

WATER TANKS

FOR PRIVATE
FIRE PROTECTION

1976



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See Inside Back Cover for Official NFPA Definitions

SC-AM-76

Standard for
Water Tanks for Private Fire Protection

NFPA 22-1976

This Standard was adopted by the National Fire Protection Association in its present form at the NFPA Annual Meeting, May 17-20, 1976, on recommendation of the NFPA Committee on Water Tanks. It amends Standard for Water Tanks for Fire Protection, NFPA 22-1974.

Changes other than editorial are denoted by a vertical line in the margin of the pages in which they appear.

Origin and Development of NFPA 22

In 1909, the NFPA Committee on Gravity Tanks presented a Standard on Gravity Tanks which, with amendments considered in 1912 and 1913, was adopted in 1914. Revised or amended editions were adopted in 1915, 1917, 1918, 1919, 1922, 1926, 1928, 1930, 1931, 1933, 1936, 1941, 1949 and 1950.

The Committee name was changed to the Committee on Water Tanks and their recommendations resulted in changes, adopted in 1957, 1958, 1962, 1965, 1967, 1970, 1971 and 1974.

Tanks other than gravity (including at that time concrete reservoirs) and valve pits were first covered in 1913, pressure tanks (formerly covered by Standards for Sprinkler Systems) in 1915, and tank heating in 1922. The title has been amended from time to time.

The 1974 edition of this Standard was approved by the American National Standard Institute as an American National Standard and designated Z278.1-1974. The 1976 edition will be submitted for similar approval.

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This list represents the membership at the time the Committee was balloted on the text of this edition. Since that time, changes in the membership may have occurred.

Interpretation Procedure of the Committee on Water Tanks

Those desiring an interpretation shall supply the Chairman with five identical copies of a statement in which shall appear specific reference to a single problem, paragraph, or section. Such a statement shall be on the business stationery of the inquirer and shall be duly signed.

When applications involve actual field situations they shall so state and all parties shall be named.

The Interpretations Committee will reserve the prerogative to refuse consideration of any application that refers specifically to proprietary items of equipment or devices. Generally inquiries should be confined to interpretation of the literal text or the intent thereof.

Requests for interpretations should be addressed to the National Fire Protection Association, 470 Atlantic Avenue, Boston, MA. 02210.

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Standard for
Water Tanks for Private Protection

NFPA 22-1976

NOTICE

An asterisk (*) preceding the number or letter designating a paragraph indicates explanatory material on that paragraph in Appendix.

Chapter 1 Introduction

1-1 Scope.

1-1.1 The design, construction, installation, and maintenance of tanks and accessory equipment supplying water for private fire protection, including gravity, suction, and pressure tanks, towers, foundations, pipe connections and fittings, valve enclosures, tank filling and protection against freezing.

1-2 Purpose. The purpose of this standard is to provide a basis for the design, construction, operation and maintenance of water tanks for private fire protection.

1-3 Types of Tanks. This standard covers elevated tanks on towers or building structures; grade or below grade water storage tanks and pressure tanks.

1-4 Capacity and Elevation.

1-4.1 The size and elevation of the tank shall be determined by conditions at each individual property after due consideration of all factors involved. Where tanks are to supply sprinklers see separately published standards as follows, but not limited to *Standard for the Installation of Sprinkler Systems, NFPA 13-1975, Sections 2-4, 2-5, 2-6.*

1-4.2 Whenever possible, standard sizes of tanks and heights of towers shall be used as given in *2-1.3, 3-1.2, 4-1.3 and 5-2.1.*

1-5 Location of Tanks.

1-5.1 The location chosen shall be such that the tank and structure will not be subject to fire exposure from adjacent buildings. If lack of yard room makes this impracticable, the exposed steel work shall be suitably fireproofed or protected by open sprinklers. (*See A-7-1.1.*) Fireproofing where necessary shall include steel work within 20 feet of combustible buildings or windows and doors from which fire might issue.

1-5.2 When steel or iron is used for supports inside the building near combustible construction or occupancy, it shall be fireproofed inside the building, six feet above combustible roof coverings and within 20 feet of windows and doors from which fire might issue. (See A-7-1.1.) Steel beams or braces joining two building columns, which support a tank structure, shall also be suitably fireproofed when near combustible construction or occupancy. Interior timber shall not be used to support or brace tank structures.

1-5.3 Fireproofing where required shall have a fire resistance rating of not less than two hours.

1-5.4 Foundations or footings shall furnish adequate support and anchorage for the tower.

1-5.5 If the tank or supporting trestle is to be placed on a building, the building shall be designed and built to carry the maximum loads.

1-6 **Tank Materials.** Types of materials include steel, wood, concrete, and embankment-supported rubberized fabric. The elevated wood and steel tanks are supported on steel or reinforced concrete towers.

1-7 **Welding.** Steel gravity and suction tanks and steel plate risers should preferably be of welded construction and the joint design and the welding shall fully conform to the current edition of the *American Water Works Association Standard for Steel Tanks, Standpipes, Reservoirs, and Elevated Tanks for Water Storage, AWWA D100-73, AWS D5.2-73*, and that the tank builder presents to the authority having jurisdiction evidence fully satisfactory to the authority that said rules have been complied with. The authority may accept a written certificate from the builder as evidence that said rules have been complied with or may require a certificate from a qualified consulting engineer or commercial testing laboratory. In either case the certificate shall be supplemented with evidence satisfactory to the authority that the said rules have been complied with in the following four particulars:

1-7.1 That all welding procedures used have been qualified in accordance with the current edition of the *American Water Works Association Standard for Steel Tanks, Standpipes, Reservoirs, and Elevated Tanks, for Water Storage, AWWA D100-73, AWS D5.2-73*. The evidence of such qualification should be presented in the form of a report bearing proper witness certification of a reputable testing laboratory.

1-7.2 That all welding operators employed on the job were qualified in accordance with the current edition of the *American Water Works Association Standard for Steel Tanks, Standpipes, Reservoirs, and Elevated Tanks, for Water Storage, AWWA D100-73, AWS D5.2-73*.

1-7.3 That welded joints have been tested by the sectioning or radiographic methods as required by the *American Water Works Association Standard for Steel Tanks, Standpipes, Reservoirs, and Elevated Tanks, for Water Storage, AWWA D100-73, AWS D5.2-73*.

1-7.4 That the tank has been subjected to the required hydrostatic test.

1-8 Bolting. Bolted steel construction has been employed for tanks in some cases where special conditions make it desirable. In all such cases, however, the work shall be handled only by experienced contractors who are able to give assurance that careful workmanship and expert supervision will be employed and who will provide a bond guaranteeing the watertightness of the tank for a number of years.

1-9 Workmanship.

1-9.1 It is expected that manufacturers of approved structures shall follow not only the letter but the spirit of this standard, employing their experience and ability to make structures which shall prove reliable under all specified conditions; also, that they shall replace all parts which may be found defective from faulty materials or workmanship, or that are not in accordance with this standard.

1-9.2 The introduction of welding for tank structures makes impossible the simple checking in the field by an inspector, after completion of a structure, of important details such as the thickness of butt-welded plates in tanks and tubular columns; the appearance of welding in tank plates when a balcony is omitted, and in tubular columns and at struts except near the ladder and base of the structure; and the extent of inaccessible dents and out-of-roundness of tubular columns and struts.

1-9.3 It is, therefore, of utmost importance during shop fabrication and field erection that careful inspection be provided by the contractors' representatives.

1-10 Plans. The contractor shall furnish stress sheets and plans required by the purchaser and the authority having jurisdiction for approval or for obtaining building permits and licenses for erection of the structure.

1-11 Engineer's Authority.

1-11.1 The engineer shall have the power to reject materials and workmanship which do not conform to this standard, but in case of dispute, the contractor may appeal to the authority having jurisdiction.

1-11.2 **Rejection.** The acceptance of any material or finished members by the engineer shall not be a bar to their subsequent rejection if they are found to be defective. Rejected material and workmanship shall be replaced promptly or made good by the contractor.

1-11.3 **Facilities for Inspection.** Material and workmanship shall at all times be subject to the inspection of engineers representing the purchaser.

1-12 Tank Contractor Responsibility.

1-12.1 Upon completion of a tank construction contract, and having tested the tank and made it watertight, the tank contractor shall notify the authority having jurisdiction so that the tank can be inspected and given the formal approval necessary.

1-12.2 **Cleaning Up.** Upon completion of the work, the contractor shall remove or dispose of all rubbish and other unsightly material caused by his operations, and shall leave the premises in as good condition as he found them.

1-13 Inspection of Completed Equipment.

1-13.1 A joint inspection of the tank shall be made by a representative of the tank contractor and a representative of the owner prior to placing the tank in service.

1-13.2 Written reports of these inspections shall be made in triplicate and a copy signed by the contractors and the owners shall be sent to the authority having jurisdiction.

1-14 **Attachments to Tank Structures.** Tank structures shall not be employed to support signs, flagpoles, steel stacks, etc., unless particularly designed for the purpose.

1-15 **Lightning Protection.** To prevent lightning damage to tanks, protection shall be installed to conform to paragraph 2210 of *Lightning Protection Code, NFPA 78-1975*.

1-16 Care and Maintenance.

1-16.1 No waste material, such as boards, roofing, paint cans, etc., shall be left in the tank or in the space at the top of the tank since it may get into the water and obstruct the piping.

1-16.2 The hatch covers in the roofs and the door at the top of the frostproof casing shall always be kept securely fastened with substantial catches as a protection against freezing and windstorm damage.

1-16.3 Ice which may cause injury to personnel or damage to property shall not be allowed to collect in or on any part of the tank or structure.

1-16.4 Bases of the tower columns shall be kept free from dirt and rubbish which would otherwise permit the accumulation of moisture with consequent corrosion. The tops of foundation piers shall always be at least 6 inches above the ground level.

1-16.5 Coal or ashes or combustible material or construction of any kind shall not be piled near the columns. This may cause failure of the steel work due to fire, heating or corrosion. The tank site shall be kept cleared of weeds and brush.

1-16.6 Examination of all points, including the inside of steel tanks without corrosion protection (*see A-2-7.13*) and the hoops and grillage of a wood tank, shall be made at least once in two years. Steel work without corrosion protection shall be kept painted to prevent the formation of rust. Frequent repainting may be necessary when the paint is exposed to conditions causing rapid disintegration.

1-16.7 Before repainting, the surface shall be thoroughly dried and all loose paint, rust, scale and other surface contamination shall be removed. After proper surface preparation, the original paint system shall be restored. It may be necessary or economical to repaint the entire inside surface. On the exterior, normal maintenance will involve local patching and periodic application of one complete finish coat when the preceding has weathered thin or for improved appearance after patching.

1-16.8 The painters shall not allow any scrapings or other foreign material to fall down the riser or outlet. If the opening is covered for protection, only a few sheets of paper tied over the end of the settling-basin-stub shall be used. The paper shall be removed upon the completion of the job.

1-16.9 If corrosion protection is maintained in a steel tank, (*see A-2-7.13*) the tank shall be cleaned often enough to prevent sediment and scale from entering the discharge pipe.

1-16.10 Repairs to the interior of the tank shall not be made with materials that may become dislodged and obstruct the outlet pipe. The authority having jurisdiction shall always be notified in advance when and for how long the tank is to be out of service.

Chapter 2 Steel Gravity and Suction Tanks

2-1 General.

2-1.1 This chapter applies to the design, fabrication, and erection of steel gravity water tanks, including pump suction tanks.

2-1.2 Capacity. The capacity of the tank is the number of U. S. gallons available above the outlet opening. The net capacity between the outlet opening of the discharge pipe and the inlet of the overflow shall be at least equal to the rated capacity. For gravity tanks with large plate risers, the capacity shall be the number of U. S. gallons between the inlet of the overflow and the designated low-water level line.

2-1.3 Standard Sizes. The standard sizes of steel tanks are: 5,000, 10,000, 15,000, 20,000, 25,000, 30,000, 40,000, 50,000, 60,000, 75,000, 100,000, 150,000, 200,000, 300,000, and 500,000 U. S. gallons net capacity. Tanks of other sizes are built occasionally.

2-1.4 Form. Steel tanks may be of any form desired provided they conform to this standard throughout.

2-1.5 Strength. The material as specified shall be without defects affecting its strength or service. The workmanship shall be good, so that defects or injuries are not produced during manufacture or erection. Unit stresses as specified shall not be exceeded. This structure and its details shall possess the requisite strength and rigidity.

2-2 Materials.

2-2.1 Plates, Shapes and Tubular Columns.

2-2.1.1 Plates. Plate materials shall be open hearth, electric furnace, or basic oxygen process steel conforming to the following ASTM Specifications: A36-75a; A283-75a, Grades A, B, C, and D; except that when plates of thickness greater than $\frac{3}{4}$ in. are used, A283-75a, Grade D steels shall not be specified; or A113-75a, Grade C (cold pressing plates); as alternatives A285-74a, Grades A, B, and C; A516-74a, Grades 55 and 60; A442-74a, Grades 55 and 60 or A131-75, Grades A, B, and C may be used.

2-2.1.2 Basis of Furnishing Plates. Plates may be furnished on the weight basis with permissible underrun and overrun according to the tolerance table for plates ordered to weight published in ASTM Specification A6-75.

2-2.1.3 Shapes. Structural materials shall be open hearth, electric furnace, or basic oxygen process steel conforming

to ASTM A36-75a; A113-75a, Grades A and B; or A131-75, Grades A, B, and D.

2-2.1.4 Tubular Columns. Steel pipe may be used as tubular columns or other structural members provided it complies with specifications ASTM A139-74, Grade B; ASTM A53-73a, Type E or S, Grade B; API Standard 5L, Grade B and providing the minimum wall thickness of any such material shall comply with the design requirements and the minimum thickness requirement of this standard. For the purposes of this standard, the allowable underrun shall be subtracted from the nominal wall thickness when calculating the minimum pipe wall thickness. Tubular sections shall not be flattened to form end connections.

2-2.1.5 Copper-bearing steel with content of about 0.20 percent copper may be used. In other particulars the steel shall conform to the specifications enumerated above.

2-2.2 Bolts, Anchor Bolts and Rods. Bolts and Anchor bolts shall conform to the latest revision of ASTM Specification A307-68, Grades A or B. ASTM A36-75a shall be considered an acceptable alternate material for anchor bolts. Rods shall be open hearth, electric furnace, or basic oxygen process steel, conforming to the latest revision of ASTM A36-75a.

2-2.3 Forgings. Forgings shall conform to the following current Specifications of the American Society for Testing and Materials. Steel shall be made only by the open-hearth process.

Plate Forgings—A283-74a and A285-74a—Class C.

Forgings, other than plate—A668-72—Class B.

Forged and Rolled Pipe Flanges—A181-68—Grade I.

2-2.4 Castings. Castings shall conform to current ASTM Specifications A27-73, Grade 60-30 full annealed.

2-2.5 Reinforcing Steel. Reinforcing steel shall comply with the latest revision of the ASTM Specification A615-75, Grade 40 or Grade 60.

2-2.6 Filler Metal Electrodes. Manual, shielded metal-arc-welding electrodes shall conform to requirements of AWS A5.1-69 Specifications for Mild Steel Covered Arc-Welding Electrodes. Electrodes shall be any E60XX or E70XX Classification suitable for the electric current characteristics, the position of welding and other conditions of intended use. Electrodes for other welding processes shall conform to applicable AWS Specifications for Filler Metal.

2-3 Loads.

2-3.1 Dead Load. The dead load shall be the estimated weight of all permanent construction and fittings. The unit weight of steel shall be considered 490 pounds, and of concrete, 144 pounds per cubic foot.

2-3.2 Live Load. Under normal conditions, the live load shall be the weight of all the liquid when overflowing the top of the tank. The unit weight of water shall be considered as 62.4 pounds per cubic foot. Proper provisions must be made for temporary stresses during erection. When roofs have a slope of less than 30 degrees, they shall be designed to support a uniform weight of 25 pounds per square foot on the horizontal projection.

2-3.3 Wind Load. Under normal conditions the wind load or pressure shall be assumed to be 30 pounds per square foot on vertical plane surfaces, 18 pounds per square foot on projected areas of cylindrical surfaces and 15 pounds per square foot on projected areas of conical and double curved plate surfaces. When designing for wind velocities over 100 miles per hour, all above-mentioned unit pressures shall be adjusted in proportion to the square of the velocity assuming that the above pressures are for 100 miles per hour.

2-3.4 Earthquake Load. Tanks shall meet local requirements for resisting earthquake damage.

2-3.5 Balcony and Ladder Loads. A vertical load of 1,000 pounds shall be assumed to be applied to any 10 square feet of area on the balcony floor and on each platform; 500 pounds applied to any 10 square feet area on the tank roof; 350 pounds on each vertical section of ladder; and all of the structural parts and connections shall be designed to withstand such loads. The above loadings need not be combined with snow loading.

2-4 Unit Stresses.

2-4.1 General. The maximum stresses in pounds per square inch produced by the foregoing loads or any combination of them, shall not exceed the values in Table 2-4.1.

2-4.2 Stress Increases. When wind or earthquake loads are considered in calculating stresses, the permissible working unit stresses may be increased 25 percent, provided that the resulting section is not less than that required for dead and live loads alone; however, in the design of concrete foundations the increase may be 33.3 percent. Wind and earthquake loads need not be considered simultaneously.

Table 2-4.1

Tension: On net section, Rolled Steel	15,000
Tension: Anchor bolts	15,000
Bending:	
Tension on extreme fibers, except column base plates	15,000
Column base plates	20,000
Compression on extreme fibers of rolled sections, and plate girders and built-up members for values of:	
ld	
— not in excess of 600	15,000
bt	
ld	9,000,000
— in excess of 600	<u>ld</u>
bt	<u>bt</u>
in which l is the unsupported length and d the depth of the member; b is the width; and t the thickness of its compression flange; all in inches; except that l shall be taken as twice the length of the com- pression flange of a cantilever beam not fully stayed at its outer end against translation or rotation.	
Pins, extreme fiber	22,500
Cast steel	11,250

2-5 Details of Design.

