

Contents

Foreword	1
1. Scope	3
2. Equipment, Facilities and Procedures for Pressure Testing	5
2.1 General Responsibilities for the Manufacturer	5
2.2 Equipment and Facilities: Particular Requirements	5
2.3 Test Fluid.....	6
2.4 Witnessing and Test Reporting	7
2.5 Removal and/or Refitting of Parts	7
3. Types and Sequence of Tests.....	9
3.1 Recommended Test Requirements	9
3.2 Information to be Provided by the Purchaser	9
3.3 Test Sequence	9
4. Shell Test	11
4.1 Purpose	11
4.2 Hydrostatic Shell Test	11
4.3 Low Pressure Air Shell Test.....	12
4.4 Acceptance Criteria	12
5. Body Cavity Relief Test.....	13
5.1 Purpose	13
5.2 Frequency of Testing	13
5.3 General	13
5.4 Test Procedure for Trunnion-Mounted Ball or Slab Gate Valve with Internal Cavity Relief.....	13
5.5 Test Procedure for Floating Ball Valve with Internal Cavity Relief.....	13
5.6 Test Procedure for Ball Valve, Expanding Gate Valve or Expanding Plug Valve with External Cavity Relief	14
5.7 Acceptance Criteria	14
6. Seat Test	15
6.1 Purpose	15
6.2 General	15
6.3 High Pressure (HP) Hydrostatic Seat Test Procedure.....	16
6.4 High Pressure (HP) Hydrostatic Seat Test Procedure.....	16
6.5 High Pressure (HP) Hydrostatic Seat Test Procedure.....	17
6.6 Low Pressure (LP) Air Seat Test Procedure.....	17
6.7 Low Pressure (LP) Air Seat Test Procedure	18
6.8 Low Pressure (LP) Air Seat Test Procedure	19
6.9 High Pressure Gas Seat Test	19
6.10 Acceptance Criteria	20
7. Operational Test.....	21
7.1 Purpose	21
7.2 Frequency of Testing	21
7.3 Procedures	21
7.4 Acceptance Criteria	21
8. Anti-static Test.....	23
8.1 Purpose	23
8.2 Frequency of Testing	23
8.3 Procedure	23
8.4 Acceptance Criteria	23

9. Back Seat Test (Globe and Gate Valves)	25
9.1 Purpose	25
9.2 General	25
9.3 Frequency of Testing	25
9.4 Procedure	25
9.5 Acceptance Criteria	25
10. Disc Strength Test (Butterfly Valves).....	27
10.1 Purpose	27
10.2 Frequency of Testing	27
10.3 Procedure	27
10.4 Acceptance Criteria	27
11. Test Times	29
12. References	31
13. Definitions	33
Appendix A: Typical Valve Test Report	37
Appendix B: Information relevant to testing to be supplied by the purchaser ..	39
Appendix C: Leak rates typically achievable by good quality valves.....	40

Tables

Table 1 Recommended Valve Test Requirements	10
Table 2 Hydrostatic Shell Test Minimum Durations	29
Table 3 Hydrostatic and Air/Gas Seat Test Minimum Durations	29