****
USACE / NAVFAC / AFCEC **UFGS-33 56 21.17 (May 2025)**

Preparing Activity: NAVFAC **Superseding**
UFGS-33 56 21.17 (November 2018)

UNIFIED FACILITIES GUIDE SPECIFICATIONS

References are in agreement with UMRL dated July 2025
****

SECTION TABLE OF CONTENTS

DIVISION 33 - UTILITIES

SECTION 33 56 21.17

SINGLE WALL ABOVEGROUND FIXED ROOF STEEL POL STORAGE TANK

05/25

2.1 MATERIALS
2.1.1 Materials for System Components, Pipe, and Fittings
2.2 STRUCTURAL STEEL
2.3 CARBON STEEL, PIPE FITTINGS, FLANGES, GASKETS, AND BOLTING
2.4 STAINLESS STEEL PIPE, FITTINGS, FLANGES, GASKETS, AND BOLTING
2.5 ALUMINUM PIPING FOR STILLING WELLS
2.6 BOLTING AND ALUMINUM FLANGES FOR STILLING WELLS
2.7 WELDING FOR ALUMINUM PIPING
2.7.1 Process for Aluminum
2.7.2 Aluminum Welding Electrodes and Rods
2.8 BOLTING FOR SHELL MANHOLE COVERS
2.9 GASKETS FOR MANHOLE COVERS, STILLING WELL FLANGES, AND ROOF CENTER VENT
2.10 TANK BOTTOM TO FOUNDATION SEAL
2.10.1 Tank Bottom to Foundation Gasket - Self Anchored Tanks
2.10.2 Tank Shims and Tank Grout - Anchored Tanks
2.10.3 Chime Sealant
2.11 INTERIOR PROTECTIVE COATING SYSTEM
2.12 EXTERIOR PROTECTIVE COATING SYSTEM
2.13 APPURTENANCES
2.13.1 Floating Pan Installation Hatch
2.13.2 Floating Pan
2.13.2.1 Pan Integrity
2.13.2.2 Floating Pan Prototype Fire Test
2.13.2.3 Joint Connections
2.13.2.4 Aluminum Extrusions
2.13.2.5 Aluminum Sandwich Panels
2.13.2.6 Support Legs
2.13.2.7 Periphery Seals
2.13.2.8 Penetrations
2.13.2.9 Manhole
2.13.2.9.1 Pressure/Vacuum Vent
2.13.2.10 Grounding Cables
2.13.2.11 Anti-Rotation Cable
2.13.3 Sample Gauge Hatch
2.13.4 Floating Seal and Retrieval Winch
2.13.5 Mechanical Tape Level Gauge
2.13.6 Mechanical Tape Level Gauge
2.13.7 Venting
2.13.7.1 Overflow/Circulation Vents
2.13.7.2 Center Roof Vent
2.13.8 Circumferential Stairway and Platforms
2.13.9 Manhole Access Platforms
2.13.10 Roof Perimeter Guardrail
2.13.11 Internal Ladders
2.13.12 Internal Ladder Access Hatch
2.13.13 Emergency Vent
2.13.14 Roof Circulation Vent/Inspection Hatches
2.13.15 Water Draw-Off System
2.13.15.1 Basis of Design of Water Draw-Off System
2.13.15.1.1 Detail Drawing
2.13.16 Side Stream Filtration System
2.13.16.1 Basis of Design of Side stream Filtration System
2.13.16.2 Detail Drawing
2.13.17 Shell Manholes
2.13.18 Scaffold Cable Support
2.13.19 Antiseize Compound
2.13.20 Channel Mounting

-- End of Section Table of Contents --

****

USACE / NAVFAC / AFCEC **UFGS-33 56 21.17 (May 2025)**

Preparing Activity: NAVFAC **Superseding**
UFGS-33 56 21.17 (November 2018)

UNIFIED FACILITIES GUIDE SPECIFICATIONS

References are in agreement with UMRL dated July 2025
****

SECTION 33 56 21.17

SINGLE WALL ABOVEGROUND FIXED ROOF STEEL POL STORAGE TANK
05/25

****

NOTE: This guide specification covers the requirements for design and installation of atmospheric aboveground steel tanks with fixed cone roofs.

Adhere to UFC 1-300-02 Unified Facilities Guide Specifications (UFGS) Format Standard when editing this guide specification or preparing new project specification sections. Edit this guide specification for project specific requirements by adding, deleting, or revising text. For bracketed items, choose applicable item(s) or insert appropriate information.

Remove information and requirements not required in respective project, whether or not brackets are present.

Comments, suggestions and recommended changes for this guide specification are welcome and should be submitted as a Criteria Change Request (CCR).
****

****

NOTE: Coordinate use of floating pans with UFC 3-460-01 prior to editing this specification.
****

****

NOTE: Earthwork, concrete work, piping, and other work in connection with the tanks should be included in the appropriate sections of the project specification or in a separate project specification.
****

****

NOTE: The following information must be shown on the project drawings:

1. The extent of the work included in the project should be indicated on drawings showing the site layout, location of outlets and inlets, water draw off connection, manholes, other tank appurtenances, and other data required for design by the Contractor.

2. If concrete foundation work is provided under a separate contract, Government work should include foundations, setting anchor bolts, concrete retaining ring, and other pertinent work such as sand for sand cushion, water for testing, and furnishing and installing any tank accessories not a part of this specification.

****

****

NOTE: This section is not intended for tanks with aluminum geodesic dome roofs.

This section is not intended to be used without Section 33 56 21.18 SINGLE WALL POL TANK UNDERTANK INTERSTITIAL SPACE and Section 33 52 43.13 AVIATION FUEL PIPING or Section 33 52 40 FUEL SYSTEMS PIPING (NON-HYDRANT). For piping, pipe fittings, flanges, gaskets, and bolting, refer to Section 33 52 43.13 AVIATION FUEL PIPING or Section 33 52 40 FUEL SYSTEMS PIPING (NON-HYDRANT).

****

PART 1 GENERAL

1.1 REFERENCES

****

NOTE: This paragraph is used to list the publications cited in the text of the guide specification. The publications are referred to in the text by basic designation only and listed in this paragraph by organization, designation, date, and title.

Use the Reference Wizard's Check Reference feature when you add a Reference Identifier (RID) outside of the Section's Reference Article to automatically place the reference in the Reference Article. Also use the Reference Wizard's Check Reference feature to update the issue dates.

References not used in the text will automatically be deleted from this section of the project specification when you choose to reconcile references in the publish print process.

****

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 IRON AND STEEL INSTITUTE (AISI)

AISI E 1	(2011) Steel Plate Engineering Data Series - Design of Plate Structures, Volumes I & II

AMERICAN PETROLEUM INSTITUTE (API)

API MPMS 2.2A	(1995; R 2017) Manual of Petroleum Measurement Standards Chapter 2-Tank Calibration Section 2A-Measurement and Calibration of Upright Cylindrical Tanks by the Manual Tank Strapping Method
API MPMS 2.2B	(1989; R 2019) Manual of Petroleum Measurement Standards Chapter 2: Tank Calibration - Section 2B: Calibration of Upright Cylindrical Tanks Using the Optical Reference Line Method
API MPMS 2.2C	(2002; R 2013) Manual of Petroleum Measurement Standards Chapter 2: Tank Calibration - Section 2C - Calibration of Upright Cylindrical Tanks Using the Optical-Triangulation Method
API MPMS 2.2D	(2003; R 2014) Manual of Petroleum Measurement Standards Chapter 2: Tank Calibration - Section 2D Calibration of Upright Cylindrical Tanks Using the Internal Electro-Optical Distance-Ranging Method
API RP 2009	(2002; R 2007; 7th Ed) Safe Welding, Cutting, and Hot Work Practices in Refineries, Gasoline Plants, and Petrochemical Plants
API Std 650	(2013; Errata 1 2013; Addendum 1 2014; Errata 2 2014; Addendum 2 2016; Addendum 3 2018) Welded Tanks for Oil Storage
API Std 653	(2014; Addendum 1 2018; Errata 1 2010; Addendum 2 2020; Addendum 3 2023; Errata 2 2025) Tank Inspection, Repair, Alteration, and Reconstruction
API Std 2000	(2014) Venting Atmospheric and Low-Pressure Storage Tanks

AMERICAN SOCIETY FOR NONDESTRUCTIVE TESTING (ASNT)

ASNT SNT-TC-1A	(2020) Recommended Practice for Personnel Qualification and Certification in Nondestructive Testing

AMERICAN SOCIETY OF MECHANICAL ENGINEERS (ASME)

ASME B16.5	(2020) Pipe Flanges and Flanged Fittings

	NPS 1/2 Through NPS 24 Metric/Inch Standard
ASME B16.9	(2024) Factory-Made Wrought Buttwelding Fittings
ASME B16.11	(2021) Forged Fittings, Socket-Welding and Threaded
ASME B31.3	(2024) Process Piping
ASME B73.1	(2020) Specification for Horizontal End Suction Centrifugal Pumps for Chemical Process
ASME B73.2	(2023) Specification for Vertical In-Line Centrifugal Pumps for Chemical Process
ASME BPVC SEC IX	(2017; Errata 2018) BPVC Section IX-Welding, Brazing and Fusing Qualifications

AMERICAN WELDING SOCIETY (AWS)

AWS A5.10/A5.10M	(2023) Welding Consumables - Wire Electrodes, Wires and Rods for Welding of Aluminum and Aluminum-Alloys - Classification
AWS QC1	(2016) Specification for AWS Certification of Welding Inspectors

ASTM INTERNATIONAL (ASTM)

ASTM A123/A123M	(2024) Standard Specification for Zinc (Hot-Dip Galvanized) Coatings on Iron and Steel Products
ASTM A325	(2014) Standard Specification for Structural Bolts, Steel, Heat Treated, 120/105 ksi Minimum Tensile Strength
ASTM A325M	(2014) Standard Specification for Structural Bolts, Steel, Heat Treated, 830 MPa Minimum Tensile Strength (Metric)
ASTM A492	(1995; R 2019) Standard Specification for Stainless Steel Rope Wire
ASTM B209	(2014) Standard Specification for Aluminum and Aluminum-Alloy Sheet and Plate
ASTM B209M	(2014) Standard Specification for Aluminum and Aluminum-Alloy Sheet and Plate (Metric)
ASTM B241/B241M	(2022) Standard Specification for Aluminum and Aluminum-Alloy Seamless Pipe and Seamless Extruded Tube
ASTM B247	(2020) Standard Specification for Aluminum

	and Aluminum-Alloy Die Forgings, Hand Forgings, and Rolled Ring Forgings
ASTM B247M	(2020) Standard Specification for Aluminum and Aluminum-Alloy Die Forgings, Hand Forgings, and Rolled Ring Forgings (Metric)
ASTM C920	(2018; R 2024) Standard Specification for Elastomeric Joint Sealants
ASTM D471	(2016a; R 2021) Standard Test Method for Rubber Property - Effect of Liquids
ASTM D3489	(2017) Standard Test Method for Microcellular Urethane Materials
ASTM D4065	(2012) Standard Practice for Plastics: Dynamic Mechanical Properties: Determination and Report of Procedures
ASTM D4814	(2020a) Standard Specification for Automotive Spark-Ignition Engine Fuel
ASTM E329	(2023) Standard Specification for Agencies Engaged in Construction Inspection, Testing, or Special Inspection

