
USACE / NAVFAC / AFCESA UFGS-13420 (August 2004)

Preparing Activity: USACE Superseding
UFGS-13420A (May 2004)

UNIFIED FACILITIES GUIDE SPECIFICATIONS

References are in agreement with UMRL dated 25 June 2004

Latest change indicated by CHG tags

SECTION TABLE OF CONTENTS

DIVISION 13 - SPECIAL CONSTRUCTION

SECTION 13420

SELF-ACTING BLAST VALVES

08/04

PART 1 GENERAL

- 1.1 REFERENCES
- 1.2 SUBMITTALS
- 1.3 SYSTEMS DESCRIPTION
 - 1.3.1 Contractor Design of Structural Supports
 - 1.3.2 Sustained Blast Overpressures
 - 1.3.3 Blast Overpressure Waveforms
 - 1.3.4 Performance Requirements
 - 1.3.4.1 Field Removable Valve Units
 - 1.3.4.2 Penetrations
- 1.4 QUALIFICATIONS
- 1.5 DELIVERY AND STORAGE
- 1.6 WARRANTY

PART 2 PRODUCTS

- 2.1 MATERIALS
 - 2.1.1 Iron Castings
 - 2.1.2 Steel Castings
 - 2.1.3 Corrosion Resistant Alloy Steel Castings
 - 2.1.4 Structural Steel
 - 2.1.5 Stainless Steel
 - 2.1.5.1 Plate, Sheet, and Strip
 - 2.1.5.2 Bars and Shapes
 - 2.1.5.3 Spring Wire
 - 2.1.6 Aluminum
 - 2.1.6.1 Castings
 - 2.1.6.2 Sheet and Plate
 - 2.1.6.3 Bars and Rods
 - 2.1.7 Anchors
 - 2.1.8 Primer
- 2.2 COMPONENTS
 - 2.2.1 Blast Operation of Valves Mounted in Casing Supports

- 2.2.2 Blast Operation of Valves Mounted in Piping or Ducts
- 2.2.3 Pass Through Impulse
- 2.2.4 Minimum Operating Overpressure
- 2.2.5 Operating Temperatures
- 2.2.6 Air Flow Capacity
- 2.3 ACCESSORIES
- 2.4 FABRICATION
 - 2.4.1 Valve Units
 - 2.4.2 Casing Supports
 - 2.4.3 Pipe Mountings
 - 2.4.4 Surface Preparations, Coatings, and Finishes
 - 2.4.4.1 Valve Unit Finishes
 - 2.4.4.2 Casing Support Finishes
- 2.5 TESTS, INSPECTIONS, AND VALIDATIONS
 - 2.5.1 Blast Tests on Prototype Valve Units
 - 2.5.2 Factory Air Flow Tests
 - 2.5.3 Verification Inspection of Welds

PART 3 EXECUTION

- 3.1 INSTALLATION
 - 3.1.1 Valve Units
 - 3.1.2 Casing Supports
- 3.2 TESTS
- 3.3 MANUFACTURER'S FIELD SERVICE

-- End of Section Table of Contents --

USACE / NAVFAC / AFCESA UFGS-13420 (August 2004)

Preparing Activity: USACE Superseding
UFGS-13420A (May 2004)

UNIFIED FACILITIES GUIDE SPECIFICATIONS

References are in agreement with UMRL dated 25 June 2004

Latest change indicated by CHG tags

SECTION 13420

SELF-ACTING BLAST VALVES 08/04

NOTE: This guide specification covers the requirements for self-acting blast valves used for blast protection of supply and exhaust air systems.

Comments and suggestions on this guide specification are welcome and should be directed to the technical proponent of the specification. A listing of technical proponents, including their organization designation and telephone number, is on the Internet.

Recommended changes to a UFGS should be submitted as a Criteria Change Request (CCR).

Use of electronic communication is encouraged.

Brackets are used in the text to indicate designer choices or locations where text must be supplied by the designer.

PART 1 GENERAL

NOTE: This guide specification covers self-acting blast valves for facilities subjected to blast overpressures from accidental explosions, conventional weapons, explosion devices used by terrorists, and nuclear weapons.

