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2007 ASME Boiler & Pressure Vessel Code

2008a Addenda

July 1, 2008

I RULES FOR CONSTRUCTION OF POWER BOILERS

ASME Boiler and Pressure Vessel Committee
Subcommittee on Power Boilers



The American Society of
Mechanical Engineers



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2007 ASME

BOILER AND PRESSURE VESSEL CODE

SECTIONS

- I Rules for Construction of Power Boilers
- II Materials
 - Part A — Ferrous Material Specifications
 - Part B — Nonferrous Material Specifications
 - Part C — Specifications for Welding Rods, Electrodes, and Filler Metal
 - Part D — Properties (Customary)
 - Part D — Properties (Metric)
- III Rules for Construction of Nuclear Facility Components
 - Subsection NCA — General Requirements for Division 1 and Division 2
 - Division 1
 - Subsection NB — Class 1 Components
 - Subsection NC — Class 2 Components
 - Subsection ND — Class 3 Components
 - Subsection NE — Class MC Component
 - Subsection NF — Supports
 - Subsection NG — Core Support Structures
 - Subsection NH — Class 1 Components in Elevated Temperature Service
 - Appendices
 - Division 2 — Code for Concrete Containments
 - Division 3 — Containments for Transportation and Storage of Spent Nuclear Fuel and High Level Radioactive Material and Waste
- IV Rules for Construction of Heating Boilers
- V Nondestructive Examination
- VI Recommended Rules for the Care and Operation of Heating Boilers
- VII Recommended Guidelines for the Care of Power Boilers
- VIII Rules for Construction of Pressure Vessels
 - Division 1
 - Division 2 — Alternative Rules
 - Division 3 — Alternative Rules for Construction of High Pressure Vessels
- IX Welding and Brazing Qualifications
- X Fiber-Reinforced Plastic Pressure Vessels
- XI Rules for Inservice Inspection of Nuclear Power Plant Components
- XII Rules for Construction and Continued Service of Transport Tanks

ADDENDA

Colored-sheet Addenda, which include additions and revisions to individual Sections of the Code, are published annually and will be sent automatically to purchasers of the applicable Sections up to the publication of the 2010 Code. The 2007 Code is available only in the loose-leaf format; accordingly, the Addenda will be issued in the loose-leaf, replacement-page format.

INTERPRETATIONS

ASME issues written replies to inquiries concerning interpretation of technical aspects of the Code. The Interpretations for each individual Section will be published separately and will be included as part of the update service to that Section. Interpretations of Section III, Divisions 1 and 2, will be included with the update service to Subsection NCA.

Interpretations of the Code are distributed annually in July with the issuance of the edition and subsequent addenda. Interpretations posted in January at www.cstools.asme.org/interpretations are included in the July distribution.

CODE CASES

The Boiler and Pressure Vessel Committee meets regularly to consider proposed additions and revisions to the Code and to formulate Cases to clarify the intent of existing requirements or provide, when the need is urgent, rules for materials or constructions not covered by existing Code rules. Those Cases that have been adopted will appear in the appropriate 2007 Code Cases book, “Boilers and Pressure Vessels” and “Nuclear Components.” Supplements will be sent automatically to the purchasers of the Code Cases books up to the publication of the 2010 Code.

SUMMARY OF CHANGES

Addenda to the 2007 Edition of the Code are issued in the form of replacement pages. Revisions, additions, or deletions are incorporated directly into the affected pages. It is advisable, however, that all replaced pages be retained for reference.

Replace or insert the pages listed. Changes given below are identified on the pages by a margin note, **A08**, placed next to the affected area. Revisions to the 2007 Edition are indicated by **07**. For the listing below, the *Page* references the affected area. A margin note, **A08**, placed next to the heading indicates *Location*. Revisions are listed under *Change*.

The Record Numbers listed below are explained in more detail in “List of Changes in Record Number Order” following the Summary of Changes.

<i>Page</i>	<i>Location</i>	<i>Change (Record Number)</i>
xix–xxix	Roster	Updated to reflect 2008 Addenda
xxxi	Preamble	(1) First sentence revised (07-1776) (2) Footnote 5 added (07-1776)
1	PG-2.4	Added (07-334)
2	PG-5.6	Added (06-1382)
5	PG-9.2	Entries added (03-425, 01-416)
6	PG-9.4	Revised (04-1627)
10	PG-19	Footnote 1 revised (07-1744)
11	Table PG-19	Last row added (03-425)
13–19.3	PG-26	Added (07-1670)
	Table PG-26	Added (07-1670)
	PG-27.2	PG-27.2.1, PG-27.2.1.1, PG-27.2.1.2, PG-27.2.1.5, and PG-27.2.2 revised (04-1670)
	PG-27.3	Nomenclature revised (04-1627)
	PG-27.4	(1) Note (1) revised (07-1670) (2) Note (3) revised (07-50) (3) Note (6) revised (03-425, 01-416) (4) Note (11) added (04-1627)
	PG-29.1	Variable w added to equation and nomenclature (07-1670)
	PG-29.11	Variable w added to equation and nomenclature (07-1670)
	PG-31.2	Definitions of t_f and t_h revised (02-2580)
32	PG-32.1.2	In the nomenclature, definition of t revised (02-2580)
37	Fig. PG-52.1	In General Note (a), “Fig. PG-53.1” corrected to “Fig. PG-52.1” by errata (07-714)
45, 46	PG-60.1	Revised (06-127)
	PG-60.1.6	Second paragraph revised (07-1816)
47	PG-60.3.7(e)	Added (07-1816)

(c)



