

# CONTENTS

	<b>Page</b>
<b>FOREWORD</b> .....	1
<b>1 INTRODUCTION AND SCOPE</b> .....	2
1.1 INTRODUCTION.....	2
1.2 SCOPE.....	2
1.3 DEFINITIONS .....	2
1.4 GENERAL RESPONSIBILITIES OF THE PURCHASER .....	3
1.5 PROJECT PLANNING .....	3
<b>2 TYPES OF STORAGE VESSEL</b> .....	4
2.1 SELECTION OF STORAGE VESSEL TYPE.....	4
2.2 MOUNDED STORAGE .....	4
<b>3 FOUNDATION AND EARTH MOUND</b> .....	6
3.1 INFORMATION REQUIRED BY THE CONTRACTOR.....	6
3.2 SOIL INVESTIGATION .....	6
3.2.1 Fieldwork .....	6
3.2.2 Laboratory Work .....	7
3.2.2.1 Classification Tests .....	8
3.2.2.2 Other Tests.....	8
3.2.3 Reporting .....	8
3.3 TYPES OF FOUNDATION.....	9
3.3.1 Soil Bearing Foundations.....	9
3.3.2 Sandbed on Piled Concrete Slab .....	10
3.3.3 Vessels on Saddles.....	10
3.4 SETTLEMENT OF SOIL BEARING FOUNDATIONS.....	10
3.4.1 Immediate Settlements.....	10
3.4.2 Long-term Settlements .....	10
3.4.3 Total and Differential Settlements .....	11
3.5 SETTLEMENT MONITORING .....	11
3.5.1 Settlement Monitoring During Preloading.....	11
3.5.2 Settlement Monitoring During Operation .....	11
3.6 FOUNDATION DESIGN.....	12
3.6.1 General.....	12
3.6.2 Operational Phase of Vessel .....	12
3.6.3 Construction Phase of Vessel .....	12
3.7 MOUND DESIGN.....	13
3.7.1 Geometry.....	13
3.7.2 External Loads.....	13
3.7.3 Erosion Protection .....	13
3.8 FOUNDATION AND MOUND MATERIAL .....	14
3.9 CONSTRUCTION OF FOUNDATION AND MOUND .....	14
3.9.1 Foundation.....	14
3.9.2 Mound.....	15
<b>4 VESSEL</b> .....	16
4.1 DESIGN .....	16
4.1.1 General.....	16
4.1.2 Design Conditions .....	18
4.1.3 Design Loads.....	18
4.1.3.1 Dead Weight of the Vessel .....	18
4.1.3.2 Weight of Liquid in the Vessel.....	18
4.1.3.3 Internal Design Pressure.....	18
4.1.3.4 Negative Internal Pressure .....	20