NACE INTERNATIONAL (NACE)

NACE SP0178	(2007) Design, Fabrication, and Surface Finish Practices for Tanks and Vessels to be Lined for Immersion Service

NATIONAL ELECTRICAL MANUFACTURERS ASSOCIATION (NEMA)

NEMA MG 1	(2021) Motors and Generators

NATIONAL FIRE PROTECTION ASSOCIATION (NFPA)

NFPA 30	(2024; ERTA 1 2025) Flammable and Combustible Liquids Code
NFPA 70	(2023; ERTA 1 2024; TIA 24-1; TIA 25-2) National Electrical Code
NFPA 704	(2022) Standard System for the Identification of the Hazards of Materials for Emergency Response

NORTH ATLANTIC TREATY ORGANIZATION (NATO)

AFLP-3747	(2013; Rev 9) Guide Specifications (Minimum Quality Standards) for Aviation Turbine Fuels (F-24, F-27, F-34, F-35, F-37, F-40 And F-44)

U.S. DEPARTMENT OF DEFENSE (DOD)

MIL-DTL-5624	(2024; Rev X) Turbine Fuel, Aviation,

	Grades JP-4 and JP-5
MIL-DTL-83133	(2015; Rev J) Turbine Fuels, Aviation, Kerosene Type, JP-8 (NATO F-34), NATO F-35 and JP-8 + 100 (NATO F-37)
MIL-PRF-23236	(2009; Rev D; Notice 1 2023) Coating Systems for Ship Structures
UFC 3-460-01	(2019; with Change 3, 2023) Design: Petroleum Fuel Facilities

U.S. NATIONAL ARCHIVES AND RECORDS ADMINISTRATION (NARA)

29 CFR 1910.23	(Nov 2016) Ladders
29 CFR 1910.25	(Dec 2019) Stairways

1.2 SUBMITTALS

****

NOTE: Review Submittal Description (SD) definitions in Section 01 33 00 SUBMITTAL PROCEDURES and edit the following list, and corresponding submittal items in the text, to reflect only the submittals required for the project. The Guide Specification technical editors have classified those items that require Government approval, due to their complexity or criticality, with a "G." Generally, other submittal items can be reviewed by the Contractor's Quality Control System. Only add a "G" to an item if the submittal is sufficiently important or complex in context of the project.

For Army projects, fill in the empty brackets following the "G" classification with a code of up to three characters 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 and Air Force projects.

The "S" classification indicates submittals required as proof of compliance for sustainability Guiding Principles Validation or Third Party Certification and as described in Section 01 33 00 SUBMITTAL PROCEDURES.

Government approval is required for submittals with a "G" or "S" classification. Submittals not having a "G" or "S" classification are for Contractor Quality Control approval. Submittals not having a "G" or "S" classification are for information only. When used, a code following the "G" classification identifies the office that will review the submittal for the Government. Submit the following in accordance with Section 01 33 00 SUBMITTAL PROCEDURES:

SD-01 Preconstruction Submittals

Copies of API Publications; G, [_____]

Acknowledgement of API Std 650; G, [_____]

NACE Visual Comparator; G, [_____]

Acknowledgement of Surface Finish Requirements; G, [_____]

SD-02 Shop Drawings

Steel Tank; G, [_____]

[Tank Bottom Shimming and Grouting Plan; G, [_____]

] Floating Pan; G, [_____]

Overflow/Circulation Vents; G, [_____]

Water Draw-Off System; G, [_____]

Product Saver Tank; G, [_____]

[Side Stream Filtration System; G, [_____]

] Channel Mounting Pads; G, [_____]

Tank Erection Bracing Plan; G

Roof Circulation Vent/Inspection Hatches; G

****

NOTE: Include emergency vent in SD-03 and SD-05 only on tanks smaller than 15.24 meters 50 feet in diameter and without a floating pan.

****

SD-03 Product Data

Structural Steel; G, [_____]

Carbon Steel, Pipe Fittings, Flanges, Gaskets, and Bolting; G, [_____]

Aluminum Piping; G, [_____]

Aluminum Flanges; G, [_____]

Gaskets for Manhole Covers, Stilling Well Flanges, and Roof Center Vent; G, [_____]

[Tank Bottom to Foundation Gasket; G, [_____]

][Tank Grout; G, [_____]

][Tank Shims; G, [_____]

] Floating Pan; G, [_____]

Sample Gauge Hatch; G, [_____]

[Floating Seal and Retrieval Winch; G, [_____]

] Mechanical Tape Level Gauge; G, [_____]

Center Roof Vent; G, [_____]

[Stairway Step and Platform Tread Grating; G, [_____]

][Stairway Bolting; G, [_____]

][Emergency Vent; G, [_____]

][Side Stream Filtration System; G, [_____]

] Antiseize Compound; G, [_____]

SD-04 Samples

[Tank Bottom to Foundation Gasket; G, [_____]

] SD-05 Design Data

[Emergency Ventilation Calculations; G, [_____]

] Steel Tank Design; G, [_____]

Floating Pan Design; G, [_____]

SD-06 Test Reports

Visual Examination of Vertical Shell-Seam Tack Welds

Visual Examination of Initial Pass of Internal Shell-to-Bottom Weld

Vacuum Box Testing of Internal Shell-to-Bottom Initial Weld Pass

Visual Examination of Completed Internal and External Shell-to-Bottom Welds

Radiographic Examination of Shell Butt Weld

Visual Examination of Shell Butt Welds

Visual Examination of Fillet Welds

Visual Examination of Tank Bottom Plates

Vacuum Box Testing of Tank Bottom Fillet Weld

Pneumatic Tests of Reinforcing Plates

Hydrostatic Testing

[Approval of Professional Engineer in Lieu of Hydrostatic Testing

] Shell Settlement Measurements Taken Before, During, and After Hydrostatic Testing

Internal Bottom Elevation Readings Taken Before and After Hydrostatic Testing

Shell Plumbness

Shell Roundness

Maximum Local Deviations, Shell

Tightness Test Records

Tank Bottom Puddle Test

Roof Puddle Test

Stilling Well Plumbness Test

API Std 653 Inspection Reports; G, [_____]

Ringwall Tolerance Test Report

SD-07 Certificates

Qualifications of Tank Erector

Welding Procedure Specifications (WPS)

Welding Procedure Qualification Records (PQRs)

Welder Performance Qualification Records (WPQ)

Tank Calibration Experience

Qualifications of Floating Pan Manufacturer

Weld Inspector Certification

NDE Personnel Certification

Qualifications of Testing Agency

Qualifications of API Std 653 Inspector

SD-09 Manufacturer's Field Reports

Mill Test Reports; G, [_____]

Impact Test Data; G, [_____]

Floating Pan Prototype Fire Test; G, [_____]

SD-10 Operation and Maintenance Data

API Std 653 Inspection Reports, Data Package 2

[Tank Calibration Table, Data Package 2

][Electronic Calibration Table, Data Package 2

] Maintenance Instructions, Data Package 2

Operator Instructions, Data Package 2

1.3 COPIES OF API PUBLICATIONS

Provide four copies of API RP 2009, API Std 650, and API MPMS 2.2A, API MPMS 2.2B, API MPMS 2.2C and API MPMS 2.2D to the Contracting Officer.

1.4 RELATED REQUIREMENTS

****

NOTE: If fuel used is not listed in this section, consult UFC 3-460-01, "Design: Petroleum Fuel Facilities", Chapter 2-2 for ASTM or MIL-DTL specification number, and list below.

In the electrical design, include the following: potted explosion proof MI cable for connections to electric actuators in the dike area; tank grounding system; conduit routing such that it cannot be stepped upon; supporting conduit on cast-in-place concrete supports inside the secondary containment area; considering conduit supports during design and addressing aboveground and belowground conduit and locations of boxes, lights, etc.

Refer to AW 078-24-27 for Standard Design of Aboveground Vertical Steel Fuel Tanks with Fixed Roofs.

****

Materials, design, fabrication, welding, erection, testing, and appurtenances must be in accordance with UFC 3-460-01, API Std 650, and as indicated and specified herein. Submit acknowledgement of API Std 650 as required standard. Product[s] to be stored in the tank [is][are] [_____][MIL-DTL-5624 Grade JP-4][and][MIL-DTL-5624 Grade JP-5][and][MIL-DTL-83133 JP-8][and][AFLP-3747 Jet A F-24][and][ASTM D4814 Mogas(F-46)][and][Diesel (F-76)]. Section[23 03 00.00 20 BASIC MECHANICAL MATERIALS AND METHODS][05 50 13 MISCELLANEOUS METAL FABRICATIONS], 33 56 21.18 SINGLE WALL POL TANK UNDERTANK INTERSTITIAL SPACE, and Section 26 20 00 INTERIOR DISTRIBUTION SYSTEM apply to this section except as specified otherwise.

1.5 DESIGN REQUIREMENTS

****

NOTE: Insert design information for loads on tanks as given in UFC 3-460-01, "Design: Petroleum Fuel Facilities". Insert the size and volume of the tank. Edit as required for project. Coordinate with structural drawing notes.

Use maximum value for range of products that might be stored at designated temperature. For tank with floating roof, add Minimum Design Specific Gravity

and use the lowest value for products that might be stored.

****

Design tank[repairs] to resist the[following] loads and forces[:][listed on the structural drawings and for the following:]

[a. Wind: [_____] kilometers per hour [_____] mph.

] b. Design specify gravity of liquid is [_____] to [_____].

[c. Maximum Fill Rate: [_____] [lps] [gpm].

][d. Maximum Issue Rate: [_____] [lps] [gpm].

] e. Design shell and nozzles for a design liquid level equal to overflow condition.

f. Provide[non-elevated][elevated] foundation.

1.5.1 Seismic Design Requirements

Seismic loads and forces must be in accordance with API Std 650 Annex E.

1.5.1.1 Columns

****

NOTE: Allow only one roof support column in floating roof tanks of 80,000 bbls and larger.

Do not allow roof support columns in floating pan tanks smaller than 80,000 bbls nominal size.

****

[Provide tank with no more than one roof support column. Design roof support columns to resist the forces caused by sloshing of the liquid contents during a seismic event.][Provide exterior epoxy coated roof support column.][Roof support columns are not allowed.]

1.5.1.2 Shell Height

Shell height must provide clearance between the pan at full overflow (bottom of pan at top of overflow) and the fixed roof that includes an allowance of at least 300 mm 12 inches for sloshing due to seismic event.

1.5.2 Tank Nozzles

Design tank nozzles to accommodate external piping loads in accordance with API Std 650.

1.5.3 Tank Roof

****

NOTE: On tanks 15.24 m 50 feet or more in diameter that do not have a floating pan, include the first bracketed subparagraph below. On tanks less than 15.24 m 50 feet in diameter that do not have a floating pan, include the second bracketed subparagraph below. On tanks with floating pans,

delete both subparagraphs below.
****

Provide tank roof plates, lap welded with inner plates on top, and at least 6 mm 1/4 inch thick (includes 1.5 mm 1/16 inch corrosion allowance). Support beams must be designed so as to minimize uncoatable surfaces. Provide solid web or HSS (Hollow Structural Section) type roof beams. Open web trusses are not permitted. Do not attach roof support members to the roof plate. Provide a roof with every part having a slope of 2:12.

