

§ 178.338-2

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enclosed within an outer shell or jacket, with insulation between the inner vessel and outer shell or jacket, and having piping, valves, supports and other appurtenances as specified in this subchapter. For the purpose of this specification, *tank* means inner vessel and *jacket* means either the outer shell or insulation cover.

(c) Each tank must be designed, constructed, certified, and stamped in accordance with Section VIII of the ASME Code.

(d) The exterior surface of the tank must be insulated with a material compatible with the lading.

(1) Each cargo tank must have an insulation system that will prevent the tank pressure from exceeding the pressure relief valve set pressure within the specified holding time when the tank is loaded with the specific cryogenic liquid at the design conditions of—

(i) The specified temperature and pressure of the cryogenic liquid, and

(ii) The exposure of the filled cargo tank to an average ambient temperature of 85 °F.

(2) For a cargo tank used to transport oxygen, the insulation may not sustain combustion in a 99.5 percent oxygen atmosphere at atmospheric pressure when contacted with a continuously heated glowing platinum wire. The cargo tank must be marked in accordance with § 178.338-18(b)(7).

(3) Each vacuum-insulated cargo tank must be provided with a connection for a vacuum gauge to indicate the absolute pressure within the insulation space.

(e) The insulation must be completely covered by a metal jacket. The jacket or the insulation must be so constructed and sealed as to prevent moisture from coming into contact with the insulation (see § 173.318(a)(3) of this subchapter). Minimum metal thicknesses are as follows:

Type metal	Jacket evacuated		Jacket not evacuated	
	Gauge	Inches	Gauge	Inches
Stainless steel	18	0.0428	22	0.0269
Low carbon mild steel ..	12	0.0946	14	0.0677
Aluminum	0.125	0.1000

(f) An evacuated jacket must be in compliance with the following requirements:

(1) The jacket must be designed to sustain a minimum critical collapsing pressure of 30 psig.

(2) If the jacket also supports additional loads, such as the weight of the tank and lading, the combined stress, computed according to the formula in § 178.338-3(b), may not exceed 25 percent of the minimum specified tensile strength.

[Amdt. 178-77, 48 FR 27703, June 16, 1983, as amended at 49 FR 24316, June 12, 1984; Amdt. 178-104, 59 FR 49135, Sept. 26, 1994; 66 FR 45387, Aug. 28, 2001; 68 FR 75754, Dec. 31, 2003]

§ 178.338-2 Material.

(a) All material used in the construction of a tank and its appurtenances that may come in contact with the lading must be compatible with the lading to be transported. All material used for tank pressure parts must conform to the requirements in Section II of the ASME Code (IBR, see § 171.7 of this subchapter). All material used for evacuated jacket pressure parts must conform to the chemistry and steelmaking practices of one of the material specifications of Section II of the ASME Code or the following ASTM Specifications (IBR, see § 171.7 of this subchapter): A 242, A 441, A 514, A 572, A 588, A 606, A 633, A 715, A 1008/A 1008M, A 1011/A 1011M.

(b) All tie-rods, mountings, and other appurtenances within the jacket and all piping, fittings and valves must be of material suitable for use at the lowest temperature to be encountered.

(c) Impact tests are required on all tank materials, except materials that are excepted from impact testing by the ASME Code, and must be performed using the procedure prescribed in Section VIII of the ASME Code.

(d) The direction of final rolling of the shell material must be the circumferential orientation of the tank shell.

(e) Each tank constructed in accordance with part UHT in Section VIII of the ASME Code must be postweld heat treated as a unit after completion of all welds to the shell and heads. Other tanks must be postweld heat treated as required in Section VIII of the ASME Code. For all tanks the method must be as prescribed in the ASME Code. Welded attachments to pads may be made after postweld heat treatment.

(f) The fabricator shall record the heat and slab numbers and the certified Charpy impact values of each plate used in the tank on a sketch showing the location of each plate in the shell and heads of the tank. A copy of the sketch must be provided to the owner of the cargo tank and a copy must be retained by the fabricator for at least five years and made available, upon request, to any duly identified representative of the Department.

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[Amdt. 178-77, 48 FR 27703, 27713, June 16, 1983, as amended at 49 FR 24316, June 12, 1984; 68 FR 19281, Apr. 18, 2003; 68 FR 75754, Dec. 31, 2003; 70 FR 34076, June 13, 2005]

§ 178.338-3 Structural integrity.

(a) *General requirements and acceptance criteria.* (1) Except as permitted in paragraph (d) of this section, the maximum calculated design stress at any point in the tank may not exceed the lesser of the maximum allowable stress value prescribed in Section VIII of the ASME Code (IBR, see § 171.7 of this subchapter), or 25 percent of the tensile strength of the material used.

(2) The relevant physical properties of the materials used in each tank may be established either by a certified test report from the material manufacturer or by testing in conformance with a recognized national standard. In either case, the ultimate tensile strength of the material used in the design may not exceed 120 percent of the minimum ultimate tensile strength specified in either the ASME Code or the ASTM standard to which the material is manufactured.

(3) The maximum design stress at any point in the tank must be calculated separately for the loading conditions described in paragraphs (b), (c), and (d) of this section. Alternate test or analytical methods, or a combination thereof, may be used in lieu of the procedures described in paragraphs (b), (c), and (d) of this section, if the methods are accurate and verifiable.

(4) Corrosion allowance material may not be included to satisfy any of the design calculation requirements of this section.

(b) *Static design and construction.* (1) The static design and construction of

each tank must be in accordance with appendix G in Section VIII of the ASME Code (IBR, see § 171.7 of this subchapter). The tank design must include calculation of stress due to the design pressure, the weight of lading, the weight of structures supported by the tank wall, and the effect of temperature gradients resulting from lading and ambient temperature extremes. When dissimilar materials are used, their thermal coefficients must be used in calculation of the thermal stresses.

(2) Stress concentrations in tension, bending, and torsion which occur at pads, cradles, or other supports must be considered in accordance with appendix G in Section VIII of the ASME Code.

(c) Stresses resulting from static and dynamic loadings, or a combination thereof, are not uniform throughout the cargo tank motor vehicle. The following is a simplified procedure for calculating the effective stress in the tank resulting from static and dynamic loadings. The effective stress (the maximum principal stress at any point) must be determined by the following formula:

$$S = 0.5 (S_y + S_x) \pm (0.25(S_y - S_x)^2 + S_z^2)^{0.5}$$

Where:

(1) S = effective stress at any given point under the most severe combination of static and dynamic loadings that can occur at the same time, in psi.

(2) S_y = circumferential stress generated by internal and external pressure when applicable, in psi.

(3) S_x = the net longitudinal stress, in psi, generated by the following loading conditions:

(i) The longitudinal tensile stress generated by internal pressure;

(ii) The tensile or compressive stress generated by the axial load resulting from a decelerative force applied independently to each suspension assembly at the road surface using applicable static loadings specified in § 178.338-13 (b);

(iii) The tensile or compressive stress generated by the bending moment resulting from a decelerative force applied independently to each suspension assembly at the road surface using applicable static loadings specified in § 178.338-13 (b);