This guide specification is intended for procurement of standard products that are readily available and have the required performance characteristics. This guide specification is not intended for procurement of blast valves having special performance characteristics such as actuation by delay paths and sensor actuation since they are not readily available as standard products and may require long lead times for development.

1.1 REFERENCES

NOTE: Issue (date) of references included in project specifications need not be more current than provided by the latest guide specification. Use of SpecsIntact automated reference checking is recommended for projects based on older guide specifications.

The publications listed below form a part of this specification to the extent referenced. The publications are referred to within the text by the basic designation only.

AMERICAN INSTITUTE OF STEEL CONSTRUCTION (AISC)

AISC 303	(2000) Code of Standard Practice for Steel Buildings and Bridges
AISC 325	(2001) LRFD Manual of Steel Construction
AISC 335	(1989) Structural Steel Buildings Allowable Stress Design and Plastic Design

AMERICAN WELDING SOCIETY (AWS)

AWS A2.4	(1998) Standard Symbols for Welding, Brazing and Nondestructive Examination
AWS A5.4	(1992) Stainless Steel Electrodes for Shielded Metal Arc Welding
AWS B2.1	(2000) Welding Procedure and Performance Qualification
AWS D1.1/D1.1M	(2002) Structural Welding Code - Steel

ASTM INTERNATIONAL (ASTM)

ASTM A 108	(1999) Steel Bars, Carbon, Cold-Finished, Standard Quality
ASTM A 123/A 123M	(2002) Zinc (Hot-Dip Galvanized) Coatings on Iron and Steel Products
ASTM A 148/A 148M	(2003) Steel Castings, High Strength, for Structural Purposes
ASTM A 153/A 153M	(2003) Zinc Coating (Hot-Dip) on Iron and Steel Hardware
ASTM A 159	(1983; R 2001) Automotive Gray Iron Castings
ASTM A 167	(1999) Stainless and Heat-Resisting Chromium-Nickel Steel Plate, Sheet, and

Strip

ASTM A 176	(1999) Stainless and Heat-Resisting Chromium Steel Plate, Sheet, and Strip
ASTM A 220/A 220M	(1999) Pearlitic Malleable Iron
ASTM A 27/A 27M	(2003) Steel Castings, Carbon, for General Application
ASTM A 276	(2003) Stainless Steel Bars and Shapes
ASTM A 278/A 278M	(2001) Gray Iron Castings for Pressure-Containing Parts for Temperatures Up to 650 Degrees F (350 Degrees C)
ASTM A 297/A 297M	(2003) Steel Castings, Iron-Chromium and Iron-Chromium-Nickel, Heat Resistant, for General Application
ASTM A 307	(2002) Carbon Steel Bolts and Studs, 60 000 PSI Tensile Strength
ASTM A 313/A 313M	(2003) Stainless Steel Spring Wire
ASTM A 351/A 351M	(2003) Castings, Austenitic, Austenitic-Ferritic (Duplex), for Pressure-Containing Parts
ASTM A 36/A 36M	(2003a) Carbon Structural Steel
ASTM A 439	(1983; R1999) Austenitic Ductile Iron Castings
ASTM A 447/A 447M	(1993; R 2003) Steel Castings, Chromium-Nickel-Iron Alloy (25-12 Class), for High-Temperature Service
ASTM A 47/A 47M	(1999) Ferritic Malleable Iron Castings
ASTM A 48/A 48M	(2000) Gray Iron Castings
ASTM A 536	(1984; R 1999e1) Ductile Iron Castings
ASTM A 560/A 560M	(1993; R 1998) Castings, Chromium-Nickel Alloy
ASTM A 564/A 564M	(2002a) Hot-Rolled and Cold-Finished Age-Hardening Stainless Steel Bars and Shapes
ASTM A 666	(2000) Annealed or Cold-Worked Austenitic Stainless Steel Sheet, Strip, Plate, and Flat Bar
ASTM B 108	(2003a) Aluminum-Alloy Permanent Mold Castings
ASTM B 209	(2002a) Aluminum and Aluminum-Alloy Sheet

	and Plate
ASTM B 209M	(2002a) Aluminum and Aluminum-Alloy Sheet and Plate (Metric)
ASTM B 211	(2002) Aluminum and Aluminum-Alloy Bar, Rod, and Wire
ASTM B 211M	(2002) Aluminum and Aluminum-Alloy Bar, Rod, and Wire (Metric)
ASTM B 221	(2002) Aluminum and Aluminum-Alloy Extruded Bars, Rods, Wire, Profiles, and Tubes
ASTM B 221M	(2002) Aluminum and Aluminum-Alloy Extruded Bars, Rods, Wire, Profiles, and Tubes (Metric)
ASTM B 85	(2003) Aluminum-Alloy Die Castings