[1.5.3.1 Emergency Ventilation

Provide emergency ventilation by a frangible roof design. The weld attaching the roof plate to the top angle must not be greater than 5 mm 3/16 inch.

][1.5.3.2 Emergency Vent Devices

Submit emergency ventilation calculations for selection of emergency vents.

]1.5.4 Corrosion Allowance

Provide corrosion allowance of 1.6 mm 1/16 inch in thickness of steel for the interior of the shell, roof, and interior structural members.

1.5.5 Design Metal Temperature

****
NOTE: Insert design metal temperature for locations not covered by API Std 650. Obtain low temperature from weather data. Determine the design metal temperature in accordance with API Std 650.
****

API Std 650[[_____] degrees C [_____] degrees F].

1.5.6 Tank Bottom

Tank bottom[and annular ring] must be as indicated. Bottom plates must be lap welded with inner plates on bottom.

1.6 QUALIFICATIONS OF TANK ERECTOR

****
NOTE: For NAVFAC projects, include the following requirement in the Project Information Form (PIF).
****

The Contractor must be regularly engaged in the erection of API Std 650 tanks. The Contractor must certify successful completion of at least 12 field erected API Std 650 aboveground tanks in the past 3 years. The information provided in the Contractor's certification must include the date of the notice to proceed, date of completion, location of tank, Owner, Owner's point of contact, tank size, configuration (e.g., vertical AST, horizontal AST), product stored, and material of construction.

1.6.1 Welding Qualifications

All welders on site must be qualified in accordance with ASME BPVC SEC IX.

Submit Welding Procedure Specifications (WPS), Welding Procedure Qualification Records (PQRs), and Welder Performance Qualification Records (WPQ). Complete all WPQs specifically for this project. Welders may qualify on site or be qualified prior to arriving on site, but when welders are qualified on site,give the Contracting Officer notice and opportunity to witness each of the welder performance qualification tests 24 hours in advance of the performance of each of the tests.

1.6.2 Tank Erection Bracing Plan

Submit Tank Erection Bracing Plan.

1.7 TANK CALIBRATION EXPERIENCE

Perform calibration of the tank using a qualified organization that can certify to having performed successful and accurate calibration of at least eight tanks of comparable type and size within the last 2 years. Submit certified data on tank calibration experience.

1.8 QUALIFICATIONS OF FLOATING PAN MANUFACTURER

****
NOTE: For NAVFAC projects include the following requirement in the Project Information Form (PIF).
****

The floating pan manufacturer must be regularly engaged in the manufacture and installation of floating pans in API Std 650 tanks. The manufacturer must certify successful manufacture and installation by the manufacturer of at least 10 floating pans of the type specified in field erected API Std 650 aboveground tanks within the past 5 years. A minimum of five of those installations must have been performed on U.S. military installations. The information provided in the manufacturer's certification must include the date of the notice to proceed, date of completion, location of tank, customer project number or construction contract number, owner's point of contact, tank size, and construction type.

1.9 QUALITY ASSURANCE

1.9.1 Delivery and Storage Handling

Handle, store, and protect system components and materials to prevent damage before and during installation in accordance with the manufacturer's recommendations, and as approved by the Contracting Officer. Replace damaged or defective items.

1.9.2 Steel Tank Drawing Requirements

****
NOTE: See FC 1-300-09N Navy and Marine Corps Design Procedures for professional engineer requirements.
****

Drawings for the steel tank and floating pan must be prepared, sealed, signed, and dated by a registered professional engineer. Include erection diagrams and detail drawings of the tank roof, shell plates, wind girders, openings, and connections for fittings and appurtenances. The steel tank drawings must include the following:

a. Tank erection details showing dimensions, sizes, thickness, gages, materials, finishes, and erection procedures.

b. Tank component details to include as a minimum:

(1) Floating pan (including details of support legs, manways, periphery seals, joint attachments, anti-rotation cables, and grounding cables).

(2) Locations of floating pan pressure/vacuum vents and rim seals.

(3) Internal pipe and fittings, including supports and bearing plates.

[(4) Tank Bottom to foundation gasket.

][(5) Tank Bottom Shimming and Grouting plan and details. Includes, but is not limited to, shim materials, spacing layout, and method of shim insertion. Include any calculations used to determine spacing. Must include non-shrink grout placement method, including surface preparation of concrete ringwall and bottom of tank, formwork installation and stripping, backer rod usage, pouring of the non-shrink grout, temperature maintenance of grout (if necessary), curing, and final surface preparation and chamfering of non-shrink grout.

(6) Tank Anchors.
]

(7) Location of alarm and control switches.

(8) Location of nozzles including nozzles for gauges and alarms.

(9) Roof support system details.

(10) Roof manhole.

(11) Circulation vents/inspection hatches.

(12) Center roof vent.

(13) Overflow port/circulation vent.

(14) Shell manholes and davits.

(15) Stairway, including replaceable stair tread installation and platforms.

(16) Channel mounting pads.

(17) Tank Data Plate Plan and Information.

(18) Shell to bottom connection.

(19) Tank bottom to ringwall interface.

(20) Stilling wells.

(21) Grounding lugs.

(22) Sump.

(23) Scaffold Cable Support.

(24) Shell circulation vents.

1.9.3 Data Requirements

Calculations for the steel tank design and floating pan design must be prepared by a State registered Professional Engineer. Include calculations for the buoyancy of the floating pan and the structural stability of the floating pan when resting on the support legs. Steel tank design calculations must include calculations for the design of the shell, as well as calculations for the design of the roof,[frangible roof connection,][tank anchorage,][emergency vent,] and roof support.

1.9.4 Weld Inspector Certification

Contractor must arrange for the services of an independent (impartial third party not a part or affiliated with Contractor or subcontractor principal or subsidiary businesses) weld inspector certified by the American Welding Society to oversee all weld tests and examinations required by API Std 650.

1.9.5 Test Reports

Test Reports must consist of the following:

a. Records made by the AWS certified inspector for all duties performed per paragraph 4.2 of AWS QC1.

b. All Nondestructive Examination (NDE) (e.g., radiograph, ultrasound, etc.) reports with unique weld ID for each weld tested.

c. "Weld Map". These maps/drawings correlate the shop drawings submitted to the NDE reports. The NDE report that shows a weld number as acceptable is correlated with weld number on the drawings.

Provide the location of each weld, what procedure was used, which welder made the weld, the results of the visual test, and the results of the NDE.

1.9.6 Inspection and NDE Personnel

All inspection and NDE personnel must be qualified in accordance with the following requirements. The Contractor must submit the qualifications of all the testing personnel that will perform all field tests for review by the Contracting Officer. The qualifications of all personnel on the job site that will perform welding inspections and NDE must be submitted for approval. All inspectors and NDE examiners must have a minimum of one-year experience inspecting the piping or plate material being used and five-years in military or commercial fueling systems or petroleum refineries, power generating plants, paper mills, or chemical process plants.

1.9.6.1 NDE Personnel Certification

A written procedure/quality assurance program for the training, examination, certification, control and administration of NDE personnel must be established. The procedures must be based on appropriate specific

and general guidelines of training and experience recommended by ASNT SNT-TC-1A. Submit proof of compliance of nondestructive test examiners with API Std 650 including, but not limited to, examiners performing radiographic (RT), visual (VT), penetrant (PT), ultrasonic (UT), [and][or] magnetic particle (MT) testing.

1.9.6.2 Qualifications of Testing Agency

The testing agency, testing laboratory, technical consultant or contractor's approved quality assurance organization must meet the requirements of ASTM E329.

1.9.7 Qualifications of API Std 653 Inspector

Contractor must arrange for the services of an independent (impartial third party not a part or affiliated with Contractor or subcontractor principal or subsidiary businesses) API Std 653 inspector. API Std 653 Inspector must have a minimum of 5 years of experience. Submit copy of current certificate.

PART 2 PRODUCTS

2.1 MATERIALS

Conform to the following requirements except that materials not definitely specified must conform to API Std 650. All materials must be carbon steel unless otherwise noted.

2.1.1 Materials for System Components, Pipe, and Fittings

****

NOTE: Unless otherwise specified: In corrosive environments (such as near the ocean or humid locations) select the first option; in non-corrosive environments select the second option.

****

a. [All piping and fittings outside the tank (except for the tank fill line, tank issue line, and tank low suction line) must be stainless steel. The tank fill line, tank issue line, and tank low suction line piping and fittings must be interior and exterior coated carbon steel. All valves (except DBB valves) and ball joints must be stainless steel. DBB valves must be as specified.][All piping, and fittings 63 mm 2.5 inches and larger must be interior and exterior coated carbon steel. All piping and fittings 50 mm 2 inches and smaller must be stainless steel. All valves larger than 63 mm 2.5 inches must be carbon steel with stainless steel trim. All valves 50 mm 2 inches and smaller must be stainless steel. DBB valves must be as specified.]

b. All piping and fittings inside the tank must be exterior and interior epoxy coated carbon steel except for piping 50 mm 2 inches and smaller which must have an uncoated interior. Stilling well and ladder material must be as indicated.

c. Do not weld stainless steel to carbon steel, except where specifically indicated or specified.

d. If materials for system components are not specified, they must be

stainless steel.

e. Provide stainless steel HLV float control chamber, pilot, level switch housings, and level switch probe holders.

2.2 STRUCTURAL STEEL

API Std 650. Provide mill test reports for shell plates, shell nozzle reinforcing plates, shell insert plates, and all steel plate used in construction of shell penetrations. Provide impact test data when required by API Std 650 for the material group and thickness provided.

2.3 CARBON STEEL, PIPE FITTINGS, FLANGES, GASKETS, AND BOLTING

****
NOTE: If stainless steel bolting is required on tank interior, DOR to select option below.
****

Carbon steel, pipe fittings, flanges, gaskets, and bolting must be provided in accordance with Section 33 52 43.13 AVIATION FUEL PIPING or Section 33 52 40 FUEL SYSTEMS PIPING (NON-HYDRANT), except gaskets inside tank and on roof nozzles must be non-asbestos, fuel resistant composition, or preformed type[, and bolting on interior of tank must be stainless steel]. Flanges must be weld-neck type in accordance with ASME B16.5, except flanges in tank interior may be slip-on. Threaded fittings must conform to ASME B16.11 (Class 3000), and butt-welded fittings must conform to ASME B16.9.

2.4 STAINLESS STEEL PIPE, FITTINGS, FLANGES, GASKETS, AND BOLTING

Stainless steel pipe, pipe fittings, flanges, gaskets, and bolting must be provided in accordance with Section 33 52 43.13 AVIATION FUEL PIPING or Section 33 52 40 FUEL SYSTEMS PIPING (NON-HYDRANT) and API Std 650, except: flanges must be weld-neck type in accordance with ASME B16.5, threaded fittings must conform to ASME B16.11 (Class 3000), and butt-welded fittings must conform to ASME B16.9.

