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good weldable quality in conjunction with metal of tank.
(3) If the bottom washout nozzle extends 6 inches or more from shell of tank, a V-shaped breakage groove shall be cut (not cast) in the upper part of the outlet nozzle at a point immediately below the lowest part of the inside closure seat or plug. In no case may the nozzle wall thickness at the root of the “V” be more than 1/8-inch. Where the nozzle is not a single piece, provision shall be made for the equivalent of the breakage groove. The nozzle must be of a thickness to insure that accidental breakage will occur at or below the “V” groove or its equivalent. On cars without continuous center sills, the breakage groove or its equivalent may not be more than 15 inches below the tank shell. On cars with continuous center sills, the breakage groove or its equivalent must be above the bottom of the center sill construction.
(4) The closure plug and seat shall be readily accessible or removable for repairs.
(5) The closure of the washout nozzle must be equipped with a 3/4-inch solid screw plug. Plug must be attached by at least a 1/4-inch chain.
(6) Joints between closures and their seats may be gasketed with suitable material.

(b) Attachments not otherwise specified shall be applied by approved means.

§ 179.100–17  Closures for openings.

(a) Closures shall be of approved design and made of metal not subject to rapid deterioration by the lading. Plugs, if used, shall be solid, with NPT threads, and shall be of a length which will screw at least six threads inside the face of fitting or tank.

(b) [Reserved]

§ 179.100–18  Tests of tanks.

(a) Each tank shall be tested by completely filling tank and manway nozzle with water or other liquid having similar viscosity, at a temperature which shall not exceed 100 °F during the test; and applying the pressure prescribed in §179.101. The tank shall hold the prescribed pressure for at least 10 minutes without leakage or evidence of distress.

(b) Insulated tanks shall be tested before insulation is applied.

(c) Caulking of welded joints to stop leaks developed during the foregoing test is prohibited. Repairs in welded joints shall be made as prescribed in AAR Specifications for Tank Cars, appendix W (IBR, see §171.7 of this subchapter).

(d) Testing of exterior heaters is not a specification requirement.

§ 179.100–19  Tests of safety relief valves.

(a) Each valve shall be tested by air or gas for compliance with §179.15 before being put into service.

(b) [Reserved]

§ 179.100–20  Stamping.

(a) To certify that the tank complies with all specification requirements, each tank shall be plainly and permanently stamped in letters and figures at least 3/8 inch high into the metal.