THE SOCIETY FOR PROTECTIVE COATINGS (SSPC)

SSPC Paint 25	(1997; R 2000) Zinc Oxide, Alkyd, Linseed Oil Primer for Use Over Hand Cleaned Steel, Type I and Type II
---------------	--

1.2 SUBMITTALS

NOTE: Submittals must be limited to those necessary for adequate quality control. The importance of an item in the project should be one of the primary factors in determining if a submittal for the item should be required.

A "G" following a submittal item indicates that the submittal requires Government approval. Some submittals are already marked with a "G". Only delete an existing "G" if the submittal item is not complex and can be reviewed through the Contractor's Quality Control system. Only add a "G" if the submittal is sufficiently important or complex in context of the project.

For submittals requiring Government approval on Army projects, a code of up to three characters within the submittal tags may be used following the "G" designation to indicate the approving authority. Codes for Army projects using the Resident Management System (RMS) are: "AE" for Architect-Engineer; "DO" for District Office (Engineering Division or other organization in the District Office); "AO" for Area Office; "RO" for Resident Office; and "PO" for Project Office. Codes following the "G" typically are not used for Navy projects.

Submittal items not designated with a "G" are

considered as being for information only for Army
projects and for Contractor Quality Control approval
for Navy projects.

Government approval is required for submittals with a "G" designation; submittals not having a "G" designation are for [Contractor Quality Control approval.] [information only. When used, a designation following the "G" designation identifies the office that will review the submittal for the Government.] The following shall be submitted in accordance with Section 01330 SUBMITTAL PROCEDURES:

SD-02 Shop Drawings

Contractor Design of Structural Supports[; G][; G, [_____]]

Fabrication, erection, and installation drawings when concrete opening and framing systems require changes to accommodate proposed valve casings. These drawings shall show framing layouts, elevations, sections, enlarged details, casing locations with dimensions, connections, and material designations. Weld symbols used shall conform to AWS A2.4.

SD-03 Product Data

Self-Acting Blast Valve Systems

Valve unit data consisting of catalog cuts, brochures, circulars, specifications, and product data that shows complete dimensions and completely describe overpressure ratings, pass-through impulse leakage ratings, air flow rates, actuation mechanisms, and materials. When this data shows several products, the actual products proposed shall be clearly identified.

Contractor Design of Structural Supports

Design and analysis calculations showing concrete opening and framing systems requiring changes to accommodate the proposed valve casings. When applicable, analysis and calculations shall include a narrative discussion of the analysis techniques used; sketches showing the design overpressure loadings, member cross-sections, layouts and dimensions; elastic and plastic section properties for all load-carrying members; minimum yield and tensile strengths for steel materials; plastic moment capacities for load-carrying members; resistance function sketches showing equivalent ultimate resistance and elastic deflections; and design deformation limits and response values for maximum deflections, ductility ratios, and support rotations. Design and analysis calculations shall be stamped by a Registered Professional Engineer experienced in dynamic analysis and design methods.

Self-Acting Blast Valve Systems

Manufacturer's instructions for valve unit and casing installation and field testing.

Manufacturer's Field Service

Information describing training to be provided, training aids to be used, and a description of the training.

SD-06 Test Reports

Blast Tests on Prototype Valve Units
Factory Air Flow Tests
Tests

Certified blast and air flow test reports for valve units, including the name and location of the testing agency or laboratory, the date of the tests, a description of the valve units tested, the overpressure waveforms, and the testing apparatus. The test reports shall document the pass-through impulse leakage, the ability of the valve units to resist the specified loads, and the air flow rate versus pressure loss characteristics over the operating pressures. Test reports shall include an analysis and interpretation of test results.