2.5 ALUMINUM PIPING FOR STILLING WELLS

Aluminum pipe must be ASTM B241/B241M, alloy 6061-T6, Schedule 40 for pipe sizes 50 mm 2 inches through 300 mm 12 inches; Schedule 80 for pipe sizes 50 mm 2 inches and smaller.

2.6 BOLTING AND ALUMINUM FLANGES FOR STILLING WELLS

Aluminum flanges must be ASME B16.5, Class 150 or Class 300 where indicated, Flat Face Type, except aluminum must conform to ASTM B247M ASTM B247, alloy 6061-T6 or alloy 356-T6. Alternatively, flange may be made from machined 6061-T6 plate conforming to ASTM B209M ASTM B209 and following the necessary major diameter, bolt circle, bolt hole, and thickness tolerances of ASME B16.5. Aluminum flanges may be welding neck or slip-on type. Provide bolting in accordance with Section 33 52 43.13 AVIATION FUEL PIPING or Section 33 52 40 FUEL SYSTEMS PIPING (NON-HYDRANT). Provide electrical isolation for separation of dissimilar metals.

2.7 WELDING FOR ALUMINUM PIPING

2.7.1 Process for Aluminum

ASME B31.3, Gas Tungsten Arc Welding (GTAW) Process or Gas Metal Arc Welding (GMAW) Process. Backing rings are not permitted.

2.7.2 Aluminum Welding Electrodes and Rods

AWS A5.10/A5.10M, ER5356 electrodes.

2.8 BOLTING FOR SHELL MANHOLE COVERS

Bolting for shell manholes must be in accordance with Section 33 52 43.13 AVIATION FUEL PIPING or Section 33 52 40 FUEL SYSTEMS PIPING (NON-HYDRANT).

2.9 GASKETS FOR MANHOLE COVERS, STILLING WELL FLANGES, AND ROOF CENTER VENT

Provide composition asbestos-free, fuel and fire-resistant gaskets for shell manhole covers, stilling well flanges, and roof center vent.

2.10 TANK BOTTOM TO FOUNDATION SEAL

****

NOTE: Include the first bracketed subparagraph for self anchored tanks. Include the second bracketed subparagraph for anchored tanks.

****

[2.10.1 Tank Bottom to Foundation Gasket - Self Anchored Tanks

Tank bottom to foundation gasket for self anchored tanks must be 12 mm 1/2-inch thick, nonporous Buna-N with a Shore A Durometer Hardness of not more than 40 and a rated tensile strength of at least 10,300 kPa 1,500 psi. The inside and outside edge of the gasket must be cut on a radius. Provide gasket in segments at least 2.4 meters 8 feet long. Provide three samples of the tank bottom-to-foundation gasket material measuring 13 mm 1/2-inch by 75 mm 3 inches by 225 mm 9 inches.

][2.10.2 Tank Shims and Tank Grout - Anchored Tanks

Grout must be non-shrink type and consist of one part Portland cement to 1-1/2 parts sand by volume. Do not use calcium chloride admixtures. When the ambient temperature is expected to fall below 16 degrees C 60 degrees F within the next 48 hours, the cement used must be "high early strength" type.

]2.10.3 Chime Sealant

****

NOTE: Edit the chime sealant specification if needed to accommodate coating system section or different joint types.

****

Seal the tank bottom perimeter to foundation ring wall joint. Sealant must be liquid applied non-sag, two part polysulfide rubber joint sealant composed of 100 percent solids, and conforming to ASTM C920, Class 25. The sealant must be suitable for use on steel, epoxy coated surfaces and

concrete. The sealant must be rated with a Shore A Hardness of not more than 30, a minimum tensile strength of 1,000 kPa 150 psi, a minimum elongation of 100 percent at 350 kPa 50 psi without breaking, and a minimum elongation of 200 percent at 550 kPa 80 psi without breaking. The sealant must be resistant to jet fuel, sunlight, cold, and ozone without shrinking. Applied sealant must have a life expectancy of at least 15 years. Use with bond breaker tape recommended by the manufacturer.

2.11 INTERIOR PROTECTIVE COATING SYSTEM

****

NOTE: In order to protect product quality and to extend the life of the tank, the prescribed interior surfaces of steel petroleum storage tanks must be coated in accordance with UFC 3-460-01, "DESIGN; PETROLEUM FUEL FACILITIES".

Other guidance as to interior surface treatment is as follows:

1. Specify bare interior metal surfaces and coating with SAE-30 weight oil if the coating is to be done at a later date. Uncoated surfaces must be cleaned of contaminants, including mill scale.

2. Include instructions in the coating specification to seal all uncoatable areas of the roof support structure by caulking all gaps and joints in roof beams including between coated beams and roof plates. Problems can arise when the roof plates are welded in cooler weather and the underside coated in warmer sunny weather as the roof plate expands and pulls away from the roof rafters leaving a gap that is too large to caulk. For example, Roof plate on a 15 meter 50 feet diameter tank welded in winter may lift at center in the summer by as much as 40 mm 1-1/2 inches. Consider local geographical conditions at the time of construction when caulking roof support beams, roof plates etc. It is recommended for locations like Seattle and Guam, that have more stable year-round temperatures and condensation.

3. Include instructions in coating specification to caulk the underside of roof plate seams that are not welded on the underside.

4. Refer to Section 09 97 13.17 THREE COAT EPOXY INTERIOR COATING OF WELDED STEEL PETROLEUM FUEL TANKS.

****

Interior of the tank must be bare steel. Coat interior of tank with SAE 30 oil for temporary protection.

2.12 EXTERIOR PROTECTIVE COATING SYSTEM

Section 09 97 13.27 HIGH PERFORMANCE COATING FOR STEEL STRUCTURES.

2.13 APPURTENANCES

2.13.1 Floating Pan Installation Hatch

Provide permanent floating pan installation hatch on the tank roof. Provide with bolted cover and water tight gasket.

2.13.2 Floating Pan

The floating pan must be naturally buoyant by means of honeycomb cell aluminum sandwich panels, be suitable for operation with liquids having a specific gravity of 0.70, be internal to the tank, have full surface contact with the fuel, be equipped with a seal at each penetration, and meet the requirements of API Std 650 Appendix H. A rim must be provided around the floating pan periphery and extend a minimum of 150 mm 6 inches above the free liquid surface. The rim must contain turbulence and prevent fuel from splashing up onto the top surface of the floating pan.

2.13.2.1 Pan Integrity

The floating pan must support the following loading conditions without causing damage to the pan, sinking the pan, or allowing product to spill onto the top surface of the pan in the event the pan is punctured.

a. A uniform load as required in API Std 650, including buoyancy required to support at least twice its dead weight (including the weight of the flotation compartments, seal, and all other floating roof and attached components), plus additional buoyancy to offset the calculated friction exerted by peripheral and penetration seals during filling.

****

NOTE: Include the first bracketed list item for tanks larger than 9144 mm 30 feet in diameter, and the second bracketed list item for smaller tanks.

****

[b. A point load of 227 kg on a 93,000 sq mm 500 pounds on a one square foot area anywhere on the floating pan while it is floating or resting on the legs.

][c. A point load of 113 kg on a 93,000 sq mm 250 pounds on a one square foot area anywhere on the floating pan while it is floating or resting on the legs.

]2.13.2.2 Floating Pan Prototype Fire Test

Perform a fire test on another floating pan design of the same manufacturer that is constructed from the same materials and joining method of the pan being proposed and that meets the floating pan specification in aviation turbine fuel or motor gasoline with a flash point of less than minus 7 degrees C 20 degrees F. Submit manufacturer's certification of fire test indicating the manufacturer's floating pan design has been successfully fire tested and that both of the following tests were successfully performed, without significant damage to the pan, sinking the pan or the fire spreading to the whole surface of the fuel.

a. Hole Fire: The test-floating pan must have a 300 mm 12 inch or larger diameter hole cut through it. After being lit, the fuel in the hole must burn for a minimum of 2 hours.

b. Rim Fire: After being lit, the fuel around the test rim section must burn for a minimum of 2 hours.

2.13.2.3 Joint Connections

Aluminum sandwich panels must be joined together by means of a gasketed joint that transmits loads without structural failure or leakage.

2.13.2.4 Aluminum Extrusions

Extrusions must be made from alloy 6063-T6 in accordance with ASTM B209M ASTM B209.

2.13.2.5 Aluminum Sandwich Panels

Panels must be made from alloy 3003 H14, 3003 H16, 3105 H14, or 5010 H24 in accordance ASTM B209M ASTM B209. The skin of the panels must have a minimum thickness of 0.356 mm 0.014 inches. The core of the panels must be 25 mm one-inch aluminum honeycomb.

2.13.2.6 Support Legs

Floating pan must be provided with two position self-draining aluminum legs that are designed to support a uniform load of 600 Pa 12.5 pounds per square foot. Stainless steel support legs are not allowed. The legs must be tubular structural members at least 50 mm 2 inches in diameter and ride with the pan when the fuel level is above the high leg position. The low position must be as indicated and the high position must be 1950 mm 78 inches above the shell-to-bottom joint. The exact location and number of the support legs must be as recommended by the floating pan manufacturer. Provide each support leg with a 63 mm 2.5 inch polytetrafluoroethylene (PTFE) foot securely fastened to the bottom end of the leg. The portion of the PTFE foot below the metal leg must be 25 mm one-inch thick. The PTFE foot must be slotted on one side to allow for drainage. The legs must be capable of allowing a person, standing on top of the floating pan while the tank is in service, to perform the following functions:

a. Change from the high to the low position.

b. Change from the low to the high position.

c. Completely remove the legs.

d. Adjust the legs vertically a distance equal of plus or minus 75 mm 3 inches.

2.13.2.7 Periphery Seals

Periphery seals must be flexible wiper squeegee and made of closed cell cast urethane. The periphery seal must fit the space between the tank shell and the outer edge of the floating pan with two flexible seals, a primary and a secondary. The seals, primary and secondary as a unit, must accommodate a deviation between the path of the floating pan relative to the tank shell of an additional 100 mm 4 inches of compression and an additional extension of 50 mm 2 inches from its normal compressed position at any fluid level. The primary seal must be above the liquid level. Foam filled coated-fabric seals must not be accepted. The secondary seal must be above the primary seal. Seals must be capable of being replaced

during tank operations, be durable in the tank's environment, be abrasion resistant, and not discolor or contaminate the liquid stored in the tank. Seals must be manufactured in the United States and must be provided in minimum continuous lengths of 8.54 meter 28 feet with no factory splices. Seals must be compatible with avgas, fuel oil, gasoline/ethanol, gasoline/MTBE 80/20, gasoline (unleaded), aviation turbine fuels, kerosene, and sea water. The following tables list the required physical properties of periphery seals:

TABLE 1: PHYSICAL PROPERTIES OF PERIPHERY SEALS

Physical Properties	Test Method	Values
Maximum operating temperature	Dynamic mechanical analysis per ASTM D4065	82 C 180 F (min)
Tensile strength	ASTM D412	39130 kPa 5675 psi (min)
Elongation at break	ASTM D412	640 percent (min)
Tear resistance (Die C)	ASTM D624	61.30 N/mm 350 PLI (min)
Abrasion resistance	Tabor, mg loss at 100 cycles per ASTM D3489	8 mg 0.00028 ounce (max)
Compression set	ASTM D575A	25 percent (max)

TABLE 2: JET FUEL SOAK TEST PARAMETERS

Jet Fuel Soak Test 96 hrs. at 67.2 C 153 F per ASTM D471	Before Immersion	After Immersion	Percent Change
Tensile strength	37895 kPa 5496 psi	36440 kPa 5285 psi	minus 3.8 percent (min)
Elongation at break	640 percent	729 percent	plus 13.9 percent (min)
Hardness	73 Shore A	66 Shore A	minus 7.0 percent (min)
Volume change	-	-	plus 6.0 percent (max)

2.13.2.8 Penetrations

All penetrations must have a rim that extends a minimum of 150 mm 6 inches above the free liquid to contain product turbulence and prevent the tank product from splashing up onto the top surface of the floating pan.