<i>Page</i>	<i>Location</i>	<i>Change (Record Number)</i>
	Fig. PG-60.3.7	Added (07-1816)
	Fig. PG-60.3.9	Title revised (07-1816)
	PG-60.3.9	Figure reference revised (07-1816)
48	Safety Valves and Safety Relief Valves	Footnote 20 corrected by errata (07-306)
49	PG-67.2.4	Metric value corrected by errata (08-115)
	PG-67.2.6	Metric value corrected by errata (08-115)
	PG-67.3	Last sentence added (07-518)
52, 52.1	PG-68.3	(1) Second metric value corrected by errata (08-115) (2) Last sentence added (06-567)
92	Table PW-39	(1) Third and fourth columns revised (06-1589) (2) General Note (a)(6) corrected by errata (07-1532) (3) General Note (a)(11)(f) redesignated to (a)(13) by errata (07-1302)
93	Table PW-39	(1) Third column revised (06-1589) (2) General Note (a)(6) corrected by errata (07-1532) (3) General Note (a)(8)(c)(3) redesignated to (a)(9) by errata (07-1302)
94	Table PW-39	(1) Third and fourth columns revised (06-1589) (2) General Note (a)(6)(e) redesignated to (a)(7) by errata (07-1302) (3) General Note (a)(8) added (07-466)
95	Table PW-39	(1) Third and fourth columns revised (06-1589) (2) General Note (d) added (07-466)
96	Table PW-39	(1) Fourth column revised (06-1589) (2) General Note (b) added (07-466) (3) Last sentence added to Note (4)(d) (07-1267)
97	Table PW-39	Third and fourth columns revised (06-1589)
98	Table PW-39	(1) Third and fourth columns revised (2) First parenthetical temperature revised in General Note (a) (06-1589)
99	Table PW-39	(1) Third, fourth, and fifth columns revised (2) First parenthetical temperature revised in General Note (06-1589)
105.1, 105.3	PW-44	Added (04-1627)
153	PHRSG-4(b)	Last sentence added (07-1775)
	Table PHRSG-4	Added (07-1775)
181	A-125	Nomenclature revised (07-1670)
191	A-317.2.1	Last entry added to nomenclature (07-1670)
192, 192.1	A-317.3	Nomenclature revised (07-1670)

(d)



<i>Page</i>	<i>Location</i>	<i>Change (Record Number)</i>
232	Table A-360	(1) The first two publications under ASNT Specification revised (06-12) (2) Note (1) deleted, and subsequent notes renumbered (07-105)
233	Form A-370	Number 2 added under "E" Code Symbol Stamp (07-1300)

NOTE:

Volume 58 of the Interpretations to Section I of the ASME Boiler and Pressure Vessel Code follows this page of this Addenda.

(e)



LIST OF CHANGES IN RECORD NUMBER ORDER

Record Number	Change
01-416	Revised PG-9.2, PG-27.4, and Note (6) to incorporate UNS N06625 material for steam service.
02-2580	Revised definition of "tf" and "th" in PG-32.1.2 and definition of "t" in PG-32.1.2.
03-425	Revised PG-9.2; PG-27.4, Note (6); and Table PG-19 to incorporate Code Case 2226-2.
04-1627	Revised PG-9.4, PG-27.2.1, PG-27.2.1.1, PG-27.2.1.2, PG-27.2.1.5, and PG-27.3, and added Note (1) to PG-27.4 and PW-44 to permit inclusion of clad thickness in the calculated strength of boiler tubes.
06-12	Revised Table A-360 to indicate adoption of SNT-TC-1A-2006 and CP-189-2006.
06-127	(a) Revised the text of PG-60.1 to preclude designs incorporating cross-webbed construction and better describe the requirements for gage glass designs incorporating multiple sections, as well as the conditions that will allow omitting overlapping of the adjacent sections. (b) Inserted new footnote for PG-60.1, and renumbered the existing footnotes.
06-567	(a) Revised PG-68.1 to clarify that the location rules of PG-68.3 and mounting rules of PG-71 apply to safety relief valves for separately fired superheaters. (b) Issued intent interpretation.
06-1082	Added new paragraph PG-5.6 to provide guidance on the necessary actions, if during any phase of construction or erection, a component is heated to a temperature greater than 1,475°F (800°C).
06-1589	(a) Cooling rate "60°C/hr" in Table PW-39, Note (1) for P-No. 7 and 10I revised to "55°C/hr." (b) Minimum holding time "2 min/mm" in Table PW-39 for P-Nos. 1, 3, 5A, 5B (Group Nos. 1 and 2), 6, 7, and 10I revised to "1 hr/25 mm."
07-50	Deleted PG-27.4, Note (3)(d), and revised the "Value of C" table in PG-27.4, Note (3) so that it pertains to threaded sections or pipe.
07-105	Deleted Note (1) in Table A-360.
07-306	Editorially corrected PG-67, Note (19).
07-334	Added PG-2.4 to clarify service limitations as applied to thermal fluid heaters.
07-466	Incorporated Code Case 2578 by revising Table PW-39, P-No. 4, P-No. 5A, and P-No. 5B materials to include the exemption of PWHT for attaching bare thermocouple wire by CDW and ERW.
07-518	Revised PG-67.3 to clarify the set pressure of Economizer Safety Relief Devices.
07-714	Fig. PG-52.1 corrected by errata.
07-1267	Added Note (4)(d) of Table PW-39 for P-No. 5B, Group No. 2 materials to direct the user to document the use of Note (4)(d) on the Manufacturer's Data Report.
07-1300	Revised A-370 Guide to Information Appearing on Certificate of Authorization for "E" code symbol stamp to cover design and assembly of electric boilers at the location shown on the certificate of authorization and field sites controlled by the location.
07-1302	Revised Table PW-39 for P-No.1, P-No.3, and P-No.4 to correctly format the listed conditions for exemption from PWHT requirements for stud welding of nonload-carrying studs.
07-1532	Table PW-39 corrected by errata.
07-1670	Added para. F-26 and Table PG-26 to impose weld joint strength reduction factors on certain welds, primarily longitudinal and spiral, designed for service in the creep regime. New factor "w" was incorporated into equation in PG-27 (cylindrical components), PG-29 (heads), A-125 (thick-wall cylinder formula), and A-370 (alternative equation for cylinders under internal pressure).
07-1744	Corrected Footnote 8 reference to Appendix A-370.
07-1775	Revised PHRS-4(b), and added Table PHRS-4.
07-1776	Added PHRS to the list of devices in the Preamble.
07-181	(a) In PG-60.1.6, added reference to PG-60.3.7(a) through (e) where examples on acceptable "flow through" valve construction are listed. (b) In PG-60.3.7, added (e) defining the acceptable "Y Pattern" globe valve construction, including printing the figure used in B31.1 as new Fig. PG-60.3.7. (c) Redesignated Fig. PG-60 as Fig. PG-60.3.9, and corrected the reference to that figure in PG-60.3.9.
03-115	Paras. PG-32, PG-67, and PG-68 corrected by errata.