2-5.1 Minimum Thickness. The minimum thickness for any part of the structure shall be $3/16$ inch for parts not in contact and $1/4$ inch for parts in contact with water contents. The controlling thickness of rolled shapes for the purposes of the foregoing stipulations shall be taken as the mean thickness of the flanges, regardless of web thickness. The minimum thickness for tubular columns and struts shall be $1/4$ inch. Round or square bars used for wind bracing shall have a minimum diameter or width of $3/4$ inch. Bars of other shapes, if used, shall have a total area at least equal to a $3/4$ inch round bar.

2-5.1.1 Tanks with diameters of 120 feet to 200 feet inclusive shall have a minimum shell thickness of $5/16$ inch; tanks more than 200 feet in diameter shall have a minimum shell thickness of $3/8$ inch.

2-5.2 Thickness for Corrosion. Interior bracing required to support the water content, if unavoidable, shall always have $1/16$ -inch additional thickness added to the calculated sections. The sections shall be open to facilitate cleaning and painting, except in the case of tubular sections which must be hermetically sealed to prevent internal corrosion. The plates of tanks to contain salt, or alkaline water shall be $1/16$ -inch thicker than calculated.

2-5.3 Thickness of Tank Plates. Tank plates shall be designed on the basis of the following maximum membrane tensile stresses which shall be reduced for the joint efficiencies set forth

2-5.5 Accessibility of Bottoms. Grillages shall be designed so that the tank bottom and beams will be accessible for inspection and painting.

2-5.6 Net Sections. Net sections shall be used in calculating the tensile stress in plates and members.

2-5.7 Load Location. In calculating the thickness of plates (except as specified in 2-5.3) stressed by the weight or pressure of the tank contents, the pressure at the lower edge of each ring shall be assumed to act undiminished on the entire area of the ring. In welded tanks the longitudinal joints in adjacent circumferential courses may be either staggered or in alignment. Welded joints crossing each other shall be grooved and welded continuously through the intersections.

2-5.8 Opening Reinforcement. All openings over four inches in diameter in the shell, suspended bottom, or larger steel plate riser or tubular support shall be reinforced. This reinforcement may be the flange of a fitting, an additional ring of metal, excess plate metal above that actually required or combinations of these; except that excess plate metal due to joint efficiency shall not be counted if the center of the opening is within one opening diameter of any plate seam or point of support attachment. For the purposes of this standard, the opening diameter shall be taken as the maximum dimension of the hole cut in the plate perpendicular to the direction of maximum stress.

2-5.8.1 Sufficient welding shall be provided to transmit to the plate the full net strength of the reinforcing ring or flange. In computing the net reinforcing area of a fitting, such as a boiler maker's flange, or a manhole saddle, having a neck, the material in the neck may be considered as part of the reinforcing for a distance, measured from the surface of the parent plate or that of an intervening reinforcement plate, equal to four times the thickness of the material in the neck.

2-5.9 Roof Supports. The supports for tank roofs, not containing water, shall be designed in accordance with current steel construction specifications of the American Institute of Steel Construction, except that rafters in contact with a steel roof and having a slope of less than 2 inches in 12 inches and consisting of beam or channel shapes less than 15 inches deep may be considered as adequately laterally braced by friction be-

tween the roof plate and the top flange; and, except that the roof purlin depth may be less than 1/30 of the span length; and, except that the maximum slenderness ratio L/R for columns supporting roof shall be 175.

2-5.10 Roofs and Top Girders. All tanks storing drinking water shall have roofs. Tanks without roofs shall have a top girder or angle having a minimum section modulus as determined by the following formula:

$$S = \frac{HD^2}{10,000}$$

NOTE: In the above formula S is the minimum required section modulus in inches cubed of the top angle or girder, including a length of tank shell equal to twenty times its thickness; H is the height of the cylindrical portion of the tank shell in feet; and D is the diameter of the cylindrical portion of the tank shell in feet.

2-5.11 Welded Joints. The types of joints used and their design shall conform to the current *American Water Works Association Standard for Steel Tanks, Standpipes, Reservoirs, and Elevated Tanks, for Water Storage, AWWA D100-73, AWS D5.2-73.*

2-6 Workmanship.

2-6.1 Plate Edges. The plate edges to be welded may be universal mill edges or they may be prepared by shearing, machining, chipping or by mechanically guided oxygen cutting, except that edges of irregular contour may be prepared by manually guided oxygen cutting. When edges of plates are oxygen-cut, the surface obtained shall be uniform and smooth and shall be cleaned of slag accumulations before welding.

2-6.2 Rolling. Plates shall be cold rolled to suit the curvature of the tank and the erection procedure in accordance with Table 2-6.2:

Table 2-6.2

Plate Thickness	Minimum Diameter for Plates Not Rolled
Plates less than $\frac{3}{8}$ in.	40 ft.
$\frac{3}{8}$ in. to less than $\frac{1}{2}$ in.	60 ft.
$\frac{1}{2}$ in. to less than $\frac{5}{8}$ in.	120 ft.
$\frac{5}{8}$ in. and heavier	Must be rolled for all diameters

2-6.3 Double Curved Plates. Plates which are curved in two directions may be pressed either cold or hot or may be dished with a "mortar and pestle" die by repeated applications.

2-6.4 Milling Columns. The ends of columns shall be milled to provide a satisfactory bearing unless the design provides sufficient welding to resist the total calculated loads.

2-6.5 Welding. Welding shall conform to the current *American Water Works Association Standard for Steel Tanks, Standpipes, Reservoirs, and Elevated Tanks for Water Storage, AWWA D100-73, AWS D5.2-73.* (See Chapter 3.)

2-6.6 Fitting Roofs. The roof shall fit tightly to the top of the tank to prevent circulation of air over the surface of the water. When a spider is used it shall not obstruct the flow of water into the overflow inlet.

2-6.7 Preventing Ice Damage. The contractor shall keep the tank, structure, and building roofs free of ice caused by leakage during the construction and until the tank equipment is made watertight.

2-6.8 Coatings for Bottom Plates on Soil or Concrete. (See also 6-1.)

2-6.8.1 The underside of all bottom plates shall be protected again corrosion by one of the following methods: (a) paint with two coats of paint after the bottom has been completely welded, (b) erect bottom upon oil-saturated sand cushion.

2-6.8.2 When the tank bottom is placed upon oiled sand, the sand will be saturated to a depth of four inches with heavy petroleum base oil, gravity range 12°-18° Baume.

2-6.9 Testing.

2-6.9.1 Flat Bottoms. Upon completion of the welding of the tank bottom it shall be tested by one of the following methods and shall be made entirely tight:

(a) Air pressure or vacuum may be applied to the joints, using soap suds, linseed oil, or other suitable material for the detection of leaks.

(b) The joints may be tested by the magnetic particle method.

2-6.9.2 General. Upon completion of the tank, it shall be filled with water furnished at the tank site by the purchaser at proper pressure to fill the tank to the maximum working water level. Any leaks which are disclosed in this test in the shell, bottom, or roof (if the roof contains water), shall be repaired by chipping or melting out any defective welds and then rewelding. No repair work shall be done on any joints unless the water in the tank is at least two feet below the point being repaired. The tank shall be watertight under test to the satisfaction of the purchasers' inspector.

2-6.9.3 Disposal of Test Water. The purchaser shall provide means for disposing of test water up to the tank inlet or drain pipe.

2-7 Accessories.

2-7.1 Connections. Connections shall be provided on the tank for the necessary pipes, braces, frost-casing and walkway supports.

2-7.2 Roof Vent.

2-7.2.1 When the steel roof is essentially airtight, there shall be a substantial vent above the maximum water level. A vent pipe shall have a cross-sectional area at least equal to one-half the area of the discharge pipe or pipes or fill pipe, whichever is the larger. A corrosion resistant screen or perforated plate with $\frac{3}{8}$ -inch holes, to exclude birds or animals, shall be provided and have a net area at least equal to the vent line. In the case of a screen, this requires a gross area at least three times the cross-sectional area of the vent pipe. The screen or perforated plate shall be protected against accumulation of sleet. The weather hood or equivalent, over the perforated plate or screen, shall be readily removable. The overflow pipe shall not be included as vent area. The vent may be combined with the roof finial. Equivalent venting may be used provided the area cannot be obstructed by sleet and the ingress of birds and animals is prevented.

2-7.2.2 When dual service is specified and where local health departments require screening vents against insects, a special fail-safe vent shall be provided to minimize the risk in the event that these insect screens frost over.

2-7.3 Roof Anchorage. Each roof plate shall be securely fastened to the top of the tank.

2-7.4 Roof Hatch. An easily accessible roof door or hatch having a minimum opening dimension of 24 inches shall be provided in the roof. The hatch cover shall be built of steel plate at least 3/16 inch thick. The opening shall have a curb at least 4 inches high, and the cover shall have a downward overlap of at least 2 inches. A substantial catch shall be provided to keep the cover closed.

An additional roof hatch or flanged vent with a removable cover having a minimum opening dimension or diameter of 24 inches and a neck 4 inches minimum height shall be provided at, or near, the center of the tank. The opening shall be constructed so that an exhaust fan may be bolted to the hatch if required for ventilation during painting. The flange shall be drilled with at least four 13/16 inch diameter holes on a 30¼ inch diameter bolt circle.

2-7.5 Ladders—General. Outside and inside steel ladders arranged for convenient passage from one to the other and through the roof hatch shall be provided. Ladders shall not interfere with opening the hatch cover and shall not incline outward from the vertical at any point. For pedestal-supported tanks, the ladder shall be placed inside an access tube extending through the center of the tank.

2-7.6 Outside Fixed Shell and Roof Ladder.

2-7.6.1 The outside tank ladder for suction and multiple column supported gravity tanks shall be fixed at least seven inches from the tank side and rigidly bolted or welded to brackets not over 12 feet apart which are welded to the tank plates. The bottom bracket shall not be more than six feet above the base of the tank cylinder, and the ladder shall extend up the tank shell and radially along the roof with the top bracket within approximately two feet of the roof hatch, and there shall be at least one foot clearance at the sides and front of the ladder at the balcony. All ladders shall be equipped with a cage, a rigid notched rail, or other approved ladder safety device.

2-7.7 Inside Ladder.

2-7.7.1 The inside fixed ladder provided for passage between the roof hatch and tank bottom shall not be rigidly connected to the bottom plates.

2-7.7.2 A ladder shall extend from the top to the bottom of the inside of large steel riser pipes and shall be secured to the shell plates by brackets spaced not over 12 feet apart, the upper bracket being located at the top of the riser.

2-7.7.3 All ladders exceeding 20 feet shall be equipped with a cage, a rigid notched rail or other approved ladder safety device.

2-7.8 Ladder Bars and Rungs. Ladder side bars shall be not less than two inches by 5/16-inch flat steel for fixed ladders and 2½ inches by 3/8 inch for movable ladders. Side bars shall be spaced at least 16 inches apart. Rungs shall be at least ¾ inch round or square steel spaced 12 inches on centers. The rungs shall be firmly welded to the side bars. Ladders and connections shall be designed to support a concentrated load of 350 pounds.

2-7.9 Repainting (*see 1-16.7*).

2-7.10 Painting Inaccessible Parts. Parts inaccessible after fabrication, but subject to corrosion, shall be protected by paint before assembly, except surfaces in watertight joints shall be coated with clear oil or lacquer.

2-7.11 Shop Painting.

2-7.11.1 All interior surfaces of steel tanks exposed to water immersion or the vapor-phase zone above the high water level shall be cleaned by blasting or pickling and shop primed in accordance with the requirements for Inside Paint System No. 2 (wash primer plus vinyl red lead) or Inside Paint System No. 4 (Bureau of Reclamation VR-3 Vinyl) of AWWA Standard D102-64.

2-7.11.2 All exterior surfaces and inside dry surfaces (pedestal tanks) shall be cleaned by blasting or pickling and shop primed in accordance with the requirements for Outside Paint System No. 1 (alkyd) of AWWA Standard D102-64.

2-7.11.3 The appropriate primers for other interior and exterior paint systems may be used provided permission is first obtained from the authority having jurisdiction.

2-7.12 Field Painting.

2-7.12.1 After construction, all weld seams, unprimed shop margins, and any areas on which the shop paint has been damaged shall be blast cleaned and patch primed with the same primers used in the shop.

2-7.12.2 All finish coat painting for interior (wet) surfaces shall be in accordance with the requirements for Inside Paint Systems No. 2 or No. 4 of AWWA Standard D102-64, utilizing the same basic system throughout the shop and field painting. For System No. 2, at least two complete field coats shall be used to provide a minimum total dry film thickness of 4.0 mils. A 5.0 mil minimum total thickness with one additional coat may be specified by the purchaser. For System No. 4, the basic system shall be at least three complete field coats to provide a minimum total dry film thickness of 6.0 mils.

2-7.12.3 All exterior and inside dry finish coat painting shall be in accordance with the requirements for Outside Paint System No. 1 of AWWA Standard D102-64, utilizing two coats of the color specified by the purchaser to provide a minimum total dry film thickness of 4.0 mils. As provided by the AWWA Standard, the purchaser may specify an extra complete coat of primer for a total minimum thickness of 5.0 mils for the more severe atmospheric exposures.

2-7.12.4 Other finish coats may be used provided they are compatible with the shop primers and provided permission is first obtained from the authority having jurisdiction.

***2-7.13 Painting Application.** All painting shall be accomplished in accordance with the appropriate requirements of Steel Structures Painting Council Paint Application Specification No. 1 (Shop, Field and Maintenance Painting).

Chapter 3 Pressure Tanks

3-1 General.

3-1.1 Service. Pressure tanks may be used for limited private fire protection services, such as those covered by the following NFPA standards:

NFPA 13-1975 — Standard for the Installation of Sprinkler Systems

NFPA 14-1976 — Standard for the Installation of Standpipe and Hose Systems

NFPA 15-1973 — Standard for Water Spray Fixed Systems for Fire Protection

Pressure tanks shall not be used for any other purpose unless approved by the authority having jurisdiction.

3-1.2 Capacity. The capacity shall be as approved by the authority having jurisdiction.

3-1.3 Air Pressure and Water Level. Unless otherwise approved by the authority having jurisdiction, the tank shall be kept two-thirds full of water, and an air pressure of at least 75 pounds per square inch by the gage shall be maintained. As the last of the water leaves the pressure tank, the residual pressure shown on the gage shall not be less than zero, and shall be sufficient to give not less than 15 pounds pressure at the highest sprinkler under the main roof of the building.

***3-1.4 Air Lock.** Methods used for prevention of air-lock shall be as approved by the authority having jurisdiction in each particular case.

3-1.5 Location. Pressure tanks shall be located above the top level of sprinklers, but may be located in the basement or elsewhere subject to the approval of the authority having jurisdiction. (*See 3-1.9.*)

3-1.6 Construction.

3-1.6.1 General. Except as herein specified to the contrary, pressure tanks shall be constructed in accordance with the current Rules for the Construction of Unfired Pressure Vessels, Section VIII, Division 1, Unfired Pressure Vessels of the *ASME Boiler and Pressure Vessel Code*. This code permits the fusion process of welding with certain regulations for strength, qualification of welders, and tests.

3-1.6.2 Tests.

(a) Each pressure tank shall be given the tests specified by the ASME Rules before painting, except that the hydrostatic test pressure shall in no case be less than 150 pounds per square inch.

(b) In addition to the ASME tests, each pressure tank shall be filled two-thirds full and tested at the normal working pressure with all valves closed, and shall not lose more than one-half pound pressure in 24 hours.

(c) A certificate signed by the manufacturer shall be filed with the authority having jurisdiction, certifying that the foregoing tests have been made.

(d) A repetition of the above tests may be required after the tank has been set in place and connected. In all cases where conditions do not permit shipping the tank assembled, the above tests shall be conducted after erection in the presence of a representative of the authority having jurisdiction.

3-1.6.3 Supports. The supports shall be steel or reinforced concrete, located so as to prevent sagging or vibration, and to properly distribute the loads due to the weight of the vessel completely full of water. Stresses in steel supports shall not exceed those permitted by the Section 11 for Steel Towers. For horizontal tanks there shall be at least one support near each end of the tank and these supports so located that combined stresses in any part of the tank shall not exceed those specified in 3-1.6.1.

3-1.6.4 Painting. Tanks shall be thoroughly cleaned by scraping, wire brushing, and wiping, and shall be painted inside and outside with at least two complete coats of an approved metal protective paint. One of the stamps required by the ASME Specifications for Material and also one of the ASME Standard Pressure Vessel stamps shall not be rendered illegible.

3-1.7 Care and Maintenance. The interior of pressure tanks shall be inspected carefully at three-year intervals to determine if corrosion is taking place and if repainting or repairing is needed. When necessary, they shall be thoroughly scraped and wire brushed and repainted with an approved metal-protective paint. Each relief valve shall be tested at least once each month.

3-1.8 Marking.

3-1.8.1 General. All stamps required by the ASME Specifications shall be applied. The name plate or water-level

marking (*see 3-1.8.2 and 3-1.8.3*) shall be securely fastened without obliterating any lettering. If screws are used they shall not penetrate the tank plate more than one-half its thickness.

3-1.8.2 Nameplate. A metal nameplate large enough to contain the following information with raised or stamped letters and numbers of sufficient size to be easily read, shall be provided:

Name and location of manufacturer;

Year of erection;

Length and diameter;

Total capacity (gallons);

Working pressure (lbs. per sq. in.).

The nameplate shall also serve for the water-level indicator.

