

ASME BPVC VIII-1 2023

PTB-4-2021 / E4.3.1; E4.3.2; E4.3.3; E4.3.4; E4.3.5

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Layout

Input values:	1.234	or	1.234
Calculated values:	1.234	or	1.234
Critical values:	1.234	or	1.234
Estimated values:	1.234	or	1.234



ASME BPVC VIII-1 2023

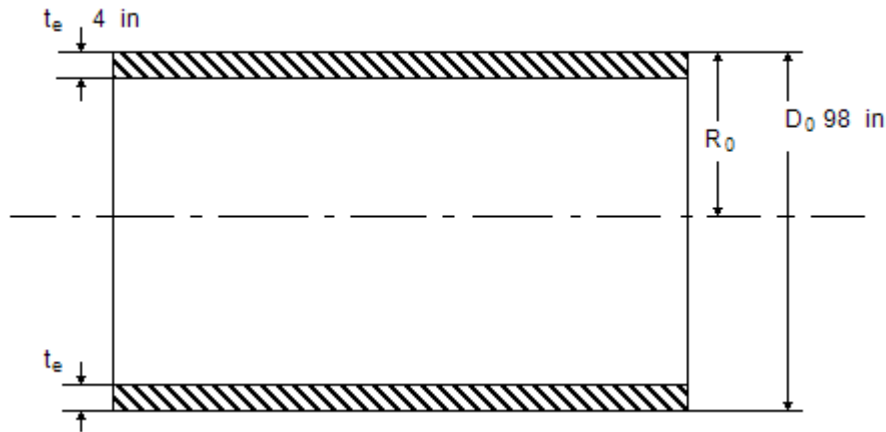
PTB-4-2021 / E4.3.1; E4.3.2; E4.3.3; E4.3.4; E4.3.5

E4.3.1 - Thickness of cylindrical shells under internal pressure - ASME BPVC VIII-1 UG-27 & Appendix-1: 2023

Cylindrical shells

Design pressure	p_D	356 psi
Hydrostatic head	D_p	0 psi
Calculation pressure	P_0	356 psi
Calculation temperature	T_0	148.9 °C

Material K02700-SA-516-70-Class:-Size:



Design wall thickness	t_e	4 in
Wall thickness allowance	c_1	0.125 in
Allowance (corrosion)	c_2	0 in
Weld joint efficiency (or Cast Quality Factor)	E	1
Circumferential weld joint efficiency for Eq. 2	E_c	1

Outside diameter	D_o	98 in
corroded inside radius	R	45.12 in

Results

Allowable stress	S	20000 psi
Outside radius	R_o	49 in
Effective thickness	t_0	3.875 in

Calculation as thin shell is applicable

Required thickness	$t(R_o)$	0.866 in	JA $t(R)$	0.8119 in
thin shell acc. UG-27			t_{UG-27}	0.8119 in
Minimum wall thickness without condition acc. UG-16			t_{UG-16}	0.05906 in
Minimum wall thickness acc. UG-16			t_{long}	0.4002 in
Required wall thickness for circumferential seam			t	0.8119 in
$t = \text{Max}\{\text{Min}[t_R; t_{R0}], t_{UG-16}\}$			$t+c_1+c_2$	0.9369 in
with allowances				

Allowable excess pressure	P	1633 psi
Allowable excess pressure for longitudinal stress for Eq. (2)	P_{long}	3557 psi
Allowable excess pressure without hydrostatic head	MAWP	1633 psi

Remark



ASME BPVC VIII-1 2023

PTB-4-2021 / E4.3.1; E4.3.2; E4.3.3; E4.3.4; E4.3.5

For calculation of openings according to UG-37

Required thickness

$t(E=1)$ **0.866** in

Calculated with outside diameter

Allowable unreinforced opening diameter d for welded, brazed, and flued connections acc. UG 36(c)3