CONTENTS

Foreword		xv
Statements of Policy		vii
Personnel		x
Preamble		xi
Summary of Changes		xiii
List of Changes in BC Order		xxxvi
PART PG	GENERAL REQUIREMENTS FOR ALL METHODS OF CONSTRUCTION	1
General		
PG-1	Scope	1
PG-2	Service Limitations	1
PG-3	Referenced Standards	1
PG-4	Units	1
Materials		
PG-5	General	2
PG-6	Plate	2
PG-7	Forgings	3
PG-8	Castings	3
PG-9	Pipes, Tubes, and Pressure Containing Parts	3
PG-10	Material Identified With or Produced to a Specification Not Permitted by This Section, and Material Not Fully Identified	6
PG-11	Miscellaneous Pressure Parts	7
PG-12	Water Level Indicators and Connector Materials	8
PG-13	Stays	9
PG-14	Rivets	9
Design		
PG-16	General	9
PG-17	Fabrication by a Combination of Methods	10
PG-18	Design Validation by Proof Test	10
PG-19	Cold Forming of Austenitic Materials	10
PG-20	Maximum Allowable Working Pressure	10
PG-22	Loadings	11
PG-23	Stress Values for Calculation Formulas	12
PG-25	Quality Factors for Steel Castings	12
PG-27	Cylindrical Components Under Internal Pressure	13
PG-28	Welded Access or Inspection Openings Under External Pressure	16
PG-29	Dished Heads	16
PG-30	Stayed Dished Heads	18
PG-31	Unstayed Flat Heads and Covers	18

Openings and Compensation

PG-32	Openings in Shells, Headers, and Heads	21
PG-33	Compensation Required for Openings in Shells and Formed Heads.....	25
PG-34	Flanged-in Openings in Formed Heads	28
PG-35	Compensation Required for Openings in Flat Unstayed Heads and Flat Stayed Plates	28
PG-36	Limits of Metal Available for Compensation	28
PG-37	Strength of Compensation	29
PG-38	Compensation for Multiple Openings.....	29
PG-39	Methods of Attachment of Pipe and Nozzle Necks to Vessel Walls	30
PG-42	General Requirements for Fittings, Flanges, and Valves	31
PG-43	Nozzle Neck Thickness	31
PG-44	Inspection Openings	31
PG-46	Stayed Surfaces	34
PG-47	Staybolts	35
PG-48	Location of Staybolts	35
PG-49	Dimensions of Staybolts	36
PG-52	Ligaments	36
PG-53	Ligaments	38
PG-55	Supports and Attachment Lugs	39

Boiler External Piping and Boiler Proper Connections

PG-58	Outlets and External Piping	39
PG-59	Application Requirements for the Boiler Proper	43

Design and Application

PG-60	Requirements for Miscellaneous Pipe, Valves, and Fittings	45
PG-61	Feedwater Supply	48

Safety Valves and Safety Relief Valves

PG-67	Boiler Safety Valve Requirements	48
PG-68	Superheater and Reheater Safety Valve Requirements.....	52
PG-69	Certification of Capacity of Safety and Safety Relief Valves.....	52
PG-70	Capacity of Safety Valves.....	57
PG-71	Mounting.....	57
PG-72	Operation	58
PG-73	Minimum Requirements for Safety and Safety Relief Valves	58

Fabrication

PG-75	General	62
PG-76	Cutting Plates and Other Stock	62
PG-77	Plate Identification	62
PG-78	Repairs of Defects in Materials	62
PG-79	Tube Holes and Ends	62
PG-80	Permissible Out-of-Roundness of Cylindrical Shells.....	63
PG-81	Tolerance for Formed Heads	63
PG-82	Holes for Stays	63

Inspection and Tests

PG-90	General	63
PG-91	Qualification of Inspectors	65
PG-93	Inspection and Repair of Flat Plate in Corner Joints	65
PG-99	Hydrostatic Test.....	65

Certification by Stamping and Data Reports

PG-101	Heating Surface Computation.....	66
PG-104	General	66
PG-105	Code Symbol Stamps	66
PG-106	Stamping of Boilers	68
PG-107	Field Assembly	71
PG-108	Stamping for Field-Assembled Boilers.....	71
PG-109	Stamping of Pressure Piping.....	72
PG-110	Stamping of Safety Valves	72
PG-111	Location of Stampings	72
PG-112	Manufacturer's Data Report Forms.....	73
PG-113	Master Data Report Form	75