3-1.8.3 Water-Level Indicator. A metal plate, preferably the nameplate (*see 3-1.8.2*), bearing an easily observed raised arrow and raised or stamped lettering " $\frac{2}{3}$ capacity line" shall be secured to the tank plate behind the gage glass in a position such that the arrow will be at the water level when the tank is two-thirds full. For horizontal tanks the two-thirds capacity line is $63/100$ of the diameter above the bottom.

3-1.9 Housing. Where subject to freezing the tank shall be located in a substantial noncombustible housing unless it is within a heated room in the building. The tank room shall be large enough to provide free access to all connections, fittings and manhole, with at least 18 inches around the rest of the tank. The distance between the floor and any part of the tank shall be at least three feet.

3-1.9.1 The floor of the tank room shall be watertight and arranged to drain outside of the enclosure. The tank room shall be adequately heated to maintain a minimum temperature of 40°F and shall be equipped with ample lighting facilities.

3-2 Pipe Connections and Fittings.

3-2.1 Openings. A manhole and all openings needed for connection of the piping and fittings specified in the following articles shall be provided. The manhole and threaded openings shall conform in design with the current ASME Rules for the Construction of Unfired Pressure Vessels. The manhole shall be placed below the water level.

3-2.2 Tank Discharge. The discharge pipe shall be sized to supply the required amount of water for the fire protection system, but in no case less than 4 inches. The discharge pipe shall be connected to the bottom of the tank by means of a fitting which projects 2 inches above the bottom to form a settling basin and prevent sediment from passing into the system. An approved horizontal swing-check-valve and an approved O.S. & Y. gate valve shall be located in the discharge pipe, directly under or near the tank. The pipe shall be adequately supported.

3-2.3 Filling Pipe. The water-filling pipe shall be at least $1\frac{1}{2}$ in. in diameter, run separately from the filling pump or other acceptable source of supply, and shall be adequately supported and protected from mechanical injury. It may be connected to the top or bottom of the tank as required by the authority having jurisdiction. (*Figs. B-3-1 and B-3-2*). An approved horizontal bronze-seat, swing-check-valve, and a renewable-disc globe valve shall be provided in the pipe near the tank, the globe valve being placed between the check valve and the tank.

3-2.4 Air Pipe. The air supply pipe shall be at least one inch in size, well-supported and protected from breakage. It shall be connected to the tank above the water level as shown in Figures B-3-1 and B-3-2. A horizontal bronze-seat swing-check-valve and an approved renewable-disc globe valve, both of reliable make shall be provided in the pipe near the tank, the globe valve being placed between the tank and the check valve.

3-2.5 Water-Level Gage. A $\frac{3}{4}$ -inch water-level gage with an approved valve at each end shall be provided with the center of the glass tube at the normal water level. The gage glass shall be not over 12 inches long for horizontal tanks or 18 inches for vertical tanks. Approved angle globe-valves with renewable discs shall be installed in the connections from the gage to the tank independent of the shutoff valves which are a part of the gage fittings. The water-level gage shall be connected through valves into the tank as shown in Figures B-3-1 and B-3-2. A pet cock shall be provided for draining the glass. All fittings and nipples shall be of brass, not less than $\frac{3}{4}$ inch in size, except that the nipple extending into the tank may be $\frac{1}{2}$ inch.

3-2.5.1 The glass gage tube shall be protected from mechanical injury by a usual guard consisting of at least three $\frac{3}{16}$ -inch brass rods.

3-2.5.2 The valves on the water-level gage connections shall be opened only when ascertaining the amount of water in the tank.

3-2.6 Air-Pressure Gage. An approved 4½-inch dial, double-spring gage, shall be connected into the air chamber between the tank and any valve, generally to the line between the upper end of the water-level gage and the tank, as shown in Figures B-3-1 and B-3-2. The pressure gage shall have a maximum range equivalent to twice the normal working pressure when installed and shall be controlled by a valve arranged to drain. A plugged outlet at least ¼ inch in size shall be provided between the valve and the gage for the inspector's gage.

3-2.7 Safety Appliances. A reliable brass pop relief-valve not less than ¾ inch in size set to blow at a pressure 10 percent in excess of the normal tank pressure shall be placed in the air-supply pipe between the check-valve and the air compressor. There shall also be a properly designed brass relief-valve not less than 1½ inch in size at the filling pump set to relieve pressures 10 percent in excess of the pressure at the pump when the tank is under normal working pressure. No safety appliances shall be installed between the tank and other valves.

3-2.8 Emergency Drain. (*Figs. B-3-1 and B-3-2.*) Provision shall be made to drain each tank independently of all other tanks and the sprinkler system by a pipe not less than 1½ inch in diameter. The drain valve shall be a globe valve with renewable disc, and shall be located near the tank.

3-2.8.1 Use of a drain other than shown in Figures B-3-1 and B-3-2 below the pressure tank, after shutting off other water supplies, is not permitted under any condition, as collapse of the pressure tank may result.

3-2.9 Water Filling Supply. The filling supply or pump shall be reliable and capable of replenishing the water required to be maintained in the tank against the normal tank pressure in not more than four hours. A properly designed relief valve shall be provided at the pump as specified in 3-2.7.

3-2.10 Air Compressor. An air compressor, capable of delivering not less than 16 cubic feet of free air per minute for tanks of 7,500 gallons total capacity and not less than 20 cubic feet per minute for larger sizes, shall be provided. The compressor must be located in the tank house, unless otherwise permitted by the authority having jurisdiction. A safety valve shall be provided, as specified in 3-2.7.

3-2.11 Arrangement. All pipe connections and valves, including the manhole, the emergency drain-valve, and all valves on the discharge pipe, shall be arranged for convenient manipulation.

3-2.12 Watertight Intersections at Roofs and Floors. The intersections of all piping with the building roof and concrete or waterproof floors, shall be watertight. (*See 8-1.1*). Flashings shall be of copper.

Chapter 4 Wood Gravity and Suction Tanks

4-1 General.

4-1.1 This chapter applies to the design, fabrication, and erection of wood gravity water tanks, including pump suction tanks.

4-1.2 **Capacity.** The capacity of the tank is the number of U.S. gallons available above the outlet opening. The net capacity between the outlet opening of the discharge pipe and the inlet of the overflow shall be at least equal to the rated capacity.

4-1.3 **Standard Sizes.** The standard sizes of wood tanks are 5,000, 10,000, 15,000, 20,000, 25,000, 30,000, 40,000, 50,000, 60,000, 75,000, and 100,000 gallons net capacity. Tanks of other sizes are built.

4-1.4 **Strength.** The materials as specified shall have no defects other than those permitted by the grading rules for the lumbers listed in 4-2.2. The use of second-hand materials, including hoops, lumber, etc., is not permitted. The workmanship shall be good so that defects or injuries are not produced during manufacture or erection. Unit stresses, as specified in 4-4.1, shall not be exceeded except where additionally reinforced. (See 4-6.3—*Chime*.) The structure and its details shall possess the requisite strength and rigidity.

4-2 Material.

4-2.1 **Lumber—General.** All lumber shall be well seasoned and free from rot, sap, loose or unsound knots, worm holes and shakes in accordance with National Wood Tank Institute, Bulletin A 25.

4-2.2 Lumber—Staves and Bottom.

4-2.2.1 Untreated lumber in the staves and the bottom shall be thoroughly air dried "all heart" or "tank stock" without any sapwood after shaping. Acceptable untreated species are red cypress (coast type), redwood, southern white cedar (Dismal Swamp), western yellow cedar, western red cedar and Douglas fir (coast type), the varieties being arranged in the order of preference.

4-2.2.2 Cypress, redwood, southern white cedar (Dismal Swamp) or western yellow cedar are advised as the increased serviceability will ordinarily more than offset the slightly greater cost of the complete installation. Fir deteriorates rapidly especially if the water is overheated during the heating season. (See 10-1.9.)

4-2.2.3 Acceptable treated species include all those listed in 4-2.2.1 without sapwood restriction. Treatment shall consist of an eight pound per cubic foot retention of creosote or pentachlorophenol applied after shop fabrication, according to the American Wood Preservers Association by the empty-cell process.

4-2.3 Timber-Supports. Wooden dunnage beams, when used shall be a dense grade of Southern Pine or Douglas fir or a construction heart-untreated redwood or red cypress (Coast type) except that structural grades of other species may be used if treated with a six- to eight-pound per cubic foot retention of creosote or pentachlorophenol applied according to the standard specifications of the American Wood Preservers Association by the empty-cell process. (See 4-4.1 and 4-5.8.) Dunnage beams if of wood, shall be at least 4×6 inch nominal size.

4-2.4 Hoops. Hoops shall be round bars of iron or steel. Iron bars shall conform to current specifications A84 or A189 of the American Society for Testing and Materials. Steel bars shall conform to current specifications A36-75 or A502-75 of the American Society for Testing and Materials. Steel shall be made only by the open hearth or electric furnace processes.

4-2.5 Hoop Lugs. The lugs shall be malleable iron, cast steel or fabricated steel and shall have equal or greater ultimate strength than the A36-75 or A502-75 steel hoop they are used with.

4-2.6 Steel Shapes. The steel for structural shapes shall conform to current Specification A36-75 structural steel of the American Society for Testing and Materials.

4-3 Loads.

4-3.1 Dead Load. The dead load shall be the estimated weight of all permanent construction and fittings.

4-3.2 Live Load. Under normal conditions, the live load shall be the weight of all the liquid when overflowing the top of the tank. The unit weight of water shall be considered as 62.4 pounds per cubic foot. Proper provision must be made for temporary stresses during erection. When roofs have a slope of less than 30 degrees they shall be designed to support a uniform weight of 25 pounds per square foot on the horizontal projection.

4-3.3 Wind Load. Under normal conditions the wind load, or pressures shall be assumed to be 30 pounds on vertical plane surfaces, 18 pounds on projected areas of cylindrical surfaces and 15 pounds per square foot on projected areas of conical and double curved plate surfaces. When designing for wind velocities over 100 miles per hour, all above mentioned unit pressures shall be adjusted in proportion to the square of the velocity assuming that the above pressures are for 100 miles per hour.

4-3.4 Earthquake Load. Tank structures should meet local requirements for resisting earthquake damage.

4-3.5 Balcony and Ladder Loads. A vertical load of 1,000 pounds shall be assumed to be applied to any 10 square feet of area on the balcony floor and on each platform; 500 pounds applied to any 10 square foot area on the tank roof; 350 pounds on each vertical section of ladder; and all of the structural parts and connections shall be designed to withstand such loads. The above loadings need not be combined with snow loading.

4-4 Unit Stresses.

4-4.1 General. The following stresses in pounds per square inch apply particularly to wood tanks and shall not be exceeded. (Unit working stresses for steel supporting construction are given in 7-4.)

4-4.1.1 Tension Hoops. The unit stress for tension hoops of A84 Iron shall be 12,500, of A189 and A306 steel shall be 15,000 (use with hydrostatic load and neglect initial tension). A36-75 or A502-75 shall be 20,000 pounds per square inch.

4-4.1.2 Timber. The allowable working stresses for timbers mentioned in 4-2.3 and 4-5.8 shall be as follows:

Working Stresses for Timber (Select Grade)

Species	ALLOWABLE STRESS LB. PER SQ. IN.			
	BENDING		COMPRES- SION perpendic- ular to grain	COMPRES- SION parallel to grain; short columns
	In ex- treme fiber	Horizontal Shear		
Cedar, western red	900	80	200	700
Cedar, northern and southern white	750	70	175	550
Douglas fir (Western Washing- ton and Oregon)	1600	90	345	1175
Douglas fir (Western Washing- ton and Oregon), dense grade	1750	105	380	1290
Douglas fir (Rocky Mountain type)	1100	85	275	800
Pine, southern yellow	1600	110	345	1175
Pine, southern yellow, dense grade	1750	120	380	1290
Pine, white, sugar, western white, western yellow	900	85	250	750
Pine, Norway	1100	85	300	800
Redwood	1200	70	250	1000
Spruce, red, white, Sitka	1100	85	250	800

4-4.2 Wind and Earthquake Allowance. For stresses due to a combination of wind or earthquake with other loads, the above working unit stress may be increased 25 percent. Wind and earthquake loads need not be considered simultaneously. In no case shall the strength of the member be less than that required for dead and live loads alone.

4-5 Details of Design.

4-5.1 Lumber Thickness. The lumber in the staves and the bottom shall be at least $2\frac{1}{2}$ inch (nominal) dressed to not less than $2\frac{1}{8}$ inch thickness for tanks less than 20 ft. in depth or diameter, and for larger tanks at least 3 inch (nominal) dressed to not less than $2\frac{3}{8}$ inch thickness.

4-5.2 Hoop Sizes. Hoops shall be not smaller than the pitch diameter of $\frac{3}{4}$ inch thread. Not more than two sizes of hoops shall be used on a tank.

4-5.3 Hoop Schedules. A hoop is assumed to support one-half of the length of the stave to the two adjacent hoops. Typical hoop schedules for standard size tanks are shown in Figure A-4-5.3, based upon the area at the root of cut threads. Other schedules are satisfactory provided the unit stress as stated in Section 4-4 is not exceeded.

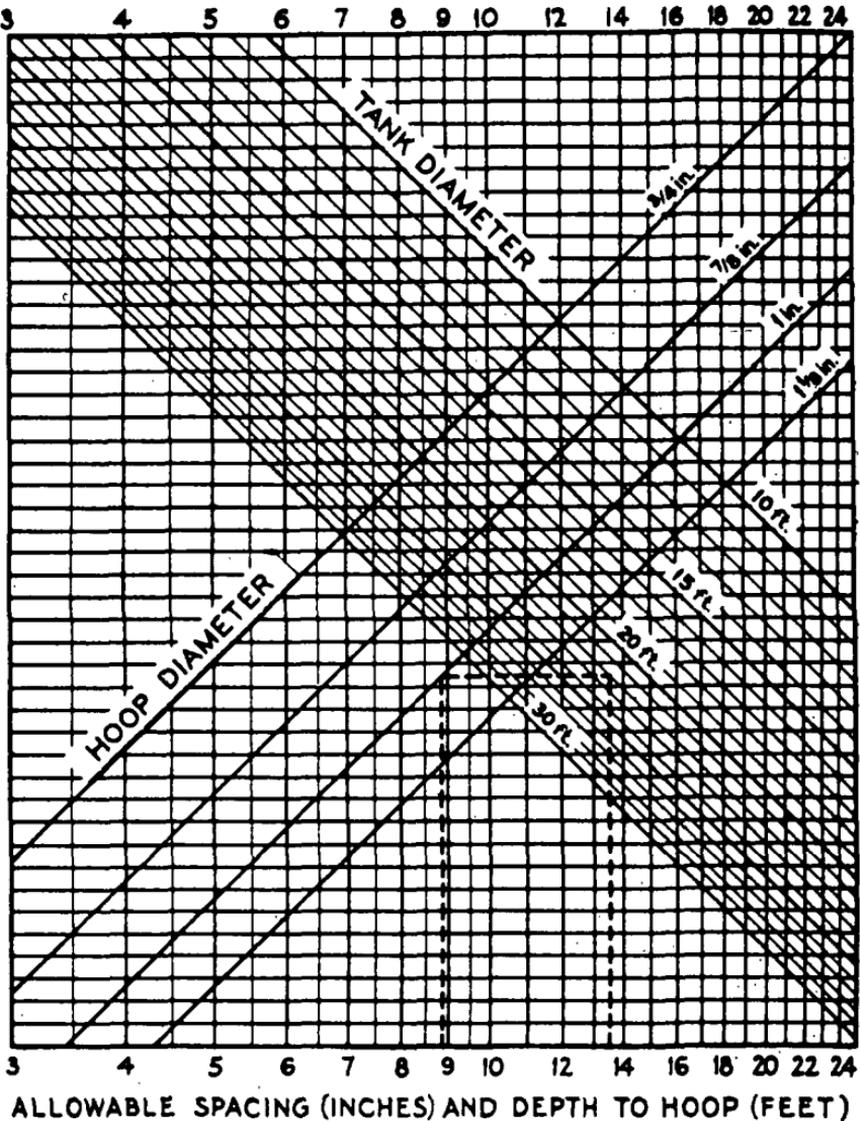


Fig. 4-5.3

Hoop Spacing Diagram for Wood Tanks.

Note: "Hoop spacing" is one-half the distance from the hoop next above to the one next below the one being considered; "tank diameter" is the average outside diameter; "depth" is the distance from the hoop being considered to the top of the stave or if the staves are notched for flat cover joists, to the bottom of the notch.

The diagram is computed by the following formula assuming plain threaded ends using the area at the root of the thread.

4-5.4 Hoops at Bottom.

4-5.4.1 One hoop shall be placed approximately at the center of the bottom planks of tanks with diameters of 19 ft. or less. The stress in this hoop shall not exceed one-half the allowable unit tension, the excess strength being provided to take care of the swelling of the bottom planks.

4-5.4.2 Two hoops of equal size shall be placed opposite the tank bottom on tanks with diameters of over 19 ft. The stress in the upper hoop shall be limited as stated above.

4-5.5 Hoops at Top. The top hoop shall be placed 3 in. below the bottom of the flat cover joists or 3 in. below the top of the staves if the flat cover is omitted. The maximum spacing of hoops shall not exceed 21 in.

4-5.6 Hoop Lugs. The ends of the hoop sections shall be connected by malleable iron, cast steel or fabricated steel lugs and shall have equal or greater ultimate strength than the A36-75 or A502-75 steel hoop they are used with. The lugs shall be designed so that water shall not be pocketed. The hoops shall be so located on the tank that the lugs come in fairly uniform spiral lines.

4-5.7 Main Supports. Steel I-beams or reinforced concrete beams shall be used for the main supports on which the dunnage beams rest.

4-5.8 Spacing of Supports. The maximum distance in the clear between the beams on which the tank bottom rests shall not exceed 21 inches. The maximum distance between the outer edge of the outer dunnage beam and inside surface of the tank staves measured on a line perpendicular to the beam at its mid-point shall not exceed 14 inches.

