.2	Liquid-Vapor Mixture and Solids Formation	76
4.9.3	Location of a PRD in a Normally Liquid System	76
4.9.4	Multiple PRDs	76
<b>5</b>	<b>Disposal Systems</b>	<b>77</b>
<b>5.1</b>	<b>General</b>	<b>77</b>
<b>5.2</b>	<b>Fluid Properties That Influence Selection and Design of Disposal Systems</b>	<b>77</b>
5.2.1	Physical, Chemical, and Reactive Properties	77
5.2.2	Temperature	78
5.2.3	Hazardous and Nuisance Properties	79
5.2.4	Viscosity and Solidification	79
5.2.5	Miscibility	79
5.2.6	Recovery Value	80
<b>5.3</b>	<b>System Design Load</b>	<b>80</b>
5.3.1	General	80
5.3.2	Loads from Pressure Systems	80
5.3.3	Establishing Design Load for the Disposal System	81
5.3.4	Refinement of the Disposal System Design Load	82
<b>5.4</b>	<b>System Arrangement</b>	<b>82</b>
5.4.1	General	82
5.4.2	Single-device Disposal Systems	83
5.4.3	Multiple-device Disposal System	84
5.4.4	Header Segregation	84
<b>5.5</b>	<b>Piping</b>	<b>85</b>
5.5.1	General	85
5.5.2	Backpressure	86
5.5.3	Line Sizing	86
5.5.4	Multiple-relief Scenario	87
5.5.5	Isothermal Pressure Drop Calculation Method	87
5.5.6	Lapple Pressure Drop Calculation Method	90
5.5.7	Fanno Line Pressure Drop Calculation Method	93
5.5.8	Nonideal Gas Behavior	93
5.5.9	Frictional Resistance of Fittings ( <i>K</i> -factors)	94
5.5.10	Mixed-Phase Fluids	94
5.5.11	Mechanical Design of the Disposal System	97
5.5.12	Acoustic Fatigue	97
5.5.13	Setting the Mechanical Design Temperature for Flare Headers	100
5.5.14	Reaction Forces	100
5.5.15	Shock Loading	101
5.5.16	Pipe Anchors, Guides, and Supports	101
5.5.17	Self-draining/Heat Tracing	101
5.5.18	Routing of Discharge Piping/Sloping	101
<b>5.6</b>	<b>Disposal to a Lower-pressure System</b>	<b>102</b>
<b>5.7</b>	<b>Disposal to Flare</b>	<b>102</b>
5.7.1	General	102
5.7.2	Combustion Properties	103

	Page	
5.7.3	Combustion Methods . . . . .	112
5.7.4	Flare Systems Designs . . . . .	120
5.7.5	Sizing . . . . .	122
5.7.6	Purging . . . . .	124
5.7.7	Ignition of Flare Gases . . . . .	127
5.7.8	Liquid Seal Drum . . . . .	138
5.7.9	Flare Knockout Drum . . . . .	139
5.7.10	Siting Considerations for the Flare . . . . .	140
5.7.11	Flare Gas Recovery Systems . . . . .	140
<b>5.8</b>	<b>Disposal to Atmosphere . . . . .</b>	<b>144</b>
5.8.1	General . . . . .	144
5.8.2	Formation of Flammable Mixtures . . . . .	144
5.8.3	Exposure to Toxic Vapors or Corrosive Chemicals . . . . .	151
5.8.4	Ignition of a Relief Stream at the Point of Emission . . . . .	152
5.8.5	Excessive Noise Levels . . . . .	154
5.8.6	Air Pollution . . . . .	154
5.8.7	Knockout Drums Venting to Atmosphere . . . . .	154
5.8.8	Disposal Through Common Vent Stack . . . . .	156
5.8.9	Sewer . . . . .	157
5.8.10	Vent Stacks . . . . .	157
<b>5.9</b>	<b>Design Details for Seal and Knockout Drums . . . . .</b>	<b>161</b>
<b>Annex A</b>	<b>An Analytical Methodology for Fire Evaluations . . . . .</b>	<b>163</b>
<b>Annex B</b>	<b>Special System Design Considerations . . . . .</b>	<b>181</b>
<b>Annex C</b>	<b>Sample Calculations . . . . .</b>	<b>184</b>
<b>Annex D</b>	<b>Typical Details and Sketches . . . . .</b>	<b>224</b>
<b>Annex E</b>	<b>High-integrity Protection Systems (HIPS) . . . . .</b>	<b>227</b>
<b>Bibliography</b>	<b>. . . . .</b>	<b>233</b>