2.13.2.9 Manhole

****

NOTE: Review Federal, State, and local regulations to ensure compliance with air emission regulations. Consider the slotted stilling wells in the review. At least one 900 mm 36 inch diameter manhole must be provided for each floating pan to provide access to the tank interior when the floating pan is on its supports and the tank is empty; provide two for tanks larger than 50,000 bbl.

****

Provide [_____] 900 mm 36 inch floating pan manhole[s]. Manhole must have a clear inside diameter of at least 900 mm 36 inches. Manhole must have a rim that extends a minimum of 150 mm 6 inches above the free liquid to contain product turbulence and prevent the tank product from splashing up onto the top surface of the floating pan. The manhole cover must be equipped with a ground cable connected to the floating pan.

2.13.2.9.1 Pressure/Vacuum Vent

The pressure/vacuum (PV) vent must be sized by the internal floating pan manufacturer for the maximum fill rate of [_____] L/s gpm and the maximum withdrawal rate of [_____] L/s gpm. When the PV vent is in the open position, the float must hang from a strap.

2.13.2.10 Grounding Cables

Provide two or more 3 mm 1/8-inch diameter, stranded, extra-flexible, stainless steel, wire rope ground cables. Each cable must extend from the top of the floating pan to the fixed roof and must be long enough to accommodate the full travel of the pan. The exact location, number, and size of grounding cables must be as recommended by the floating pan manufacturer.

2.13.2.11 Anti-Rotation Cable

Provide 6 mm 1/4-inch diameter anti-rotation cables made of 304 stainless steel conforming to ASTM A492. Fittings for anti-rotation cables including cable clamps, pins, sockets, turnbuckles, U-bolts and nuts must be 304 stainless steel. Cable must be made taut by means of the turnbuckle. The exact location, number, and size of the anti-rotation cables must be as recommended by the floating pan manufacturer.

2.13.3 Sample Gauge Hatch

****

NOTE: Some facilities prefer a lockable gauge hatch over a floating seal and retrieval winch. DOR to select appropriate option for lockable hatch in subparagraph SAMPLE GAUGE HATCH or optional subparagraph FLOATING SEAL AND RETRIEVAL WINCH for floating seal and retrieval winch.

****

Provide sample gauge hatch on top of stilling well where indicated for manual gauging. Provide gasket for dissimilar metal protection. The tank erector must measure the stilling well gauge hatch hold-off distance with the tank empty, half full, and full, and place the information on a permanently affixed marker attached to the sample gauge hatch. This must be performed during tank[fill][hydrostatic] testing. The stilling well gauge hatch hold-off distance is defined as the distance from the tank bottom datum plate to the top of the gauge hatch.[Hatch must be lockable.]

[2.13.4 Floating Seal and Retrieval Winch

Provide a floating seal, retrieval cable, weight, and a retrieval winch on sample gauge roof nozzle equipped with fully slotted stilling well.

Floating seal must move freely inside the stilling well with the rise or fall in liquid level while providing a double seal against the escape of vapors from the stilling well. Seal elastomers must be Buna-N and must seal at approximately the same level as the stilling well floating pan penetration seal (approximately 150 mm 6 inches above the level of the liquid). Retrieval winch and cable must be capable of retrieving floating seal into a storage compartment mounted on top of the stilling well nozzle. All fasteners must be stainless steel; all other metallic components of float and seal must be aluminum. Storage compartment and components, except for bearings, must be stainless steel. The retrieval cable must be 3 mm 1/8 inch stainless steel. Storage compartment must be equipped with a latch and hinge so that the compartment (with a fully retrieved float, cable, and weight) and winch can be temporarily moved out of the way to provide access to the stilling well. Latch and hinge must be designed to hold the compartment securely to the nozzle in winds up to 200 km/h 125 mph. Storage compartment flange must also be provided with a rain lip to provide a weather tight seal around the top of the roof nozzle. Winch must be hand operated, must require no more than 22 N 5 pounds of force to operate, and must be equipped with an anti-reverse mechanism and operator that may be disengaged from the retrieval spool when not being operated manually. When disengaged from the winch, the retrieval spool must maintain tension on the retrieval cable not exceeding the weight of the cable and the weight.

]2.13.5 Mechanical Tape Level Gauge

****
NOTE: Edit paragraph accordingly based on whether tank has an internal floating pan.
****

The mechanical tape level gauge must be attached to[a floating roof anchor weight provided by the manufacturer][the tank floor by guidewire anchors] and complete with all necessary incidental pipe, pulleys, fittings, supports, support brackets, tension springs, and guide wire assemblies.[The floating roof anchor weight rests on the floating roof pan, but is not attached to the pan.] The gauge must automatically provide the location of the[floating pan][product level] within plus or minus 1.6 mm 1/8 inch of the actual liquid level. The head must be made of aluminum and must be mounted on the exterior of the tank shell approximately 1370 mm 54 inches above the tank bottom. The head must contain a glass covered window. The seals must be made of Teflon. The shafts and graduated tape assembly must be made of non-corrosive and non-sparking materials. The tape drum must be made of a non-corrosive material. The tape must be of sufficient length to measure the liquid level from the bottom to the top of the storage tank. Gauge measurements must be graduated in 1.6 mm 1/16 inch increments. The tape must be carried over pulleys housed in elbow assemblies at each change of direction.

[2.13.6 Mechanical Tape Level Gauge

****
NOTE: For Cut and Cover Tanks.
****

The mechanical tape level gauge must be complete with all necessary components to be flange mounted and extend down into the tank via a stilling well. The gauge must automatically provide the location of the

fuel level within plus or minus 1.6 mm 1/8 inch of the actual liquid level. The head must be made of aluminum and must be mounted in the pump house as shown on the drawings. The head must contain a glass covered window. The seals must be made of Teflon. The shafts, graduated tape, and tape drum assembly must be made of non-corrosive and non-sparking materials. The tape must be of sufficient length to measure the liquid level from the bottom to the top of the storage tank. Gauge measurements must be graduated in 1.6 mm 1/16 inch increments.

]2.13.7 Venting

Provide tank venting as indicated.

2.13.7.1 Overflow/Circulation Vents

****
NOTE: Ensure overflow capacity is adequate to protect the tank from damage in the event of an overflow with all receipt pumps running.
****

Provide open overflow/circulation vents on the upper shell as indicated and in accordance with API Std 650, Appendix H and API Std 2000. Provide vents with stainless steel bird screen with 0.2 square meters 2.0 square feet of net open area minimum. Insect screens are not allowed.

2.13.7.2 Center Roof Vent

****
NOTE: In non-corrosive environments (e.g., desert locations), include text to provide center roof vent welded directly to the tank roof and coat stairway in accordance with the coating specification for the exterior of the tank.
****

Provide open vent at the center or at the highest elevation of the roof. Open vent must have a [stainless steel] weatherhood as indicated and stainless steel bird screen as indicated on the drawings with openings welded in place. Weatherhood must be removable. Insect screens are not allowed.

2.13.8 Circumferential Stairway and Platforms

****
NOTE: In corrosive environments include bracketed text to provide bolt-on, removable, hot dip galvanized, double stringer stairway as indicated.

For the remote locations only (e.g., Guam), provide alternate text to allow thermal spray/metalizing as an alternative to hot dip galvanizing only with Government approval of an acceptable process, approach, materials, and system components.

In non-corrosive environments (e.g., desert locations), include specification paragraph text and modify the drawing details to indicate the portion of the appurtenance that is not welded to the tank

roof or shell is to be made of carbon steel and coated in accordance with the coating specifications for the exterior of the tank.

****

OSHA 29 CFR 1910.25 Stairways. Provide[bolt-on removable double stringer] circumferential stairways as indicated.[Hot-dip galvanize stairway in accordance with ASTM A123/A123M Grade 100. All bolted connections must be galvanized prior to erection. Hot dip galvanize stairway and platform sections after all welding is complete. No welding on the stairway will be permitted after galvanizing. Cold spray-on galvanizing is not allowed as a substitute for hot dip galvanizing or its repair. Provide stairway with replaceable galvanized stairway step and platform tread grating. The stairway must be of bolted construction to allow for complete removal after construction to avoid interference with coating operations. Stairway bolting must be ASTM A325M ASTM A325, hot dipped galvanized. All mounting brackets, used to connect the stairway to the tank, must be welded to the tank using seal welded mounting plates and must be coated with the tank.][Coat stairway in accordance with the tank exterior coating specification.] Provide one approach step on the secondary containment concrete as indicated. Provide shell mounted metal bar stairway step and platform tread grating with non-slip nosings. Support the stairway and platforms completely on the shell of the tank with bottom-of-shell-mounted portion clear of and not structurally supported or connected to the ground or approach steps. Provide rise and run of stairway steps as indicated, adjusting slightly to suit final layout of the tank and its appurtenances, but with rise and run consistent from the ground level to the top platform. Construct stairway entirely of steel. Provide landings for accessing the upper manhole, high level alarm switches, level control float pilot chamber, and tank roof. Railings must be continuous around the platforms, except for access openings, and must be constructed similar to the roof perimeter guardrail. At access openings, any space wider than 25 mm one inch between the tank and the platform must be floored. Ends of handrails, guardrails, and posts must be sealed by welding.[Guardrails must be constructed in welded sections and their posts seal welded or bolted to the stringers.] Continuously butt-weld platform guardrail toeboards to guard rail posts. Do not field weld galvanized materials.

[2.13.9 Manhole Access Platforms

****

NOTE: The following paragraph is intended for use when no berm is provided and the ring wall is elevated. Delete manhole access platform paragraph if berm is provided.

****

Provide platform for accessing the lower shell manhole and circumferential stairway as indicated and in accordance with Section 05 50 13 MISCELLANEOUS METAL FABRICATIONS.

]2.13.10 Roof Perimeter Guardrail

****

NOTE: In corrosive environments include bracketed text to provide bolt-on, removable, hot-dip galvanized, guardrails as indicated.

For the remote locations only (e.g., Guam), provide alternate text to allow thermal spray/metalizing as an alternative to hot-dip galvanizing only with Government approval of an acceptable process, approach, materials, and system components.

In non-corrosive environments (e.g., desert locations), include specification paragraph text and modify the drawing details to indicate the portion of the guardrail that is not welded to the tank roof is to be made of carbon steel and coated in accordance with the coating specifications for the exterior of the tank.