Figures

PG-28	Maximum Internal Projection of Welded Access or Inspection Openings.....	16
PG-31	Some Acceptable Types of Unstayed Flat Heads and Covers	19
PG-32	Chart Showing Limits of Sizes of Openings With Inherent Compensation in Cylindrical Shells	23
PG-33.1	Nomenclature and Formulas for Reinforced Openings.....	26
PG-33.2	Some Representative Configurations Describing the Dimensions t_e , h , and d	27
PG-33.3	Chart for Determining Value of F	28
PG-38	Illustrations of the Rule Given in PG-38.4	30
PG-42.1	Welding End Transitions Maximum Envelope.....	33
PG-46.2	Acceptable Proportions for Ends of Through-Stays	35
PG-52.1	Diagram for Determining the Efficiency of Longitudinal and Diagonal Ligaments Between Openings in Cylindrical Shells.....	37
PG-52.2	Example of Tube Spacing With Pitch of Holes Equal in Every Row.....	38
PG-52.3	Example of Tube Spacing With Pitch of Holes Unequal in Every Second Row	38
PG-52.4	Example of Tube Spacing With Pitch of Holes Varying in Every Second and Third Row	38
PG-52.5	Example of Tube Spacing With Tube Holes on Diagonal Lines.....	38
PG-52.6	Diagram for Determining Equivalent Longitudinal Efficiency of Diagonal Ligaments Between Openings in Cylindrical Shells.....	40
PG-58.3.1	Code Jurisdictional Limits for Piping — Drum Type Boilers	41
PG-58.3.2	Code Jurisdictional Limits for Piping — Forced-Flow Steam Generator With No Fixed Steam or Waterline	42
PG-59.1	Typical Boiler Bushings	44
PG-60	Typical Arrangement of Steam and Water Connections for a Water Column ...	47
PG-67.4	Requirements for Pressure Relief Forced-Flow Steam Generator	50
PG-80	Maximum Permissible Deviation From a Circular Form e for Cylindrical Parts Under External Pressure	64
PG-105.1	Official Symbols for Stamps to Denote The American Society of Mechanical Engineers' Standard for Boilers	67
PG-105.2	Official Symbol for Stamp to Denote The American Society of Mechanical Engineers' Standard for Assembly	67
PG-105.3	Official Symbol for Stamp to Denote The American Society of Mechanical Engineers' Standard for Welded Piping.....	67
PG-105.4	Official Symbol for Stamp to Denote The American Society of Mechanical Engineers' Standard for Safety Valves	67
PG-106	Form of Stamping (U.S. Customary)	69

Tables		
PG-19	Post Cold-Forming Strain Limits and Heat-Treatment Requirements.....	11
PG-39	Minimum Number of Threads Per Connection	31
PG-68.7	Superheat Correction Factor, K_{sh} (U.S. Customary)	53
PG-68.7M	Superheat Correction Factor, K_{sh} (SI).....	54
PART PW	REQUIREMENTS FOR BOILERS FABRICATED BY WELDING	76
General		
PW-1	General	76
Materials		
PW-5	General	76
Design		
PW-8	General	77
PW-9	Design of Welded Joints	77
PW-10	Heat Treatment	78
PW-11	Radiographic and Ultrasonic Examination of Welded Butt Joints.....	78
PW-13	Head-to-Flange Requirements	78
PW-14	Openings in or Adjacent to Welds	78
PW-15	Welded Connections.....	78
PW-16	Minimum Requirements for Attachment Welds.....	81
PW-19	Welded-in Stays.....	86
Fabrication		
PW-26	General	88
PW-27	Welding Processes	88
PW-28	Welding Qualification and Weld Records	88
PW-29	Base Metal Preparation	89
PW-31	Assembly.....	89
PW-33	Alignment Tolerance, Shells and Vessels (Including Pipe or Tube Used as a Shell)	90
PW-34	Alignment, Tube and Pipe.....	90
PW-35	Finished Longitudinal and Circumferential Joints	90
PW-36	Miscellaneous Welding Requirements	91
PW-38	Preheating	91
PW-39	Requirements for Postweld Heat Treatment	91
PW-40	Repair of Defects	101
PW-41	Circumferential Joints in Pipes, Tubes, and Headers	102
PW-42	Joints in Valves and Other Boiler Appurtenances.....	103
PW-43	Loading on Structural Attachments.....	104
Inspection and Tests		
PW-46	General	106
PW-47	Check of Welding Procedure	106
PW-48	Check of Welder and Welding Operator Performance Qualifications.....	106
PW-49	Check of Heat Treatment Practice.....	106
PW-50	Qualification of Nondestructive Examination Personnel	106
PW-51	Acceptance Standards for Radiography	106
PW-52	Acceptance Standards for Ultrasonic Examination	107
PW-53	Test Plates.....	107
PW-54	Hydrostatic Test.....	110

