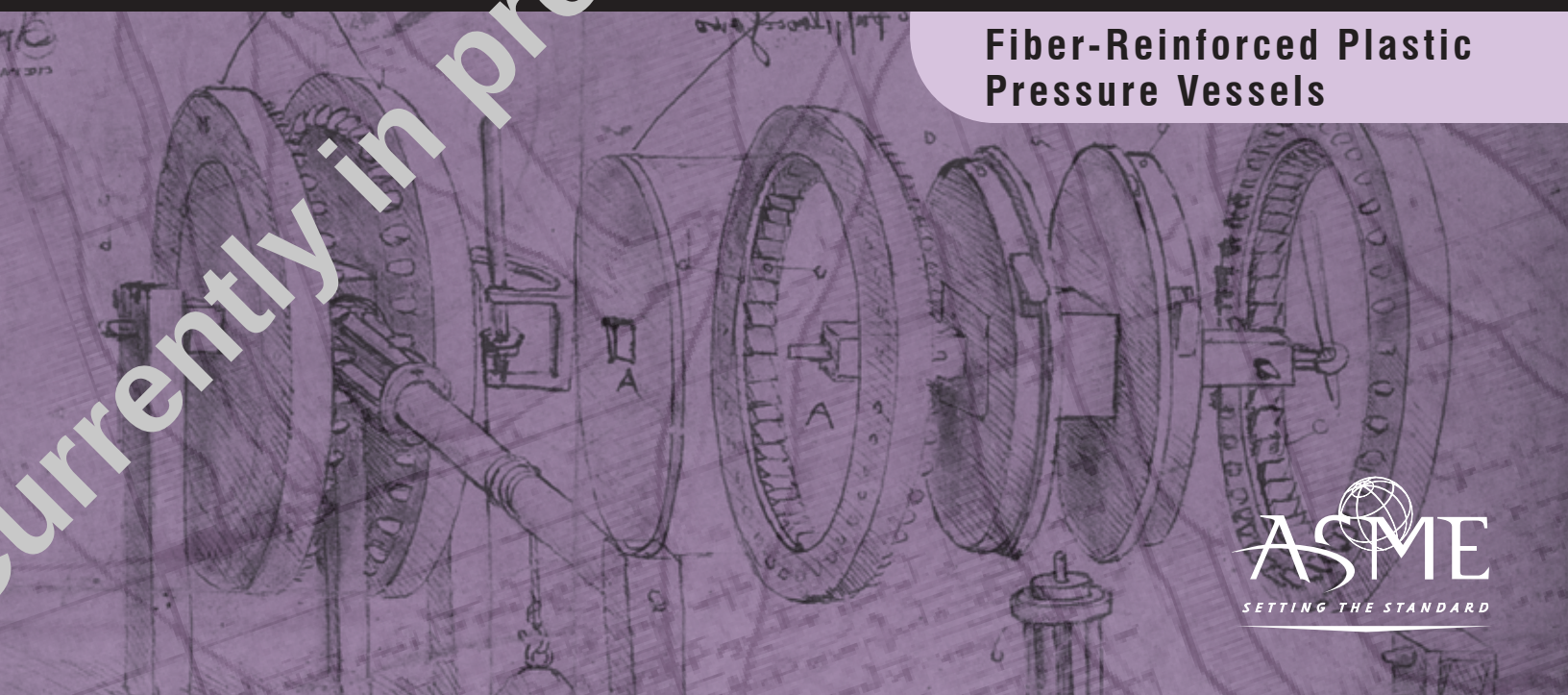
ASME BPVC.X-2023

SECTION X

2023 ASME Boiler and Pressure Vessel Code

An International Code

Fiber-Reinforced Plastic Pressure Vessels



ASME

SETTING THE STANDARD

AN INTERNATIONAL CODE

2023 ASME Boiler & Pressure Vessel Code

2023 Edition July 1, 2023

X

FIBER-REINFORCED PLASTIC PRESSURE VESSELS

ASME Boiler and Pressure Vessel Committee
on Fiber-Reinforced Plastic Pressure Vessels

The American Society of Mechanical Engineers

Two Park Avenue • New York, NY • 10016 USA

Date of Issuance: July 1, 2023

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ASME Collective Membership Mark

ASME Single Certification Mark

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FOREWORD*

In 1911, The American Society of Mechanical Engineers established the Boiler and Pressure Vessel Committee to formulate standard rules for the construction of steam boilers and other pressure vessels. In 2009, the Boiler and Pressure Vessel Committee was superseded by the following committees:

(a) Committee on Power Boilers (I)
(b) Committee on Materials (II)
(c) Committee on Construction of Nuclear Facility Components (III)
(d) Committee on Heating Boilers (IV)
(e) Committee on Nondestructive Examination (V)
(f) Committee on Pressure Vessels (VIII)
(g) Committee on Welding, Brazing, and Fusing (IX)
(h) Committee on Fiber-Reinforced Plastic Pressure Vessels (X)
(i) Committee on Nuclear Inservice Inspection (XI)
(j) Committee on Transport Tanks (XII)
(k) Committee on Overpressure Protection (XIII)
(l) Technical Oversight Management Committee (TOMC)

Where reference is made to "the Committee" in this Foreword, each of these committees is included individually and collectively.

The Committee's function is to establish rules of safety relating to pressure integrity, which govern the construction** of boilers, pressure vessels, transport tanks, and nuclear components, and the inservice inspection of nuclear components and transport tanks. The Committee also interprets these rules when questions arise regarding their intent. The technical consistency of the Sections of the Code and coordination of standards development activities of the Committees is supported and guided by the Technical Oversight Management Committee. This Code does not address other safety issues relating to the construction of boilers, pressure vessels, transport tanks, or nuclear components, or the inservice inspection of nuclear components or transport tanks. Users of the Code should refer to the pertinent codes, standards, laws, regulations, or other relevant documents for safety issues other than those relating to pressure integrity. Except for Sections XI and XII, and with a few other 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. In formulating the rules, the Committee considers the needs of users, manufacturers, and inspectors of pressure vessels. The objective of the rules is to afford reasonably certain protection of life and property, and to provide a margin for deterioration in service to give a reasonably long, safe period of usefulness. Advancements in design and materials and evidence of experience have been recognized.

This Code contains mandatory requirements, specific prohibitions, and nonmandatory guidance for construction activities and inservice inspection and testing activities. The Code does not address all aspects of these activities and those aspects that 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 engineers 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.

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 the application of these programs to their design.

* The information contained in this Foreword is not part of this American National Standard (ANS) and has not been processed in accordance with ANSI's requirements for an ANS. Therefore, this Foreword may contain material that has not been subjected to public review or a consensus process. In addition, it does not contain requirements necessary for conformance to the Code.

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

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 Committee meets regularly to consider revisions of the rules, new rules as dictated by technological development, Code Cases, and requests for interpretations. Only the 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 Submittal of Technical Inquiries to the Boiler and Pressure Vessel Standards Committees). Proposed revisions to the Code resulting from inquiries will be presented to the Committee for appropriate action. The action of the Committee becomes effective only after confirmation by 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 (ANSI) and published at http://go.asme.org/BPVCPublicReview to invite comments from all interested persons. After public review and final approval by ASME, revisions are published at regular intervals in Editions of the Code.

The 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 Committee. ASME is to be notified should questions arise concerning improper use of the ASME Single Certification Mark.

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.

The words "shall," "should," and "may" are used in this Standard as follows:

- *Shall* is used to denote a requirement.
- *Should* is used to denote a recommendation.
- *May* is used to denote permission, neither a requirement nor a recommendation.

STATEMENT OF POLICY ON THE USE OF THE ASME SINGLE CERTIFICATION MARK 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 the ASME Single Certification Mark 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 ASME Single Certification Mark for the benefit of the users, the enforcement jurisdictions, and the holders of the ASME Single Certification Mark who comply with all requirements.

Based on these objectives, the following policy has been established on the usage in advertising of facsimiles of the ASME Single Certification Mark, 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 the ASME Single Certification Mark 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." An ASME corporate logo shall not be used by any organization other than ASME.

The ASME Single Certification Mark 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 the ASME Single Certification Mark who may also use the facsimile in advertising to show that clearly specified items will carry the ASME Single Certification Mark.

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 ASME Single Certification Mark described in the governing Section of the Code.

Markings such as "ASME," "ASME Standard," or any other marking including "ASME" or the ASME Single Certification Mark 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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B. Wasiluk
G. M. Wilkowski
S. X. Xu
Y. Zou
K. Gresh, *Alternate*
H. S. Mehta, *Contributing Member*

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R. C. Cipolla
M. M. Farooq
K. Gresh
E. J. Houston
R. Janowiak
S. H. Pellet
D. Rudland
D. A. Scarth
S. X. Xu

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F. G. Abatt
G. A. Antaki
R. C. Cipolla
R. G. Gilada
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R. Janowiak
M. Kassar
M. Moenssens
D. P. Munson
R. M. Pace
S. H. Pellet
D. Rudland
D. A. Scarth