4-5.9 Air Circulation under Tank Bottom. Tank supports shall be designed to allow a free circulation of air under the tank bottom and about the ends of the staves.

4-6 Workmanship.

4-6.1 Lumber Edges and Surfaces. Planks for staves and bottom shall be planed on both sides. The edges of staves and bottom planks shall be machine planed or sawed. Edges of staves shall be cut to obtain full bearing at joints. A fore plane may be used for smoothing up the edges. The last stave to be placed in the tank shall be carefully planed to the required size.

4-6.2 Croze. The croze shall be cut at right angles to the center line of the staves. The edges of the bottom planks shall be beveled on the under side and smoothed off on the upper side by planing to obtain a tight joint at the croze. The depth and width of the croze shall be at least $\frac{3}{4}$ inch and $2\frac{1}{8}$ inch, respectively, for 3 inch nominal staves, and $\frac{5}{8}$ inch and 2 inch for $2\frac{1}{2}$ inch nominal staves.

4-6.3 Chime. The chime shall be of uniform depth and not less than $3\frac{1}{2}$ inches. Before erection, the chimes of staves shall be fastened with at least three nails or staples with staggered spacing, 2 inch fasteners with 3 inch nominal staves, and $1\frac{1}{2}$ inch fasteners with $2\frac{1}{2}$ inch nominal staves. Nails or staples shall be coated with zinc or copper, or shall be of other material highly resistant to corrosion.

4-6.4 Dowels. The edges of each bottom plank shall be bored with holes not over five feet apart for wooden dowels not less than $\frac{1}{2}$ inch in diameter for planks up to $2\frac{1}{2}$ inch nominal and $\frac{5}{8}$ inch in diameter above that thickness.

4-6.5 Splices. Finger joint splices may be used in a stave or bottom plank if permitted by the authority having jurisdiction. Such joints in adjacent staves or bottom planks shall be staggered a minimum of two feet.

4-6.6 Joints at Bottom. The joints between staves shall not come nearer than $\frac{1}{2}$ inch to a joint between the bottom planks.

4-6.7 Extra Staves. One or more extra staves shall be shipped with each tank.

4-6.8 Marking of Staves. The proper hoop spacing shall be plainly marked on at least every sixth stave before shipment.

4-6.9 Clearance at Supports. The distance between the ends of dunnage beams and the inside surface of the staves shall be not less than 1 inch or more than 3 inches. The supports shall be of such depth that the clearance beneath the ends of staves is not less than 1 inch at any point.

4-6.10 Hoop Forming. Hoops shall be cut to proper length and bent in the shop to the radius of the tank. The sections of a hoop shall be of approximately equal length.

4-6.11 Hoop Threads. The threads shall have a tight fit in the nuts and shall be U. S. Standard.

4-6.12 Hoop Tightening. Care shall be taken in setting up the nuts on the hoops to prevent an excessive initial stress in the hoops. The threads of the nuts shall be fully engaged.

4-6.13 Removal of Rubbish. All waste lumber and rubbish shall be removed from inside of the tank and from the flat cover, if provided, before filling to prevent possible obstruction of piping.

4-7 Accessories.

4-7.1 Roof—General. When the tank is located out of doors it shall have a flat wooden cover over the top and above this a conical roof, except that the flat cover may be omitted and the conical cover made self-supporting provided that approval of the detailed design is first obtained from the authority having jurisdiction. Roofs shall be constructed as shown by Figures B-4-1 and B-4-2 or in accordance with other designs approved by the authority having jurisdiction. Roof boards shall be not less than 1 inch nominal thickness, or $\frac{3}{8}$ inch Exterior Grade Plywood and laid without spacing between. If plywood is used, end joints shall be made over roof joists or ply clips shall be used to support edges. Shiplap or matched joints shall be used on boards in the flat cover, unless plywood is used. The joint between the tank staves and roof shall be tight. Nails or staples shall be heavily galvanized, or nonferrous metals.

4-7.2 Flat Cover. The flat cover, if provided, shall rest on parallel joists, spaced not over 36 inches on centers. The nominal size of joists shall be at least 2 x 6 inch for lengths up to 18 feet, 3 x 6 inch for lengths up to 22 feet, and 3 x 8 inch for lengths up to 30 feet. Two joists of the above specified dimensions shall be placed at the center of the tank to support the center post. The full section of all joists at their ends shall be solidly supported by resting in slots cut entirely through the staves or by other means approved by the authority having jurisdiction.

4-7.3 Conical Roof. (Figure B-4-2.)

4-7.3.1 The conical roof should be preferably supported by 2 x 4 in. rafters spaced not over 36 in. apart around the top of the tank.

4-7.3.2 Although the rafter and header type of construction is considered preferable, other types of roof construction may be acceptable, provided approval of design is first obtained from the authority having jurisdiction.

4-7.3.3 The roof shall be covered with galvanized iron, at least 60 lb. asphalt, asbestos or equivalent fire-resistive roofing, securely fastened in place. Prepared asphalt roofing shall be laid with at least 2½ inch laps, properly cemented, and using ¾ inch galvanized roofing nails with at least ½ inch heads and large washers spaced not over 3 inches on centers, or .050 nonferrous staples ½ inch in length for 65 pound covering and ¾ inch for 90 pound covering. Rows of nails shall be spaced not over 2 feet apart vertically and horizontally.

4-7.4 Roof Anchorage. All parts of the roof and cover shall be securely fastened together and anchored to the tank staves to prevent extreme winds from blowing them loose.

4-7.5 Roof Hatches.

4-7.5.1 A hatch not less than 20 inches by 22 inches shall be built in the conical roof, accessible from the tank ladder. The hatch shall be placed high enough up the conical roof to make entrance to the flat roof reasonably easy when the cover for the flat roof hatch is in place.

4-7.5.2 The four sides of the hatch shall be of not less than 1½ inch dressed stock and shall be raised not less than 3 inches above the roof boards. The top of the hatch cover shall be made of not less than 1 inch dressed and matched boards or ¾ inch Exterior Grade Plywood, and shall be covered with the same material as specified for the roof. The edges of the hatch cover shall be of not less than 1½ inch dressed stock and shall lap down over the raised sides of the hatch. The hatch cover shall be arranged to open freely by sliding upward on two ½ inch guide rods securely bolted to the roof, one on each side of the cover. A substantial handle shall be bolted to the lower side of the cover.

4-7.5.3 Other forms of hatch covers may be acceptable provided approval is first obtained from the authority having jurisdiction.

4-7.5.4 A hatch not less than 20 inches by 22 inches shall be built in the flat cover, if provided, located directly beneath the hatch in the conical roof. The hatch cover shall be made of 1

inch dressed and matched boards or $\frac{3}{8}$ inch Exterior Grade Plywood, and shall be of sufficient size to prevent its falling through the hatch.

4-7.6 Ladders—General. Inside and outside ladders arranged for convenient passages from one to the other and through the roof hatch shall be provided. Ladders shall not interfere with opening the hatch cover. All ladders exceeding 20 feet shall be equipped with a cage, a rigid notched rail or other approved ladder safety device.

4-7.7 Outside Ladders.

4-7.7.1 A steel ladder shall be provided on the outside of the tank extending from the balcony to the roof. The sides of the ladder shall extend 18 inches above the top of the tank and thence downward in an arch to the roof or cover where the ends shall be securely fastened. The ladder shall be placed at least 3 feet to one side of the tower ladder if a balcony is provided. (See 4-7.9.)

4-7.7.2 The outside ladder shall have not less than 2 x $\frac{5}{16}$ inch flat side bars, spaced at least 16 inches apart and at least $\frac{3}{4}$ inch round or square rungs, spaced 12 inch on centers. The rungs shall be firmly welded to the side bars. The ladder shall be securely fastened at least 6 inches from the side of the tank by brackets not over 12 feet apart. The upper brackets shall be placed not more than 12 inches below the top of the tank staves and the lower end of the ladder shall be securely fastened to the balcony (4-7.9) or, in the absence of a balcony, to the tower ladder. The brackets shall be designed to support a load of 350 pounds on the ladder, and shall be securely fastened to the tank with through bolts not less than $\frac{3}{8}$ inch in diameter.

4-7.8 Inside Ladder.

(a) A wooden ladder made of the same type wood as the tank shall be provided on the inside of the tank extending from the hatch to the tank bottom with a slope of about 10° from the vertical.

(b) The inside ladder, up to 16 feet in height, shall have 2 x 4 inch side pieces. Ladders over 16 feet shall have 2 x 6 inch side pieces. All side pieces shall be spaced at least 16 inches apart. Rungs shall be $1\frac{1}{4}$ x 3 inches spaced 12 inches on centers, securely spiked with bronze nails into slots not less than $\frac{3}{4}$ inch and not more than 1 inch in depth. The ladder shall be securely fastened at the upper and lower ends with bronze nails.

4-7.9 Balcony—General. A wooden or steel balcony shall be placed around the base of the tank when the tank bottom is elevated more than 25 feet above the main building roof. For tanks of diameter in excess of 15 feet 6 inches, the width of balcony shall be 24 inches and for smaller tanks not less than 18 inches.

4-7.10 Balcony Floor. If the balcony is of wood, the plank shall be at least $1\frac{1}{2}$ -inch dressed lumber of good, sound quality spaced $\frac{1}{2}$ inch apart. The planks may be laid crosswise on stringers or lengthwise on cross beams, spaced not over 4 feet apart; if of steel it shall be built of at least $\frac{1}{4}$ -inch plate and shall be provided with drain holes.

4-7.11 Balcony Clearance. A clearance of not less than 3 inches nor more than 5 inches at any point shall be provided between the balcony and the tank staves. The clearance in the inside angles of polygonal balconies with plank laid lengthwise, shall be limited to a maximum of 5 inches by means of properly supported filler pieces.

4-7.12 Balcony Supports. The balcony supports shall be built of structural steel shapes except that reinforced concrete supports may be used when the tank is located on a concrete tower.

4-7.13 Balcony Railing. A railing 36 inches high shall be placed around the balcony and shall be rigid. The top rail and posts shall be of not less than 1 inch pipe or of angles not lighter than $1\frac{3}{4} \times 1\frac{3}{4} \times \frac{3}{16}$ inch or $2 \times 1\frac{1}{2} \times \frac{1}{4}$ inch. An intermediate rail shall be provided or diagonal latticing used.

4-7.14 Balcony Opening. When a hole is cut in the balcony for the tower ladder it shall be at least 18 inches by 24 inches.

4-7.15 Painting Inaccessible Parts. Portions of steelwork inaccessible after erection shall be painted before assembling.

4-7.16 Shop Painting. All steel work, except where encased in concrete, and threads at ends of hoops, shall be given a shop coat of red lead paint (Federal Specifications TT-P-86 Type I or Type II). Other paints may be used, with the approval of the authority having jurisdiction.

4-7.17 Field Painting—Steel Work. After erection, a patch coat of the same kind of paint as the shop coat shall be applied to all steel surfaces from which the shop coat has become removed and also to the thoroughly cleaned hoop threads. At

least one overall field coat of a good grade of paint for metallic surfaces, of color specified by the purchaser, shall be applied to all steel work.

4-7.18 Painting Conditions. All steel shall be thoroughly cleaned of mill scale, rust, and grease before painting by scraping, wire brushing and wiping. Painting shall not be done out of doors during wet or freezing weather. The coats of paint shall completely cover the steelwork.

4-7.19 Painting—Woodwork. Exposed woodwork such as balconies, stringers, and supporting beams shall be given at least two coats of a good grade lead free preservative. While the painting of a wood tank is usually desirable from the standpoint of appearance, its value in increasing the life of the tank has not been definitely determined.

4-7.20 Lightning Protection (*see 1-15*).

Chapter 5 Embankment-Supported Rubberized-Fabric Tanks

5-1 General.

5-1.1 This section applies to the materials, embankment preparation and installation of embankment-supported rubberized-fabric tanks.

Table 5-1
Physical Properties of the Finished
Embankment Tank Assembly

	Federal Standard 191 Method	ASTM Method	
Weight	5041	D751	40.5 ± 2 oz./sq. yd.
Thickness	5030	D751	0.042" ± 0.003"
Breaking Strength	Warp 5100	D751	300 lbs. Avg.
	Fill 5100	Grab	300 lbs. Avg.
Tear Strength	Warp 5134	D39	20 lbs. Avg.
	Fill 5134	Tongue	20 lbs. Avg.
Adhesion of Coating to Fabric: Jaw Separation Speed 12"/min.	5970	D751	15 lbs./in. width, min.
Puncture Resistance— per Paragraph 4.6.17 of MIL-T-6396C			
Parallel to warp			90 lbs. min.
Parallel to fill			90 lbs. min.
45° to cords			90 lbs. min.
Abrasion Resistance, Wheel—H-22 Weight—100 gms/wheel	5306	D1175 Taber	No fabric showing after 4000 cycles
Blocking Resistance	5872		Rating of 1—max.
Seam strength 2" wide specimen	8311*		No seam slippage
Low Temperature Flexibility Paragraph 4.4.4.2 of MIL-C-8068A (ASC)			No cracking at -20° F

* Federal Test Method Standard 601

5-2 Standard Capacities.

5-2.1 The standard capacities are in increments of 100,000 gallons up to 1,000,000 gallons.

5-3 Materials.

5-3.1 Construction. The material shall be a nylon fabric, coated with an elastomer compounded to provide abrasion and weather resistance. (See Table 5-1.)

5-3.2 Design. The tank shall be designed as follows.

5-3.2.1 The tank shall be designed to result in an assembly which will have seams of a strength equal to or greater than the strength of the basic tank construction.

5-3.2.2 The top surface of the tank shall be coated with a weather-resistant aluminum color elastomeric paint.

5-3.2.3 The tank shall be designed to accommodate the field attachment of inlet/outlet fittings during installation.

5-3.2.4 The tank shall be tested for leakage prior to shipment.

5-4 Embankment Preparation and Tank Installation Procedure.

5-4.1 Foundation. The embankment and earth base which supports the tank shall be installed in accordance with Figure B-5-1.

5-4.1.1 The embankment shall be designed for stability and drainage. Where two tanks are installed with a single embankment between tanks, such embankment shall be designed to resist load of a full single tank when one tank is drained.

5-4.1.2 A shallow excavation may be made below nominal grade level where local soil and groundwater conditions permit. The removed soil, if suitable, may be used to extend the embankment above grade for the required height (cut and fill method.)

5-4.1.3 The internal and external slopes of the embankment shall be $1\frac{1}{2}$ to 1. The slope shall be maintained in original design conditions to assure the integrity of the embankment. Also, the soil shall provide a stable embankment. All of the above is subject to verification by a qualified professional soils engineer.

5-4.1.4 The inside corners of the embankment at intersections of dike walls may be rounded, using a radius of one foot \pm at the bottom and a radius of two ft. six in. \pm at top of dike

with uniform gradation from bottom to top, as approved by an authorized design or soils engineer.

5-4.1.5 The floor of the embankment shall be graded to locate the inlet/outlet fitting at a minimum of three inches below the toe of the embankment inside juncture with the floor. Grading between the fitting location and all points along the juncture of the sloping side walls and the floor shall be uniform in order to provide positive drainage.

5-4.1.6 Earth dike construction tolerances may be: Plus or minus six inches for surface variance on interior slope of dike walls; plus two percent on specified vertical dimension for dike height; plus or minus one percent on horizontal dimensions specified for dike length and width if approved by the soils engineer.

5-4.1.7 Six-inch-thick layer of fine sand or top soil shall be used for surface layer of the floor, underlaid by three-inch thickness of selected pea gravel, to provide firm, smooth bed and good drainage.

5-4.1.8 The finished surfaces of inside dike walls and floor shall be free from sharp rocks and debris.

5-4.1.9 Provide four-inch diameter porous drain pipe around perimeter of floor to ensure positive drainage of melted snow and rain water from inside dike; outlet of pipe also serves as "tell-tale leak detector" for tank.

5-4.1.10 Provide cement lined gutter shown on Fig. B-5-1 through top, and down outside of the end wall nearest inlet/outlet fitting to provide positive drainage of melted snow and rain water from tank top.

5-4.1.11 Exterior sides and top of dike walls shall be protected against surface erosion.

5-4.2 Installation.

5-4.2.1 Installation of the tank in the prepared embankment shall be accomplished with the assistance of the tank manufacturer's field technician.

5-4.2.1.1 The tank as shipped to the site shall be packaged in a material designed for ease of handling by a crane and winch and to facilitate efficient placement in the enclosure.

5-4.2.1.2 The fittings shall be installed on site.

5-4.2.1.3 The tank is filled and final adjustments on the tank shall be made to insure it rests uniformly against the embankment on all four sides. Adjustments in anchoring stakes are made at this time. The stakes shall be installed in accordance with Figure B.5.1. The tank is secured all around the top periphery of the embankment walls utilizing ropes which pass through straps built on to the outer surface of the tank and which are tied around the stakes. The tank shall also be tested for leakage after installation. This entire operation to be carried out under the direction of the tank manufacturer's field technician.

5-5 Tank Sump and Support for Bottom Fittings.

5-5.1 **Inlet-Outlet.** The concrete pad which contains the common inlet/discharge fitting and drain fitting of the tank shall be located near a corner of the embankment floor with the centerline of the inlet/discharge fitting located a minimum of seven feet from the bottom edges of the sloping embankment walls. (See Fig. B-5-1.)

5-5.2 **Finish.** The surface of the concrete pad shall be smooth, with the edges rounded. The soil-to-concrete interface around the pad shall have a slight shoulder of sand to support the tank so that the coated-fabric construction of the tank is not abraded on the edge of the concrete.

5-6 Pipe Connections and Fittings.

5-6.1 **General Information.** The tank fittings, accessories, and piping connections shall be as shown in Figs. B-5-2. The fittings attached to the tank shall be flanged type. All metal parts shall be corrosion resistant.

5-6.2 Fittings Attached to Tank.