****

Construction of roof perimeter guardrail must be as-detailed on the drawings and in accordance with OSHA. Provide[bolt-on removable] roof perimeter guardrails as indicated.[Hot-dip galvanize guardrails in accordance with ASTM A123/A123M Grade 100. All bolted connections must be galvanized prior to erection. Hot dip galvanize guardrail sections after all welding is complete. No welding on the guardrails will be permitted after galvanizing. Cold spray-on galvanizing is not allowed as a substitute for hot dip galvanizing or its repair. The guardrail must be of bolted construction to allow for complete removal after construction to avoid interference with coating operations. Guardrail bolting must be ASTM A325M ASTM A325, hot dipped galvanized. All mounting brackets, used to connect the guardrails to the tank, must be welded to the tank using seal welded mounting plates and must be coated with the tank.][Coat guardrails in accordance with the tank exterior coating specification.]

2.13.11 Internal Ladders

OSHA 29 CFR 1910.23. Provide an internal ladder extending from the internal ladder access hatch to the tank bottom as indicated. Provide with aluminum safety rail as indicated. Provide removable aluminum safety rail extension as indicated. Provide two 63 mm 2-1/2 inch sch 40 pipe 2-1/2 inches long. Weld one of the pipes (align vertically) to the top rail of the roof perimeter guardrail near the internal ladder access hatch. Weld the second pipe (align vertically) to the toeboard directly below the first for storing the removable safety rail extension.

2.13.12 Internal Ladder Access Hatch

****

NOTE: In non-corrosive environments (e.g., desert locations), include text to provide internal ladder access hatch welded directly to the tank roof and coat stairway in accordance with the coating specification for the exterior of the tank.

****

Provide internal ladder access hatch and 6 mm 0.25 inches[stainless steel] cover with rain lip as indicated for access to the interior of the tank through the roof. Provide with stainless steel hardware (flat bar, round bar, eyebolt).

[2.13.13 Emergency Vent

****

NOTE: On tanks 15.24 meters 50 feet or more in diameter that do not have a floating pan, delete bracketed paragraph. On tanks less than 15.24 meters 50 feet in diameter that do not have a floating pan, include bracketed paragraph. On tanks with floating pans, delete bracketed paragraph.

****

Provide emergency vent devices in accordance with API Std 2000 and NFPA 30.

]2.13.14 Roof Circulation Vent/Inspection Hatches

****

NOTE: In non-corrosive environments (e.g., desert locations), include text to provide roof manhole welded directly to the tank roof and coat stairway in accordance with the coating specification for the exterior of the tank.

****

Provide[stainless steel] roof vent/inspection hatches in the fixed roofs of aboveground storage tanks as indicated and in accordance with API Std 650, Appendix H. Each roof vent/inspection hatch must be provided with a roof reinforcing plate the same thickness as the roof plate. Provide with stainless steel bird screen as indicated on the drawings and 0.2 square meters 2.0 square feet of net open area minimum. Insect screens are not allowed.

2.13.15 Water Draw-Off System

Provide a water draw-off system complete with all system components and controls and connected to the AST as indicated. System must remove fuel from its associated storage tank, separate the fuel and water by gravity, return the fuel back to the storage tank, and discharge the water. The system and its components must meet the requirements of the specification herein. The system must include, but is not limited to, the following piping, fittings, valves, system components, and controls:

****

NOTE: In cold climates with a lowest one day mean temperature less than minus 26 degrees C minus 15 degrees F (see API Std 650 Fig. 4.2) include the "In Cold Climates" option.

****

a. Product Saver Tank: Provide a product saver tank with the tank, piping and fittings packaged and fabricated as a single system. Fabricate from Type 304 stainless steel with tank volume as indicated. Provide tank with removable top, 25 mm one-inch inlet line, 25 mm one-inch drain line, and other lines as indicated, all with full port ball valves and cam-type connections. Provide concrete mounting pad and anchor tank to it. Ground to dedicated grounding system.[Product saver tank must be provided with a high and high-high level switch system, which must be a float-type switch tied directly into the pump starter circuit.]

[b. In Cold Climates: In cold climates provide the product saver tank system with a sump heater and insulate and heat trace the piping.

] c. Product Saver Pump: Pump must be a close coupled centrifugal having a capacity of 0.6 lps 10 gpm at not less 18 meters 60 feet of head and a required Net Positive Suction Head of not more than one meter 3 feet. Pump motor must be in accordance with NEMA MG 1. All pump components in contact with fuel must be stainless steel. The unit must be UL listed and labeled for use in Class I, Division 2, Group D hazardous environments as defined by NFPA 70, with a maximum temperature rating of["T2D"-419 degrees F] [_____]. The motor must be non-overloading at every point on the pump curve.

d. Piping, Valves, Fittings, and Instruments,: Pipe, pipe fittings, flanges, manual valves, gaskets, and bolting must be in accordance with Section 33 52 43.13 AVIATION FUEL PIPING or Section 33 52 40 FUEL SYSTEMS PIPING (NON-HYDRANT). Materials of construction must be as described in this specification paragraph MATERIALS FOR SYSTEM COMPONENTS, PIPE, AND FITTINGS except as modified herein.

e. Electrical: Provide completely prewired with single point of service connection at manual motor starter with rotary switch for pump motor. Rotary switch must be 2-position where: Position 1 is "OFF" and must be lockable in this position, and Position 2 is "ON" and must be momentary and spring-return to the "OFF" position. Provide suitable for Class I, Division 1, Group D service.

2.13.15.1 Basis of Design of Water Draw-Off System

The system must be arranged in the same general configuration as indicated. However, these are not fabrication drawings and are for basis of design only. The Contractor must be responsible for providing a complete and usable system.

2.13.15.1.1 Detail Drawing

Submit detailed drawings showing the Water Draw-Off System, including types, sizes, location, and installation details for:

a. Pipe hangers and supports

b. Grounding

c. Tank

d. Pump

e. Controls

f. Valves

g. Piping

[2.13.16 Side Stream Filtration System

****
NOTE: As an option, provide additional side stream filtration system. Delete bracketed paragraph if side stream filtration system is not provided.
****

Provide a packaged, skid mounted, pre-engineered, factory assembled,

factory tested, side stream filtration system complete with all system components and controls. System must remove fuel from its associated storage tank at 6.3 lps 100 gpm, filter the fuel to remove particulate matter and water, and then return the clean, dry fuel back to the storage tank. The system and its components must meet the requirements of the specification herein. The system must include, but is not limited to, the following piping, fittings, valves, system components, and controls:

****

NOTE: In cold climates with a lowest one day mean temperature less than minus 26 degrees C minus 15 degrees F (see API Std 650 Fig. 4.2) include the "In Cold Climates" option.

****

a. Filter Separator: 6.3 lps 100 gpm, horizontal construction, EI 1581 Fifth Edition, Category M100, Type S, 1034 KPa 150 psi ASME code compliant construction, raised face flanged connections, carbon steel construction, MIL-PRF-23236 epoxy coated interior in accordance with Section 33 52 43.28 FILTER SEPARATOR, AVIATION FUELING SYSTEM. Provide with automatic air vent, safety relief valve, differential pressure gage, sampling probes, water interface control, ASME code stamp, water slug flow control valve (with check feature), high water level conductance probe, manual drain full port ball valve with Kamlock connection and sight glass with density ball and isolation valves. Provide two sets of spare elements. Coalescer and Separator element length must be 1092 mm 43 inches.

b. Water Slug Control Valve: must be of same manufacturer as HLV.

[c. In Cold Climates: In cold climates provide the filter/separator with a sump heater and insulate and heat trace the drain piping.

] d. Pumps: In-line ASME B73.1 or ASME B73.2 chemical process pump, cast steel construction with stainless steel impeller, shaft and trim, and with mechanical seals. Capacity must be 6.3 lps 100 gpm at 30.5 meters 100 feet TDH (minimum). Motor must be explosion proof, 7.5 KW 10 HP (maximum), 3600 RPM, 460 volts, 3 phase, 60 hertz and must be non-overloading at any point on the curve with a 1.0 service factor.

e. Basket Strainer: The basket strainer must be carbon steel with ANSI Class 150 raised-face flanges and with side drain port. Provide with same differential pressure gage used for filter/separator; use stainless steel tubing and ball valves. Mount DP gage to SS heavy gage mounting channel and securely support from skid frame.

f. Piping, Valves, Fittings, and Instruments: Pipe, pipe fittings, flanges, manual valves, thermal relief valves, pressure indicators, flow switches, gaskets, and bolting must be in accordance with Section 33 52 43.13 AVIATION FUEL PIPING or Section 33 52 40 FUEL SYSTEMS PIPING (NON-HYDRANT). Materials of construction must be as described in this specification paragraph MATERIALS FOR SYSTEM COMPONENTS, PIPE, AND FITTINGS except as modified herein.

g. Suction Hose: Smooth bore, corrugated hose with static wire. Hose must be suitable for[JP-4][JP-5][JP-8][Jet A F-24][Mogas (F-54)][Diesel (F-76)] [_____] service, vacuum rated, with a minimum of 200 mm 8 inches bend radius. End connections must be as indicated.

h. Water Draw-Off System: must be as described in this specification. Product saver tank must be provided with a high and high-high level switch system.

i. Mounting Skid: Mounting skid must be fabricated from carbon steel and epoxy coated. Provide concrete mounting pad. Anchor mounting skid to mounting pad.

j. Controls: Provide with integral side stream filtration system control panel with start/stop pushbuttons, audible horn, visual alarm light, and with acknowledge and reset pushbuttons. Provide a pump start/stop pushbutton station with green (run) and red (stop) lights. Provide a paddle type flow switch downstream of the pump to energize the alarm circuits as indicated and de-energize the pump motor if flow is blocked. Provide a conductance probe in the filter/separator sump to energize the alarm circuits as indicated and de-energize the pump motor in the presence of water. Provide the product saver tank with high and high-high level alarms, which must energize the alarm circuits and de-energize the pump as indicated. Interlock the limit switches on the low suction line double block and bleed valve and on the tank fill line double block and bleed valve to allow the pump to be started only if both limit switches indicate the valves are in the open position. Interlock the skid control panel with the Emergency Fuel Shutdown system to de-energize the skid if any ESD pushbutton is depressed. All lights must be the push to test type. All system components must be rated for Class I, Division 1, Group D service.

k. Electrical: Provide complete prewired with single point of service connection at horsepower rated disconnect switch. Provide combination motor/starter with HOA switch for pump motor. Provide all electrical system components, conduit and fittings suitable for Class I, Division 1, Group D service.

2.13.16.1 Basis of Design of Side stream Filtration System

The system must be arranged in the same general configuration as indicated. However, these are not fabrication drawings and are for basis of design only. The Contractor must be responsible for providing a complete and usable system.

2.13.16.2 Detail Drawing

Submit detailed drawings showing the Side stream Filtration System including types, sizes, location, and installation details for:

a. Pipe hangers and supports

b. Bonding and Grounding

c. Filter/Separator

d. Fuel pump

e. Tank truck off-loading control valve

f. Flow switches

g. Air eliminator assembly

h. Hoses

i. Valves

j. Piping

]2.13.17 Shell Manholes

Provide shell manholes, manhole covers with filler drums, and davits as indicated. Hinged covers are not allowed.