Figures		
PW-9.1	Butt Welding of Plates of Unequal Thickness	77
PW-9.2	Prohibited Welded Joint.....	78
PW-15	Examples of Weld Strength Calculations.....	80
PW-16.1	Some Acceptable Types of Welded Nozzles and Other Connections to Shells, Drums, and Headers	82
PW-16.2	Some Acceptable Forms of Welds for Lugs, Hangers, and Brackets on Shells, Drums, and Headers	86
PW-19.4(a)	Some Acceptable Types of Diagonal Braces for Installation by Welding.....	87
PW-19.4(b)	Unacceptable Types of Diagonal Braces for Installation by Welding.....	87
PW-43.1	Method of Computation of Attachments to Tubes	104
PW-43.2	Chart for Determining Load Factor, L_f	105
PW-53.1	Test Specimens From Longitudinal Welded Test Plates	108
PW-53.2	Method of Forming Longitudinal Test Plates.....	108
PW-53.3(a)	Details of Tension Test Specimens	110
PW-53.3(b)	Details of Bend Test Specimens	111
 Tables		
PW-11	Required Radiographic and Ultrasonic Examination of Welded Butt Joints	79
PW-33	Alignment Tolerance of Sections to Be Butt Welded.....	90
PW-39	Mandatory Requirements for Postweld Heat Treatment of Pressure Parts and Attachments	92
PW-39.1	Alternate Postweld Heat Treatment Requirements for Carbon and Low Alloy Steels	101
PW-43.1	Tube Attachment Angle Design Factor, K	105
PART PR	REQUIREMENTS FOR BOILERS FABRICATED BY RIVETING	112
PART PB	REQUIREMENTS FOR BOILERS FABRICATED BY BRAZING	113
General		
PB-1	General	113
 Materials		
PB-5	General	114
PB-6	Brazing Filler Metals	114
PB-7	Fluxes and Atmospheres	114
 Design		
PB-8	General	114
PB-9	Strength of Brazed Joints	114
PB-10	Brazed Joint Efficiency	115
PB-14	Application of Brazing Filler Metal	115
PB-15	Permissible Types of Joints	115
PB-16	Joint Clearance.....	115
PB-17	Joint Brazing Procedure.....	115
PB-18	Openings	115
PB-19	Brazed Connections	115
 Fabrication		
PB-26	General	116
PB-28	Qualification of Brazing Procedure.....	116
PB-29	Qualification of Brazers and Brazing Operators.....	117
PB-30	Cleaning of Surfaces to Be Brazed.....	117
PB-31	Clearance Between Surfaces to Be Brazed	117

PB-32	Postbrazing Operations.....	117
PB-33	Repair of Defective Brazing.....	117
Inspection and Tests		
PB-46	General	117
PB-47	Check of Brazing Procedure.....	117
PB-48	Brazer and Brazing Operator	118
PB-49	Visual Examination.....	118
PB-50	Exemptions.....	118
Marking and Reports		
PB-51	General	118
Figure		
PB-15	Some Acceptable Types of Brazed Joints	116
Tables		
PB-1	Maximum Design Temperatures [°F (°C)] for Brazing Filler Metal.....	114
PB-16	Recommended Joint Clearance at Brazing Temperature	116
PART PWT	REQUIREMENTS FOR WATERTUBE BOILERS	119
General		
PWT-1	General	119
Materials		
PWT-5	General	119
Design		
PWT-8	General	119
PWT-9	Tubes and Pipe	119
PWT-10	Tube Wall Thickness	119
PWT-11	Tube Connections	119
PWT-12	Staybolting Box-Type Headers.....	123
PWT-13	Staying Segment of Heads	123
PWT-14	Firing Doors.....	123
PWT-15	Access and Firing Doors.....	123
Figures		
PWT-11	Examples of Acceptable Forms of Tube Attachment	122
PWT-12.1	Box-Type Header Joint	123
PWT-12.2	Method of Forming Waterleg Joints by Welding	123
Table		
PWT-10	Maximum Allowable Working Pressures for Seamless Steel and Electric Resistance Welded Steel Tubes or Nipples for Watertube Boilers, Where Expanded Into Drums or Headers, for Different Diameters and Gages of Tubes Conforming to the Requirements of Specifications SA-178 Grade A, SA-192, and SA-226	120

PART PFT	REQUIREMENTS FOR FIRETUBE BOILERS	124
General		
PFT-1	General	124
Materials		
PFT-5	General	124
Design		
PFT-8	General	124
PFT-9	Thickness Requirements	124
PFT-10	Shell Joints	124
PFT-11	Attachment of Heads and Tubesheets.....	124
PFT-12	Tubes	125
Combustion Chambers		
PFT-13	Combustion Chamber Tubesheet.....	126
PFT-14	General	127
PFT-15	Plain Circular Furnaces	127
PFT-17	Ring-Reinforced Type	127
PFT-18	Corrugated Furnaces.....	128
PFT-19	Combined Plain Circular and Corrugated Type.....	129
PFT-20	Attachment of Furnaces.....	129
PFT-21	Fireboxes and Waterlegs	130
Stayed Surfaces		
PFT-22	General	130
PFT-23	Working Pressure for Stayed Curved Surfaces.....	131
PFT-24	Staying Horizontal Return Tube Boilers	132
PFT-25	Staying Segments of Heads	132
PFT-26	Area Supported by Stay.....	132
PFT-27	Maximum Spacing	132
PFT-28	Staybolts and Stays.....	134
PFT-29	Flexible Staybolts	134
PFT-30	Crown Bars and Girder Stays.....	134
PFT-31	Stay Tubes	135
PFT-32	Stresses in Diagonal Stays	135
Doors and Openings		
PFT-40	Welded Door Openings	136
PFT-41	Openings in Wrapper Sheets	136
PFT-42	Fireside Access Openings	136
PFT-43	Requirements for Inspection Openings.....	136
PFT-44	Opening Between Boiler and Safety Valve.....	136
Domes		
PFT-45	Requirements for Domes.....	136
Setting		
PFT-46	Method of Support	137

Piping, Fittings, and Appliances

PFT-47	Water Level Indicators.....	137
PFT-48	Feed Piping.....	138
PFT-49	Blowoff Piping.....	138
PFT-50	Thickness of Furnaces and Tubes Under External Pressure	139
PFT-51	Maximum Allowable Working Pressure	139

Figures

PFT-12.1	Some Acceptable Forms of Tube Attachment on Firetube Boilers	126
PFT-17.2	Acceptable Type of Ring-Reinforced Furnace	127
PFT-18.1	Morison Furnace	128
PFT-19	Connection Between Plain and Corrugated Furnace.....	129
PFT-20	Welding Ogee Ring	129
PFT-21	Some Acceptable Methods of Forming Waterleg Joints by Welding	130
PFT-23.1	Stayed Wrapper Sheet of Locomotive-Type Boiler.....	131
PFT-25	Example of Staying of Heads Adjacent to Cylindrical Furnaces.....	133
PFT-27	Pitch of Staybolts Adjacent to Upper Corners of Fireboxes.....	134
PFT-32	Measurements for Determining Stresses in Diagonal Stays	135
PFT-46.1	Spacing and Weld Details for Wall-Support Lugs Set in Pairs on Horizontal-Return Tubular Boilers	138
PFT-46.2	Welded Bracket Connection for Horizontal-Return Tubular Boilers.....	138