SD-07 Certificates

Self-Acting Blast Valve Systems

Certificates stating that the valves provided were manufactured using the same materials, dimensions and tolerances as blast tested prototype valve units and that air flow and pressure drop rating meet specification requirements. Each certificate shall be signed by an official authorized to certify in behalf of the manufacturer and shall identify the quantity and date of shipment or delivery to which the certificate applies.

SD-10 Operation and Maintenance Data

Self-Acting Blast Valve Systems

Information bound in manual format consisting of manufacturer's safety precautions, preventative maintenance and schedules, troubleshooting procedures, special tools, parts list, and spare parts data. All data shall be edited to cover only the valves furnished.

1.3 SYSTEMS DESCRIPTION

This section specifies self-acting blast valve systems consisting of blast valve units and mountings. All valve units and valve mountings shall be provided by one manufacturer.

1.3.1 Contractor Design of Structural Supports

**NOTE: Delete reference to structural steel when
valve casings are cast directly into concrete.**

In lieu of the concrete openings and supports indicated the Contractor may design openings and supports to accommodate the proposed valve system. Openings and framing shall be designed using loads computed from the blast overpressures specified or indicated. Structural steel mechanical properties such as minimum yield stress and tensile strength and member

section properties shall be determined based on the proposed framing system. Dynamic increase factors shall be based on applicable strain rates and the concrete unconfined compressive strength, concrete reinforcement yield stress, and structural steel yield stress. Flexural analyses shall be performed using equivalent single degree of freedom or other approved dynamic analysis methods. Deformation limits shall be selected by the Contractor so that ultimate deflections do not inhibit proper valve unit operation.

1.3.2 Sustained Blast Overpressures

NOTE: Delete this paragraph when only triangular overpressure waveforms are specified.

Blast overpressure waveforms may be specified or indicated as sustained (infinite duration) overpressures, triangular waveforms with peak overpressures and finite durations, or other pressure versus time histories. When the blast overpressures are low, a sustained overpressure can be specified or indicated conveniently without loss of economy. When the blast overpressures are high, specifying or indicating triangular waveforms will enhance economy and availability. The sustained overpressures shown in the text cover tested commercial products that are readily available. Some triangular waveform peak overpressures and durations for tested commercial products are shown below.

Peak Overpressure MPa (psi)	Duration (milliseconds)
12.41 (1800)	0.64
3.31 (480)	3
2.59 (375)	5
2.41 (350)	15

Sustained or triangular blast overpressure waveforms may be either specified or indicated on blast valve schedules shown on the drawings. Other waveforms should be shown on the drawings using waveform diagrams.

Casing mounted [supply valve] [exhaust valve] [valve] units shall operate under a zero rise time, sustained (infinite duration) blast overpressure of [1.793 MPa] [1.103 MPa] [276 kPa] [_____] kPa [260] [160] [40] [_____] psi [, and casing mounted exhaust valve units shall operate under a zero rise time, sustained (infinite duration) blast overpressure of [1.793 MPa] [1.103 MPa] [276 kPa] [_____] kPa [260] [160] [40] [_____] psi.] [Valve units mounted in [supply] [exhaust] [diesel engine exhaust] piping or ducts shall operate under a zero rise time, sustained (infinite duration) blast overpressure of [1.793 MPa] [1.103 MPa] [276 kPa] [_____] kPa [260] [160] [40] [_____] psi.]

1.3.3 Blast Overpressure Waveforms

NOTE: Delete this paragraph when only sustained overpressures are specified. Coordinate with paragraph SUSTAINED BLAST OVERPRESSURES.

Casing mounted [supply valve] [exhaust valve] [valve] units shall operate under a triangular blast overpressure waveform having a zero rise time and a peak overpressure and duration of [_____] kPa psi and [_____] milliseconds [, and casing mounted exhaust valve units shall operate under a triangular blast overpressure waveform having a zero rise time and a peak overpressure and duration of [_____] kPa psi and [_____] milliseconds]. [Valve units mounted in [supply] [exhaust] [diesel engine exhaust] piping or ducts shall operate under a triangular blast overpressure waveform having a zero rise time and a peak overpressure and duration of [_____] kPa psi and [_____] milliseconds.] [Valve units shall operate under triangular blast overpressure waveforms having a zero rise time and the peak overpressures and durations indicated.] [Valve units shall operate under the blast waveforms indicated.]