2.13.18 Scaffold Cable Support

Provide two scaffold cable supports on the tank roof in accordance with API Std 650. Locate the support near the center of the tank and in a manner that supported cables will have maximum range and flexibility of operation with minimum interference with other tank fittings.

2.13.19 Antiseize Compound

Provide marine grade antiseize compound for fasteners on tank exterior flanges and bolted connections and covers. On tank interior fasteners, use oil only.

2.13.20 Channel Mounting

Provide seal welded channel mounting pads with seal welded stainless steel bolting studs for mounting channel to support conduit, tubing, and level alarm test/drain piping. Rack tubing, small piping, and conduit parallel to the shell as indicated. Do not mount within 2 meters 7 feet above stairway.

2.13.21 Anchors

When anchors are required by API Std 650 provide with anchor bolt chairs conforming to AISI E 1 Steel Plate Engineering Data and as indicated.

PART 3 EXECUTION

3.1 SAFETY PRECAUTIONS

API RP 2009 for fire and explosion hazard areas.

3.2 API Std 653 INSPECTION REPORTS

****

NOTE: The intent of the requirement for an API Std 653 Inspection of a newly erected tank is to assure full compliance with API Std 650, the design, and tank manufacturer shop drawings, such that at the next (first) out-of-service inspection, it can reasonably be assured there are no latent violations of API Std 650 and API Std 653 from construction. The purpose of the plate UT measurements is to assure every plate installed meets the design thickness for location.

For API Std 653 Post-Repair Inspections of existing tanks, refer to Sections 33 01 50.65 INSPECTION OF

FIELD FABRICATED FUEL STORAGE TANKS and 33 01 50.75 REPAIR OF FIELD FABRICATED FUEL STORAGE TANKS.

****

The API Std 653 inspector must inspect the completed tank in accordance with API Std 653 and deliver a full report to the Contracting Officer. The report must include a record of ultrasonic thickness measurements (UTMs), exclusive of the coating, of each tank bottom plate, each bottom shell course plate at five random locations per plate, the shell along the circumferential stairway at five locations per shell course. The record of UTMs must include sketches of the tank bottom plate and shell plate layouts. The location on each plate, where each ultrasonic thickness measurement (UTM) is taken, must be recorded. Five UTMs must be recorded on each tank bottom plate and on each lowest shell course plate. Five UTMs must be recorded for each of the shell courses above the lowest shell course and must be taken along the circumferential stairway. The report must include the tank data plate information and photograph of the tank data plate. Provide electronic copies of the tank inspection reports to Service Headquarters or officially designated alternate, Service Control Points, and DLA-Energy. The paper and electronic copies of the report and UTMs must be provided to the Contracting Officer for filing with the tank's "as-built drawings." Refer to Section 01 45 00 QUALITY CONTROL for API Std 653 inspector certification requirements.

3.3 CONSTRUCTION

3.3.1 Accessibility

Install all work so that parts requiring periodic inspection, operation, maintenance, and repair are readily accessible. Install concealed valves, expansion joints, controls, dampers, and system components requiring access in locations freely accessible through access doors.

3.3.2 Tank Erector Site Superintendent

Tank erector site superintendent must be on site at all times during any work by that crew.

3.3.3 Floating Pan Superintendent

Floating pan superintendent must be on site at all times during any work by the crew.

3.3.4 Tank

****

NOTE: Provide a reinforced concrete ring wall for all tanks, regardless of size.

****

Provide tank of welded construction and support tank on a concrete ring wall. On the side of the tank furthest from the sump, slope the tank bottom down to the sump approximately 150 mm 6 inches for each 3.00 meters 10 feet of tank radius. Butt weld or lap weld bottom plates with the outer plates on top. Lap annular ring on top of bottom plates or butt weld to the bottom plates. Reinforce openings larger than 50 mm 2 inches in diameter through plating of the tank shell and roof. Provide structural stiffening, consisting of rings, thicker plates, or other approved means, to maintain roundness when the tank is subjected to wind

or seismic loads.

3.3.4.1 Hazard Identification System

Label the tank with a hazard identification system in accordance with NFPA 704.

3.3.4.2 Data Plate

In accordance with API Std 650. Include tank data plate information in as-built drawings.

3.3.4.3 Ringwall Tolerance

For tanks with concrete ring wall, provide top of foundation elevation with no more than plus or minus 3 mm 1/8 inch deviation in any 9 m 30 ft of circumference. Circumference tolerance must not exceed plus or minus 6 mm 1/4 in in total circumference. Submit Ringwall Tolerance Test Report.

3.3.5 Roof Plate Seams

****

NOTE: Include the second (bracketed) sentence below in corrosive environments (e.g., the Pacific and all other humid locations where condensation may regularly collect on the underside of the roof).

****

Tank roof plate must be lap welded with the plates closer to the center of the tank on top.[Seal weld the underside of all roof plate lap welded seams.]

3.3.5.1 Prohibition of Protective Coatings on Surfaces to be Welded

Remove protective coatings on surfaces to be welded and on surfaces within 25 mm one inch from weld preparation. "Weld-through" inorganic zinc coatings and similar coatings will not be permitted.

3.3.6 Roof Supports

[When columns are provided in the tank, provide column base plates and 13 mm 1/2-inch thick bearing plates. Weld the columns to the column base plates. Center the column base plates on the bearing plates and weld the column base clip-guides to the bearing plates. Do not weld the column base plates to their bearing plates. Continuously seal weld the bearing plates to the tank bottom so as to provide a seal against the entry of water or other liquids into the space between the column bearing plates and the tank bottom. Bearing plates must be larger than the base plates by at least 150 mm 6 inches in either direction. Provide seal-welded cap plates on all columns. Roof support columns must be of pipe or round structural tubing.][Roof support columns are not allowed.]

3.3.7 Surface Finishing

Provide Contracting Officer with NACE visual comparator as described in NACE SP0178 Section 5. Finish interior surfaces before hydrotesting, in accordance with Section 5 of NACE SP0178 and accompanying Visual Comparator, to the condition described and shown for NACE Weld Designation "C" welds. Finish exterior surfaces, in accordance with Section 5 of

NACE SP0178 and accompanying Visual Comparator, to the condition described and shown for NACE Weld Designation "D" welds. Submit acknowledgement of surface finish requirements. Remove all weld splatter, sharp corners, edges and points from all carbon steel surfaces before coating.

3.3.8 Tank Bottom To Foundation Seal

****
NOTE: Include the first bracketed paragraph for self anchored tanks. Include the second bracket paragraph for anchored tanks.
****

[After welding of tank bottom annular ring butt welds of self anchoring tanks are complete, provide specified tank bottom to foundation gasket between the top of the foundation and the tank bottom with no gaps or overlaps between segments.

][All anchored tanks are to be grouted before loading with water or product and before tightening anchor bolts. Prepare the top of the foundation for shimming and grouting by removing all dirt, sand, and loose material. Provide 25 mm one-inch shim on top of foundation at high point and develop all other shim stacks to match the elevation of the shim at the high point of the foundation. Place shims a minimum of 38 mm 1-1/2 inches inside the perimeter of the tank bottom and under the tank shell. Do not retemper (add water) to a stiffening grout mix. Place grout within 30 minutes after mixing with water or discard the mix.

]3.3.9 Attachments

****
NOTE: For non-anchored tanks only, include the following instructions in the execution section of the exterior coating specification:

After the exterior coating is cured, provide specified bond breaker tape on the outer perimeter of the tank bottom to foundation gasket as recommended. Seal the outer edge of the joint between the concrete foundation and the tank bottom plate by caulking with specified polysulfide sealant.
****

All exterior permanent shell and roof attachments must be connected to the tank using continuously welded mounting plates. Mounting plates must exceed the size of the attachment by a minimum of 25 mm one inch. All mounting plate corners must have a 50 mm 2 inch radius. Attachment must be seal welded to the mounting plate with structurally sound welds of sufficient size to support the intended loads.

3.3.10 Nozzles

All shell nozzles must be flanged type. Shell nozzles sizes larger than 50 mm 2 inches must have a reinforcing plate. Nozzles for pipe connections inside the tank must be flanged inside near the shell. Reinforcing plates for shell nozzles must be rolled to the curvature of the shell.

3.3.11 Tank Bottom Sump

Weld sump to the underside of the tank bottom at the lowest point of the tank bottom as indicated.

3.3.12 Roof to Rafter Joint Size

Construct roof plate and rafter joint such that the size of the gap is suitable for the elongation of sealant material used in the interior coating specification.

3.4 INSTALLATION OF INTERNAL FLOATING PAN

****
NOTE: Modify the coating specification to provide additional coating inspection after the floating pan is installed to ensure damage to the coating that may result from installation of the pan is properly repaired by the contractor.
****

Install floating pan after coating of the interior of the tank is complete. Protect tank coatings during installation of floating pan to prevent damage. Repair damage to the coating that may occur during the installation of the pan. Adjust the floating pan support legs to the pan low level position after commissioning.

3.5 END CONNECTIONS FOR SYSTEM COMPONENTS, VALVES, PIPE, AND FITTINGS

All valve, system components, pipe and fitting connections including, but not limited to, piping for the Water Draw-Off System, Side stream Filtration System, drains, thermal reliefs, HLV float pilot chamber, and level switches must be welded or flanged except as indicated. Piping and fittings 63 mm 2.5 inches and larger must be butt welded. Piping and fittings 50 mm 2 inches and smaller may be butt welded or socket welded. Threaded connections are not allowed except where welded or flanged connections to appurtenances are not available, e.g., pressure gauges, fuel sample connections, level switch probes, HLV float pilot chamber.

3.6 FIELD QUALITY CONTROL

The Contracting Officer will conduct field inspections and witness field tests and trial operations specified in this section. The Contractor must perform all trial operations and field tests and provide all labor, equipment and incidentals required for testing.

[3.6.1 Tank Calibration Table

****
NOTE: Delete paragraph if it is in the best interest of the Government to enter into a separate contract for tank calibration.
****

After installation of the tank is complete, provide two calibration tables, one in English units and one in metric units. Tables must be laminated. Both tables must show the volume of the fuel for all liquid levels in the tank starting at the bottom of the sump and going up to the level of the overflow. The English unit calibration table must show the

volume of fuel in gallons and in barrels of 42 gallons and the level of the fuel in 1/16-inch increments. The metric table must show the volume of the fuel in liters and in m3 and the level of the fuel in 2.0 mm increments. The table must include notes at the bottom indicating 42 gallons = 1 barrel; and one kiloliter = one cubic meter. Volume calculations must be in the smaller units. Larger units may be obtained by rounding off. The 0 mm 0 inch level must be the level of the bottom of the shell. Level below the bottom of the shell must be shown in negative units starting at the bottom of the shell. The level of the bottom of the shell, alarm set points, high level shut off valve actuation point, and the level of the overflows must be identified on the calibration table (strapping chart). The table must not include tank volume above the level of the overflows. Also, provide Electronic Calibration Table compatible with the Electronic Automatic Tank Gauging System. Contact Contracting Officer for direction on required format.

