

**1513.0120 NEW CONSTRUCTION, REPAIRS, ALTERATIONS, AND ORIGINAL TEST OF CONTAINERS, OTHER THAN REFRIGERATED STORAGE TANKS.**

Subpart 1. **Construction and testing.** Containers used with systems covered in parts 1513.0300 to 1513.0380, 1513.0700 to 1513.0830, and 1513.1000 to 1513.1070 must be made of steel or other material compatible with ammonia, and tested in accordance with the current ASME code. An exception to the ASME code requirements is that construction under Table UW 12 at a basic joint efficiency of under 80 percent is not authorized.

Subp. 2. **Additional requirements.** Containers designed and constructed in accordance with the ASME code, other than refrigerated storage containers, shall comply with the additional requirements in items A to C.

A. The entire container must be post weld heat treated after completion of all welds in or to the shells and heads. The method employed must be as prescribed in the ASME code, except that provisions for extended time at lower temperature for post weld heat treatment are not permitted. Implements of husbandry do not require post weld heat treatment if they are fabricated with hot formed heads or with cold formed heads that have been stress relieved.

B. Welded attachments to pads may be made after post weld heat treatment.

C. Steels used in fabricating pressure containing parts of a container must not exceed a specified tensile strength of 70,000 psi (does not apply to parts 1513.0600 to 1513.0640, 1513.0700 to 1513.0830 and 1513.0900 to 1513.0930), except implements of husbandry may be fabricated from steel having a specified tensile strength of 75,000 psi.

Subp. 3. **Inspectors.** All containers, except refrigerated storage tanks with a design pressure of 15 psig and less, and cylinders and containers covered in parts 1513.0600 to 1513.0710 must be inspected by a person who holds a valid National Board commission as a commissioned inspector or as an owner-user inspector as defined in the National Board Inspection Code.

Subp. 4. **Certified welder.** Welding for the repair or alteration of a pressure container must be performed in compliance with the applicable provisions of the current edition of the National Board Inspection Code. All repair or alteration must conform to the ASME code section and edition to which the container was constructed.

**Statutory Authority:** *MS s 18C.121*

**History:** *21 SR 277*

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