$d \leq 89 \text{ mm}$ for $t \leq 10 \text{ mm}$

or

$d \leq 3 \frac{1}{2} \text{ in}$ for $t \leq \frac{3}{8} \text{ in}$

$d \leq 60 \text{ mm}$ for $t > 10 \text{ mm}$

or

$d \leq 2 \frac{3}{8} \text{ in}$ for $t > \frac{3}{8} \text{ in}$

Equations

$$R_0 = \frac{D_0}{2} = \frac{2489 \text{ mm}}{2} = 1245 \text{ mm}$$

$$t+c_1+c_2=t+c_1+c_2=20.62 \text{ mm}+3.175 \text{ mm}+0 \text{ mm}=23.8 \text{ mm}$$

corroded inside
radius

$$R=R_0-t_0=1245 \text{ mm}-98.42 \text{ mm}=1146 \text{ mm}$$

1) Thin shell For

$$P_0 \leq 0.385 \cdot S \cdot E \Leftrightarrow 2.455 \text{ MPa} \leq 53.09 \text{ MPa}$$

and

with the inside radius R

$$t_e \leq \frac{(R_0 - t_e)}{2} \Leftrightarrow 101.6 \text{ mm} \leq 571.5 \text{ mm}$$

$$t(R) = \frac{P_0 \cdot R}{S \cdot E - 0.6 \cdot P_0} = \frac{2.455 \text{ MPa} \cdot 1146 \text{ mm}}{137.9 \text{ MPa} \cdot 1 - 0.6 \cdot 2.455 \text{ MPa}} = 20.62 \text{ mm}$$

UG-27 (1)

$$P(R) = \frac{S \cdot E \cdot t_0}{R + 0.6 \cdot t_0} = \frac{137.9 \text{ MPa} \cdot 1 \cdot 98.42 \text{ mm}}{1146 \text{ mm} + 0.6 \cdot 98.42 \text{ mm}} = 11.26 \text{ MPa}$$

UG-27 (1)

or with the outside radius R_0

$$t(R_0) = \frac{P_0 \cdot R_0}{S \cdot E + 0.4 \cdot P_0} = \frac{2.455 \text{ MPa} \cdot 1245 \text{ mm}}{137.9 \text{ MPa} \cdot 1 + 0.4 \cdot 2.455 \text{ MPa}} = 22 \text{ mm}$$

App. 1-1 (1)

$$P(R_0) = \frac{S \cdot E \cdot t_0}{R_0 - 0.4 \cdot t_0} = \frac{137.9 \text{ MPa} \cdot 1 \cdot 98.42 \text{ mm}}{1245 \text{ mm} - 0.4 \cdot 98.42 \text{ mm}} = 11.26 \text{ MPa}$$

App. 1-1 (1)

$$\text{Log}(x) = \text{Ln}(x)$$

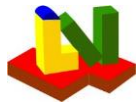
Longitudinal Stress (Circumferential Joints)

$$t_{\text{long}} = \frac{P_0 \cdot R}{2 \cdot S \cdot E_c + 0.4 \cdot P_0} = \frac{2.455 \text{ MPa} \cdot 1146 \text{ mm}}{2 \cdot 137.9 \text{ MPa} \cdot 1 + 0.4 \cdot 2.455 \text{ MPa}} = 10.16 \text{ mm}$$

UG-27 (2)

$$P_{\text{long}} = \frac{2 \cdot S \cdot E_c \cdot t_0}{R - 0.4 \cdot t_0} = \frac{2 \cdot 137.9 \text{ MPa} \cdot 1 \cdot 98.42 \text{ mm}}{1146 \text{ mm} - 0.4 \cdot 98.42 \text{ mm}} = 24.53 \text{ MPa}$$

UG-27 (2)