5-6.2.1 The tank shall include either one or two access manhole fittings with cover plates in the top surface, to each of which is attached a vent pipe with a pressure-relief cap.

5-6.2.2 The fittings located in the bottom of the tank shall include a combination inlet/outlet fitting and a drain fitting. Both of these fittings shall be located and secured to the concrete sump in the bottom of the tank.

5-6.2.3 A vortex-plate assembly, as shown in Fig. B-5-2, shall be bolted to the combination inlet/outlet fitting. This assembly, in addition to controlling vortex flow, also serves as a guard to make it possible to pump the calculated water capacity out of the tank at a high rate of flow.

5-6.3 Water-Level Gage. Provide a water-level gage for the tank consisting of a sight glass, constructed of clear acrylic tubing of $2\frac{3}{8}$ -inch outside diameter. Where subject to freezing, the water gage assembly shall be installed in the heated pump house.

5-7 Tank Heating.

5-7.1 Recirculation Fitting. For tank installations in locations where weather conditions make it necessary to provide a heating system, a fitting for a water recirculation line shall be located in the bottom of the tank diagonally opposite from the concrete sump containing the inlet/outlet for the tank as shown in Fig. B-5-2. The tank heating requirements are shown in Table 5-2.

5-7.2 A water temperature of not less than 42°F shall be maintained in embankment supported tanks. A water recirculation system, with a heat-exchanger, as shown in Fig. B-5-3 is an acceptable method with arrangement as follows. When the ambient air temperature drops below 42°F , a thermostat activates a pump which draws water from the tank through the inlet/discharge and pumps the water back into the tank through the recirculation fitting located in the bottom of the tank at the end diagonally opposite from the inlet/discharge.

5-7.3 When the temperature of the water flowing through the inlet/discharge line in the pump house drops below 44°F , a second thermostat activates a heat exchanger.

5-7.4 The recirculation line shall be not less than two inches in diameter. The size of the line required is a function of tank size and the winter weather conditions prevailing at the site, as indicated in Fig. 10-1.4, showing isothermal lines for lowest one-day temperatures. Therefore, the exact size of the recirculation line shall be determined by the design engineer of the customer or contractor associated with the tank installation.

5-8 Care and Maintenance of Embankment-Supported Rubberized-Fabric Suction Tanks.

5-8.1 No waste materials, such as boards, paint cans, trim or loose material, shall be left in the tank or on the surface of the tank.

5-8.2 The access fitting(s) in the top of the tank shall be kept securely fastened as a protection against freezing and wind-storm damage.

5-8.3 Large accumulations of ice shall not be allowed to collect on the top of the tank. This may be overcome by maintaining the temperature of the water above freezing and the tank filled to capacity.

5-8.4 The tank shall be located in a protected area or be enclosed by a manproof fence.

5-8.5 Combustible material of any kind shall not be permitted near the tank; and the site shall be kept cleaned of weeds, brush and dead foliage.

5-8.6 The exposed surface of the tank shall be inspected for painting every two years and the interior of the tank shall be cleaned and inspected as required to eliminate a buildup of sediment.

5-8.7 Before painting, the surface of the tank shall be thoroughly cleaned with detergents and washed and allowed to thoroughly dry.

5-8.8 A paint and procedures of application recommended by the manufacturer shall be used to refurbish the top surface of the tank.

5-8.9 The exterior surfaces of the embankment and berm for embankment-supported tanks and care shall be taken to maintain continuous planting of grass in order to protect against erosion.

Chapter 6 Tank and Tower Foundations in the Ground

6-1 Design.

6-1.1 Concrete foundations shall be built of concrete with a specified compressive strength of not less than 3000 psi. Design, materials, and construction shall conform with the current *American Concrete Building Code Requirements for Reinforced Concrete (ACI 318)* with water considered as a live load.

6-1.2 Steel suction tanks shall be set upon a compacted crushed stone or granular base or on concrete foundations. At least four inches of crushed stone or sand, mixed with oil and laid on the compacted grade, shall be provided at the finished tank grade.

6-1.3 A reinforced concrete ringwall extending below the frost line and at least 2.5 feet deep and 10 inches thick shall be placed directly beneath the tank shell for tanks supported on crushed stone or granular bases. This ring shall project at least six inches above surrounding grade, and shall be reinforced against temperature and shrinkage and to resist the lateral pressure of the confined fill with its surcharge. The minimum reinforcing shall be .25 percent of the cross-sectional area, with additional reinforcement as may be required for resisting lateral earth pressure. Tops of ring wall foundations shall be level within $\frac{1}{4}$ inch (plus or minus $\frac{1}{8}$ inch) in one plate length (34 feet more or less) and no two points on the wall shall differ by more than $\frac{1}{2}$ inch (plus or minus $\frac{1}{4}$ inch).

6-1.4 For soil unsuitable to provide direct support for the tank without excessive settlement, shallow foundation construction may not be adequate, and a proper foundation shall be designed by a foundation engineer.

6-2 Details.

6-2.1 The tops of foundations piers shall be level and at least six inches above grade, and shall be located accurately at the correct elevations. The bottom of foundations shall be located below the frost line or at least four feet below grade, whichever is greater.

6-2.2 Pier foundations may be of any suitable shape and may be either plain or reinforced concrete. When supporting a tower, the center of gravity of pier shall lie in the continued center of gravity line of the tower column, or shall be designed for the eccentricity. The top surface shall extend at least three inches beyond the bearing plates on all sides and shall be chamfered at the edge.

6-3 Anchorage.

6-3.1 The weight of piers shall be sufficient to resist the maximum net uplift occurring with the tank empty and wind loads on the structure, as specified in previous sections. The wind shall be considered blowing from any direction. The weight of earth vertically above the base of the pier may be included.

6-3.2 Anchor bolts shall be arranged to securely engage a weight at least equal to the net uplift with the tank empty and the wind blowing from any direction. Their lower ends shall be hooked or fitted with anchor plate.

6-3.3 Anchor bolts shall be accurately located with sufficient free length of thread to fully engage their nuts. Expansion bolts are not acceptable. The minimum size of anchor bolts shall be $1\frac{1}{4}$ inch.

6-4 Grouting. Bearing or base plates shall have complete bearing on the foundation or be laid on one-inch minimum thickness cement grout to secure a complete bearing. The stressed portion of anchor bolts shall not be exposed except where necessary. If the stressed portions of anchor bolts must be exposed, they shall be protected from corrosion by encasing them in cement mortar unless they are accessible for complete cleaning and painting.

6-5 Soil Bearing Pressures.

6-5.1 The design soil bearing pressure and corresponding depth of foundation shall be determined by subsurface investigation and by review of foundation experience in the vicinity. Such an investigation shall include test borings made by or under the supervision of an experienced soils engineer or soils testing laboratory, and to the depth necessary to determine the adequacy of support (usually 20 to 30 feet minimum).

6-5.2 The design soil bearing pressure shall not exceed that which would cause settlements which impair the structural integrity of the tank.

6-5.3 Foundations shall not be constructed over buried pipes or immediately adjacent to existing or former deep excavations unless the foundation bases go below the excavation.

6-5.4 The design soil bearing pressure shall provide for a factor of safety of three based on the calculated ultimate bearing capacity of the soil for all direct vertical loads, including wind moment load on the columns. The factor of safety shall not be less than two when considering the toe pressure for the direct vertical loads, plus the overturning moment caused by wind shear at the tops of individual piers.

Chapter 7 Steel Towers

7-1 General.

***7-1.1** This section defines the design, fabrication and erection of steel towers to support water tanks. (*For fire protection, see appendix.*)

7-1.2 Height. The height of tower is the vertical distance from the top of the foundations to the bottom capacity line of the tank.

7-1.3 Strength. The material as specified shall be without defects affecting the strength or service of the structure. The workmanship shall be good, so that defects or injuries are not produced in the manufacture or erection. Unit stresses as specified shall not be exceeded. The structures and its details shall possess the requisite strength and rigidity.

7-1.4 Details. The details shall conform to the following rules and, where not covered therein, to the current *Code for Welding in Building Construction, AWS D1.0*.

7-2 Material.

7-2.1 Plates, Shapes and Tubular Columns.

7-2.1.1 Plates. Plate materials shall be open hearth, electric furnace, or basic oxygen process steel conforming to the following ASTM Specifications: A36-75a; A283-75a, Grades A, B, C, and D; except that when plates of thickness greater than $\frac{3}{4}$ in. are used, A283-75a, Grade D steels shall not be specified; or A113-75a, Grade C (cold pressing plates); as alternatives A285-74a, Grades A, B, and C; A516-74a, Grades 55 and 60; A442-74a, Grades 55 and 60 or A131-75, Grades A, B, and C may be used.

7-2.1.2 Shapes. Structural materials shall be open-hearth, electric furnace, or basic oxygen process steel conforming to the latest revision of ASTM A36-75; A113-75, Grades A and B; or A131-75, Grades A, B, or C. Copper-bearing steel with content of about 0.20 percent copper may be used. In other particulars the steel shall conform to the specifications enumerated above. (*See 2-2.1.*)

7-2.1.3 Tubular Columns. Steel pipe may be used as tubular columns or other structural members provided it complies with specifications ASTM A139-74, Grade B; ASTM A53-73a, Type E or S, Grade B; API Standard 5L, Grade B and providing the minimum wall thickness of any such material

shall comply with the design requirements and the minimum thickness requirement of this standard. For the purposes of this standard, the allowable underrun shall be subtracted from the nominal wall thickness when calculating the minimum pipe wall thickness. Tubular sections shall not be flattened to form end connections.

7-2.2 Bolts, Anchor Bolts and Rods. Bolts and anchor bolts shall conform to the latest revision of ASTM Specification A307-68, Grades A or B. ASTM—A36-75 shall be considered an acceptable alternate material for anchor bolts. Rods shall be open-hearth, electric furnace or basic oxygen process steel, conforming to the latest revision of ASTM—A36-75. (*See 2-2.2.*)

7-2.3 Pins. Pins shall comply with the latest revision of any of the following ASTM Specifications; A307-68, Grades A or B; A108-73, Grades 1018 or 1025; of A36-75. Size and diameter tolerances on turned pins shall be equal to that of cold finished shafting. Surface finish shall depend upon application, but in no case be rougher than 125 micro-inches.

7-3 Loads.

7-3.1 Dead Load. The dead load shall be the estimated weight of all the permanent construction and fittings. The unit weight of steel shall be considered as 490 pounds and of concrete as 144 pounds per cubic foot.

7-3.2 Live Load. Under normal conditions, the live load shall be the weight of all the liquid when overflowing the top of the tank. The unit weight of water shall be considered as 62.4 pounds per cubic foot. Proper provision must be made for temporary stresses during erection. When roofs have a slope of less than 30 degrees they shall be designed to support a uniform weight of 25 pounds per square foot on the horizontal projection.

7-3.3 Live Load—Large Risers.

7-3.3.1 The water directly above any riser shall not be considered as carried by the tower columns except when the riser is suspended from the tank bottom or from the tower columns.

7-3.3.2 If a hemispherical or ellipsoidal bottom is rigidly attached to the top of a large riser by a flat horizontal diaphragm plate and the riser is supported by a separate solid foundation or is suspended from the tower, the riser plates shall be considered as supporting the water load in a hollow cylinder having an outside radius equal to the radius of the riser at the tank bottom plus one-half the distance from the edge of the riser to

the connection of the flat horizontal diaphragm plate to the hemispherical or ellipsoidal bottom plates. The inside radius of this hollow cylinder shall be considered equal to the radius of the riser at the tank bottom. This load can be deducted from the weight of the tank water when designing the tower unless the riser is suspended from the tower.

7-3.3.3 If the hemispherical or ellipsoidal shape is continuous to the shell of the large riser without flat horizontal diaphragm plate and the riser is supported by a separate solid foundation or is suspended from the tower, the riser plates shall be designed to carry the water load of a hollow cylinder extending from the bottom of the tank to the top of the tank. The outside radius of this hollow cylinder shall be taken as two feet greater than, and the inside radius equal to, the radius of the riser shell at the tank bottom. This load shall not be deducted from the tank water load when designing the tank and tower except that it may be deducted for the tower design of tanks with ellipsoidal bottoms of a flat shape at the connection to risers supported by a separate solid foundation.

7-3.3.4 If the bottom is a torus shape the riser plate shall be designed to carry the weight of all water in the tank between a cylinder which intersects the bottom at its lowest elevation and a cylinder the diameter of the riser. This load can be deducted from the weight of the tank water when designing the tower.

7-3.4 Wind Load. The wind pressure shall be assumed to be 30 pounds per square foot on a vertical plane surface. In calculating the wind load on a cylindrical surface, 18 pounds per square foot shall be applied to the total area of the vertical projection, and the point of application of the load shall be at the center of gravity of the projected area. The load on the tower shall be assumed to be concentrated at the panel points. When designing for wind velocities over 100 miles per hour, all above mentioned unit pressures shall be adjusted in proportion to the square of the velocity assuming that the above pressures are for 100 miles per hour.

7-3.5 Balcony and Ladder Loads. A vertical load of 1,000 pounds shall be assumed to be applied to any 10 square feet of area on the balcony floor and on each platform; 500 pounds applied to any 10 square foot area on the tank roof; 350 pounds on each vertical section of ladder; and all of the structural parts and connections shall be designed to withstand such loads. The above loadings need not be combined with snow loading.

7-3.6 Earthquake Load. Tank towers shall meet the local requirements for resisting earthquake damage.

7-4 Unit Stresses.

7-4.1 General. The maximum stresses in pounds per square inch produced by the above loads shall not exceed the following:

Table 7-4.1

AXIAL TENSION: On net section, rods and A36-75 structural steel shapes
15,000

AXIAL COMPRESSION: Gross section of columns and struts of structural

shapes: $\frac{P}{A} = \left\{ \begin{array}{l} \frac{18,000}{L^2} \\ 1 + \frac{18,000r^2}{L^2} \end{array} \right\}$ or 15,000 psi, whichever is the smaller.

For tubular columns and struts: $\frac{P}{A} = XY$, in which $X = \frac{18,000}{1 + \frac{L^2}{18,000r^2}}$
or 15,000 psi, whichever is the smaller, and

$$(1) Y = \left(\frac{2}{3}\right) \left(100 \frac{t}{R}\right) \left[2 - \left(\frac{2}{3}\right) \left(100 \frac{t}{R}\right) \right]$$

$$(2) Y = \text{Unity (1.00)} \text{ for values of } \frac{t}{R} \text{ equal to or greater than } 0.015.$$

In the foregoing formulae, the symbols have the following meanings:

P = total axial load in pounds.

A = cross-sectional area in square inches.

L = effective length in inches.

r = least radius of gyration in inches.

R = radius of the tubular member to the exterior surface in inches.

t = thickness of the tubular member in inches: minimum allowable thickness $\frac{1}{4}$ inch.

All circumferential joints in tubular sections shall be butt joints welded for complete penetration.

Compression on short lengths — 18,000 psi. (See 7.5.4.)

7-4.2 Slenderness Ratio. The maximum permissible slenderness ratio L/r for compression members carrying weight or pressure of tank contents shall be 120.

The maximum permissible slenderness ratio L/r for compression members carrying loads from wind and earthquake only shall be 175.

The maximum permissible slenderness ratio L/r for columns carrying roof loads only shall be 175.

7-4.3 Bending.

Table 7-4.3

Tension on extreme fibers, except column base plates	15,000
Column base plates	20,000
Compression on extreme fibers of rolled sections, and plate girders and built-up members for values of:	
$\frac{ld}{bt}$ not in excess of 600	15,000
$\frac{ld}{bt}$ in excess of 600	9,000,000
	$\frac{ld}{bt}$

in which l is the unsupported length and d is the depth of the member; b is the width; and t the thickness of its compression flange; all in inches; except that l shall be taken as twice the length of the compression flange of a cantilever beam not fully stayed at its outer end against translation or rotation.

Pins, extreme fiber	22,500
Cast steel	11,250

7-4.4 Shearing.

Table 7-4.4

Pins and turned bolts in reamed or drilled holes	11,250
Unfinished bolts	7,500
Webs of beams and plate girders, gross section	9,750
Cast steel	7,325
Tank plates and structural connection materials	11,250

7-4.5 Bearing.

Table 7-4.5

	<i>Double Shear</i>	<i>Single Shear</i>
Turned bolts in reamed or drilled holes	30,000	24,000
Unfinished bolts	18,750	15,000
Pins	24,000	
Contact area of milled surfaces	22,500	
Contact area of fitted stiffeners	20,250	
Expansion rollers and rockers (pounds per linear inch) where d is the diameter of roller or rocker in inches		600d

7-4.6 Combined Stresses: Members subject to both axial and bending stresses shall be so proportioned that the sum of the stresses at the critical point does not exceed the allowed axial stress.

7-4.7 Wind and Earthquake Allowances.

7-4.7.1 Wind. For stresses due to a combination of dead load, live load and wind load as specified in this standard and for wind load alone, the above working stresses may be increased a maximum of 25 percent. In no case shall the resulting section be less than that required for dead and live loads alone.

7-4.7.2 Earthquake. For stresses due to a combination of dead load, live load and earthquake load as specified in this standard and for earthquake load alone, the above working stresses may be increased up to $33\frac{1}{3}$ percent. In no case shall the resulting section be less than that required for dead and live loads alone.

7-4.7.3 Wind and earthquake need not be considered as acting simultaneously.

7-4.8 Fillet and Groove Welds. Welded joints shall be proportioned so that the loads specified in Section 7-3 shall not cause stresses therein in excess of design stresses obtained by applying to the allowable working stresses in the base material, the efficiencies in the current *American Water Works Association Standard for Steel Tanks, Standpipes, Reservoirs, and Elevated Tanks, for Water Storage, AWWA D100-73, AWS D5.2-73.*

7-5 Details of Design.

