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(2) Two or more bolts that give metal to metal contact between the bolts and the parts to be bonded.

(3) Metal to metal contact between adjacent parts under designed operating conditions.

§ 154.516 Piping: Hull protection.

A vessel's hull must be protected from low temperature liquid leakage by a drip pan, or other means specially approved by the Commandant (G–MSO), at:

(a) Each piping connection dismantled on a routine basis;

(b) Cargo discharge and loading manifolds; and

(c) Pump seals.

[CGD 74–289, 44 FR 26009, May 3, 1979, as amended by CGD 82–063b, 48 FR 4782, Feb. 3, 1983]

§ 154.517 Piping: Liquid pressure relief.

The cargo loading and discharge crossover headers, cargo hoses, and cargo loading arms must have means to relieve cargo pressure and to remove liquid cargo.

§ 154.519 Piping relief valves.

(a) The liquid relief valve that protects the cargo piping system from liquid pressure exceeding the design pressure must discharge into:

(1) A cargo tank; or

(2) A cargo vent mast if that vent mast has a means for the detection and removal of the liquid cargo that is specially approved by the Commandant (G–MSO).

(b) A relief valve on a cargo pump that protects the cargo piping system must discharge into the pump suction.

[CGD 74–289, 44 FR 26009, May 3, 1979, as amended by CGD 82–063b, 48 FR 4782, Feb. 3, 1983]

§ 154.520 Piping calculations.

A piping system must be designed to meet the allowable stress values under § 56.07–10 of this chapter and, if the design temperature is −110° C (−166° F) or lower, the stress analysis must be specially approved by the Commandant (G–MSO) and must include:

(a) Pipe weight loads;

(b) Acceleration loads;

(c) Internal pressure loads;

(d) Thermal loads; and

(e) Loads from the hull.

[CGD 74–289, 44 FR 26009, May 3, 1979, as amended by CGD 82–063b, 48 FR 4782, Feb. 3, 1983]

§ 154.522 Materials for piping.

(a) The materials for piping systems must meet § 154.625 for the minimum design temperature of the piping, except the material for open ended vent piping may be specially approved by the Commandant (G–MSO) if:

(1) The temperature of the cargo at the pressure relief valve setting is −55° C (−67° F) or warmer; and

(2) Liquid can not discharge to the vent piping.

(b) Materials for piping outside the cargo tanks must have a melting point of at least 925° C (1697° F), except for short lengths of pipes with fire resisting insulation that are attached to the cargo tanks.

§ 154.524 Piping joints: Welded and screwed couplings.

Pipe lengths without flanges must be joined by one of the following:

(a) A butt welded joint with complete penetration at the weld root except that for design temperatures colder than −10° C (14° F) the butt weld must be double welded or must be welded using:

(1) A backing ring that for design pressures greater than 979 kPa gauge (142 psig) must be removed after the weld is completed;

(2) A consumable insert; or

(3) An inert gas back-up on the first weld pass.

(b) A slip-on welded joint with sleeves and attachment welds is allowed for an open ended pipe with an external diameter of 50 mm (2 in.) or less and a design temperature of −55° C (−67° F), or warmer.

(c) A socket weld fitting with attachment welds is allowed for pipe with an external diameter of 50 mm (2 in.) or less and a design temperature of −55° C (−67° F) or warmer.

(d) Screwed couplings are allowed for instrumentation and control piping that meets § 56.30–20 and § 56.50–105 (a)(4) and (b)(4) of this chapter.