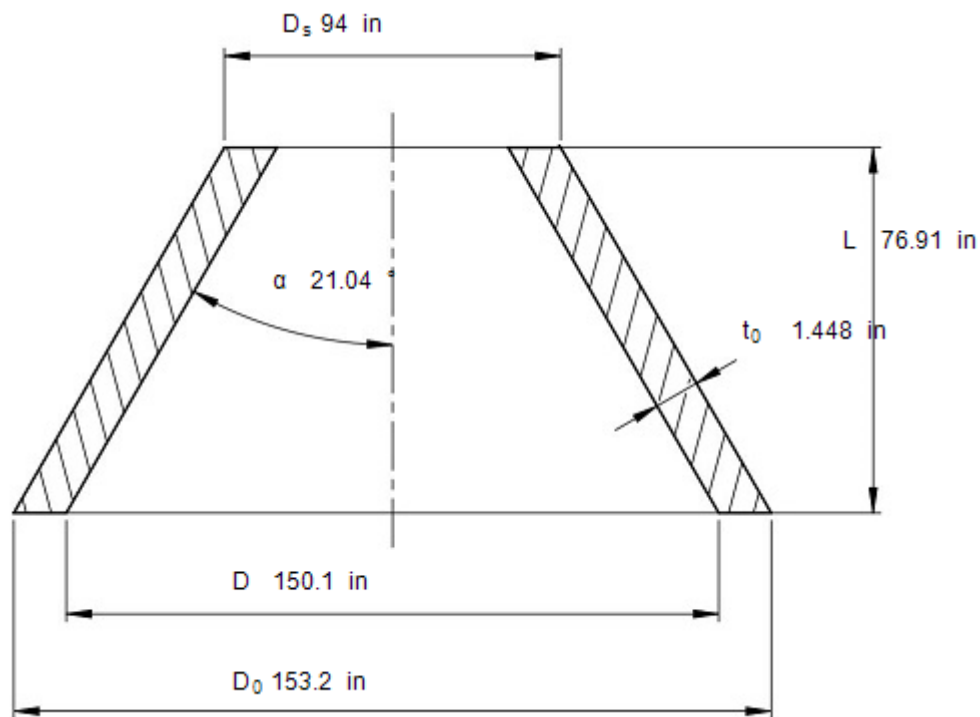
ASME BPVC VIII-1 2023

PTB-4-2021 / E4.3.1; E4.3.2; E4.3.3; E4.3.4; E4.3.5

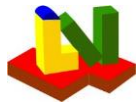
E4.3.2 - Cone without knuckle under internal pressure - ASME BPVC VIII-1 UG-32 & Appendix-1: 2023

Conical sections without knuckle acc. to UG-32(f)

Design pressure	p_D	356 psi
Hydrostatic head	D_p	0 psi
Calculation pressure	p_0	2.455 MPa
Calculation temperature	T_0	300 °F
Final wall thickness	t_e	1.573 in
Wall thickness allowance	c_1	0 in
Allowance (corrosion)	c_2	0.125 in
Effective thickness without allowances	t_0	1.448 in



Half-apex angle ($\leq 30^\circ$ without knuckle)	α	21.04 °
Outside diameter at the large end	D_0	153.2 in
Inside diameter at the large end	D	150.1 in
Outside diameter at the small end	D_s	94 in
Cone length	L	76.91 in
Weld joint efficiency (or Cast Quality Factor)	E	1
Material		
Allowable stress	S	20000 psi



ASME BPVC VIII-1 2023

PTB-4-2021 / E4.3.1; E4.3.2; E4.3.3; E4.3.4; E4.3.5

Calculation

Required thickness		t	1.446 in
incl. allowances (t _e)	1.573 in	t+	1.571 in
Allowable excess pressure incl. hydrost. head		P	356.4 psi
Allowable excess pressure without hydrostatic Head		MAWP	356.4 psi

Remark

Geometrical conditions

valid

Strength condition

Wall thickness acceptable

For calculation of openings according to UG-37(a) in nomenclature for t_r

Design diameter according to UG-37(a):tr(b)	D ₁	in
Required thickness	t(E=1)	in

Equations according to UG-32(g)

$$\cos(\alpha) = \cos(\alpha) \Leftrightarrow \cos(21.04^\circ) = 0.9333$$

$$D = D_0 - 2 \cdot \frac{t_0}{\cos(\alpha)} = 3891 \text{ mm} - 2 \cdot \frac{36.78 \text{ mm}}{0.9333} = 3812 \text{ mm}$$

$$t = \frac{P_0 \cdot D}{2 \cdot \cos(\alpha) \cdot (S \cdot E - 0.6 \cdot P_0)} = \frac{2.455 \text{ MPa} \cdot 3812 \text{ mm}}{2 \cdot 0.9333 \cdot (137.9 \text{ MPa} \cdot 1 - 0.6 \cdot 2.455 \text{ MPa})} = 36.74 \text{ mm}$$

$$P = \frac{2 \cdot S \cdot E \cdot t_0 \cdot \cos(\alpha)}{D + 1.2 \cdot t_0 \cdot \cos(\alpha)} = \frac{2 \cdot 137.9 \text{ MPa} \cdot 1 \cdot 36.78 \text{ mm} \cdot 0.9333}{3812 \text{ mm} + 1.2 \cdot 36.78 \text{ mm} \cdot 0.9333} = 2.457 \text{ MPa}$$

Rem.: App.1-5(d) or (e) indicates if a reinforcement ring is required.