7-5.1 Sections. Sections shall preferably be symmetrical. Members shall preferably be built of standard structural shapes or of tubular sections. Structural shapes shall be designed with open sections to permit painting all surfaces exposed to air or moisture and subject to corrosion. Tubular sections of columns and struts shall be airtight.

7-5.2 Minimum Thickness—General. The minimum thickness of metal shall be $\frac{1}{4}$ inch except in the webs of channels and I-beams and in minor parts which carry no load. The minimum size of sway rods shall be $\frac{3}{4}$ inch.

7-5.3 Columns.

7-5.3.1 Splices. Column splices shall be designed to withstand the maximum possible uplift or at least 25 percent of the maximum compression whichever is greater. The abutting joints of welded tubular columns may be either butt welded with a backer strip or spliced by plates welded to both sections being joined. Where a horizontal plate minimum thickness of $\frac{1}{4}$ inch is used to seal the top and bottom of a column section the backing strip or splice plate may be omitted.

7-5.3.2 Strength Diaphragm in Tubular Columns. A

substantial diaphragm or equivalent resistance to local tube distortion shall be provided at all panel points, points of concentrated loading and at the top diagonal wind rod connections. When a horizontal plate (minimum thickness $\frac{1}{4}$ inch) is used to seal the top and/or bottom of a column section and is located within 18 inches of the panel point a diaphragm plate is not necessary.

7-5.4 Combined Shapes. The shapes shall be separated at least $\frac{3}{8}$ inch if they are not contact. For tension members, the component parts of which are separated by spacers, the spacer shall not be over 3 feet, 6 inches apart and shall be attached by welding or bolting.

7-5.5 Starred Angles. Compression members built of two angles in a star section shall have pairs of tie plates or angles spaced not over 20 inches on center for 3-inch, 24 inches for 4-inch, 36 inches for 5-inch, 42 inches for 6-inch, and 48 inches for 8-inch angles. The tie plates or angles shall be connected to each of the angles of the compression members by not less than two bolts and at least three bolts shall be used in 6-inch or 8-inch angles. Equivalent welded tie plates may be used.

7-5.6 Connections—General. The strength of connections shall be sufficient to transmit the full stress in the member. A group of bolts at the end of any member, transmitting stress into that member should have its center of gravity in the line of the center of gravity of the member; if not, provision shall be made for the effect of the resulting eccentricity. Connections between the columns, struts and tension members shall be made by gusset plates which may also serve as splice plates. Diagonal bracing shall, when possible, be connected to the same gusset plates that connect the columns and struts. Bolts shall not be subjected to tensile stress.

7-5.7 Pins. Adjustable tension members shall be connected to gusset plates by finished or cold rolled steel pins. Pins shall be headed on one end and threaded on the other, threaded on both ends, or plain on each end with washers welded on to them. Threaded ends shall be fitted with nuts and the threads shall be burred outside the nuts to prevent easy removal of the nuts.

7-5.8 Net Area of Pin-Plate. The net area of the gusset-plate section ahead of a clevis pin shall not be less than 62.5 percent of the net area of the tension member.

7-5.9 Clevises, Forked Ends, Turnbuckles.

7-5.9.1 Bar or plate clevises, forged clevis-nuts, or forked ends shall be used to connect adjustable tension members to the

clevis-pins. The strength of clevises shall not be less than that of the tension member. The minimum sectional area through forked ends shall not be less than the area of the tension member at its smallest section.

7-5.9.2 Clevis plates may be fusion welded to wind rods. There shall be two plates at each end of the rod. The plates shall be symmetrical. There shall not be any open spaces between rod and clevis plates. The plates shall be bent in easy lines to reduce to a minimum the stretch under load, or they shall be flat with filler plates on the pin. In any case, the clevis pin shall be designed to carry the maximum stresses, including bending, without overstressing.

7-5.9.3 Turnbuckles shall be of the open type and shall have a strength not less than that of the tension member.

7-5.10 Tank Connection. The center of gravity lines of the column, circular girder, the lowest plate of the tank cylinder shall meet at a point or the columns shall be designed for the eccentricity. The combined axial and bending stress in the detail connecting the top of the column to the tank plate shall not be more than $33\frac{1}{3}$ percent in excess of the allowable axial working-stress which in the case of compression, is that allowed for short lengths.

7-5.11 Tie Plates. The main constituent parts of columns shall be solidly tied together at points of connection of tension or compression members.

7-5.12 Length of Tension Members. The horizontal projection of the unsupported length in inches of a nonadjustable tension member in a horizontal or inclined position shall not exceed 200 times the radius of gyration about the horizontal axis.

7-5.13 Column Bases and Caps.

7-5.13.1 Columns shall have bases built of steel plates and structural shapes. The lower end of each column shall be faced and must bear fully on the base plate or shall have sufficient welding to transmit loads to the base plate. The base plate and anchor bolt connections to the column shall be designed to load the foundation uniformly and also to transmit the net uplift from the column when subjected to the greatest possible wind stress to the foundations with the tank empty. Footings shall be designed without pockets or else be filled with concrete and flashed with asphalt to prevent the collection of dirt and moisture inside.

7-5.13.2 When the tower supports a flat bottom tank, the columns shall have steel caps designed to transmit the load from the grillage beams concentrically to the columns. The upper ends of the columns shall be faced and bear fully on the cap plates or shall have sufficient welding to transmit all loads to the top plate. If the batter of columns exceeds 1.8 inches horizontal to 12 inches vertical, rigid ties shall be provided between the column bases.

7-5.14 Circular Girder with Inclined Columns. Tops of inclined columns shall be connected by a continuous, horizontal circular girder if the tank bottom is suspended. The outer flange should preferably be symmetrical about the web plate, but if eccentric, the allowable working stresses for the flanges shall be reduced 25 percent. The bending moment shall be considered as carried entirely by the flanges, the shear by the web, and the compression by the flanges and web in proportion to their areas at the section considered. Splices shall be designed to transmit the load in the spliced member. The horizontal component of the maximum column load shall be transmitted to the girder by welding. The circular girder may be used as a balcony. Drain holes shall be provided in the web plate.

7-5.15 Circular Girder with Vertical Columns. If the columns are vertical and the tank bottom suspended, the circular girder shall be as stated in 7-5.14 or shall be a structural shape connected to the tank by welding.

7-5.16 Interior Bracing. Bracing inside the tank shall be avoided if possible but if used, 1/16-inch additional thickness shall be added to the calculated sections to provide for corrosion. The sections shall be open to facilitate cleaning and painting.

7-5.17 Top Struts. The thrust from battered columns supporting a flat bottom tank shall be resisted by struts connected to the extreme top of the columns or to the cap plates on all sides of the tower.

7-5.18 Grillage. When the tower supports a flat bottom tank all of the supporting beams shall be steel and shall be welded, or bolted to the post cap girders. The latter shall be welded, or bolted to the column caps and shall be braced to prevent overturning. The load on the outside grillage beams shall be considered as increasing from zero at the ends to a maximum at the center.

7-5.19 Base Braces. When the tower is supported by a building, insecure earth, or foundations extending more than

about one foot above grade, rigid members shall be placed between the adjacent column bases or foundations. Rigid members shall be provided between adjacent column bases when the columns are welded to the base plates and the batter exceeds 1.8 horizontal to 12 vertical.

7-5.20 Web Stiffeners. Web stiffeners shall be provided at points of concentrated loading on beams and girders when necessary to prevent buckling of webs. Web stiffeners shall be designed in accordance with the specifications of the American Institute of Steel Construction.

7-5.21 Large Risers. Water Spheres.

7-5.21.1 Large steel plate pipes three feet or more in diameter shall be designed to withstand stress caused by the weight or pressure of the tank and riser contents and also the load imposed upon the top of the riser pipe by the tank bottom or by members supporting the tank bottom as specified in 2-3.2. If the design of the riser plates is controlled by hoop tension, 0.3 of the compressive stress in the vertical direction shall be added to the full calculated tensile stress in the horizontal direction in determining the thickness. If the design of the riser plates is controlled by vertical compression, 0.3 of the tensile stress in the horizontal direction shall be added to the full calculated compressive stress in the vertical direction in applying the formulae in 2-4.1.

7-5.21.2 The thickness of the bottom ring of the steel plate shall be sufficient so that the specified unit stresses shall not be exceeded when combined with bending, or other stress around the manhole or other openings.

7-5.21.3 For the design of water spheres and conical frustum at the base of the sphere, the symbol R representing the radius in 2-4.1 shall be taken as the radius of the sphere, or the radius of the cone perpendicular to the conical surface.

7-5.21.4 The surface of the conical frustum supporting the sphere shall not be inclined to the horizontal at an angle less than 30° . If compression reinforcing is required at the junction of the conical frustum and the tubular support, the effective width in inches of each plate at the joint that may be considered as contributing to this required reinforcing shall be limited to the square root of the product of each plate thickness in inches and its respective inside radius in inches.

7-5.22 Anchor Bolts. In earthquake locations there shall be at least two anchor bolts per column.

7-6 Workmanship.

7-6.1 Shearing. All shearing shall be done neatly, and material over $\frac{3}{4}$ inch thick, except base plates or other plates not carrying actual stress, shall have $\frac{1}{8}$ inch planed from the sheared edges.

7-6.2 Straightening and Fitting. The several pieces forming built sections shall be straight and shall fit close together.

7-6.3 Use of Bolts and Welding. Members shall be welded throughout, except in field connections of nonadjustable tension members carrying wind stress only, and of compression members and grillages in towers supporting tanks of 30,000 gallons or less capacity, where unfinished bolts may be used. The threads of unfinished bolts shall be burred outside of the nuts. High tensile bolts or the equivalent may be used in field connections of towers supporting tanks of 100,000 gallons or less capacity. Where machined bolts are needed, the bolt holes shall be reamed parallel and the bolts machined to a driving fit, burring the threads outside the nuts unless special approved locking devices are provided.

7-6.4 Threads and Nuts. Screw threads on rods shall be cut or rolled to the United States Standard or shall have self-locking threads, and shall make tight fits in nuts and turnbuckles. All threads and nuts in turnbuckles shall be engaged. Machined bolts shall have threads entirely outside the holes, and washers not less than $\frac{1}{8}$ inch thick shall be used under the nuts. Nuts on all bolts shall be drawn tight and threads burred outside the nuts.

7-6.5 Grouting of Base Plates. During field erection the columns shall be built on thin metal wedges which, after structure is completed, shall be driven to equal resistance so that all columns will be loaded equally and then the spaces beneath the base plates and the anchor bolt holes completely filled with portland cement mortar, consisting of a minimum of one part portland cement to three parts clean sand.

7-6.6 Assembly.

7-6.6.1 Component parts of built-up members shall be held in firm contact by adequate clamps or other means. Spaces in which inaccessible corrosion can form shall not be left between component parts of members.

7-6.6.2 Erection bolts or other positive devices imparting sufficient strength and stiffness to resist all temporary weights

and lateral loads, including wind, shall be used for temporarily fastening the members together and bracing the framework.

7-6.7 Alignment. Members and all component parts shall be straight and free from appreciable buckles or warping.

7-6.8 Tubular Column Distortion. The column axis shall not deviate from a straight line more than $1/1000$ of the laterally unsupported length. At no cross-section shall the difference between the maximum and minimum outside diameters exceed 2 percent of the nominal outside diameter. Local dents shall be no deeper than the plate thickness.

7-7 Accessories.

7-7.1 Connections. Connections shall be provided on the tower for the necessary pipe and frostproof casing braces.

7-7.2 Ladders—General. A steel ladder shall be placed on one of the tower columns extending from a point within easy reach of the ground to the balcony around the tank or to the revolving tank ladder. The ladder shall not incline outward from the vertical at any point. When the tower supports a wood tank or when the balcony is not used as a circular girder, the ladder may pass through an opening in the balcony not less than 18 x 24 inches in the clear. The ladder shall be securely fastened at its upper end. Welding of ladders and their connections is permitted. Ladders for pedestal supported tanks shall preferably be placed inside the pedestal.

7-7.3 Ladders—Details.

7-7.3.1 The ladder shall have not less than $2 \times 5/16$ inch flat side bars spaced at least 16 inches apart and at least $3/4$ -inch round or square rungs, spaced 12 inches on centers. The rungs shall be firmly welded to the side bars. The sections of the ladder shall be connected by lap or butt joints. If joints are bolted, at least two $1/2$ -inch bolts shall be used on each side of each splice.

7-7.3.2 The ladder shall be connected to the tower column or the pedestal support by flat bar brackets spaced not over 12 feet apart. The brackets shall be rigidly connected to the column and designed to support a load of 350 pounds on the ladder. All ladders must be equipped with a cage or rigid notched rail ladder safety device.

7-7.3.3 Other arrangements of tower ladders may be permitted provided approval is first obtained from the authority having jurisdiction. Such arrangements are not recommended,

however, unless made necessary by a special design of tower, and with distances greater than 12 feet between supports, the side bars of the ladder should be made of angles not lighter than $1\frac{3}{4} \times 1\frac{1}{4}$ inches or their equivalent.

7-7.4 Walkway.

7-7.4.1 A walkway at least 18 inches wide, extending from a point accessible from the tower ladder to an expansion joint located under the tank and terminating in a platform giving at least 20 inches clearance around the enlarged portion of the frostproofing casing, shall be provided when the tower is 30 feet or more in height. Walkway flooring shall be 2 inches dressed plank spaced $\frac{1}{2}$ inch apart, or $\frac{1}{4}$ inch steel plate with drain holes. The walkway and platform shall be rigidly supported and braced laterally to prevent swinging.

7-7.4.2 All supports shall be of steel and shop connections shall be welded. A railing 36 inches high shall be placed on each side of the walkway and around the outer edge of the platform and shall be rigid. The top rail and posts shall be of not less than 1-inch pipe or of angles not lighter than $1\frac{3}{4} \times 1\frac{3}{4} \times \frac{3}{16}$ inch. An intermediate rail shall be provided or diagonal laticing used. Ends of threads shall be burred on all bolted connections.

7-7.5 Balcony.

7-7.5.1 Towers over 20 feet high, and having a horizontal circular girder at the top of the inclined columns, to resist the inward thrust from the columns, shall be provided with a balcony at least 24 inches wide around the base of the cylindrical portion of the tank. A rigid railing at least 36 inches high shall be provided around the outside of the balcony. The top rail and posts shall be not lighter than $1\frac{3}{4} \times 1\frac{3}{4} \times \frac{3}{16}$ inch angles or their equivalent. An intermediate rail or laticing shall be provided.

7-7.5.2 A balcony shall not be required for pedestal or tripod supported tanks. For inclined column tower supported tanks without a cylindrical shell, a balcony shall not be omitted without the approval of the authority having jurisdiction.

7-7.6 **Painting Inaccessible Parts.** Parts inaccessible after fabrication, but subject to corrosion, shall be protected by paint before assembly.

NOTE: The interior of hermetically sealed surfaces, including such tubular columns need not be painted.

7-7.7 Shop Painting. All steel, except where encased in concrete, or where edges or surfaces are to be welded shall be cleaned by blasting or pickling and shop primed with one coat of red lead paint in accordance with the requirements for Outside System No. 1 (alkyd) of AWWA Standard D102-64. The appropriate primers for other exterior paint systems may be used provided permission is first obtained from the authority having jurisdiction. In any event the primer shall be the same as selected for exterior tank surfaces (*see 2-7.11*).

7-7.8 Field Painting. After construction, all weld seams, unprimed shop margins, field bolts, and any areas on which the shop paint has been damaged shall be blast cleaned and patch primed with the same primer used in the shop. Two overall finish coats shall be used in accordance with the requirements for Outside Paint System No. 1 of AWWA Standard D102-64. The color shall be as specified by the purchaser and the total dry film thickness shall be 4.0 mils minimum. As provided by the AWWA Standard, the purchaser may specify an extra complete coat of primer for a total minimum thickness of 5.0 mils for the more severe atmospheric exposures. Other finish coats may be used provided they are compatible with the shop primer and provided permission is first obtained from the authority having jurisdiction. In any event, the finish coats shall be the same type selected for exterior tank surfaces (*see 2-7.12*).

7-7.9 Painting Application. All painting shall be accomplished in accordance with the appropriate requirements of SSPC Paint Application Specification No. 1 (Shop Field and Maintenance Painting) of latest revision.

Chapter 8 Pipe Connections and Fittings

8-1 General Information.

8-1.1 Watertight Intersections at Roofs and Floors.

8-1.1.1 The intersections of all tank pipes with roofs and concrete or waterproof floors of buildings shall be watertight. Where tank pipes pass through concrete roofs a watertight intersection shall be obtained by fittings calked with oakum or by pouring the concrete solidly around the pipes each of which has first been wrapped with two or three thicknesses of building paper. If concrete is used, the upper side of the intersection shall then be well flashed with a suitable firm waterproof material that will be noncracking and retain its adhesion and flexibility. Wood roofs shall also be built tightly around the pipes and made watertight by fittings calked with oakum or by adequate flashing.

8-1.1.2 Where tank pipes pass through a concrete or waterproof floor, a watertight intersection, as described above, shall be obtained so that water from above cannot follow down the pipe to lower floors or the basement.

8-1.2 Rigid connections to steel tanks shall be made by means of a welded joint with approval of the details by the authority having jurisdiction. A rigid connection to a wood tank shall be made by means of a running nipple or by threaded flanges, one inside and one outside the tank, bolted together through the wood with movable nuts outside. Lead washers shall be placed under bolt heads, and rubber gaskets under flanges, except for hot-water or steam pipes, which shall have lead gaskets.

8-1.3 **Placing Tank in Service.** All tank piping shall be done immediately after completion of the tank and tower so that the tank can be filled and placed in service promptly. Wood tanks may be greatly damaged by shrinkage if left empty after being erected.

8-1.4 **The Contract.** To ensure installation of adequate equipment the contract shall specify that the finished work shall conform with this standard in all respects.