PART PFH	OPTIONAL REQUIREMENTS FOR FEEDWATER HEATER (WHEN LOCATED WITHIN SCOPE OF SECTION I RULES).....	141
PFH-1	141

PART PMB REQUIREMENTS FOR MINIATURE BOILERS 142

General

PMB-1	General	142
PMB-2	Scope	142

Materials

PMB-5	General	142
-------	---------------	-----

Design

PMB-8	General	142
PMB-9	Welding.....	142
PMB-10	Washout Openings	143
PMB-11	Feedwater Supply	143
PMB-12	Blowoff	143
PMB-13	Water Gages.....	143
PMB-14	Fixtures and Fittings.....	143
PMB-15	Safety Valves	143
PMB-16	Steam Stop Valves	143
PMB-17	Automatic Devices	143
PMB-21	Hydrostatic Tests and Inspection.....	143

PART PEB REQUIREMENTS FOR ELECTRIC BOILERS..... 145

General

PEB-1	General	145
PEB-2	Scope	145

PEB-3	Optional Requirements for the Boiler Pressure Vessel.....	145
Materials		
PEB-5	General	145
Design		
PEB-8	General	146
PEB-9	Welding	146
PEB-10	Inspection Openings	146
PEB-11	Feedwater Supply	146
PEB-12	Blowoff	146
PEB-13	Water Level Indicators.....	146
PEB-14	Pressure Gages.....	146
PEB-15	Safety Valves	146
PEB-16	Automatic Devices	147
PEB-17	Hydrostatic Test.....	147
PEB-18	Inspection and Stamping of Boilers	147
PEB-19	Manufacturer's Data Report for Electric Boilers	148
PART PVG	REQUIREMENTS FOR ORGANIC FLUID VAPORIZERS	149
General		
PVG-1	General	149
Materials		
PVG-5	General	149
Design		
PVG-8	General	149
PVG-9	General Requirements	149
PVG-10	Gage Glasses	149
PVG-11	Drain Valves.....	149
PVG-12	Safety Valves	149
Figure		
PVG-12	Constant <i>C</i> for Vapor Related to Ratio of Specific Heats ($k = c_p/c_v$).....	150
PART PHRSG	REQUIREMENTS FOR HEAT RECOVERY STEAM GENERATORS	151
PHRSG-1	General	151
PHRSG-2	Scope	151
PHRSG-3	Requirements for Superheater and Reheater Condensate Removal Connections	151
PHRSG-4	Desuperheater Drain Pots	151
PHRSG-5	Certification	153
Figure		
PHRSG-4	Some Acceptable Desuperheater Spraywater Protection Device Arrangements.....	152
MANDATORY APPENDICES		
I	Submittal of Technical Inquiries to the Boiler and Pressure Vessel Committee	155

II Standard Units for Use in Equations 157

NONMANDATORY APPENDIX

A Explanation of the Code Containing Matter Not Mandatory Unless
Specifically Referred to in the Rules of the Code..... 158

Index 242

FOREWORD

The American Society of Mechanical Engineers set up a committee in 1911 for the purpose of formulating standard rules for the construction of steam boilers and other pressure vessels. This committee is now called the Boiler and Pressure Vessel Committee.

The Committee's function is to establish rules of safety, relating only to pressure integrity, governing the construction¹ of boilers, pressure vessels, transport tanks and nuclear components, and inservice inspection for pressure integrity of nuclear components and transport tanks, and to interpret these rules when questions arise regarding their intent. This code does not address other safety issues relating to the construction of boilers, pressure vessels, transport tanks and nuclear components, and the inservice inspection of nuclear components and transport tanks. The user of the Code should refer to other pertinent codes, standards, laws, regulations, or other relevant documents. With few exceptions, the rules do not, of practical necessity, reflect the likelihood and consequences of deterioration in service related to specific service fluids or external operating environments. Recognizing this, the Committee has approved a wide variety of construction rules in this Section to allow the user or his designee to select those which will provide a pressure vessel having a margin for deterioration in service so as to give a reasonably long, safe period of usefulness. Accordingly, it is not intended that this Section be used as a design handbook; rather, engineering judgment must be employed in the selection of those sets of Code rules suitable to any specific service or need.

This Code contains mandatory requirements, specific prohibitions, and nonmandatory guidance for construction activities. The Code does not address all aspects of these activities and those aspects which are not specifically addressed should not be considered prohibited. The Code is not a handbook and cannot replace education, experience, and the use of engineering judgment. The phrase *engineering judgment* refers to technical judgments made by knowledgeable designers experienced in the application of the Code. Engineering judgments must be consistent with Code philosophy and such judgments must never be used to overrule mandatory requirements or specific prohibitions of the Code.

¹ *Construction*, as used in this Foreword, is an all-inclusive term comprising materials, design, fabrication, examination, inspection, testing, certification, and pressure relief.

The Committee recognizes that tools and techniques used for design and analysis change as technology progresses and expects engineers to use good judgment in the application of these tools. The designer is responsible for complying with Code rules and demonstrating compliance with Code equations when such equations are mandatory. The Code neither requires nor prohibits the use of computers for the design or analysis of components constructed to the requirements of the Code. However, designers and engineers using computer programs for design or analysis are cautioned that they are responsible for all technical assumptions inherent in the programs they use and they are responsible for the application of these programs to their design.