ASME BPVC VIII-1 2023

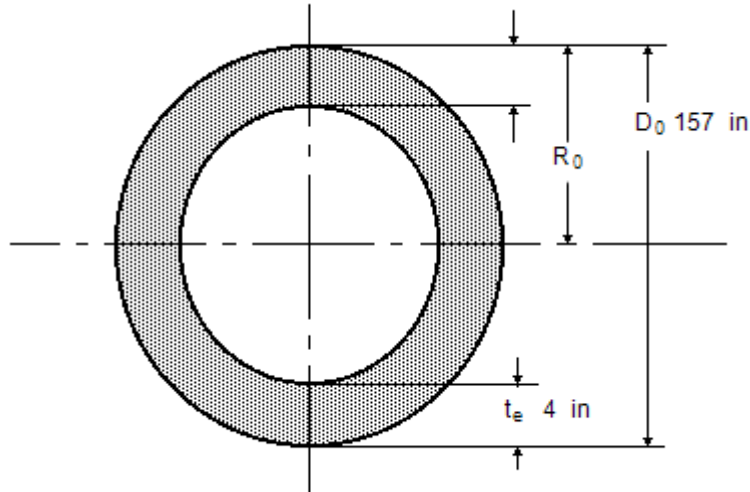
PTB-4-2021 / E4.3.1; E4.3.2; E4.3.3; E4.3.4; E4.3.5

E4.3.3 - Thickness of spherical shells under internal pressure - ASME BPVC VIII-1 UG-27 & Appendix-1: 2023

Spherical shells

Design pressure
Hydrostatic head
Calculation pressure
Calculation temperature

p_D 2080 psi
 D_p 0 psi
 P_0 **2080** psi
 T_0 454.4 °C



Outside diameter
Design wall thickness
Wall thickness allowance
Allowance (corrosion)
Weld joint efficiency (or Cast Quality Factor)

D_0 157 in
 t_e 4 in
 c_1 0 in
 c_2 0 in
 E 1 -

Material K31835-SA-542-D-Class:4a-Size:

Allowable stress

S **21000** psi

Results

Outside radius
Effective thickness

R_0 **78.5** in
 t_0 **4** in

Calculation as thin shell is applicable

Required thickness

$t(R_0)$

JA
 $t(R)$

thin shell acc. UG-27

3.739 in

3.726 in

thick shell (not applicable)

3.793 in

3.782 in

Minimum wall thickness without condition acc. UG-16

Minimum wall thickness acc. UG-16

Minimum $t = \text{Max}\{\text{Min}[t_R, t_{R0}], t_{UG-16}\}$
with allowances

t_{UG-27} **3.726** in

t_{UG-16} 0.05906 in

t **3.726** in

$t+c_1+c_2$ **3.726** in

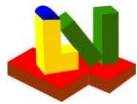
Allowable excess pressure

P **2231** psi

Allowable excess pressure without hydrostatic head

MAWP **2231** psi

Remark



For calculation of openings according to UG-37

Minimum required thickness for openings

$$t(E=1) \quad 3.726 \text{ in}$$

Allowable unreinforced opening diameter d for welded, brazed, and flued connections acc. UG 36(c)3

$$d \leq 89 \text{ mm for } t \leq 10 \text{ mm}$$

or

$$d \leq 3 \frac{1}{2} \text{ in for } t \leq \frac{3}{8} \text{ in}$$

$$d \leq 60 \text{ mm for } t > 10 \text{ mm}$$

or

$$d \leq 2 \frac{3}{8} \text{ in for } t > \frac{3}{8} \text{ in}$$

Equations

$$R_0 = \frac{D_0}{2} = \frac{3988 \text{ mm}}{2} = 1994 \text{ mm}$$

$$94.65 \text{ mm} = 94.65 \text{ mm} + 0 \text{ mm} + 0 \text{ mm}$$

corroded inside
radius

$$R = R_0 - t_0 = 1994 \text{ mm} - 101.6 \text{ mm} = 1892 \text{ mm}$$

1) Thin shell For

$$P_0 \leq 0.665 \cdot S \cdot E \Leftrightarrow 14.34 \text{ MPa} \leq 97.29 \text{ MPa}$$

and

$$t_e \leq 0.356 \cdot (R_0 - t_e) \Leftrightarrow 101.6 \text{ mm} \leq 673.7 \text{ mm}$$

with the inside radius R

$$t(R) = \frac{P_0 \cdot R}{2 \cdot S \cdot E - 0.2 \cdot P_0} = \frac{14.34 \text{ MPa} \cdot 1892 \text{ mm}}{2 \cdot 144.8 \text{ MPa} \cdot 1 - 0.2 \cdot 14.34 \text{ MPa}} = 94.65 \text{ mm}$$