**Figures**

<b>1</b>	<b>Average Rate of Heating Steel Plates Exposed to Open Gasoline Fire on One Side . . . . .</b>	<b>39</b>
<b>2</b>	<b>Effect of Overheating Carbon Steel (ASTM A515, Grade 70) . . . . .</b>	<b>40</b>
<b>3</b>	<b>Isothermal Flow Charts . . . . .</b>	<b>89</b>
<b>4</b>	<b>Adiabatic Flow of <math>\gamma = 1.0</math> (i.e. Isothermal Flow) Compressible Fluids Through Pipes at High Pressure Drops . . . . .</b>	<b>91</b>
<b>5</b>	<b>Flame Length vs Heat Release—Industrial Sizes and Releases (SI Units) . . . . .</b>	<b>109</b>
<b>6</b>	<b>Flame Length vs Heat Release—Industrial Sizes and Releases (USC Units) . . . . .</b>	<b>110</b>
<b>7</b>	<b>Approximate Flame Distortion Due to Lateral Wind on Jet Velocity from Flare Stack . . . . .</b>	<b>111</b>
<b>8</b>	<b>Steam Injected Smokeless Flare Tips . . . . .</b>	<b>116</b>
<b>9</b>	<b>Typical Flare Systems . . . . .</b>	<b>118</b>
<b>10</b>	<b>Flare Structures . . . . .</b>	<b>121</b>
<b>11</b>	<b>Flare-ring Seal—Buoyancy Seal . . . . .</b>	<b>125</b>
<b>12</b>	<b>Determination of Drag Coefficient . . . . .</b>	<b>137</b>
<b>13</b>	<b>Typical Flare Gas Recovery System . . . . .</b>	<b>141</b>
<b>14</b>	<b>Flare Gas Recovery Inlet Pressure . . . . .</b>	<b>143</b>
<b>15</b>	<b>Maximum Downwind Vertical Distance from Jet Exit to Lean-flammability Concentration Limit for Petroleum Gases . . . . .</b>	<b>148</b>

16	Maximum Downwind Horizontal Distance from Jet Exit to Lean-flammability Concentration Limit for Petroleum Gases	149
17	Axial Distance to Lean- and Rich-flammability Concentration Limits for Petroleum Gases	150
18	Sound Pressure Level at 30 m (100 ft) from the Stack Tip	160
A.1	Effect of Fuel Air Stoichiometry on Pool and Jet Fire Heat Fluxes	163
A.2	Typical Effect of Wall Temperature on Absorbed Heat Flux for Pool Fires	166
A.3	Illustration of Actual Stress Compared with the UTS for a Fire Exposed Pipe That is Depressurized	171
A.4	Fire Depressurization Work Flow Diagram	174
A.5	Minimum Depressuring Rates to Avoid Failure of a Gas-filled Vessel Fabricated from SA-516 Carbon Steel and Exposed to a Pool Fire	178
A.6	Vapor Pressure and Heat of Vaporization of Pure, Single-component Paraffin Hydrocarbon Liquids	180
B.1	Typical Flow Scheme of a System Involving a Single PRD Serving Components in a Process System with Typical Pressure Profiles	182
C.1	Equilibrium Phase Diagram for a Given Liquid	185
C.2	Dimensional References for Sizing a Flare Stack	190
C.3	Flame Center for Flares and Ignited Vents—Horizontal Distance, $x_c$ (SI Units)	196
C.4	Flame Center for Flares and Ignited Vents—Horizontal Distance, $x_c$ (USC Units)	197
C.5	Flame Center for Flares and Ignited Vents—Vertical distance, $y_c$ (SI Units)	198
C.6	Flame Center for Flares and Ignited Vents—Vertical distance, $y_c$ (USC Units)	199
C.7	Flare Knockout Drum	203
C.8	Use of the Analytical Method to Reproduce API Fire Test Data (See Plate 2 of Figure 1)	211
C.9	Use of the Analytical Method to Reproduce API Figure 1, Plates 4, and 5	212
C.10	BRL Test Data Illustrating Fire Temperature vs Time at the Top of the Front and Rear Walls of a Rail Tank Car Containing LPG and Exposed to a JP-4 Pool Fire [30]	212
C.11	BRL Test Data Illustrating Wall Temperature vs Time at the Top of the Front and Rear Walls of a Rail Tank Car Containing LPG and Exposed to a JP-4 Pool Fire [30]	213
C.12	Use of the Analytical Method to Reproduce BRL Fire Test Data (Constant Fire Temperature)	213
C.13	BAM Test Data Illustrating Fire Temperature vs Time at Various Locations Around a Rail Tank Car Containing LPG and Exposed to a Fuel Oil Pool Fire [109]	215
C.14	BAM Test Data Illustrating Wall Temperature vs Time at Various Locations Around a Rail Tank Car Containing LPG and Exposed to a Fuel Oil Pool Fire [109]	215
C.15	Use of the Analytical Method to Reproduce BAM Fire Test Data (Variable Fire Temperature)	217
C.16	Use of the Analytical Method to Reproduce BAM Fire Test Data (Constant Fire Temperature)	217
C.17	Liquid Temperature vs Time Profile from the BAM Fire Test [109]	219
C.18	Comparison of the API Empirical Method and the Analytical Method with BRL Fire Test Data	221
C.19	Calculated Wetted Area Exponent of the API Empirical Method Equation (7) Based on BRL Fire Test Data	221
D.1	Typical Horizontal Flare Seal Drum	224
D.2	Quench Drum	225
D.3	Typical Flare Installation	226