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P. Krishnaswamy
M. Moenssens
D. P. Munson
D. A. Scarth
D. J. Shim
M. Troughton
J. Wright
S. X. Xu

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A. Bushmire
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S. E. Cumblidge
K. J. Hacker
J. Harrison
D. A. Kull
C. Latiolais
F. J. Schaaf, Jr.
R. V. Swain
C. A. Nove, *Alternate*

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H. M. Stephens, Jr.
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R. Vayda

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K. Yamada

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D. Watanabe
H. Yada
K. Yamada
T. Asayama, *Contributing Member*

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T. Nuoffer
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A. Pridmore
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R. Stakenborghs
P. Vibien
M. P. Marohl, *Contributing Member*

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B. Davenport, *Alternate*

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ASME codes and standards are developed and maintained by committees with the intent to represent the consensus of concerned interests. Users of ASME codes and standards may correspond with the committees to propose revisions or cases, report errata, or request interpretations. Correspondence for this Section of the ASME Boiler and Pressure Vessel Code (BPVC) should be sent to the staff secretary noted on the Section's committee web page, accessible at https://go.asme.org/CSCommittees.

NOTE: See ASME BPVC Section II, Part D for guidelines on requesting approval of new materials. See Section II, Part C for guidelines on requesting approval of new welding and brazing materials ("consumables").

Revisions and Errata

The committee processes revisions to this Code on a continuous basis to incorporate changes that appear necessary or desirable as demonstrated by the experience gained from the application of the Code. Approved revisions will be published in the next edition of the Code.

In addition, the committee may post errata and Special Notices at http://go.asme.org/BPVCerrata. Errata and Special Notices become effective on the date posted. Users can register on the committee web page to receive e-mail notifications of posted errata and Special Notices.

This Code is always open for comment, and the committee welcomes proposals for revisions. Such proposals should be as specific as possible, citing the paragraph number(s), the proposed wording, and a detailed description of the reasons for the proposal, including any pertinent background information and supporting documentation.

Cases

(a) The most common applications for cases are

(1) to permit early implementation of a revision based on an urgent need

(2) to provide alternative requirements

(3) to allow users to gain experience with alternative or potential additional requirements prior to incorporation directly into the Code

(4) to permit use of a new material or process

(b) Users are cautioned that not all jurisdictions or owners automatically accept cases. Cases are not to be considered as approving, recommending, certifying, or endorsing any proprietary or specific design, or as limiting in any way the freedom of manufacturers, constructors, or owners to choose any method of design or any form of construction that conforms to the Code.

(c) The committee will consider proposed cases concerning the following topics only:

(1) equipment to be marked with the ASME Single Certification Mark, or

(2) equipment to be constructed as a repair/replacement activity under the requirements of Section XI

(d) A proposed case shall be written as a question and reply in the same format as existing cases. The proposal shall also include the following information:

(1) a statement of need and background information

(2) the urgency of the case (e.g., the case concerns a project that is underway or imminent)

(3) the Code Section and the paragraph, figure, or table number(s) to which the proposed case applies

(4) the edition(s) of the Code to which the proposed case applies

(e) A case is effective for use when the public review process has been completed and it is approved by the cognizant supervisory board. Cases that have been approved will appear in the next edition or supplement of the Code Cases books, "Boilers and Pressure Vessels" or "Nuclear Components." Each Code Cases book is updated with seven Supplements.

Supplements will be sent or made available automatically to the purchasers of the Code Cases books until the next edition of the Code. Annulments of Code Cases become effective six months after the first announcement of the annulment in a Code Case Supplement or Edition of the appropriate Code Case book. The status of any case is available at http://go.asme.org/BPVCCDatabase. An index of the complete list of Boiler and Pressure Vessel Code Cases and Nuclear Code Cases is available at http://go.asme.org/BPVCC.

Interpretations

(a) Interpretations clarify existing Code requirements and are written as a question and reply. Interpretations do not introduce new requirements. If a revision to resolve conflicting or incorrect wording is required to support the interpretation, the committee will issue an intent interpretation in parallel with a revision to the Code.

(b) Upon request, the committee will render an interpretation of any requirement of the Code. An interpretation can be rendered only in response to a request submitted through the online Interpretation Submittal Form at http://go.asme.org/InterpretationRequest. Upon submitting the form, the inquirer will receive an automatic e-mail confirming receipt.

(c) ASME does not act as a consultant for specific engineering problems or for the general application or understanding of the Code requirements. If, based on the information submitted, it is the opinion of the committee that the inquirer should seek assistance, the request will be returned with the recommendation that such assistance be obtained. Inquirers may track the status of their requests at http://go.asme.org/Interpretations.