8-1.5 **Approval of Layouts.** Complete information regarding the tank piping on the tank side of the connection to the yard or sprinkler system shall be submitted to the authority having jurisdiction for approval. The information submitted shall include the size and arrangement of all pipes; the size, location and type of all valves, tank-heater and other accessories;

the steam pressures available at the heater; the arrangement of and full information regarding the steam supply and return system together with pipe sizes; and the details of construction of the frostproof casing.

8-1.6 Inspection of Completed Equipments.

8-1.6.1 Immediately after the work is finished, a joint inspection of the tank piping shall be made by a representative of the contractor and a representative of the owner.

8-1.6.2 Written reports of these inspections shall be made in triplicate and a copy signed by the contractor and the owner shall be sent to the authority having jurisdiction.

8-1.6.3 This joint inspection will provide reasonable assurance that there are no defects in the work of sufficient importance to prevent the system being put immediately into service. It will also make the owner's representatives more familiar with the system.

8-1.7 Care and Maintenance. A tank and its piping constitute an important part of the fire protective equipment and shall be carefully maintained to ensure reliability. Annual inspection of the tank piping, controlling valves, check valve, heating system, mercury gage, expansion joint and all other accessories shall be made to make sure that everything is in good repair. At times of cleaning or painting the tank interior or making repairs it shall be ascertained that the tank is free of foreign material and all piping clear of obstruction before placing the tank in service again. The heating system shall be given daily supervision during freezing weather. The expansion joint shall be repacked and adjusted if it binds or develops leaks.

8-1.8 Precautions During Repairs. Whenever the tank is drained the authority having jurisdiction shall be notified well in advance. The following precautions shall be observed:

(a) Plan work carefully to enable completion in the shortest possible time.

(b) If available, a second reasonably reliable water supply with constant suitable pressure and volume, usually public water, will be connected to the system.

(c) If such a supply is not available, the fire pump shall be started and kept running to maintain suitable pressure in system.

(d) Additional portable fire extinguishers shall be placed in buildings where protection is impaired and extra, well-instructed watchmen shall be continuously on duty.

(e) The members of the private fire brigade as well as the public fire department shall be familiar with conditions.

8-1.9 Heater Thermometer. One of the chief advantages of the gravity circulation system of heating tanks is the fact that it permits convenient observation of the temperature of the coldest water at a thermometer located in the cold-water return-pipe near the heater. Failure to provide an accurate thermometer at this point or to observe it daily and keep it registering the proper temperature is to forfeit this advantage and may result in freezing the equipment.

8-1.9.1 For a gravity circulating heating system (Figures B-8-1, B-8-2, B-8-3, B-8-4, B-8-5, B-10-1, B-10-2, B-10-5) an accurate thermometer shall be located as specified in 10-1.7.2.

8-1.9.2 For a tank containing a radiator steam heater, an accurate socket thermometer shall be located as specified in 10-3.6.

8-1.10 Connections For Use Other Than Fire Protection. The authority having jurisdiction shall be consulted before the tank is designed where water for other than fire protection purposes is to be drawn from the tank. Circulation of water through the tank causes an accumulation of sediment that may obstruct the piping or sprinklers. A leak or break in a pipe for use other than fire protection may seriously impair the fire protection by partly or completely draining the elevated tank.

8-1.11 Filling. The tank shall be kept well filled, never allowing the water level to be lower than 3 or 4 inches below the designated fire service level. The filling bypass shall be kept closed when not in use.

***8-1.12 Water Level Gages.** The approved mercury gage is considered the most reliable water-level indicator for elevated tanks. The gage shall be carefully installed and adjusted and then properly maintained as described in A-8-1.12. A mercury catcher shall be provided at the top of the gage glass if there is any probability that mercury may be blown out because of fluctuating water pressure.

8-1.12.1 When a steel gravity tank is not located near a heated building of sufficient height in which the mercury gage can be located and heat is required to prevent freezing of the gage, a six-inch diameter altitude gage having a noncorrodible case may be used and located in the valve pit or heater house to prevent freezing, when permitted by the authority having jurisdiction. Provide a blow-off cock between the gage and the connection to the tank riser.

8-1.12.2 An approved, closed circuit, high and low level electric alarm may be required by the authority having jurisdiction in which case the standard for protective signaling systems shall be followed. Provision shall be made for attachment of a calibrated test gage.

8-1.13 Frostproof Casing. The frostproof casing shall be kept in good repair and weathertight throughout. Its insulating qualities are greatly impaired if joints spring open or if the casing settles away from the tank or if rotting occurs around the base.

8-1.14 Tanks with Large Risers.

8-1.14.1 Large steel plate riser pipes, three feet or more in diameter without frostproof casing, are acceptable if properly heated. (*See Chapter 10.*) The fire hazard and upkeep of the frost casting and provision of an expansion joint or walkway are avoided. On the other hand, painting and heating of the larger riser and building of the stronger and larger valve pit costs more than for equipments with the smaller risers.

8-1.14.2 The check valve and gates in the discharge pipe, filling arrangement, overflow, drain and mercury gage are generally provided and sometimes a blow-off valve is furnished near the base of the larger riser. A manhole at least 12 inches by 16 inches shall be provided with its lower edge level with the discharge piping protection specified.

8-1.15 Discharge Piping Protection. For tanks with a large steel plate riser (3 feet diameter or larger), the inlet to the vertical discharge pipe located within the large riser shall be protected against entry of foreign material. This may be done with an American National Standards Institute 125 pound flanged tee with the "run" of the reducing tee placed horizontal and with horizontal outlets one pipe size smaller than the discharge pipe or with a fabricated plate extending at least 4 inches beyond the outside diameter of the pipe. The plate shall be supported by at least three supporting bars 1-1/2 inch \times 1/4 inch, 5/8 inch round rods, or equivalent, which elevate all portions of the plate a distance at least equal to the pipe diameter above the discharge pipe inlet. Attachments of the supports to the discharge pipe may be made directly by welding or bolting or by a 1/4 inch thick tightly fitting sectional clamp or collar having 5/8 inch bolts in the outstanding legs of the clamps or collar. A clearance of at least 6 inches shall be provided between all portion of the flanges of a tee or fabricated plate and the large riser plate.

8-1.16 Steel Pipe.

8-1.16.1 Steel pipe shall conform to ASTM-A53-73, Type S, Grade A or B, manufactured by the open-hearth, electric furnace or basic-oxygen process or to ASTM-A 106-75a, Grade A or B.

8-1.16.2 For steel pipe in contact with storage water, the following shall apply: Steel pipe smaller than 2 inch shall not be used. Steel pipe 2 inch to 5 inch shall be extra strong weight. All steel pipe 6 inch and larger shall be standard weight.

8-2 Discharge Pipe.

8-2.1 At Roofs and Floors. The intersection of the discharge pipe, as well as all other tank pipes, with the roof or waterproof or concrete floors shall be watertight. (See 8-1.1.)

8-2.2 Size.

8-2.2.1 Conditions at each individual plant influence the size of discharge pipe needed. The diameter, however, shall not be less than 6 inch for tanks up to and including 25,000 gallons capacity and generally not less than 8 inch for 30,000 to 100,000 gallons inclusive or 10 inch for greater capacities.

8-2.2.2 Smaller pipe than specified above (not less than 6 inches) may be permitted in some cases if conditions are favorable and large flows of water not needed. On the other hand, larger pipe may be required because of the location and arrangement of piping, height of buildings or other conditions. In all cases approval of the pipe sizes shall be obtained from the authority having jurisdiction.

8-2.3 Kind of Pipe and Gaskets. The discharge pipe shall be flanged cast-iron or steel pipe, welded steel, or of approved corrosion-resistant materials with flanged or welded connections except that for steel-plate risers, standpipes, or suction tanks the short length of vertical pipe from the base elbow through the bottom plate may be of cast-iron with spigot at the lower end. If flanges are used, copper, lead, or good-quality rubber gaskets shall be placed between the flanges.

8-2.4 Braces. The pipe and/or large steel plate riser pipe shall be braced laterally by rods not less than $\frac{5}{8}$ inch in diameter, connected to the tower columns near each panel point. End connection of braces shall be by eyes or shackles; open hooks are not permitted.

8-2.5 Support. The discharge pipe shall be supported at its base by a double-flanged base elbow resting on a concrete or

masonry foundation, except that for tanks with steel plate risers or for suction tanks or standpipes the base elbow may have bell ends. A leaded joint at the connection of yard piping to the base elbow shall be strapped or the base elbow adequately backed up by concrete. If the discharge pipe is offset inside of a building, it shall be supported at the offset by suitable hangers from the roof or floors, in which case the base elbow may not be required. Large steel riser pipes shall be supported on a reinforced concrete pier designed to support the load specified in 9-1.4. Concrete grout shall be provided beneath the large riser to give uniform bearing when empty.

8-2.6 Offsets. The discharge pipe outside of buildings shall extend vertically to the base elbow or building roof without offsets if possible. If an offset is unavoidable it shall be supported at the offsetting elbows and at intermediate points not over 12 feet apart and shall also be rigidly braced laterally. The supports shall consist of steel beams across the tower struts or of steel rods from the tower columns so arranged that there will be no slipping or loosening.

8-2.7 Expansion Joint. Tanks with flanged or welded pipe risers (12 inch diameter and under) shall have an approved expansion joint on the fire-service discharge pipe, when the tank is on a tower which elevates the bottom 30 feet or more above the base elbow or any offset in the discharge pipe. Expansion joints shall be built to conform to 8-3.

8-2.8. Rigid Connection.

8-2.8.1 When the distance between the tank bottom and the base elbow or supporting hanger is less than 30 feet the discharge pipe shall be connected by an expansion joint built to conform to 8-3 or shall be rigidly connected in accordance with 8-1.2. The top of the pipe (or fitting attached to the top) shall extend above the inside of the tank bottom or base of a steel plate riser to form a settling basin.

8-2.8.2 The top of a steel plate riser shall be connected rigidly to the suspended bottom of the tank. The discharge pipe from a steel plate riser of a tank over a building shall be connected rigidly to the base of the larger riser. A rigid flanged connection or welded joint or a leaded joint may be used between the discharge pipe and the bottom of a suction tank or standpipe or the base of a steel plate riser of a tank on an independent tower, but, special approval of details shall be obtained from the authority having jurisdiction. When the base of a steel plate riser is in its final position on a concrete support, it shall be grouted to obtain complete bearing.

8-2.9 Swing Joints. If the vertical length of discharge pipe below an offset either inside or outside of a building is 30 feet or more, a four-elbow swing joint, of which the offset forms a part, shall be provided in the pipe.

8-2.10 Settling Basin. The depth of the settling basin in the tank bottom shall be 4 inches for a flat-bottom tank and 18 inches for a suspended-bottom tank. The settling basin at the base of a large steel plate riser shall be at least 3 feet deep.

8-2.11 Check Valve. An approved check valve shall be placed horizontally in the discharge pipe and shall be located in a pit under the tank when the tank is on an independent tower. (*Fig. B-8-1.*) When the tank is located over a building, the check valve shall ordinarily be placed in a pit, preferably outside the building. (*Fig. B-8-2.*) When yard room is not available, the check valve may be located on the ground floor or in the basement of a building provided that it is adequately protected against breakage.

8-2.12 Controlling Valves.

8-2.12.1 An approved gate valve, generally with an indicator post, shall be placed in the discharge pipe on the yard side of the check valve between the check valve and any connection of the tank discharge to other piping. (*Figure B-8-1.*) If yard room for an indicator post is not available, an approved outside screw and yoke gate valve similarly arranged, but inside of the valve pit or room, may be used.

8-2.12.2 An approved outside screw and yoke gate valve shall be placed in the discharge pipe on the tank side of the check valve. (*Figure B-8-1.*) If the tank is on an independent tower this valve shall be placed in the pit with the check valve preferably on the yard side of the base elbow. If the tank is located over a building the valve shall be placed under the roof near the point where the discharge pipe enters the building. (*Figure B-8-2.*)

8-3 Expansion Joint.

8-3.1 Connection to Tank. An approved expansion joint shall be used when required by 8-2.7 or used per 8-2.8.1. The expansion joint may be placed immediately above the foot elbow or may be connected to the tank bottom using welding for a steel tank and bolts or a special screw fitting for a wood tank. The movable nuts on bolts shall be on the outside of the tank.

8-3.2 General Design. The design shall be such that the joint will operate reliably over periods of years without attention and shall be of adequate strength to resist the stresses and corrosion to which it will be subjected. One or both of two parts that slide, one upon the other, shall be brass or other noncorrodible metal of ample strength and wearing qualities.

8-3.3 Clearances. At least 1/16-inch clearance shall be provided around all movable parts to prevent binding and at least 1/2-inch between the cast-iron body and an iron or steel slip-tube.

8-3.4 Body. The body shall be steel or cast iron and if connected to the tank bottom shall provide for a settling basin extension of proper length (8-2.10). Provision shall be made for a packing space of adequate size (8-3.7).

8-3.5 Gland. The adjustable gland shall be brass or iron and must be connected to the body casting preferably with four standard bolts at least 5/8-inch in size and of sufficient length to permit full adjustment.

8-3.6 Slip-Tube. The sliding tube at the top of the discharge pipe shall be brass or iron with triple plated brass outer surface, if the gland is iron. If the gland is brass, the slip-tube may be cast-iron or steel, but in this case the top of the packing space shall be formed with brass and a clearance of at least 1/2-inch must be provided at all points between the cast-iron body and the slip-tube. The upper part of the slip-tube shall be machined over a length such that the top of the gland can be dropped to 6 inches below the bottom of the body casting so as to permit repacking. The top of the slip-tube shall be located about 5 inches below the top of 4-inch settling-basin extensions and 12 inches below the top of 18-inch settling-basin extensions.

8-3.7 Packing. The packing shall consist of asbestos wicking saturated with rape oil and graphite or an equally suitable material. Packing at least 2 inches deep and one-half inch thick shall be provided in the packing space.

8-3.8 Connections For Use Other Than Fire Protection. Connections for use other than fire protection should preferably not be made but when unavoidable, they shall be connected rigidly to the tank bottom and a standard expansion joint if needed shall be provided in each such pipe below and entirely independent of the tank.

8-4 Filling.

8-4.1 Bypass Around Check Valve. When the tank is to be filled from the fire protection system under city or fire-pump

pressure, the filling pipe shall preferably be a bypass around the check valve. (*Figures B-8-1 and B-8-2*). The bypass shall be connected into tapped bosses on the check valve or into the discharge pipe between the check valve and all other valves. The bypass shall be not less than 2 inches. An outside screw and yoke gate valve shall be placed in the bypass and kept closed except when the tank is being filled.

8-4.2 Filling Pumps. When the tank is to be filled by a special filling pump, the pump and connections shall be of such size that the tank can be filled in 8 hours. The filling pipe shall be at least 2 inches in diameter and may, except as noted in 8-4.3, be connected directly into the tank discharge pipe, in which case an approved outside screw and yoke gate valve and a check valve shall be placed in the filling pipe near the tank discharge pipe, the check valve being on the pump side of the gate valve. The filling pump suction-pipe shall not be connected to a fire-service main supplied from the tank. The filling valve shall be open only when the tank is being filled.

8-4.3 Filling from Drinking Water Supply. When the water in the fire protection system is not suitable for drinking purposes, and the tank is filled from a potable water supply, the filling pipe shall be installed in accordance with regulations of the local health authority.

8-4.4 Filling Pipe at Roof and Floors. The intersection of a separate filling pipe with a roof or waterproof or concrete floor shall be watertight. (*See 8-1.1.*)

8-5 Overflow.

8-5.1 Size. The overflow pipe shall be of adequate capacity for operating conditions and shall be not less than 3 inches in diameter throughout.

8-5.2 Inlet. The inlet of the overflow pipe shall be located at the top capacity or high water line. Also the inlet shall be located at least 1 inch below the bottom of the flat cover joists in a wood tank, but never closer than 2 inches to the top of the tank, and shall consist of a special funnel or reducing coupling at least 5 inches in largest internal diameter. The inlet shall be arranged so that the flow of water is in no way retarded by any obstruction. On a steel tank an overflow pipe cut with the opening to fit the roof may be used, provided a suitable horizontal suction plate and vortex breaker is used to insure full capacity flow for the overflow.

8-5.3 Stub Pipe. When dripping of water or small accumulation of ice is not objectionable, the overflow may, by the

choice of the owner, pass through the side of the tank near the top. (*Figures B-8-3 and B-8-4.*) The pipe shall be extended with slight downward pitch to discharge beyond the tank or balcony and away from the ladders, and shall be adequately supported. On column supported tanks with outside overflow, vertical extensions of the pipe below the balcony are not recommended, as they may become plugged with ice.

Overflows for pedestal tanks shall preferably be extended to ground level within the access tube and pedestal. (*Figure B-8-5.*)

8-5.4 Inside Pipe. When a stub pipe is undesirable, the overflow pipe shall extend down through the tank bottom and inside the frostproof casing or steel plate riser, discharging through the casing near the ground or roof level. The section of the pipe inside the tank shall be of brass, flanged cast-iron or steel (*see 8-1.16*). Inside overflow pipes shall be braced at points not over 25 feet apart to tank and riser plates by substantial clamps. The discharge shall be visible and the pipe pitched to drain. If the discharge is exposed, the exposed length shall not exceed 4 feet and shall avoid the entrance to the valve pit or house.

8-6 Clean-Out and Drain.

8-6.1 Handhole. A standard handhole with a minimum dimension of 3 inches or a manhole shall be provided in the saucer plate, outside of the frostproof casing, at the bottom of an elevated steel tank with a suspended bottom (*Figure B-8-4*), unless the tank has a large riser pipe 3 feet or more in diameter.

8-6.2 Shell Manholes. Two manholes shall be provided in the first ring of the suction tank shell at locations to be designated by the purchaser.