UG-27 (3)

$$P(R) = \frac{2 \cdot S \cdot E \cdot t_0}{R + 0.2 \cdot t_0} = \frac{2 \cdot 144.8 \text{ MPa} \cdot 1 \cdot 101.6 \text{ mm}}{1892 \text{ mm} + 0.2 \cdot 101.6 \text{ mm}} = 15.38 \text{ MPa}$$

UG-27 (3)

or with the outside radius R_0

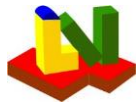
$$t(R_0) = \frac{P_0 \cdot R_0}{2 \cdot S \cdot E + 0.8 \cdot t_0} = \frac{14.34 \text{ MPa} \cdot 1994 \text{ mm}}{2 \cdot 144.8 \text{ MPa} \cdot 1 + 0.8 \cdot 14.34 \text{ MPa}} = 94.98 \text{ mm}$$

App. 1-1 (2)

$$P(R_0) = \frac{2 \cdot S \cdot E \cdot t_0}{R_0 - 0.8 \cdot t_0} = \frac{2 \cdot 144.8 \text{ MPa} \cdot 1 \cdot 101.6 \text{ mm}}{1994 \text{ mm} - 0.8 \cdot 101.6 \text{ mm}} = 15.38 \text{ MPa}$$

App. 1-1 (2)

$$\text{Log}(x) = \text{Ln}(x)$$



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PTB-4-2021 / E4.3.1; E4.3.2; E4.3.3; E4.3.4; E4.3.5

E4.3.4 - Torispherical heads (Kloepper, Korbogen, Semi-spherical) under internal pressure - ASME BPVC VIII-1 UG-32 & Appendix-1: 2023

Type of head

(1=Kloepper-, 2=Korbogen-, 3=Torispherical, 4=Hemispherical,
5=Elliptical 2:1)

3

Torispherical

Design pressure

p_D

136 psi

Hydrostatic head

D_p

0 psi

Calculation pressure

p_0

0.9377 MPa

Calculation temperature

T_0

650 °F

Final wall thickness

t_e

0.625 in

Wall thickness allowance

c_1

0 in

Allowance (corrosion)