(d) ASME procedures provide for reconsideration of any interpretation when or if additional information that might affect an interpretation is available. Further, persons aggrieved by an interpretation may appeal to the cognizant ASME committee or subcommittee. ASME does not “approve,” “certify,” “rate,” or “endorse” any item, construction, proprietary device, or activity.

(e) Interpretations are published in the ASME Interpretations Database at http://go.asme.org/Interpretations as they are issued.

Committee Meetings

The ASME BPVC committees regularly hold meetings that are open to the public. Persons wishing to attend any meeting should contact the secretary of the applicable committee. Information on future committee meetings can be found at http://go.asme.org/BCW.

INTRODUCTION (23)

1 GENERAL

The use of fiber-reinforced plastics for the manufacture of pressure vessels presents unique materials considerations in the design, fabrication, and testing of these vessels. Metallic vessels, being made from materials that are normally isotropic and ductile, are designed by using well-established allowable stresses based on measured tensile and ductility properties. In contrast, fiber-reinforced plastics are usually anisotropic and the physical properties are dependent upon the fabrication process, the placement and orientation of the reinforcement, and the resin matrix. It is the purpose of this Introduction to describe in a general way the criteria that were used in preparing Section X, Fiber-Reinforced Plastic Pressure Vessels. A list of standards referenced in this Section is provided in Table 1.1.

2 MATERIALS

It is not possible to fabricate a reinforced plastic pressure vessel of a single basic material for which there is an ASTM specification. The vessel parts are made up of various basic materials, such as fiber reinforcement and resin, which are joined in the presence of a catalyst to create a composite material that is formed into a vessel or vessel part by a specified process. The composite material will often have directional properties, which shall be considered in design. General specifications for the basic materials (fiber reinforcement and resin) are stated, as are requirements for determination of elastic properties for the composite material (laminate) produced. Elastic properties of specific laminates used in vessel fabrication are required when mandatory rules are used for vessel design. Metallic materials, when used in conjunction with reinforced fiber laminates, are required to meet ASME Boiler and Pressure Vessel Code specifications, Section VIII, Division 1. That Section must be used for the design, fabrication, quality control, and inspection of such metallic parts. However, for hydrostatic leakage testing, these metallic materials that complete the vessel are required to meet Section X requirements.

3 DESIGN

3.1 GENERAL

3.1.1 Adequacy of specific designs shall be qualified by one of the following methods:[1]

(a) Class I Design — qualification of a vessel design through the pressure testing of a prototype.

(b) Class II Design — mandatory design rules and acceptable testing by nondestructive methods.

(c) Class III Design—qualification of a vessel design through the pressure testing of a prototype, other specified tests of prototypes, mandatory design rules and acceptance testing by nondestructive methods.

3.1.2 Class I designs based on the qualification of a prototype vessel require that the minimum qualification pressure of the prototype be at least six[2] times the design pressure. The maximum design pressure is limited to 150 psi (1 MPa) for bag-molded, centrifugally cast, and contact-molded vessels; 1,500 psi (10 MPa) for filament-wound vessels; and 3,000 psi (20 MPa) for filament-wound vessels with polar boss openings.

3.1.3 Class II designs based on mandatory design rules and acceptance testing must comply with Article RD-11 and Article RT-6. The maximum design pressure allowed under this procedure shall be as specified in RD-1120.

3.1.4 Class III designs include the qualification of a prototype with the minimum qualification pressure of the prototype to be at 2.25 times the design pressure for carbon fiber vessels, and 3.5 times the design pressure for glass fiber vessels. Hybrid designs using more than one type of fiber are covered in 8-400.7. The maximum design pressure is limited to 15,000 psi (103 MPa). The minimum design pressure shall be not less than 3,000 psi (20.7 MPa).

[1] These three methods shall not be intermixed.

[2] An exception to this six times factor is applicable to vessels per (Filament Winding — Polar Boss Openings Only).