1.3.4 Performance Requirements

1.3.4.1 Field Removable Valve Units

Blast valve units shall be completely removable from casings or other mountings.

1.3.4.2 Penetrations

Except for air flow openings, any penetrations through the valve system shall be sealed against blast leakage through the penetration.

1.4 QUALIFICATIONS

Welders, welding operators, welding procedures, and weld inspectors shall be qualified in accordance with AWS B2.1 or AWS D1.1/D1.1M, as applicable.

1.5 DELIVERY AND STORAGE

Valve units, casings, and accessories delivered and placed in storage shall be protected from weather, excessive humidity and temperature variation, and dirt, dust, or other contaminants.

1.6 WARRANTY

Manufacturer's written warranty covering valve units for 2 years after installation and acceptance by the Government shall be furnished. The warranty shall provide for repair or replacement of the valve units in the event of malfunction due to defects in materials or workmanship except that finishes need only be warranted for 1 year and the warranty need not cover cleaning and other normal maintenance.

PART 2 PRODUCTS

2.1 MATERIALS

2.1.1 Iron Castings

Iron castings shall conform to ASTM A 47/A 47M, ASTM A 48/A 48M, ASTM A 159, ASTM A 220/A 220M, ASTM A 278/A 278M, ASTM A 439, or ASTM A 536.

2.1.2 Steel Castings

Carbon and alloy steel castings shall conform to ASTM A 27/A 27M Grades U-60-30, 65-35, 70-36 or 70-40, or ASTM A 148/A 148M.

2.1.3 Corrosion Resistant Alloy Steel Castings

Corrosion resistant alloy steel castings shall conform to ASTM A 297/A 297M, ASTM A 351/A 351M, ASTM A 447/A 447M, or ASTM A 560/A 560M.

2.1.4 Structural Steel

Structural steel shall conform to ASTM A 36/A 36M.

2.1.5 Stainless Steel

2.1.5.1 Plate, Sheet, and Strip

Stainless steel plate, sheet, and strip shall conform to ASTM A 167, ASTM A 176, or ASTM A 666.

2.1.5.2 Bars and Shapes

Stainless steel bars and shapes shall conform to ASTM A 276 or ASTM A 564/A 564M.

2.1.5.3 Spring Wire

Stainless steel spring wire shall conform to ASTM A 313/A 313M.

2.1.6 Aluminum

2.1.6.1 Castings

Aluminum-alloy castings shall conform to ASTM B 85 or ASTM B 108.

2.1.6.2 Sheet and Plate

Aluminum sheet and plate shall conform to ASTM B 209M ASTM B 209.

2.1.6.3 Bars and Rods

Aluminum bars and rods shall conform to ASTM B 211M ASTM B 211 or ASTM B 221M ASTM B 221.

2.1.7 Anchors

Concrete anchors shall conform to ASTM A 36/A 36M, ASTM A 108 or ASTM A 307.

2.1.8 Primer

NOTE: Delete paragraph on primer when casing
supports are galvanized and when valves are mounted
in piping or ducts.

Primer shall conform to SSPC Paint 25.

2.2 COMPONENTS

NOTE: Except for diesel exhaust piping, select
single-acting nonlatching, double-acting nonlatching
or latching type valves. Double-acting nonlatching
valves are the least expensive.

Valves shall close under the positive blast overpressures specified or indicated and shall be fully operational after the blast.

2.2.1 Blast Operation of Valves Mounted in Casing Supports

[[Supply valves] [Valves] shall be the single-acting nonlatching type that automatically return to the open position except that double-acting valves that close under both positive and negative overpressure may be substituted for single-acting valves.] [[Supply valves] [Valves] shall be the double-acting nonlatching type that close under both positive and negative blast pressure and automatically return to the open position.] [[Supply valves] [Valves] shall be the latching type that remain in the closed position until manually released.] [Exhaust valves shall be the single-acting nonlatching type that automatically return to the open position except that double-acting valves that close under both positive and negative overpressure may be substituted for single-acting valves.] [Exhaust valves shall be the double-acting nonlatching type that close under both positive and negative blast pressure and automatically return to the open position.] [Exhaust valves shall be the latching type that remain in the closed position until manually released.]

