

ASME Sec.VIII Div.1 Cheat Sheet *Design*

Internal Pressure

Shell		
Longitudinal [1, Section UG-27(c)(2)]	$\sigma_s = \frac{PR_L}{0.2t}$	$\frac{PR_L}{2SE + 0.4P}$
Circumferential [1, Section UG-27(c)(1); Section 1-1 (a)(1)]	$\sigma_s = \frac{PR_L}{t}$	$\frac{PR_L}{SE - 0.6P}$
Heads		
Hemisphere [1, Section 1-1 (a)(2); Section UG-27(d)]	$\sigma_s = \sigma_s = \frac{PR_m}{2t}$	$\frac{PR_L}{2SE - 0.2P}$
Ellipsoidal [1, Section 1-4(c)]	See Procedure 2-7	$\frac{PD_sK}{2SE - 0.2P}$

Nozzle Reinforcement

✓ **Area Removed ≤ Area Available + Area Reinforced**



External Pressure – Cylindrical shell

1. Assume thickness "T"

3. Determine Factor "A"

5. Determine Factor "B"

$$\frac{4B}{3(D_o/t)}$$

Minimum Nozzle Neck Thickness

Nominal Size	in.	mm
NPS 1/8 (DN 6)	0.060	1.51
NPS 1/4 (DN 8)	0.077	1.96
NPS 3/8 (DN 10)	0.090	2.02
NPS 1/2 (DN 15)	0.095	2.42
NPS 3/4 (DN 20)	0.099	2.51
NPS 1 (DN 25)	0.116	2.96
NPS 1 1/4 (DN 32)	0.123	3.12
NPS 1 1/2 (DN 40)	0.127	3.22
NPS 2 (DN 50)	0.135	3.42
NPS 2 1/2 (DN 65)	0.176	4.52
NPS 3 (DN 80)	0.189	4.80
NPS 3 1/2 (DN 90)	0.198	5.02
NPS 4 (DN 100)	0.207	5.27
NPS 5 (DN 125)	0.226	5.73
NPS 6 (DN 150)	0.245	6.22
NPS 8 (DN 200)	0.282	7.16
NPS 10 (DN 250)	0.319	8.11
> NPS 12 (DN 300)	0.328	8.34

Forming Strain,

if Strain ≥ 5 % Stress relieving Heat treatment to be done

Type of Part Being Formed	Forming Strain, %
Cylinders formed from plate	$\epsilon_f = \left(\frac{50t}{R_f} \right) \left(1 - \frac{R_f}{R_o} \right)$
For double curvature (e.g., heads)	$\epsilon_f = \left(\frac{75t}{R_f} \right) \left(1 - \frac{R_f}{R_o} \right)$

Stamping of Vessel



Specific Marking

- "RT-1,2,3,4"
- "HT" or "PHT"

Hydro Test,

- ✓ $1.3 \cdot \text{LSR} \cdot (\text{Design Pressure or MAWP})$
- ✓ Or $1.3 \cdot \text{MAP}$

Pneumatic Test,

- ✓ Normally, not performed. To be done in special case only.
- ✓ $1.1 \cdot \text{MAWP} \cdot \text{LSR}$

Different Stress and Allowable limit,

- ✓ $P_m \leq S$
- ✓ $P_m + P_b \leq 1.5 \cdot S$
- ✓ $P_m + P_b + Q \leq 3 \cdot S$

Permissible Out-of-Roundness,

- ✓ 1 % of Nominal Diameter
- ✓ 2 % @ opening

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Mike Jess

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