Table 1.1
Referenced Standards in This Section

Title	Number
Fitness-for-Service	API 579-1/ASME FFS-1, 2016
Cast Iron Pipe Flanges and Flanged Fittings	ASME B16.1-2020
Pipe Flanges and Flanged Fittings	ASME B16.5-2020
Plain Washers	ASME B18.22.1-2009(R2016)
Conformity Assessment Requirements	ASME CA-1-2020
Standard for Qualification and Certification of Nondestructive Testing Personnel	ASNT-CP-189-2020
Standard Test Method for Kinematic Viscosity and Opaque Liquids (the Calculation of Dynamic Viscosity)	ASTM D445-21
Standard Test Method for Tensile Properties of Plastics	ASTM D638-14
Standard Test Method for Compressive Properties of Rigid Plastics	ASTM D695-15
Standard Test Methods for Density and Specific Gravity (Relative Density) of Plastics by Displacement	ASTM D792-20
Standard Test Methods for Sampling and Testing Plasticizers Used in Plastics	ASTM D1045-19
Method of Test for Bursting Strength of Round Rigid Plastic Tubing	ASTM 1180-57(1976)
Standard Test Methods for Epoxy Content of Epoxy Resins	ASTM D1652-11(2019)
Standard Test Methods for Rheological Properties of Non-Newtonian Materials by Rotational Viscometer	ASTM D2196-20
Standard Test Method for Apparent Hoop Tensile Strength of Plastic or Reinforced Plastic Pipe	ASTM D2290-19A
Standard Test Method for Tensile Properties of Glass Strands, Yarns, and Rovings Used in Reinforced Plastics	ASTM D2343-86
Standard Test Method for Short-Beam Strength of Polymer Matrix Composite Materials and Their Laminates	ASTM D2344/D2344M-16
Standard Test Method for Epoxy Resins and Related Components	ASTM D2393-86
Standard Test Method for Gel Time and Peak Exothermic Temperature of Reacting Thermosetting Resins	ASTM D2471-99
Standard Test Method for Indentation Hardness of Rigid Plastics by Means of Barcol Impressor	ASTM D2583-13a
Standard Test Method for Ignition Loss of Cured Reinforced Resins	ASTM D2584-18
Test Method for Preparation and Tension Testing of Filament-Wound Pressure Vessels	ASTM D2585-68(1990)
Standard Practice for Obtaining Hydrostatic or Pressure Design Basis for "Fiberglass" (Glass- Fiber-Reinforced Thermosetting-Resin) Pipe and Fittings	ASTM D2992-18
Standard Test Method for Volatile Matter (Including Water) of Vinyl Chloride Resins	ASTM D3030-17
Standard Test Method for Tensile Properties of Polymer Matrix Composite Materials	ASTM D3039/D3039M-17
Standard Test Method for Constituent Content of Composite Materials	ASTM D3171-15
Standard Test Method for Compressive Properties for Polymer Matrix Composite Materials With Unsupported Gage Section by Shear Loading	ASTM D3410/D3410M-16e1
Standard Test Methods for Constituent Content of Composite Prepeg	ASTM D3529-16(2021)
Standard Test Method for Resin Flow of Carbon Fiber-Epoxy Prepreg	ASTM D3531/D3531M-16e1
Standard Test Method for In-Plane Shear Strength of Reinforced Plastics	ASTM D3846-08(2015)
Standard Test Methods for Properties of Continuous Filament Carbon and Graphite Fiber Tows	ASTM D4018-17
Standard Specification for Contact-Molded Glass-Fiber-Reinforced Thermoset Resin Corrosion- Resistant Tanks	ASTM D4097-18a
Standard Guide for Testing In-Plane Shear Properties of Polymer Matrix Composite Materials by the Rail Shear Method	ASTM D4255/D4255M-20
Standard Specification for Automotive Spark-Ignition Engine Fuel	ASTM D4814-21a
Standard Test Method for In-Plane Shear Properties of Hoop Wound Polymer Matrix Composite Cylinders	ASTM D5448/D5448M-16
Standard Test Method for Transverse Compressive Properties of Hoop Wound Polymer Matrix Composite Cylinders	ASTM D5449/D5449M-16
Standard Test Method for Transverse Tensile Properties of Hoop Wound Polymer Matrix Composite Cylinders	ASTM D5450/D5450M-16
Standard Test Method for Shear Properties of Composite Materials by V-Notched Rail Shear Method	ASTM D7078/D7078M-20e1
Standard Test Methods for Flexural Properties of Unreinforced and Reinforced Plastics and Electrical Insulating Materials	ASTM D790-17
Standard Practice for Acoustic Emission Examination of Fiberglass Reinforced Plastic Resin (FRP) Tanks/ Vessels	ASTM E1067
Standard Terminology for Nondestructive Examinations	ASTM E1316-21c
Standard Practice for Determining Damage-Based Design for Fiberglass Reinforced Plastic (FRP) Materials Using Acoustic Emission	ASTM E2478-11(2016)
Standard Test Methods for Holiday Detection in Pipeline Coatings	ASTM G62-14
Recommended Practice for Personnel Qualification and Certification in Nondestructive Testing	SNT-TC-1A(2020)

3.2 LOW MODULUS CHARACTERISTICS

Fiber-reinforced plastic laminates may have a modulus of elasticity as low as 1.0×10^6 psi (6 900 MPa), compared with that of ferrous materials which may be of the order of 30×10^6 psi (2.1 × 105 MPa). This low modulus characteristic requires careful consideration of vessel profile in order to minimize bending and avoid buckling. Spherical heads or elliptical heads having an ellipse ratio not greater than 2:1 are suggested. Spherical heads are suggested when the material has isotropic properties. Elliptical heads are preferred when the material has anisotropic properties.