2.2.2 Blast Operation of Valves Mounted in Piping or Ducts

[Valves mounted in diesel engine exhaust piping or ducts shall be the single-acting nonlatching type that return to the open position under the diesel exhaust pressure.] [[Supply valves] [Valves] mounted in piping or ducts shall be the single-acting nonlatching type that automatically return to the open position except that double-acting valves that close under both positive and negative overpressure may be substituted for single-acting valves.] [[Supply valves] [Valves] mounted in piping or ducts shall be the double-acting nonlatching type that close under both positive and negative blast pressure and automatically return to the open position.] [[Supply valves] [Valves] mounted in piping or ducts shall be the latching type that remain in the closed position until manually released.] [Exhaust valves mounted in piping or ducts shall be the single-acting nonlatching type that automatically return to the open position except that double-acting valves that close under both positive and negative overpressure may be substituted for single-acting valves.] [Exhaust valves mounted in piping or ducts shall be the double-acting nonlatching type that close under both positive and negative blast pressure and automatically return to the open position.] [Exhaust valves mounted in piping or ducts shall be the latching type that remain in the closed position until manually released.]

2.2.3 Pass Through Impulse

NOTE: Specify low pass-through impulse when valves
are in close proximity to filters and higher
pass-through impulse when valves vent to expansion

chambers or other open unoccupied areas.

The incident pass-through impulse leakage behind the valve shall not exceed [48.3] [137.9] [_____] kPa-milliseconds [7] [20] [_____] psi-milliseconds [for supply valves nor [48.3] [137.9] [_____] kPa-milliseconds [7] [20] [_____] psi-milliseconds for exhaust valves].

2.2.4 Minimum Operating Overpressure

NOTE: Insert appropriate minimum blast overpressure.

Valves shall completely close under a minimum blast overpressure of [4.1] [_____] kPa [0.6] [_____] psi.

2.2.5 Operating Temperatures

NOTE: Edit appropriate temperature requirements.

Do not include temperature ranges in the specifications when operating temperatures are shown on a valve schedule.

Valve units shall be fully operational over [a temperature range from [minus 20 to plus 77] [[_____] to [_____] degrees C [-4 to 170] [[_____] to [_____] degrees F] [a temperature range from [minus 20 to plus 77] [[_____] to [_____] degrees C [-4 to 170] [[_____] to [_____] degrees F for supply valves and [minus 20 to plus 149] [[_____] to [_____] degrees C [-4 to 300] [[_____] to [_____] degrees F for exhaust valves] [the temperature ranges indicated] [except that the maximum operating temperature for valves mounted in diesel exhaust piping or ducts shall not be less than [454] [649] [_____] degrees C [850] [1200] [_____] degrees F].

2.2.6 Air Flow Capacity

NOTE: Edit value of air flow pressure drop. Delete pressure drop in the specifications when pressure drops are shown on a valve schedule.

Valves shall meet the air flow rates [and pressure drops] indicated on the valve schedules. [The total pressure drop across each casing mounted supply and exhaust valve shall not exceed [254] [_____] Pa [1] [_____] inch of water gauge at the air flows indicated.] [The total pressure drop across each valve mounted in [diesel engine exhaust] [supply and exhaust] piping or ducts shall not exceed [_____] Pa inch of water gauge at the flows indicated.]

2.3 ACCESSORIES

Blast valve systems shall be complete with valve units, casings, fasteners, anchors, and all other accessories required to provide a complete, operable installation.

2.4 FABRICATION

Valve units and mountings shall be factory fabricated units. Valve units shall be connected to mountings using approved bolts, nuts, and washers. Welding shall be in accordance with AWS D1.1/D1.1M. Stainless steel shall be welded using electrodes conforming to AWS A5.4.

2.4.1 Valve Units

Valve units shall be atmospheric corrosion resistant. Valve bodies shall be fabricated from iron, steel or aluminum-alloy castings except that bodies for valves mounted in diesel engine exhaust piping or ducts shall be fabricated from corrosion resistant alloy steel castings. Internal parts such as spindles and pressure disks shall be fabricated from stainless steel or aluminum. Helical springs shall be fabricated from stainless steel spring wire. Special iron, steel and aluminum-alloy castings used to fabricate valve bodies, and special stainless steels and aluminum-alloys used to fabricate internal parts will be permitted when the materials used in the valve units provided are the same as those used in blast tested prototype valve units. Valve surfaces that contact to prevent blast leakage shall be machined or fitted with approved neoprene gaskets to ensure a tight fit.

