

Contents

Foreword.....	v
Acknowledgements	v
1. Introduction and Scope.....	1
1.1 Introduction.....	1
1.2 Scope	2
2. Types of Fixed Roof Storage Tanks	3
3. Venting Capacities.....	5
3.1 Normal Venting	5
3.2 Emergency Venting	5
3.3 Roof Joints and Frangibility	5
3.3.1 According to BS 2654 and API 650.....	5
3.3.2 According to EN 14015	6
3.4 Older Tanks	6
4. Explosions inside Tanks	7
5. A Review of Reported Incidents	9
6. The Limited Value of a Theoretical Approach to Tank Failure.....	11
7. Ensuring Effective Frangible Roof Joints	13
7.1 A Practical Approach	13
7.2 Conditions and Factors Influencing the Effectiveness of Frangible Roof Joints	13
7.2.1 General.....	13
7.2.2 Influence of Shape of Roof.....	13
7.2.3 Roof-to-Shell Welds	14
7.2.4 Annular Bottom Plates.....	15
7.2.5 Foundations.....	16
7.2.6 Compression Rings	17
7.2.7 Fixed Roofs with External Support Structure.....	19
7.2.8 Corrosion	19
7.3 Modifications of Existing Roof-to-Shell Connections.....	20
7.3.1 Weakening the Fillet Joint	20
7.3.2 Frangible Shell Joint.....	20
7.4 Method to Assess Available Frangibility for Existing Tanks.....	21
7.5 Low Cycle Fatigue and Shell-to-Bottom Connection.....	24
7.6 Capacity and Diameter of Emergency Vents.....	25
7.7 Insulation and Frangibility	26
8. Conclusions and Recommendations	27
Photographs.....	29
References	35
Other related EEMUA Publications.....	35
Appendix 1 Assessment of presence of frangible roof-to-shell joint in a tank structure	36

Figures

Figure 1 Fixed roof storage tank	1
Figure 2 Evaporative losses from a fixed roof tank	1
Figure 3 Typical frangible roof joint.....	2
Figure 4 Force distribution in roof-to-shell joint induced by an internal pressure in a storage tank	5
Figure 5 Ballooning effect	11
Figure 6 Dome roof tank with curved rafters	14
Figure 7 Double fillet welds at roof-to-shell connections	14
Figure 8 Seal weld for frangible roof joint	15
Figure 9 Full fillet weld at roof-to-shell connection (too strong)	15
Figure 10 Lap-welded annular bottom plates (non-preferred)	15
Figure 11 Butt-welded annular bottom plates (preferred)	16
Figure 12 Uplift acting at the shell-to-bottom connection	16
Figure 13 Top curb angle for high pressure tank (diameter > 8 metres)	17
Figure 14 Details of compression rings	18
Figure 15 Fixed roof with external support structure.....	19
Figure 16 Corrosion at the shell-to-bottom connection.....	19
Figure 17 Modification of an existing roof-to-shell connection	20
Figure 18 Frangible joint at tank shell	21
Figure 19 Flow chart to determine frangibility of roof-to-shell joint	23
Figure 20 Deflection of tank bottom on a concrete ring beam foundation.....	24
Figure 21 Deflection of tank bottom on a sand pad foundation.....	25
Figure 22 Detail from EN 14015 and BS 2654.....	26

Photographs

Photo 1 Fixed roof tank with frangible roof joint where the roof-to-shell connection failed under excessive vapour pressure.....	29
Photo 2 Fixed dome roof tank where the shell-to-bottom connection failed under excessive vapour pressure.....	31
Photo 3 Roof plating blown off a 24 metre diameter hot oil tank due to excessive over-pressure.....	33