3.6.1.1 Tank Calibration Method

The tank gauging systems must be calibrated in accordance with the API Manual of Petroleum Measurement Standards (API MPMS) for critical measurement using methods outlined in one of the following chapters.

a. API MPMS 2.2A, Measurement and Calibration of Upright Cylindrical Tanks by the Manual Strapping Method.

b. API MPMS 2.2B, Calibration of Upright Cylindrical Tanks Using the Optical Reference Line Method.

c. API MPMS 2.2C, Calibration of Upright Cylindrical Tanks Using the Optical Triangulation Method.

d. API MPMS 2.2D, Calibration of Upright Cylindrical Tanks Using the Internal Electro-Optical Distance Ranging Method.

]3.6.2 Weld Inspection

Perform inspection of welds in accordance with API Std 650. Remove slag and non-metal from initial pass on shell to bottom weld and then examine over its entire circumference both visually and with vacuum box leak test. Inspect butt welds requiring complete penetration and complete fusion by the radiographic method. Inspect roof support column welds below design liquid level by visual and dye penetrant methods. Submit the following weld inspection reports to the Contracting Officer:

a. Visual examination of vertical shell-seam tack welds, if left in place, in butt welds.

b. Visual examination of initial pass of internal shell-to-bottom weld.

c. Vacuum box testing of internal shell-to-bottom initial weld pass.

d. Visual examination of completed internal and external shell-to-bottom welds.

e. Radiographic examination of shell butt weld.

Submit reports for inspection of welds and radiographs to the Contracting Officer.

f. Visual examination of shell butt welds.

g. Visual examination of fillet welds.

h. Visual examination of tank bottom plates after welding.

i. Vacuum box testing of tank bottom fillet weld.

j. Pneumatic tests of reinforcing plates.

3.6.3 Reports of Other Tests and Examinations

Submit reports of the results of the following examinations and tests required by API Std 650 to the contracting officer:

a. Hydrostatic testing.

b. Shell settlement measurements taken before, during, and after hydrostatic testing.

c. Internal bottom elevation readings taken before and after hydrostatic testing.

d. Shell plumbness.

e. Shell roundness.

f. Maximum local deviations, shell.

3.6.4 Tightness Tests

Perform tightness tests described under this paragraph in accordance with API Std 650, as modified herein. Perform the tests after finishing welds in accordance with the paragraph SURFACE FINISHING, but prior to blast cleaning and application of the protective coating. Submit tightness test records to the Contracting Officer.

3.6.4.1 Penetrating Oil Test

Inspect tank shell-to-bottom, inside corner welds using the penetrating oil test prior to any vacuum box testing. After the initial inside fillet weld is made, apply No. 2 Diesel to the outside of the inside corner weld (before the outside weld is made). After 4 hours, inspect the inside fillet weld for oil penetration through defects. The contractor must correct any defects. Remove oil completely prior to finishing weld joint. Then, complete the remainder of the shell-to-bottom weld joint.

3.6.4.2 Vacuum Box Test of Tank Bottom

Perform a vacuum box test of the tank bottom immediately after installation and after completion of the penetrating oil test[and prior to installing any columns]. Test seams in bottom of tank and shell-to-bottom joint by applying a commercial soap film and subjecting the seam to a vacuum. Use a glass top vacuum box with hypalon or neoprene sealing gasket. Apply a commercial bubble forming solution to the weld or area to be tested; position the vacuum box over the area and slowly pull a partial vacuum. Observe the solution film for bubble formation between 0-14 kPa 0-2 psi differential pressure. Continue to open the valve until a differential pressure of 34.5 kPa 5 psi or 3.50 meters 11.5 feet of

water or 259 mm 10.2 inches of mercury is achieved and hold for at least 20 seconds while continuing to observe the solution for bubbles.

3.6.4.3 [Hydrostatic Test and]Settlement[During Fill Test]

****
NOTE: Check geotechnical report for expected tank settlement and adjust duration of hydrostatic testing to maintain tank full of water until the remainder of the expected consolidated settlement is within limits of flexibility designed into piping systems.
****

****
NOTE: Availability of utilities services and charges are established by the activity and should be stated in Division 1 of the contract specifications. Contact authority having jurisdiction to determine what kind of water can be used, what flow rate is available for filling, days and hours of availability, allowable disposal rate, required testing, and characteristics.

Use alternate test methods for testing shell, only if water supply is inadequate for filling the tank, only if tank is located outside the CONUS, and only with Service Headquarters approval.

Include location regulatory requirements for water disposal permits, treatment, and testing of test water prior to disposal. Verify water discharge may be dumped without treatment.
****

Perform hydrostatic test with fresh water only. Prior to[hydrostatic][fill] testing, check the capacity and condition of the tank venting and overflows to ensure they are adequate to handle the potential rate of fill. This procedure must be accomplished prior to application of coatings and before connecting product/operating piping to the tank. Shell settlement must be measured before, during, and after[hydrostatic testing][fill testing] in accordance with API Std 650. Hydrostatic test the shell by filling tank with water and maintaining it full for a period of not less than [24][_____] hours or until the settlement of the tank stabilizes, then inspect shell for leaks. The appearance of damp spots must be considered evidence of leakage. Minimize water retention time to limit rusting of tank interior.[Adequate water for hydrostatic testing is not expected to be available. Contractor must obtain approval of professional engineer in lieu of hydrostatic testing and must perform alternate testing of shell in accordance with API Std 650 in addition to testing specified in the paragraph FILL TEST.] Repair leaks disclosed by the test; then, retest the tank to prove the tank is leak-free. [Sufficient] water to hydrostatically test[the tanks][one tank] will[not] be provided free of charge by the Government[at a maximum rate of [_____]]. Water used on one tank must be recycled to the fullest extent possible for use in testing subsequent tanks. No water must be released to the sanitary or storm sewer systems without the expressed, written approval of the Contracting Officer.

3.6.5 Tank Bottom Puddle Test

Test slope of the tank bottom in the presence of the Contracting Officer by examining the plate immediately after hydrotesting. Puddling deeper than 5 mm 3/16 inch anywhere on the tank bottom plates must not be accepted.

3.6.6 Fill Test and Related Miscellaneous Tests

3.6.6.1 Fill Test

****

NOTE: Coordinate fuel lead time to allow the U.S. Government to secure the grade and volume required and make the necessary transportation requirements. Also, coordinate with fuel lead time requirements in Section 33 08 55 FUEL DISTRIBUTION SYSTEM START-UP (NON-HYDRANT).

****

After other tightness testing is complete and after application and cure of the interior and exterior coatings, fill test the tank using fuel. Tank piping and appurtenances must be ready for service. The Government will provide the necessary fuel for the Contractor to fill the tank with fuel. The Contractor will provide a fill test plan to fill the tanks. The Contractor must remain on standby during fill test to assist in witnessing leaks [and][or] performing necessary repair activities. Advise the Contracting Officer, in writing, at least[60][90] [_____] calendar days in advance of the need for this service and provide access to the interior of the tank for the Contracting Officer's inspection to ensure the tank is clean and dry to the Government's satisfaction prior to receiving fuel.

****

NOTE: In the specification containing level alarms, include instructions to check the operation of the low-low, low, high, and high-high level alarms and verify operation of the alarm horn and light during the fill test, shut-off of pump at low level, and closure of issue MOV at low-low level.

****

a. Floating Pan Tests

Following the installation of a floating pan, the deck penetrations and rim area must be subjected to a visual inspection for seal tightness. Leaks or seal deformations must be corrected according to manufacturer's recommendations. Following the seal inspection, the floating pan must be subjected to a flotation test. The tank must be filled to the 3 meter 10 foot level with fuel and the top of the floating pan must be visually inspected for fuel leakage. The appearance of damp spots on the top of the floating pan must be considered evidence of leakage; the Contracting Officer must be notified and the fuel removed immediately. Leaks must be repaired and the flotation test performed again.

b. Fill Test Stages

The Contractor will fill tank at increments as indicated within fill

test plan. The fill test plan is generally comprised of the various tank filling activities, fuel quantities needed, hold points at different tank levels and duration, and inspection activities to be performed during the test. Before the tank fill test, check to ensure drain valves are closed. Padlock drain valves closed for the duration of the test and provide one set of keys to the Contracting Officer. If there are no damp spots, discoloration, leaks or a measurable drop in the fuel level during the fill test period, the tank will be accepted. If leakage becomes apparent during the filling or the test period, immediately notify the Contracting Officer and Government personnel will pump the fuel from the tank. Free the tank of vapor, clean it, and then carefully inspect the tank for evidence of failures at the Contractor's expense. Repair defects found and repeat fill tests.

****

NOTE: Ensure systems that include new pumps or modifications that include pumps and piping are designed with pump overpressure recirculating relief. On projects that connect to existing receipt systems, operation of the high level shutoff valve must be verified.

****

c. Tank High Level Shutoff Valve

Check the operation of the high level shutoff valve on the inlet to the tank to ensure that the valve closes completely and as indicated, no later than the high-high level.[Check closing by the float valve.] Before the tank high level is reached, verify operation of the valve by[the manual operation of the float][as well as by] filling the level switch chamber[and again by filling the float chamber] with fuel. Check for proper operation when the tank is filled using appropriate safety measures.

d. Water Draw-Off System

Check System Operation

e. Side-Stream Filtration System

Check System Operation

Consider the consequences of closing the valve against active pumps and take precautions to avoid damaging the system. Ensure receipt pumps used to perform the test are equipped with overpressure recirculation relief or other means to protect the system from damage. If the test cannot be performed without risk of damage, notify the Contracting Officer.

3.6.7 Roof Puddle Test

After coating, test slope of the finished tank roof plate in the presence of the Contracting Officer by applying water for five minutes, evenly in all directions, at a rate of not more than 20 liters 5 gallons per minute, near the center of the roof, and examining the roof plate for puddling. Puddling deeper than 5 mm 3/16 inch anywhere on the tank roof plates will not be accepted.

3.6.7.1 Stilling Well Plumbness Test

All stilling wells must be aligned vertically and tested with a plumb bob in the presence of the Contracting Officer to ensure that they are plumb and are directly centered over the datum plates or sump.

3.6.8 Retesting

Deficiencies found must be rectified and work effected by such deficiencies must be completely retested at the Contractor's expense.

3.6.9 Maintenance Instructions

Provide the following instructions in the Operation and Maintenance Data as follows: Schedule periodic recalibration of ATG at 15 year intervals in accordance with API Manual of Petroleum Measurement Standard (API MPMS) Chapter 2.0 for tanks in custody transfer service and at 15-20 year intervals for all others, or when operating variables of the storage tank change, or when internal dimensions and structural variables of the tank change.

3.6.10 Operator Instructions

Provide the following instructions in the Operation and Maintenance Data as follows:

a. Inspect the tank bottom to foundation perimeter mastic seal monthly for deterioration and request maintenance when deterioration is found.

b. Keep the leak detection tell-tale valve/valves normally closed. Temporarily open the valves to check for tank bottom leaks on a monthly basis.

c. Test the low-low, low, high and high-high level alarm switches semiannually. Test level switches by simulating product levels either manually or by operating the water stripping system pump and level alarm/control test/drain header valves.

d. Examine and clear the tank venting semi-annually to ensure the vents have not become plugged.

-- End of Section --