4.1.3.5	Loads due to the Mound .....	20
4.1.3.6	Loads due to Uneven Support by the Foundation .....	20
4.1.3.7	Loads due to Temperature and Internal Pressure Variations.....	21
4.1.3.8	Loads due to Earthquake .....	21
4.1.3.9	Loads due to an External Explosion .....	21
4.1.4	Load Combinations.....	22
4.2	MATERIALS.....	22
4.3	CONSTRUCTION .....	23
4.3.1	Tolerances.....	23
4.3.2	Stiffeners .....	23
4.3.3	Welding.....	23
4.3.4	Heat Treatment.....	23
4.3.4.1	Pre-heat Treatment .....	23
4.3.4.2	Post-Weld Heat Treatment.....	24
4.4	FITTINGS FOR OPERATIONAL PURPOSES.....	24
4.4.1	General.....	24
4.4.2	Fittings for Product Inlet and Outlet.....	24
4.4.3	Piping.....	25
4.4.4	Drainage Facilities .....	25
4.4.5	Manholes.....	25
4.4.6	Sleeves Around Nozzles and Manholes.....	26
4.4.7	Instrumentation.....	26
4.4.7.1	General.....	26
4.4.7.2	Level Measuring Instruments.....	26
4.4.7.3	Level Alarms and Ullage Gauges.....	26
4.4.7.4	Pressure Indicators and Alarms.....	26
4.4.7.5	Vacuum Relief Valves.....	27
4.4.7.6	Temperature Measuring Devices and Indicators.....	27
4.4.7.7	Gas Detectors and Explosimeters .....	27
4.5	CORROSION PROTECTION .....	27
4.5.1	General.....	27
4.5.2	Coating .....	28
4.5.2.1	External Coating .....	28
4.5.2.2	Glass Fibre Reinforced Bitumen Coating System .....	28
4.5.2.3	Epoxy or Urethane Coating System .....	28
4.5.2.4	Coating Application .....	29
4.5.2.5	Coating Prequalification .....	29
4.5.2.6	Internal Coating.....	30
4.5.3	Cathodic Protection .....	30
4.5.3.1	General.....	30
4.5.3.2	Protection Criteria .....	30
4.5.3.3	Design .....	31
4.5.3.3.1	<i>Data to be Provided by Purchaser.....</i>	31
4.5.3.3.2	<i>Soil Resistivity Measurements .....</i>	31
4.5.3.3.3	<i>Electrical Separation.....</i>	31
4.5.3.3.4	<i>Choice of Cathodic Protection System.....</i>	32
4.5.3.3.5	<i>Transformer-Rectifiers .....</i>	32
4.5.3.3.6	<i>Automatic Potential Control .....</i>	32
4.5.3.3.7	<i>Groundbeds.....</i>	33
4.5.3.3.8	<i>Monitoring Facilities.....</i>	33
4.5.3.3.9	<i>Cables and Distribution Boxes.....</i>	34
4.5.3.3.10	<i>Design Documents .....</i>	34
4.5.3.4	Installation.....	35
4.5.3.5	Commissioning .....	35
4.5.3.6	Operation and Maintenance .....	36
4.5.3.7	Special Design Considerations .....	36
4.6	LIGHTING PROTECTION.....	37

<b>5</b>	<b>VESSEL: INSPECTION, TESTING AND CERTIFICATION</b> .....	38
5.1	INSPECTION REQUIREMENTS, PROCEDURES AND STANDARDS .....	38
5.1.1	Procedures and Standards .....	38
5.1.2	Inspection Prior to Vessel Assembly .....	38
5.1.3	Inspection During Vessel Assembly .....	38
5.1.4	Inspection After Vessel Assembly .....	38
5.2	HYDROSTATIC PRESSURE TEST .....	38
5.3	MANUFACTURING REPORT .....	39
5.4	MARKING AND CERTIFICATION .....	39
<b>6</b>	<b>GUIDELINES FOR IN-SERVICE INSPECTION</b> .....	40
6.1	INSPECTION DURING OPERATION .....	40
6.1.1	Vessel .....	40
6.1.2	Vessel Settlement .....	40
6.1.3	Mound .....	40
6.2	TECHNICAL REVIEW .....	40
6.3	RECOMMENDED MINIMUM REQUIREMENTS FOR THE TECHNICAL INTEGRITY REVIEW .....	41
6.3.1	Recommended Actions Prior to Inspection .....	41
6.3.2	Recommended Actions Post-inspection .....	41
6.4	TYPICAL FAILURE MODES .....	42
6.5	RECOMMENDATIONS FOR PLANING OF INSPECTION .....	42
<b>7</b>	<b>REFERENCES</b> .....	44
7.1	AMERICAN STANDARDS .....	44
7.2	BRITISH STANDARDS (including transposed ENs) .....	44
7.3	INTERNATIONAL STANDARDS .....	45
7.4	MISCELLANEOUS CODES AND STANDARDS .....	45
7.5	RECOMMENDED FURTHER READING .....	46
<b>8</b>	<b>GLOSSARY OF ABBREVIATIONS</b> .....	47
<b>APPENDIX A: STRESS ANALYSIS OF MOUNDED STORAGE VESSELS</b> .....		49
A.1	INTRODUCTION .....	49
A.2	CIRCUMFERENTIAL BENDING .....	49
A.2.1	Unstiffened Cylinders .....	49
A.2.2	Stiffened Cylinders .....	49
A.3	NORMAL FORCES AND SHEAR FORCES .....	50
A.4	CALCULATION METHOD FOR STIFFENED CYLINDERS .....	50
A.4.1	Nomenclature .....	50
A.4.2	Loads .....	51
A.4.2.1	Dead Weight (Load 1) .....	51
A.4.2.2	Weight of Liquid Fill (Load 2) .....	52
A.4.2.3	Internal Design Pressure (Load 3) .....	52
A.4.2.4	Negative Internal Pressure (Load 4) .....	52
A.4.2.5	Pressure Due to Mound (Load 5) .....	53
A.4.2.6	Load due to Uneven Support of the Vessel (Load 6) .....	54
A.4.2.7	Axial Loads due to Changes in Vessel Length (Load 7) .....	55
A.4.2.8	Seismic Loads (Load 8) .....	55
A.4.2.9	External Pressure Caused by Explosion of Gas Clouds (Load 9) .....	56
A.4.2.10	Supporting Pressure by the Foundation (Load 10) .....	56
A.4.3	Selection of Shell Plate Thickness .....	57
A.4.4	Bending Moments, Normal Forces and Shear Forces in Stiffening Rings .....	57
A.4.4.1	General .....	57
A.4.4.2	Bending Moments for 120° Support Angle .....	58
A.4.4.3	Normal Forces for 120° Support Angle .....	58
A.4.4.4	Shear Forces for 120° Support Angle .....	59
A.4.5	Bending Moments and Forces for 90° Support angle .....	60