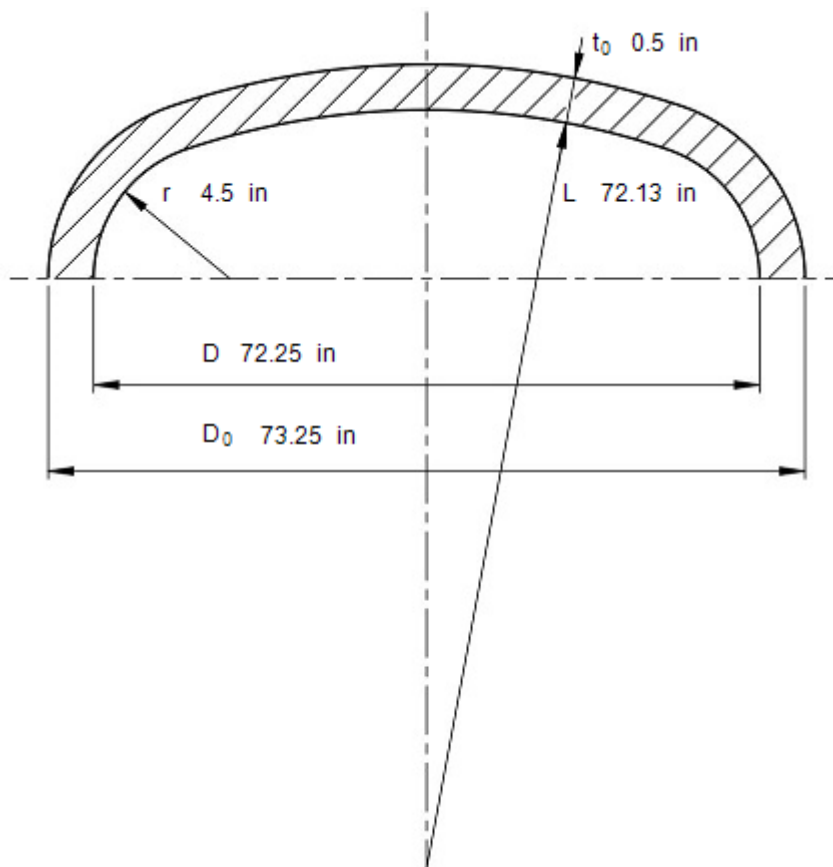
c_2

0.125 in

Effective thickness without allowances

t_0

0.5 in



Outside diameter of cylindrical shell

D_0

73.25 in

Inside diameter of cylindrical shell

(= $D_0 - 2t_0$)

D

72.25 in

Outside crown radius

L_0

72.63 in

Outside crown radius with allowances

L_1

72.75 in

Inside crown radius

(= $L_0 - t_0$)

L

72.13 in

Knuckle radius

r

4.5 in

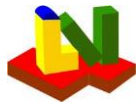
Weld joint efficiency (or Cast Quality Factor)

E

1

Material data

Material K11789-SA-387-11-Class:1-Size:



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PTB-4-2021 / E4.3.1; E4.3.2; E4.3.3; E4.3.4; E4.3.5

Elasticity modulus	E_T	2.66e+7	psi
Elastic limit	S_y	26948	psi
Reduce allowable*) stress for $R_{m20} > 485$ MPa?	Yes		(Yes/No)
Tensile strength at 20°C	R_{m20}	60190	psi
Allowable stress			
at working temperature acc. ASME-table	S_T	17100	psi
at 20°C	S_{20}	17114	psi
acc. UG-32(d) or endnote 90	S	17100	psi

) According to App. 1-4(c,d), the allowable stress must be reduced to $138 \cdot S_T / S_{20}$ (=20 ksi...) for $R_{m20} > 485$ MPa (70 ksi).

Calculation

Ratio	L/r	16.03
Factor	M	1.751
Required thickness without allowance	t	0.5026 in
incl. allowances (t_e 0.625 in $\geq t$)	t_+	0.6276 in
Allowable excess pressure incl. hydrost. head	P	135.3 psi
Allowable excess pressure without hydrostatic Head	MAWP	135.3 psi

Geometrical conditions
valid

Strength condition
Final wall thickness 15,875 < 15,940328 = required thickness

Required thickness for openings acc. to UG-37(a) in nomenclature for t_r

Using UG-32 with $E=1$	$t(E=1)$	0.5026 in
acc. section (a) in the crown region	$t_1(E=1)$	0.287 in

Allowable unreinforced opening diameter d for welded, brazed, and flued connections acc. UG 36(c)3

$d \leq 89$ mm (3.5 in.) for $t \leq 10$ mm (3/8 in.)
 $d \leq 60$ mm (2 3/8 in.) for $t > 10$ mm (3/8 in.)

Remark

Equations

$$t = \frac{P_0 \cdot L \cdot M}{2 \cdot S \cdot E - 0.2 \cdot P_0} = \frac{0.9377 \text{ MPa} \cdot 1832 \text{ mm} \cdot 1.751}{2 \cdot 117.9 \text{ MPa} \cdot 1 - 0.2 \cdot 0.9377 \text{ MPa}} = 12.77 \text{ mm}$$

$$P = \frac{2 \cdot S \cdot E \cdot t_0}{L \cdot M + 0.2 \cdot t_0} = \frac{2 \cdot 117.9 \text{ MPa} \cdot 1 \cdot 12.7 \text{ mm}}{1832 \text{ mm} \cdot 1.751 + 0.2 \cdot 12.7 \text{ mm}} = 0.9329 \text{ MPa}$$



