

ASME Sec.VIII Div.1 Cheat Sheet

Design

Internal Pressure

Shell

Longitudinal
[1. Section UG-27(c)(2)]

$$\sigma_x = \frac{PR_m}{0.21}$$

Circumferential
[1. Section UG-27(c)(1);
Section 1-1 (a)(1)]

$$\sigma_x = \frac{PR_m}{1}$$

Heads

Hemisphere
[1. Section 1-1 (a)(2);
Section UG-27(d)]

$$\sigma_x = \sigma_y = \frac{PR_m}{2t}$$

Ellipsoidal
[1. Section 1-4(c)]

See Procedure 2-7

Nozzle Reinforcement

✓ Area Removed ≤ Area Available + Area Reinforced



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"

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)	0.093	2.32
NPS 1/2 (DN 15)	0.095	2.42
NPS 5/8 (DN 20)	0.099	2.51
NPS 3/4 (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)	0.178	4.52
NPS 3 (DN 80)	0.199	4.99
NPS 3 1/2 (DN 90)	0.248	6.27
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

Hydro Test.

- ✓ 1.3 * LSR * (Design Pressure or MAWP)
- ✓ Or 1.3 * MAP

Pneumatic Test.

- ✓ Normally, not performed. To be done in special case only.
- ✓ 1.1 * MAWP * LSR

Different Stress and Allowable limit.

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

Permissible Out-of-Roundness.

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

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Tobias Bleicker

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 - The Rise of Digital Reading Asme Study Guide For Sec 9
 - Advantages of eBooks Over Traditional Books
2. Identifying Asme Study Guide For Sec 9
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Asme Study Guide For Sec 9
 - User-Friendly Interface
4. Exploring eBook Recommendations from Asme Study Guide For Sec 9

- Personalized Recommendations
- Asme Study Guide For Sec 9 User Reviews and Ratings
- Asme Study Guide For Sec 9 and Bestseller Lists

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- Asme Study Guide For Sec 9 eBook Subscription Services
- Asme Study Guide For Sec 9 Budget-Friendly Options

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- Asme Study Guide For Sec 9 Compatibility with Devices
- Asme Study Guide For Sec 9 Enhanced eBook Features

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- Joining Online Reading Communities
- Participating in Virtual Book Clubs
- Following Authors and Publishers Asme Study Guide For Sec 9

9. Balancing eBooks and Physical Books Asme Study Guide For Sec 9

- Benefits of a Digital Library
- Creating a Diverse Reading Collection Asme Study Guide For Sec 9

10. Overcoming Reading Challenges

- Dealing with Digital Eye Strain
- Minimizing Distractions
- Managing Screen Time

11. Cultivating a Reading Routine Asme Study Guide For Sec 9

- Setting Reading Goals Asme Study Guide For Sec 9
- Carving Out Dedicated Reading Time

12. Sourcing Reliable Information of Asme Study Guide For Sec 9

- Fact-Checking eBook Content of Asme Study Guide For Sec 9
- Distinguishing Credible Sources

13. Promoting Lifelong Learning

- Utilizing eBooks for Skill Development
- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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