3.3 FATIGUE

3.3.1 Like metallic materials, the composite material (laminate) of fiber-reinforced plastic vessels, when stressed at sufficiently low levels, exhibits good fatigue life. However, its low modulus of elasticity provides a higher strain per unit of stress than metals used for metallic vessels.

3.3.2 Section X, therefore, requires that a Class I design that is qualified by testing of a prototype vessel be pressure cycled 100,000 times over a pressure range of atmospheric to the design pressure; after this, the test vessel must withstand a hydrostatic qualification test not less than six times the design pressure. An exception to this 100,000 cycle requirement is applicable to vessels per RG-404.2 (Filament Winding — Polar Boss Openings Only). That classification of vessels is designed for a 5:1 factor of safety which requires cycling from atmospheric to the design pressure for 33,000 cycles; after this, the test vessel must withstand a hydrostatic qualification test not less than five times the design pressure.

3.3.3 Class II vessels qualified using mandatory design rules and acceptance testing are not required to be subjected to the above cyclic and qualification pressure test criteria.

3.3.4 Section X requires that a Class III design qualification include testing of a prototype vessel that is pressure cycled for "N" cycles as prescribed in 8-700.5.4.1 over a pressure range of 10% of design pressure to 100% of design pressure without leakage or rupture.

3.4 CREEP, STRESS-RUPTURE, AND TEMPERATURE EFFECTS

Fiber-reinforced plastic composite material (laminate) is not subject to creep or failure due to low stress-to-rupture characteristics as are some other materials. The material does, however, lose ultimate strength as the temperature is increased and gains strength but becomes more brittle as the temperature is lowered. Its low thermal conductivity and ablative properties are other factors significantly affecting the behavior of this material in the event of fire or other high-temperature environment. The maximum design, operating, and test temperatures of Class I vessels are set as follows:

(a) 150°F (65°C) for design temperatures less than or equal to 150°F (65°C);

(b) 250°F (120°C) or to within 35°F (19°C) of the glass transition temperature (whichever is lower) for design temperatures in excess of 150°F (65°C).

The maximum design, operating, and test temperatures of Class II vessels are limited to an inside wall temperature of 250°F (120°C) or to within 35°F (19°C) of the glass transition temperature of the resin (whichever is lower). The maximum design temperature of Class III vessels shall be 35°F (19°C) below the maximum use temperature of the resin as documented in the Manufacturing Specifications, but in no case shall it exceed 185°F (85°C). The minimum design temperature of Class I, Class II, and Class III vessels shall be −65°F (−54°C) (see RD-112).

3.5 FABRICATION

3.5.1 Many processes are used in the fabrication of fiber-reinforced composite materials (laminates). Class I vessels are limited to four processes, namely, filament winding, bag molding, contact molding, and centrifugal casting. Class II vessels are limited to two processes, namely, filament winding and contact molding.

3.5.2 The fabrication of more than one Class I vessel may be required to comply with the requirements for qualifying a design using the prototype vessel[3] method. Once a specific design has been qualified, the quality of subsequent vessels of the same dimension and design is to be ensured by carefully controlled fabrication procedures and rigid Quality Control Programs.

3.5.3 Every Class II vessel must be acceptance tested as specified in Article RT-6. Such tests must be documented as having met the acceptance criteria of Article RT-6 and shall become part of the Fabricator's Design Report.

[3] Prototype vessels used to qualify a design shall not be stamped with the Certification Mark.

3.5.4 Class III vessels are limited to filament-wound construction with polar loss openings.

3.6 INSPECTION

3.6.1 The general philosophy of Section VIII, Division 1, regarding inspection during fabrication is continued in this Section. Familiarity with the laminate production processes and the nature of vessel imperfections is required of the Inspector. Reliance is placed upon careful auditing of the Fabricator's Quality Control Program, close visual inspection of completed vessels by both Fabricator personnel and the Inspector, and acceptance testing where required by this Section.