The Code does not fully address tolerances. When dimensions, sizes, or other parameters are not specified with tolerances, the values of these parameters are considered nominal and allowable tolerances or local variances may be considered acceptable when based on engineering judgment and standard practices as determined by the designer.

The Boiler and Pressure Vessel Committee deals with the care and inspection of boilers and pressure vessels in service only to the extent of providing suggested rules of good practice as an aid to owners and their inspectors.

The rules established by the Committee are not to be interpreted as approving, recommending, or endorsing any proprietary or specific design or as limiting in any way the manufacturer's freedom to choose any method of design or any form of construction that conforms to the Code rules.

The Boiler and Pressure Vessel Committee meets regularly to consider revisions of the rules, new rules as dictated by technological development, Code Cases, and requests for interpretations. Only the Boiler and Pressure Vessel Committee has the authority to provide official interpretations of this Code. Requests for revisions, new rules, Code Cases, or interpretations shall be addressed to the Secretary in writing and shall give full particulars in order to receive consideration and action (see Mandatory Appendix covering preparation of technical inquiries). Proposed revisions to the Code resulting from inquiries will be presented to the Main Committee for appropriate action. The action of the Main Committee becomes effective only after confirmation by letter ballot of the Committee and approval by ASME.

Proposed revisions to the Code approved by the Committee are submitted to the American National Standards Institute and published at <http://cstools.asme.org/csconnect/public/index.cfm?PublicReview=Revisions> to invite comments from all interested persons. After the allotted time for public review and final approval by ASME, revisions are published annually in Addenda to the Code.

Code Cases may be used in the construction of components to be stamped with the ASME Code symbol beginning with the date of their approval by ASME.

After Code revisions are approved by ASME, they may be used beginning with the date of issuance shown on the Addenda. Revisions, except for revisions to material specifications in Section II, Parts A and B, become mandatory six months after such date of issuance, except for boilers or pressure vessels contracted for prior to the end of the six-month period. Revisions to material specifications are originated by the American Society for Testing and Materials (ASTM) and other recognized national or international organizations, and are usually adopted by ASME. However, those revisions may or may not have any effect on the suitability of material, produced to earlier editions of specifications, for use in ASME construction. ASME material specifications approved for use in each construction Code are listed in the Guidelines for Acceptable ASTM Editions in Section II, Parts A and B. These Guidelines list, for each specification, the latest edition adopted by ASME, and earlier and later editions considered by ASME to be identical for ASME construction.

The Boiler and Pressure Vessel Committee in the formulation of its rules and in the establishment of maximum design and operating pressures considers materials, construction, methods of fabrication, inspection, and safety devices.

The Code Committee does not rule on whether a component shall or shall not be constructed to the provisions of the Code. The Scope of each Section has been established to identify the components and parameters considered by the Committee in formulating the Code rules.

Questions or issues regarding compliance of a specific component with the Code rules are to be directed to the ASME Certificate Holder (Manufacturer). Inquiries concerning the interpretation of the Code are to be directed to the ASME Boiler and Pressure Vessel Committee.

ASME is to be notified should questions arise concerning improper use of an ASME Code symbol.

The specifications for materials given in Section II are identical with or similar to those of specifications published by ASTM, AWS, and other recognized national or international organizations. When reference is made in an ASME material specification to a non-ASME specification for which a companion ASME specification exists, the reference shall be interpreted as applying to the ASME material specification. Not all materials included in the material specifications in Section II have been adopted for Code use. Usage is limited to those materials and grades adopted by at least one of the other Sections of the Code for application under rules of that Section. All materials allowed by these various Sections and used for construction within the scope of their rules shall be furnished in accordance with material specifications contained in Section II or referenced in the Guidelines for Acceptable ASTM Editions in Section II, Parts A and B, except where otherwise provided in Code Cases or in the applicable Section of the Code. Materials covered by these specifications are acceptable for use in items covered by the Code Sections only to the degree indicated in the applicable Section. Materials for Code use should preferably be ordered, produced, and documented on this basis; Guideline for Acceptable ASTM Editions in Section II, Part A and Guideline for Acceptable ASTM Editions in Section II, Part B list editions of ASME and year dates of specifications that meet ASME requirements and which may be used in Code construction. Material produced to an acceptable specification with requirements different from the requirements of the corresponding specifications listed in the Guideline for Acceptable ASTM Editions in Part A or Part B may also be used in accordance with the above, provided the material manufacturer or vessel manufacturer certifies with evidence acceptable to the Authorized Inspector that the corresponding requirements of specifications listed in the Guideline for Acceptable ASTM Editions in Part A or Part B have been met. Material produced to an acceptable material specification is not limited as to country of origin.

When required by context in this Section, the singular shall be interpreted as the plural, and vice-versa, and the feminine, masculine, or neuter gender shall be treated as such other gender as appropriate.

STATEMENT OF POLICY ON THE USE OF CODE SYMBOLS AND CODE AUTHORIZATION IN ADVERTISING

ASME has established procedures to authorize qualified organizations to perform various activities in accordance with the requirements of the ASME Boiler and Pressure Vessel Code. It is the aim of the Society to provide recognition of organizations so authorized. An organization holding authorization to perform various activities in accordance with the requirements of the Code may state this capability in its advertising literature.

Organizations that are authorized to use Code Symbols for marking items or constructions that have been constructed and inspected in compliance with the ASME Boiler and Pressure Vessel Code are issued Certificates of Authorization. It is the aim of the Society to maintain the standing of the Code Symbols for the benefit of the users, the enforcement jurisdictions, and the holders of the symbols who comply with all requirements.