ASME BPVC VIII-1 2023

PTB-4-2021 / E4.3.1; E4.3.2; E4.3.3; E4.3.4; E4.3.5

For openings in the crown region with

Opening diameter

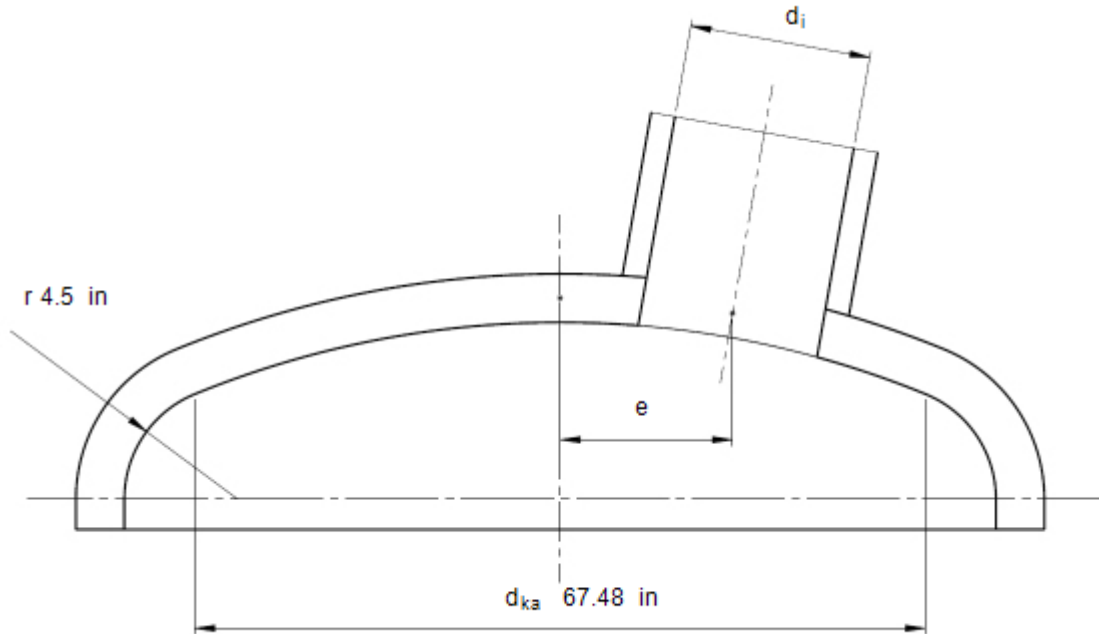
d_i

in

Distance between opening center and head center

e

in



Available reinforcement width acc. UG37

Available reinforcement width of the crown

b'

in

Diameter of the crown region

d_{ka}

67.48 in

Angle of the knuckle region

ϕ

62.24 °

Arc length of the knuckle region

b''

5.567 in

$$d_{ka} = (2 \cdot L + t_e) \cdot (D/2 - r) / (L - r)$$

$$\phi = \arccos((D/2 - r) / (L - r))$$

$$b' = (d_{ka} - d_i) / 2 - e$$

$$b'' = (r + t_e) \cdot \phi$$



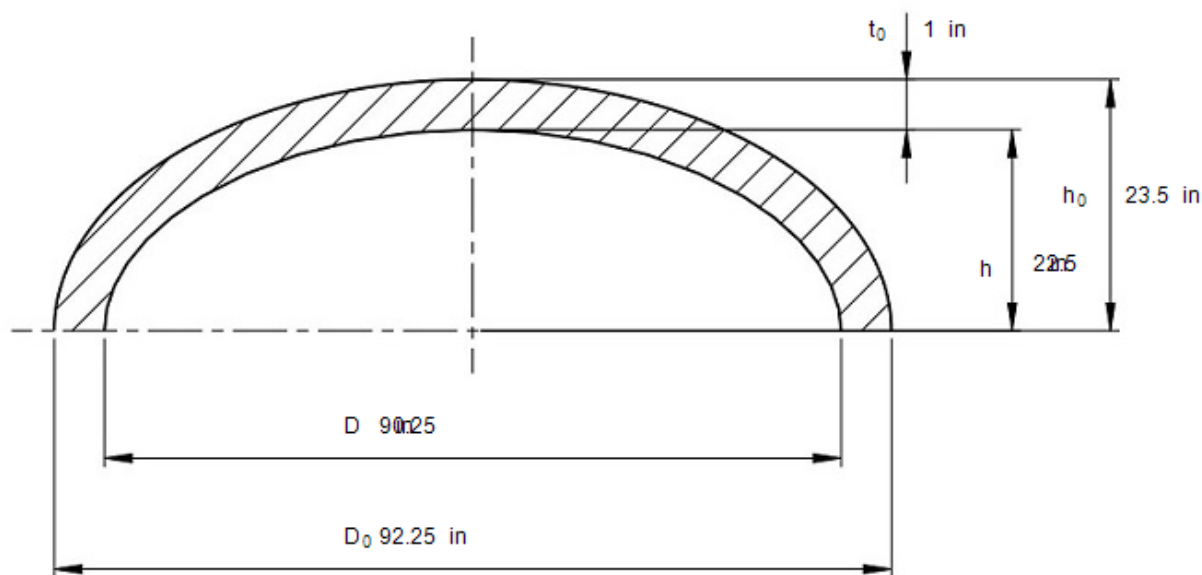
ASME BPVC VIII-1 2023

PTB-4-2021 / E4.3.1; E4.3.2; E4.3.3; E4.3.4; E4.3.5

E4.3.5 - Elliptical heads under internal pressure - ASME BPVC VIII-1 UG-32 & Appendix-1: 2023