3.6.2 This Section requires that all laminate and secondary bonding work be without use of pigments, fillers, or resin putty mixtures except as permitted by the Procedure Specification used in fabricating the vessel or vessel part.

3.7 LINERS

Liners may be used in Section X vessels as a barrier between the laminate and the vessel contents. Such liners shall not be considered part of the structural component of the vessel.

3.8 UNITS

3.8.1 Either U.S. Customary, SI, or any local customary units may be used to demonstrate compliance with all requirements of this Edition (e.g., materials, design, fabrication, examination, inspection, testing, certification, and overpressure protection).

3.8.2 In general, it is expected that a single system of units shall be used for all aspects of design except where unfeasible or impractical. When components are manufactured at different locations where local customary units are different than those used for the general design, the local units may be used for the design and documentation of that component. Similarly, for proprietary components or those uniquely associated with a system of units different than that used for the general design, the alternate units may be used for the design and documentation of that component.

3.8.3 For any single equation, all variables shall be expressed in a single system of units. When separate equations are provided for U.S. Customary units and SI units, those equations must be executed using variables in the units associated with the specific equation. Data expressed in other units shall be converted to U.S. Customary units or SI units for use in these equations. The result obtained from execution of these equations may be converted to other units.

3.8.4 Production, measurement and test equipment, drawings, welding procedure specifications, welding procedure and performance qualifications, and other fabrication documents may be in U.S. Customary, SI, or local customary units in accordance with the fabricator's practice. When values shown in calculations and analysis, fabrication documents, or measurement and test equipment are in different units, any conversions necessary for verification of Code compliance and to ensure that dimensional consistency is maintained, shall be in accordance with the following:

(a) Conversion factors shall be accurate to at least four significant figures.

(b) The results of conversions of units shall be expressed to a minimum of three significant figures.

3.8.5 Material that has been manufactured and certified to either the U.S. Customary or SI material specification (e.g., SA-516M) may be used regardless of the unit system used in design. Standard fittings (e.g., flanges, elbows, etc.) that have been certified to either U.S. Customary units or SI units may be used regardless of the units system used in design.

3.8.6 Conversion of units, using the precision specified in para. 20, shall be performed to ensure that dimensional consistency is maintained. Conversion factors between U.S. Customary units and SI units may be found in the Nonmandatory Appendix, Guidance for the Use of U.S. Customary and SI units in the ASME Boiler and Pressure Vessel Code. Whenever local customary units are used, the Manufacturer shall provide the source of the conversion factors which shall be subject to verification and acceptance by the Authorized Inspector or Certified Individual.

3.8.7 All entries on a Manufacturer's Data Report and data for Code required nameplate marking shall be in units consistent with the fabrication drawings for the component using U.S. Customary, SI, or local customary units. It is acceptable to show alternate units parenthetically. Users of this Code are cautioned that the receiving Jurisdiction should be contacted to ensure the units are acceptable.

SUMMARY OF CHANGES

Changes listed below are identified on the pages by a margin note, **(23)**, placed next to the affected area.

Page	*Location*	*Change*
xv	List of Sections	(1) Under Section III, Division 4 added
		(2) Title of Section XI and subtitle of Section XI, Division 2 revised
		(3) Information on interpretations and Code cases moved to "Correspondence With the Committee"
xix	Personnel	Updated
xli	Correspondence With the Committee	Added (replaces "Submittal of Technical Inquiries to the Boiler and Pressure Vessel Standards Committees")
xliii	Introduction	Table 1.1 updated
xlviii	Cross-Referencing in the ASME BPVC	Updated
60	Figure RF-210.2	Top-right callout editorially revised
78	Part RR	Deleted
104	Figure RS-132.1	Fourth entry from top editorially revised
104	RS-133	Added
125	8-100.6	Last sentence revised and in-text Note added
126	8-200	8-200.4 deleted
134	8-700.1	Revised
136	Table 8-700.2.1-1	Notes (10) and (11) added
135	8-700.2.1	(1) Subparagraph (c) revised
		(2) Subparagraph (e) added
135	8-700.2.2	In subparas. (a) and (c), first sentence revised
137	8-700.5.3.1	Second paragraph added
139	8-700.5.8	Revised in its entirety
141	8-1000	Forms CPV-1 and CPV-2 and Table 8-900.3.1 revised and moved to Nonmandatory Appendix AJ
212	Nonmandatory Appendix AJ	(1) Existing forms and tables revised
		(2) Forms CPV-1 and CPV-2 and Table AJ-7 added
266	Nonmandatory Appendix AM	Deleted

(23)

CROSS-REFERENCING IN THE ASME BPVC

Paragraphs within the ASME BPVC may include subparagraph breakdowns, i.e., nested lists. The following is a guide to the designation and cross-referencing of subparagraph breakdowns:

(a) Hierarchy of Subparagraph Breakdowns

(1) First-level breakdowns are designated as (a), (b), (c), etc.