Based on these objectives, the following policy has been established on the usage in advertising of facsimiles of the symbols, Certificates of Authorization, and reference to Code construction. The American Society of Mechanical Engineers does not “approve,” “certify,” “rate,” or

“endorse” any item, construction, or activity and there shall be no statements or implications that might so indicate. An organization holding a Code Symbol and/or a Certificate of Authorization may state in advertising literature that items, constructions, or activities “are built (produced or performed) or activities conducted in accordance with the requirements of the ASME Boiler and Pressure Vessel Code,” or “meet the requirements of the ASME Boiler and Pressure Vessel Code.”

The ASME Symbol shall be used only for stamping and nameplates as specifically provided in the Code. However, facsimiles may be used for the purpose of fostering the use of such construction. Such usage may be by an association or a society, or by a holder of a Code Symbol who may also use the facsimile in advertising to show that clearly specified items will carry the symbol. General usage is permitted only when all of a manufacturer’s items are constructed under the rules.

The ASME logo, which is the cloverleaf with the letters ASME within, shall not be used by any organization other than ASME.

STATEMENT OF POLICY ON THE USE OF ASME MARKING TO IDENTIFY MANUFACTURED ITEMS

The ASME Boiler and Pressure Vessel Code provides rules for the construction of boilers, pressure vessels, and nuclear components. This includes requirements for materials, design, fabrication, examination, inspection, and stamping. Items constructed in accordance with all of the applicable rules of the Code are identified with the official Code Symbol Stamp described in the governing Section of the Code.

Markings such as “ASME,” “ASME Standard,” or any other marking including “ASME” or the various Code

Symbols shall not be used on any item that is not constructed in accordance with all of the applicable requirements of the Code.

Items shall not be described on ASME Data Report Forms nor on similar forms referring to ASME that tend to imply that all Code requirements have been met when, in fact, they have not been. Data Report Forms covering items not fully complying with ASME requirements should not refer to ASME or they should clearly identify all exceptions to the ASME requirements.

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PREAMBLE

This Code covers rules for construction of power boilers,¹ electric boilers,² miniature boilers,³ high-temperature water boilers,⁴ and heat recovery steam generators⁵ to be used in stationary service and includes those power boilers used in locomotive, portable, and traction service. Reference to a paragraph includes all the subparagraphs and subdivisions under that paragraph.

The Code does not contain rules to cover all details of design and construction. Where complete details are not given, it is intended that the manufacturer, subject to the acceptance of the Authorized Inspector, shall provide details of design and construction which will be as safe as otherwise provided by the rules in the Code.

The scope of jurisdiction of Section I applies to the boiler proper and to the boiler external piping.

Superheaters, economizers, and other pressure parts connected directly to the boiler without intervening valves shall be considered as parts of the boiler proper, and their construction shall conform to Section I rules.

Boiler external piping shall be considered as that piping which begins where the boiler proper or separately fired superheater terminates at:

- (a) the first circumferential joint for welding end connections; or
- (b) the face of the first flange in bolted flanged connections; or
- (c) the first threaded joint in that type of connection; and which extends up to and including the valve or valves required by this Code.

ASME Code Certification (including Data Forms and Code Symbol Stamping), and/or inspection by the Authorized Inspector, when required by this Code, is required for the boiler proper and the boiler external piping.

Construction rules for materials, design, fabrication, installation, and testing of the boiler external piping are

contained in ASME B31.1, Power Piping. Piping beyond the valve or valves required by Section I is not within the scope of Section I, and it is not the intent that the Code Symbol Stamp be applied to such piping or any other piping.

The material for forced-circulation boilers, boilers with no fixed steam and water line, and high-temperature water boilers shall conform to the requirements of the Code. All other requirements shall also be met except where they relate to special features of construction made necessary in boilers of these types, and to accessories that are manifestly not needed or used in connection with such boilers, such as water gages and water columns.

Reheaters receiving steam which has passed through part of a turbine or other prime mover and separately fired steam superheaters which are not integral with the boiler are considered fired pressure vessels and their construction shall comply with Code requirements for superheaters, including safety devices. Piping between the reheater connections and the turbine or other prime mover is not within the scope of the Code.

A pressure vessel in which steam is generated by the application of heat resulting from the combustion of fuel (solid, liquid, or gaseous) shall be classed as a fired steam boiler.

Unfired pressure vessels in which steam is generated shall be classed as unfired steam boilers with the following exceptions:

- (a) vessels known as evaporators or heat exchangers
- (b) vessels in which steam is generated by the use of heat resulting from operation of a processing system containing a number of pressure vessels such as used in the manufacture of chemical and petroleum products

Unfired steam boilers shall be constructed under the provisions of Section I or Section VIII.

Expansion tanks connected to high-temperature water boilers without intervening valves shall be constructed to the requirements of Section I or Section VIII.

A pressure vessel in which an organic fluid is vaporized by the application of heat resulting from the combustion of fuel (solid, liquid, or gaseous) shall be constructed under the provisions of Section I. Vessels in which vapor is generated incidental to the operation of a processing system, containing a number of pressure vessels such as used in chemical and petroleum manufacture, are not covered by the rules of Section I.

¹ Power boiler — a boiler in which steam or other vapor is generated at a pressure of more than 15 psi (100 kPa) for use external to itself.

² Electric boiler — a power boiler or a high-temperature water boiler in which the source of heat is electricity.

³ Miniature boiler — a power boiler or a high-temperature water boiler in which the limits specified in PMB-2 are not exceeded.

⁴ High-temperature water boiler — a water boiler intended for operation at pressures in excess of 160 psi (1.1 MPa) and/or temperatures in excess of 250°F (120°C).

⁵ Heat recovery steam generator (HRSG) — a boiler that has as its principal source of thermal energy a hot gas stream having high-ramp rates and temperatures such as the exhaust of a gas turbine.