Ellipsoidal heads acc. UG-32(c) and Appendix 1-4(f)

Design pressure	p_D	442.2 psi
Hydrostatic head	D_p	0 psi
Calculation pressure	p_0	3.049 MPa
Calculation temperature	T_0	300 °F
Final wall thickness	t_e	1.125 in
Wall thickness allowance	c_1	0 in
Allowance (corrosion)	c_2	0.125 in
Effective thickness without allowances	t_0	1 in



Outside diameter of cylindrical shell	D_0	92.25 in
Inside diameter of cylindrical shell (= $D_0 - 2t_0$)	D	90.25 in
Outer height of head	h_0	23.5 in
Inside depth of head (minor semi-axis = $h_0 - t_0$)	h	22.5 in
Weld joint efficiency (or Cast Quality Factor)	E	1

Material data

Material	K02700-SA-516-70-Class:-Size:	
Elasticity modulus	E_T	2.829e+7 psi
Elastic limit	S_y	33668 psi
Reduce allowable*) stress for $R_{m20} > 485$ MPa?	Yes	(Yes/No)
Tensile strength at 20°C	R_{m20}	70343 psi
Allowable stress		
at working temperature acc. ASME-table	S_T	20015 psi
at 20°C	S_{20}	20000 psi
acc. UG-32(c) or App. 1-4(c)	S	20015 psi
*) According to App. 1-4(c,d), the allowable stress must be reduced to $138 * S_T / S_{20}$ (=20 ksi*...) for $R_{m20} > 485$ MPa (70 ksi).		

Results

Ratio	$D/2h$	2
Factor	K	1
Factor K_1 acc. Table UG-37	K_1	0.9
Required thickness	t	0.9992 in
incl. allowances (t_e 1.125 in $\geq t$)	t_+	1.124 in
Allowable excess pressure incl. hydrostatic Head	P	442.6 psi
Allowable excess pressure without hydrostatic Head	MAWP	442.6 psi



ASME BPVC VIII-1 2023

PTB-4-2021 / E4.3.1; E4.3.2; E4.3.3; E4.3.4; E4.3.5

Required thickness for openings acc. to UG-37(a) in nomenclature for t_r

Using UG-32 with $E=1$

Section (c) in the centre circle ($< 0.8 \cdot D$)

Equivalent spherical outside diameter $2 \cdot (K_1 \cdot D + t_E)$

$t(E=1)$ **0.9992** in

$t_1(E=1)$ **0.8993** in

D_s **164.7** in

Geometrical conditions

valid

Strength

Wall thickness acceptable

Allowable unreinforced opening diameter d for welded, brazed, and flued connections acc. UG 36(c)3

$d \leq 89 \text{ mm (3.5 in.)}$ for $t \leq 10 \text{ mm (3/8 in.)}$

$d \leq 60 \text{ mm (2 3/8 in.)}$ for $t > 10 \text{ mm (3/8 in.)}$

Remark

Equations according to UG-32

$$t = \frac{P_0 \cdot D \cdot K}{2 \cdot S \cdot E - 0.2 \cdot P_0} = \frac{3.049 \text{ MPa} \cdot 2292 \text{ mm} \cdot 1}{2 \cdot 138 \text{ MPa} \cdot 1 - 0.2 \cdot 3.049 \text{ MPa}} = 25.38 \text{ mm}$$

$$P = \frac{2 \cdot S \cdot E \cdot t_0}{K \cdot D + 0.2 \cdot t_0} = \frac{2 \cdot 138 \text{ MPa} \cdot 1 \cdot 25.4 \text{ mm}}{1 \cdot 2292 \text{ mm} + 0.2 \cdot 25.4 \text{ mm}} = 3.051 \text{ MPa}$$