2.4.2 Casing Supports

NOTE: Specify ground smooth welds when appearance is important.

Valve casing supports shall be structural steel fabricated in accordance with either AISC 335 or AISC 325. Groove welds used to splice face plates shall be complete penetration welds with complete joint fusion. In order to reduce distortion and residual stresses, a welding sequence shall be used. All welds shall be stress relieved, and welded casings shall be post weld straightened. Fabricated steel shall be well-formed to shape and size, with sharp lines and angles. Intermediate and corner joints shall be coped or mitered. Exposed welds other than fillet welds shall be ground smooth.

2.4.3 Pipe Mountings

Valves indicated for installation in piping systems shall be flange connected. Flange dimension shall be compatible with the piping specified or indicated or companion flanges shall be provided and welded to the adjacent piping.

2.4.4 Surface Preparations, Coatings, and Finishes

The coatings and finishes used shall be suitable for preventing atmospheric corrosion and shall be resistant to heat damage under the operating temperatures specified.

2.4.4.1 Valve Unit Finishes

Ferrous metal surfaces other than stainless steel shall be prepared and factory coated and finished using the manufacturer's standard process.

2.4.4.2 Casing Support Finishes

NOTE: Edit option for galvanizing or priming and painting. Priming and painting is recommended for most applications.

[Valve support casings shall be galvanized in accordance with ASTM A 123/A 123M except that surfaces that will be embedded in concrete need not be galvanized. Exposed portions of concrete anchors, fasteners that connect casing parts, and fasteners that connect valve units to casings shall be galvanized in accordance with ASTM A 153/A 153M.] [Valve support casings shall be prepared for priming in accordance with either AISC 335 or AISC 325 and factory primed and finish painted, except that surfaces that will be embedded in concrete need not be primed and shall not be finish painted. Finish painting shall be the manufacturer's standard.]

2.5 TESTS, INSPECTIONS, AND VALIDATIONS

2.5.1 Blast Tests on Prototype Valve Units

Validation of valve performance under blast shall be accomplished by blast tests performed on prototype valve units. Such tests shall validate that the specified pass-through impulse leakage is not exceeded and that the valve unit is fully operational after blast loading. When finite duration overpressure waveforms are specified, the overpressure waveforms used in the prototype test shall exceed the specified waveforms in both overpressure and impulse.

2.5.2 Factory Air Flow Tests

NOTE: Edit air flow test requirements.

Valve units shall be factory air flow tested to ensure that assembled valve units meet the air flow rates and pressure drops specified or indicated. Product sampling and air flow testing methods and procedures shall be the manufacturer's standard except that at least [5] [_____] percent of the total number of each valve type shall be tested.

2.5.3 Verification Inspection of Welds

Verification inspection of welds shall be performed by the Contractor in accordance with AWS D1.1/D1.1M.

PART 3 EXECUTION

3.1 INSTALLATION

3.1.1 Valve Units

Valve units shall be installed in accordance with the valve manufacturer's written instructions.

3.1.2 Casing Supports

Structural steel casing supports shall be erected in accordance with the

manufacturer's instructions, AISC 303 and either AISC 335 or AISC 325.

3.2 TESTS

Field tests on valve units shall be performed in accordance with the valve manufacturer's written instructions and the testing requirements specified in other specification sections.

3.3 MANUFACTURER'S FIELD SERVICE

**NOTE: Specify field service for large valve
installations. Edit instruction period duration and
instruction videotape requirements.**

Upon completion of the work, and at a time designated by the Contracting Officer, the services of one engineer and other technical personnel as required shall be provided for a period of not less than [4] [_____] hours to instruct Government personnel in the operation and maintenance of the blast valves and all other items furnished under this specification section. The instructions shall also include use of the operation and maintenance manual. The instructions shall include videotapes. An instruction outline and procedure shall be submitted and approved prior to scheduling the instruction. One copy of all instruction material including videotapes shall be provided at the time of instruction.

-- End of Section --