

API Standard 620 - Design and Construction of Large, Welded, Low-Pressure Storage Tanks

Edition	Section	Inquiry No.	Questions	Reply
9th - Feb. 1999	1.2.1	620-1-16-00	1. Does Section 1.2.1 prevent tanks with umbona roofs and secondary domes, from being marked as being in accordance with API Standard 620? 2. Does Section 1.2.1 prevent tanks with flat bottoms from having a slope?	1. No. 2. No.
9th	General	620-1-09-00	1. Does API 620 require that weld procedures be qualified by standard qualification tests in accordance with ASME Section IX, using the contractor's actual welding procedure, without any all-weld joint tests, except for the additional tests required by Question 2 below? 2. Does API 620 require or permit additional, separate qualification tests for proof of weld metal strength assumed for design using the AWS test piece as per Figure 9 of AWS 5.11, which will be different from Reply 1 above (since single-sided welds with backing strips are not used for tank construction)? 3. Does API 620 allow the use of test pieces for proof of weld metal strength assumed for design in accordance with AWS 5.11, Table 3, note 1, which is referred to by Figure 2, note 1 of AWS 5.11, and which specifically permits the use of buffered carbon steel test pieces?	1. Yes 2. Yes 3. Yes
10th - Feb. 2002	4.2 Table 4-1	620-1-13-00	Can 1/2 in. & 3/8 plate (not & 3/8 steel 2) be used for the shell of an API 620 tank with a design metal temperature of 50 deg F?	Yes. Refer to API 620 Table 4-1 and Section 4.2.3.2.
9th - Feb. 1999	4.2.3		For a tank design to meet API 620-requiring impact testing of plate material per Section 4.2.3: (a) Should the long dimension of impact test specimen be parallel to direction of maximum stress (hoop stresses are not equal) and the minimum absorbed energy value per Table R-2? or (b) Should the impact test specimen be taken transverse to the final plate rolling and the absorbed energy value per Table R-2?	All material API 620, Section 4.2.3, the direction of the axis of the impact test specimen is dependent upon the direction of plate rolling by the mill. The direction of maximum stress when installed in the tank is not a factor. The impact test energy criteria applicable to either type of specimen is per Table R-2, or per Table R-5 where applicable.
10th - Feb. 2002	4.2.3.2	620-1-06-00	Should the thickness stated in Table 5-1, Table 5, be 1/4 in.?	Yes. This was a typographical error introduced in the previous edition of the standard. This note will be corrected in the next edition of the 620.

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Edition	Section	Inquiry No.	Questions	Reply
9th - Feb. 1999	4.2 Table 4-1	620-1-06-00	1. Is it permissible to utilize plate materials at design metal temperature and thickness combination which are outside the limits contained in API 620, Table 4-1 if impact testing is performed? 2. Does API 620 allow impact testing to be performed in lieu of normalizing for combinations of plate material grade, thickness and design metal temperature that require normalizing? 3. May impact testing be utilized in lieu of normalizing for plate materials where Table 4-1 of API 620 and the ASTM specification require normalizing at 650 & 545 with thicknesses greater than 1.125 in.?	1. No. 2. No. 3. No.
10th - Feb. 2002	5.1.1	620-1-05-00	Are umbona roofs, secondary cone roofs and secondary, and secondary sloped to one side, among those designs for which API 620 does not present design rules as noted in Section 5.1.1?	Yes.
9th - Feb. 1999	Figure 5-6	620-1-11-00	Is the width of lap of the roof panels, ends or beneath the compression ring plate, prescribed in Figure 5-6 Details a, 1, 1-1, and g?	No. See 5.22.1.3
9th - Feb. 1999	Figure 5-6	620-1-12-00	May the lap welds of the roof panels, ends or beneath the compression ring plate, prescribed in Figure 5-6, Details a, 1, 1-1, and g be double lap welds or single lap welds if the appropriate joint efficiency and inspection are applied?	Yes.
9th - Feb. 1999	Figure 5-6	620-1-14-00	May the roof be full-welded to the compression ring as an alternative to the lap weld shown in Figure 5-6 Details a, 1, 1-1, and g, if all requirements for circumferential butt welds are met?	Yes.
9th - Feb. 1999	Figure 5-6	620-1-14-00	1. Does the compression, $W_{17} = L_{17} = 100$, weld in Figure 5-6 Detail a as well as to Figure 5-6 Details f and g? 2. Does the outward extension limitation of a maximum of 1/8 of the plate compression ring in Figure 5-6, Detail a apply as well to Figure 5-6 Details f and g?	1. Yes. 2. Yes.
9th - Feb. 1999	Figure 5-6	620-1-15-00	1. Is the dimension, W_{17} , of Figure 5-6 Details f and g, a limitation on the greatest inward physical projection that a plate compression ring may have?	1. No.

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