#### Tables

1	Guidance for Required Relieving Rates Under Selected Conditions	17
2	Typical Values of Cubic Expansion Coefficient for Hydrocarbon Liquids and Water	32
3	Values of Linear Expansion Coefficient, $\alpha$ , and Modulus of Elasticity, $E$	35
4	Effects of Fire on the Wetted Surfaces of a Vessel	38
5	Environment Factor	41
6	Thermal Conductivity Values for Typical Thermal Insulations	49
7	Possible Utility Failures and Equipment Affected	59
8	Design Basis for PRD Laterals and Disposal System Headers	83
9	Typical $K$ -factors for Pipe Fittings	92

10	Typical $K$ -factors for Reducers (Contraction or Enlargement)	93
11	Exposure Times Necessary to Reach the Pain Threshold	105
12	Recommended Design Thermal Radiation for Personnel	106
13	Radiation from Gaseous Diffusion Flames	108
14	Suggested Injection Steam Rates	114
A.1	Comparison of Heat Absorption Rates in Fire Tests	115
A.2	Typical Range in Equation (A.1) Parameters for an Open Pool Fire	169
A.3	Recommended Values for Equation (A.1) Parameters for an Open Pool Fire Where Other Data or Information are Unavailable	169
A.4	Typical Range in Equation (A.1) Parameters for a Jet Fire	170
A.5	Recommended Values for Equation (A.1) Parameters for a Jet Fire Where Other Data or Information are Unavailable	171
A.6	Typical Starting Points for Step 1 in Figure A.4 when Designing Depressurization System for Unwetted Walls Exposed to Jet Fires	175
A.7	High-temperature Tensile Strength of Carbon Steel and 18-8 Stainless Steel [154]	178
C.1	Optimizing the Size of a Horizontal Knockout Drum (SI Units)	206
C.2	Optimizing the Size of a Horizontal Knockout Drum (USC Units)	206
C.3	Equation (A.1) Parameters Used to Reproduce Curves in Figure 1	210
C.4	Equation (A.1) Parameters Used to Reproduce BRL Fire Test Data for the Rail Tank Car Top Front and Rear Wall Temperatures vs Time	214
C.5	Equation (A.1) Parameters Used to Reproduce BAM Fire Test Data for the Rear Locations of the Rail Tank Car Temperatures vs Time	216
C.6	Comparison of Absorbed Heat Duties Calculated with the A-1/F Empirical and Analytical Method Applying the BAM Fire Test Data	219
E.1	SIL vs Availability	230

## Introduction

The portions of this standard dealing with flares and flare systems are an adjunct to API Standard 537 [8], which addresses mechanical design, operation, and maintenance of flare equipment. It is important for all parties involved in the design and use of a flare system to have an effective means of communicating and preserving design information about the flare system. To this end, API has developed a set of flare datasheets, which can be found in API 537, Appendix E. The use of these datasheets is both recommended and encouraged as a concise, uniform means of recording and communicating design information.

The Bibliography lists the documents that are referenced informatively in this standard, as well as other documents not cited in this standard but which contain additional useful information. Some of the content of the documents listed might not be suitable for all applications and therefore needs to be assessed for each application before use.

In this standard, quantities are expressed in the International System (SI) of units and the U.S. customary (USC) units.

# Pressure-relieving and Depressuring Systems

## 1 Scope

This standard is applicable to pressure-relieving and vapor depressuring systems. Although intended for use primarily in oil refineries, it is also applicable to petrochemical facilities, gas plants, liquefied natural gas (LNG) facilities, and oil and gas production facilities. The information provided is designed to aid in the selection of the system that is most appropriate for the risks and circumstances involved in various installations.

This standard specifies requirements and gives guidelines for the following:

- examining the principal causes of overpressure;
- determining individual relieving rates;
- selecting and designing disposal systems, including such component parts as piping, vessels, flares, and vent stacks.

This standard does not apply to direct-fired steam boilers.

## 2 Normative References

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

API Standard 520-1:2008 <sup>[5]</sup>, *Sizing, Selection, and Installation of Pressure-Relieving Devices in Refineries—Part 1, Sizing and Selection*

API Recommended Practice 520-2:2003 <sup>[6]</sup>, *Sizing, Selection, and Installation of Pressure-Relieving Devices in Refineries—Part 2, Installation*

## 3 Terms, Definitions, Acronyms, and Abbreviations

### 3.1 Terms and Definitions

For the purposes of this document, the following definitions apply.

#### 3.1.1

##### **accumulation**

Pressure increase over the maximum allowable working pressure (MAWP) of the vessel during discharge through the pressure-relief device.

NOTE Accumulation is expressed in units of pressure or as a percentage of MAWP or design pressure. Maximum allowable accumulations are established by pressure design codes for emergency operating and fire contingencies.

#### 3.1.2

##### **administrative controls**

Procedures intended to ensure that personnel actions do not compromise the overpressure protection of the equipment.