(2) Second-level breakdowns are designated as (1), (2), (3), etc.

(3) Third-level breakdowns are designated as (-a), (-b), (-c), etc.

(4) Fourth-level breakdowns are designated as (-1), (-2), (-3), etc.

(5) Fifth-level breakdowns are designated as (+a), (+b), (+c), etc.

(6) Sixth-level breakdowns are designated as (+1), (+2), etc.

(b) Cross-References to Subparagraph Breakdowns. Cross-references within an alphanumerically designated paragraph (e.g., PG-1, UIG-56.1, NCD-3223) do not include the alphanumerical designator of that paragraph. The crossreferences to subparagraph breakdowns follow the hierarchy of the designators under which the breakdown appears. The following examples show the format:

(1) If X.1(c)(1)(-a) is referenced in X.1(c)(1), it will be referenced as (-a).

(2) If X.1(c)(1)(-a) is referenced in X.1(c)(2), it will be referenced as (1)(-a).

(3) If X.1(c)(1)(-a) is referenced in X.1(e)(1), it will be referenced as (c)(1)(-a).

(4) If X.1(c)(1)(-a) is referenced in X.2(c)(2), it will be referenced as X.1(c)(1)(-a).

PART RG
GENERAL REQUIREMENTS

ARTICLE RG-1
SCOPE AND JURISDICTION

RG-100 SCOPE

(a) Section X establishes the requirements for the fabrication of fiber-reinforced thermosetting plastic pressure vessels for general service, sets limitations on the permissible service conditions, and defines the types of vessels to which these rules are not applicable.

(b) To ensure that vessels fabricated according to these rules will be capable of safely withstanding the operating conditions specified by the Design Specification, this Section:

(1) gives minimum requirements for the materials of fabrication;

(2) specifies test procedures for determining laminate mechanical properties;

(3) Defines three methods of design qualification:

(-a) Class I Design — nondestructive qualification test

(-b) Class II Design — mandatory design rules and acceptance testing by nondestructive evaluation (NDE) methods

(-c) Class III Design — qualification of a vessel design through the destructive test of a prototype

(4) suggests nonmandatory design procedures for Class I vessels;

(5) provides mandatory design procedures and acceptance testing for Class II vessels;

(6) defines the general methods of fabrication which may be used;

(7) limits the types of end closures, connections, and attachments which may be employed and the means used to join them to the vessels;

(8) stipulates the procedures to be used in proving that prototype vessels will withstand specified operating and test conditions;

(9) establishes rules under which fabricating procedures used for fabricating Class I and Class III prototype and production vessels are qualified, and defines what deviations from such procedures necessitate requalification;

(10) sets forth requirements to ensure that no essential variation in qualified fabrication procedures has occurred;

(11) establishes rules for acceptance testing, inspection, and reporting;

(12) gives requirements for stamping and marking.

(c) For vessels fabricated in accordance with these rules, the provisions of Section X shall apply over any other sections of the Code. When metallic components are part of fiber-reinforced plastic vessels, they shall meet the provisions of Section VIII, Division 1.

(d) The Fabricator shall establish the effective Code edition, addenda and Code Cases for pressure vessels and replacement parts in accordance with Mandatory Appendix 9.

RG-110 APPLICATION LIMITATIONS

RG-111 DESIGN PRESSURE

The internal design pressure of vessels fabricated under this Section shall be limited as follows:

(a) Class I vessels shall not exceed 150 psi (1 MPa) for bag-molded, centrifugally cast, and contact-molded vessels; 2,000 psi (14 MPa) for filament-wound vessels and 3,000 psi (20 MPa) for filament-wound vessels with polar boss openings only.

(b) Class II vessels shall not exceed the limits specified in RD-1120.

(c) Class III vessels shall not exceed 15,000 psi (103.4 MPa) for filament-wound vessels with polar boss openings only.

RG-112 DESIGN TEMPERATURE

The design temperature of vessels fabricated under this Section shall not exceed the lower of (a) or (b).

(a) 250°F (120°C) for Class I and Class II, and 185°F (85°C) for Class III

(b) 35°F (19°C) below the maximum use temperature (see RM-121) of the resin, nor be less than −65°F (−54°C) (see RD-112)