A.4.6	Bending Moments and Forces for 60° Support angle.....	60
A.4.7	Dimensions of Stiffening Rings.....	60
A.4.8	Secondary Bending Stresses .....	61
A.4.9	Summary of Stresses .....	61
A.4.9.1	Stresses in the Shell Plates.....	61
A.4.9.1.1	<i>Circumferential Stresses in the Shell Plates</i> .....	61
A.4.9.1.2	<i>Longitudinal Stresses in the Shell Plates</i> .....	62
A.4.9.1.3	<i>Shear Stresses in the Shell Plates</i> .....	62
A.4.9.1.4	<i>Stress Intensities in the Shell Plates</i> .....	63
A.4.9.2	Stresses in the Domed Ends .....	63
A.4.9.3	Stresses in the Stiffening Rings .....	63
A.4.9.4	Stresses in the Welds between Stiffening Rings and Shell Plates .....	64
A.4.9.5	Stability of Stiffening Rings.....	65
A.4.10	Stability of Stiffening Rings, Eurocode 3 .....	66
A.4.10.1	General.....	66
A.4.10.2	Local Instability .....	67
A.4.10.3	In-plane Buckling.....	67
A.4.10.4	Shear Buckling of the Web .....	67
A.4.10.5	Flange Induced Buckling.....	68
A.4.10.6	Interaction between Buckling Modes .....	70
A.5	STRESS AND STABILITY CRITERIA .....	71
A.5.1	General.....	71
A.5.2	Shell Plates.....	72
A.5.3	Domed Ends.....	72
A.5.4	Stiffening Rings .....	73
A.6	DEFORMATION OF STIFFENING RINGS.....	73
<b>APPENDIX B: TYPICAL DESIGN FEATURES FOR VESSEL, FOUNDATION AND CONNECTIONS .....</b>		<b>75</b>
B.1	FOUNDATION MODES .....	75
B.2	MOUND.....	77
B.3	VESSEL CONNECTIONS (CONCEPTUAL).....	79
B.4	BOTTOM OUTLET WITH INSPECTION TUNNEL (CONCEPTUAL) .....	80
<b>APPENDIX C: DISTRIBUTION OF SOIL REACTION (SUPPORTING LOAD) .....</b>		<b>81</b>
<b>APPENDIX D: RECOMMENDED STEEL GRADES .....</b>		<b>82</b>
<b>APPENDIX E: PROJECT PLANNING.....</b>		<b>83</b>
[APPENDIX F DELETED]		
<b>APPENDIX G: NON-DESTRUCTIVE TESTING REQUIREMENTS .....</b>		<b>85</b>
<b>APPENDIX H: MATERIAL HARDNESS TESTING .....</b>		<b>87</b>
<b>APPENDIX I: SELECTION OF STORAGE SYSTEM.....</b>		<b>89</b>