One of the manholes shall be flanged, with a bolted cover to provide for the attachment of a mechanically operated exhaustor to remove evaporated paint solvents, abrasive blasting dusts and other impurities during surface preparation and painting. The minimum opening shall be 24 inches, with the bolts on a $30\frac{1}{4}$ inch diameter bolt circle, such that the bolts straddle horizontal and vertical center lines.

The other manhole may be either circular, 24 inches in diameter, or elliptical, 18 inches \times 22 inches minimum size.

The shell where the manholes are located shall be adequately reinforced and all portions of the manholes, including reinforcing the neck, the bolting, and the cover shall be designed to withstand the weight and pressure of the tank contents.

8-6.3 For Elevated Flat-Bottom Tanks. At least a 2-inch clean-out shall also be provided outside of the frostproof casing, in the bottom of a wood tank or a flat-bottom steel tank, when elevated. For wood tanks, the clean-out connection shall consist of a special screw fitting with gasket or a pair of 2 inch flanges. For steel tanks, the connection shall consist of an extra-heavy coupling welded to the bottom plate. The coupling shall be welded to both sides of the tank plates. A piece of 2 inch brass pipe about 5 inches long, capped at the top with a brass cap, shall be screwed into the inner fitting or flange. The clean-out shall be watertight. (See Figure B-8-3.)

8-6.4 Riser Drain.

8-6.4.1 A drain pipe at least 2 inches in diameter fitted with a reliable controlling valve and a 1/2-inch drip valve shall be connected into the tank discharge-pipe near its base, and when possible on the tank side of all valves. If the outlet is an open end it shall be fitted with a 2 1/2-inch hose connection unless it discharges into a funnel or cistern piped to a sewer. If the drain is piped directly to a sewer, a sight glass or a 3/4-inch test valve on the underside of the pipe shall be provided. If the drain pipe is to be used for a hose stream and controlling valve shall be an approved gate or angle valve.

8-6.4.2 When a circulation tank-heater is located near the base of the tank riser the drain pipe shall, if possible, be connected from the cold-water return-pipe between the cold-water valve and the heater to permit flushing water from the tank through the hot-water pipe heater and drain for clean-out purposes. (See Figure B-8-1.)

8-7 Connections For Other Than Fire Protection.

8-7.1 Dual Service Tanks. The use of an elevated tank in part for other than fire protection purposes is not advised. Frequent circulation of the water results in an accumulation of sediment which may obstruct the piping or sprinklers and a fluctuating water level hastens decaying of wood and corrosion of steel. In the few cases where dual service is necessary an adequate supply of water shall be constantly and automatically reserved in the tank for fire protection purposes.

8-7.2 Pipe For Other Than Fire Protection Purposes. The pipe for other than fire protection purposes shall be entirely separate from fire service pipes and shall extend to an elevation inside the tank below which an adequate quantity of water will be constantly retained for fire protection. The pipe for other

than fire protection purposes inside the tank shall be brass except that steel may be used if the pipe is larger than 3 inches or cast iron if 6 inches or larger. The pipe inside the tank shall be braced near the top and at points not over 25 feet apart. The expansion joint, if there is one, shall be of standard type, below the tank without connection to the tank plates. (See 8-3.8.)

8-7.3 At Roofs and Floors. Just as for other tank piping the intersection of a pipe for other than fire protection purposes, with a building roof or waterproof or concrete floor, shall be watertight. (See 8-1.1.)

Chapter 9 Valve Enclosures and Frost Protection

9-1 Valve Pit or House and Heater House.

9-1.1 General. When the tank is on an independent tower, a valve pit or house shall be built at the base of the discharge pipe to house the valves, tank heater and other fittings. If a large valve pit below grade is provided it can contain all equipment, including the check valve in the horizontal run. If a house above grade, with no large pit beneath it, is used it becomes necessary to place the O.S. & Y. gate valve in the vertical part of the tank discharge pipe and to construct a small brick or concrete pit or well to contain the check valve in the horizontal pipe below the frost line.

***9-1.2 Materials.** The valve pit below grade shall be built of portland cement concrete with a clean aggregate. Reinforced concrete should be a 1:2:4 mixture. Plain concrete, when low stresses permit its use, may be a 1:3:5 mixture. A valve house above grade shall be constructed of concrete, brick, cement plaster on metal lath or other noncombustible material with suitable heat insulating properties.

Table 9-1.2 Frostproofing Materials and Required Minimum Thicknesses

Type of Insulation	Low One-Day Mean Temperature °F																
	+30	+25	+20	+15	+10	+5	0	-5	-10	-15	-20	-25	-30	-35	-40	-45	-50
Wood Frostproof Casing		2 Ply-1 Air (Fig. B-9-1 e & f)				3 Ply-2 Air (Fig. B-9-1 c & d)				4 Ply-2 Air (Fig. B-9-1 a & b)				See Note 3			
Insulated Metal Frostproof Casing		3" Thick Fiberglass in Metal Shield (Fig. B-9-2)															
Foamglass		2" Thick				3" Thick				4" Thick							
Fiberglass (Min. 3 # Density)		1" Thick				1½" Thick				2" Thick				2½" Thk			
Polystyrene 9-1.2.1		1" Thick				1½" Thick				2" Thick				2½" Thk			
Polyurethane 9-1.2.2		None				1" Thick				2" Thick							

(Special construction is recommended for temperatures below -40°F.)

9-1.2.1 Material shall conform to ASTM Designation C578-69 Preformed, Block Type Cellular Polystyrene Thermal Insulation, Grade 2, Type II. Since nonburning Polystyrene does not exist, care must be taken in specifying this material for frost-proofing if direct exposure to flame exists.

9-1.2.2 Material shall conform to ASTM Designation C591-69 Rigid Preformed Cellular Urethane Thermal Insulation, Grade 2, Type II. Since nonburning Polyurethane does not exist, care must be taken in specifying this material for frost-proofing if direct exposure to flame exists.

9-1.3 Dimensions. A valve pit or house shall be of sufficient size to provide a clearance of 12 inches and preferably 18 inches around all contained equipment. A valve pit shall extend at least 6 inches above grade and far enough below grade to place the base-elbow below the frost line and at such an elevation that connection to the system can be conveniently made. The necessary size of pit shall be carefully planned in advance for each equipment, but ordinarily a pit 7 feet deep and 6 feet by 9 feet horizontally inside will be of sufficient size. A valve house containing only the O.S. & Y. gate in the discharge pipe and the heater can usually be made smaller.

9-1.4 Design of Valve Pit.

9-1.4.1 All parts of the pit and soil beneath shall be adequate to resist all loads including the frost-casing or large steel riser and contained water. This requires reinforced 1:2:4 concrete for the roof. The walls and floor should also be reinforced 1:2:4 mixture if subjected to appreciable bending stresses from groundwater pressure or other loads. The walls and floor may be plain 1:3:5 concrete, usually not less than 8 inches thick, when bending stresses are insignificant.

9-1.4.2 The load considered in designing the pier and its bearing which supports a large steel plate riser, when the hemispherical or ellipsoidal shape is continuous to the shell of the large riser without flat horizontal diaphragm plate, shall be the weight of the water column from the pier to the tank bottom plus the weight of a cylinder of water 4 feet greater in diameter than the large riser and extending from the bottom to the top of the tank. If a hemispherical or ellipsoidal bottom is rigidly attached to the top of a large riser by a flat horizontal diaphragm plate, the weight considered acting on the pier shall be the weight of the water column from the pier to the tank bottom plus the weight of a cylinder of water whose radius equals the radius of the riser at the tank bottom plus one-half the distance

from the edge of the riser to the connection of the flat horizontal diaphragm plate to the hemispherical or ellipsoidal bottom plates, and extending from the bottom to the top of the tank. The pier shall adjoin a pit containing the usual valves and accessories. An adequate slip-joint shall be provided between the pier and the valve pit if the soil is incapable of sustaining a load of two tons per square foot without negligible settlement.

9-1.5 Pit Manhole. A standard round manhole with cover at least 24 inches in diameter, a square metal manhole with substantially hinged cover at least 20 inches on a side, or a raised hatch of equivalent size with a cover built of 2-ply matched boards with tar-paper between, shall be provided in the roof of the valve pit. Where there is no heater in the pit the manhole shall have a properly fitted inside cover of 2-inch plank or its equivalent located at least 4 inches below the outer cover.

9-1.6 Pit Ladder. A steel ladder, rigidly secured shall extend from the manhole to the floor.

9-1.7 Waterproofing Pit. If the pit is below drainage level the outside surface shall be thoroughly waterproofed. Waterproofing may be done either by painting with asphalt and then covering with at least two layers of felt and asphalt alternately, felt to be lapped 18 inches, or by other suitable methods.

9-1.8 Pit Drain. A sump and drain shall be provided wherever a sewer is available or soil conditions make the arrangement possible. If suitable drainage cannot be obtained an injector is sometimes advisable.

9-1.9 Heater House.

9-1.9.1 A heater house above grade shall be substantial and the roof shall be strong enough to support the frostproof casing, if provided, and other loads without excessive deflection. A tight-fitting double door of sufficient size for admittance of persons or equipment shall be provided.

9-1.9.2 If the house contains a heater which burns oil or a gas which is heavier than air, and is located over a valve pit below grade, the entrance to the pit shall be outside of the heater house. The portion of the floor of the heater house which is over the pit shall be continuous concrete, tightly calked around all pipes.

9-1.9.3 If the house contains a fuel burning heater, louvers above the maximum snow level or a vent shall be provided to furnish sufficient fresh air for combustion of fuel in ad-

dition to the vent to exhaust the products of combustion from the house.

9-1.10 Heating Valve House or Pit and Heater House.

The valve or heater house above grade, as well as the valve pit, shall be heated sufficiently to maintain a temperature of at least 40°F during most severe weather.

9-2 Frostproof Casing.

9-2.1 General. An approved frostproof casing shall be placed around all exposed tank-piping in localities where the lowest mean atmospheric temperature for one day as shown by the Isothermal Map, Figure 10-1.4, is 20°F or lower. Tank piping subjected to temperatures below freezing within unheated buildings, or dry risers of elevated tanks, shall also be adequately protected. Combustible frostproof casings subjected to serious fire exposure shall be protected by at least 1 inch of cement plaster on metal lath. The casing or discharge pipe shall be braced as specified in 8-2.4, and bracing shall be provided between the frostproof casing and the discharge pipe. Noncombustible construction is preferred throughout as indicated in Figure B-9-2 or equivalent.

9-2.2 Wood.

9-2.2.1 When special permission is obtained from the authority having jurisdiction, frostproof casings may be wood, built as shown in Fig. B-9-1. (See A-9-1.2.) All lumber must be sound and free from large or loose knots. Sheathing shall be matched stock, dressed from a nominal thickness of at least 1 inch to a finished thickness not less than $\frac{5}{8}$ inch. One thickness of heavy nonabsorbent or saturated building paper shall be wrapped around all, except the outer courses of sheathing. Air spaces shall be not less than 1 inch nor more than 2 inches. Horizontal nailing strips shall be provided not over 4 feet apart.

9-2.2.2 Effective fire stops shall be provided in all air spaces about 6 feet and 10 feet above the base of the casing, except that for prefabricated casing, the lower fire stop may be at the base of the casing. If the casing contains only water pipes, noncombustible insulating material at least 4 inches thick supported on 2-inch planks, or the equivalent, shall be used for these fire stops. The insulating material shall be packed tightly in any spaces between planks and pipes. If the casing contains a steam pipe, an approved noncombustible material shall be used instead of the 2-inch planks. The pipes shall be protected against corrosion at these fire stops by liberal application of red lead paint with litharge added, as covered in 2-7.11, after careful

cleaning of the pipes with wire brushes and scrapers. At least $1\frac{1}{2}$ inch \times $1/16$ inch galvanized iron flats or $3/8$ inch round hoops shall be placed around circular casings over each nailing strip. Bracing between the frostproof casing and the discharge pipe shall be spaced at intervals of not over 4 feet except that prefabricated casing shall be braced to the discharge pipe at the ends of the sections, not over 16 feet long.

9-2.3 Top. When the casing is wood or metal an enlarged section shall be provided directly under the tank bottom and shall fit over the main portion of the casing with a slip joint lapping at least 6 inches to provide for expansion or settlement of the tower. This section shall have the same insulating qualities as the main casing and shall be tightly and securely fitted to the tank bottom. For a tank with a hemispherical or other suspended bottom it shall be built in the shop.

9-2.4 Bottom. The casing shall be substantially supported at the bottom by the roof of the valve pit or building, using beams if necessary. The joint around the bottom shall be watertight to prevent leakage from outside, and when the tank is over a building, the joint between the roof and pipes inside the casing shall also be watertight to keep water from draining into the building in case of a broken pipe. (See 8-1.1.) The lower end of the casing shall be protected from absorption of moisture.

9-2.5 Paint. Unless the lumber used in a wood casing has been suitably treated with a preservative, all exposed parts shall be given at least two coats of a good grade of paint. If a metal casing is used, all surfaces shall be given two coats of paint as specified in 2-7.11 and 2-7.12.

Chapter 10 Tank Heating

*10-1 General.

10-1.1 Elevated tanks erected on towers or building structures, and tanks on or below grade which are subjected to freezing as set forth in 10-2.1 shall be heated by one of the methods of heating as described in 10-2.

***10-1.2** The heating system shall be of such capacity that the temperature of the coldest water in the tank or riser of both will be maintained at or above 42°F during the coldest weather.

***10-1.2.1** The coldest weather temperature used to determine the need of heating shall be based upon the lowest mean temperature for one day as shown on the Isothermal Map, Figure 10-1.

10-1.2.2 A lower water temperature alarm, set at 40°F, shall be provided and connected to the local proprietary alarm system or to an approved Central Station Supervisory Service.

***10-1.3** The method of heating used shall conform to 10-2.1, 10-2.2, or 10-2.3 according to the type of tank and its geographical location.

***10-1.4** The method of heating used shall employ the use of one of the heaters described in 10-3.1, 10-3.2, 10-3.3, 10-3.4, 10-3.5, 10-3.6, or 10-3.7, which shall have a Btu capacity per hour according to Figure 10-1.4 and Tables 10-1.4(a), 10-1.4(b), and 10-1.4(c) for determination of heater capacity.

10-1.4.1 The heater shall be plainly marked with a plate or cast lettering giving the Btu/hr. input and type of heater and the manufacturer's name.

10-1.4.2 The allowable working pressure of the heater shall not be less than the maximum filling pressure sustained when tank is being filled.

10-1.5 Location. The heater shall be located in a valve pit, special heater-house or in a building at or near the base of the tank structure. When the tank is over a building the heater may be located in the top story. Heaters when placed inside of combustible frostproof casings shall not be in contact with any combustible material.

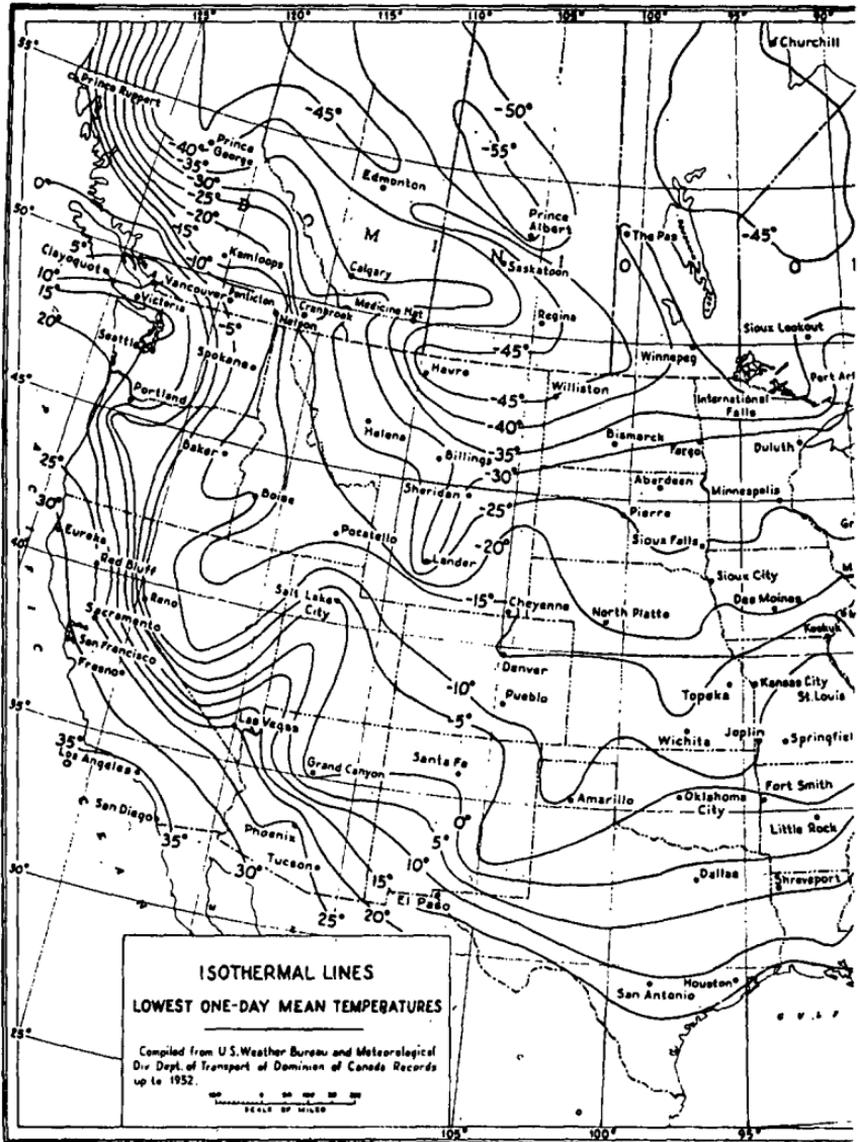


Fig. 10-1.4. Isothermal Lines—Lowest One-Day Mean Temperatures. Compiled from United States Weather Bureau Records.

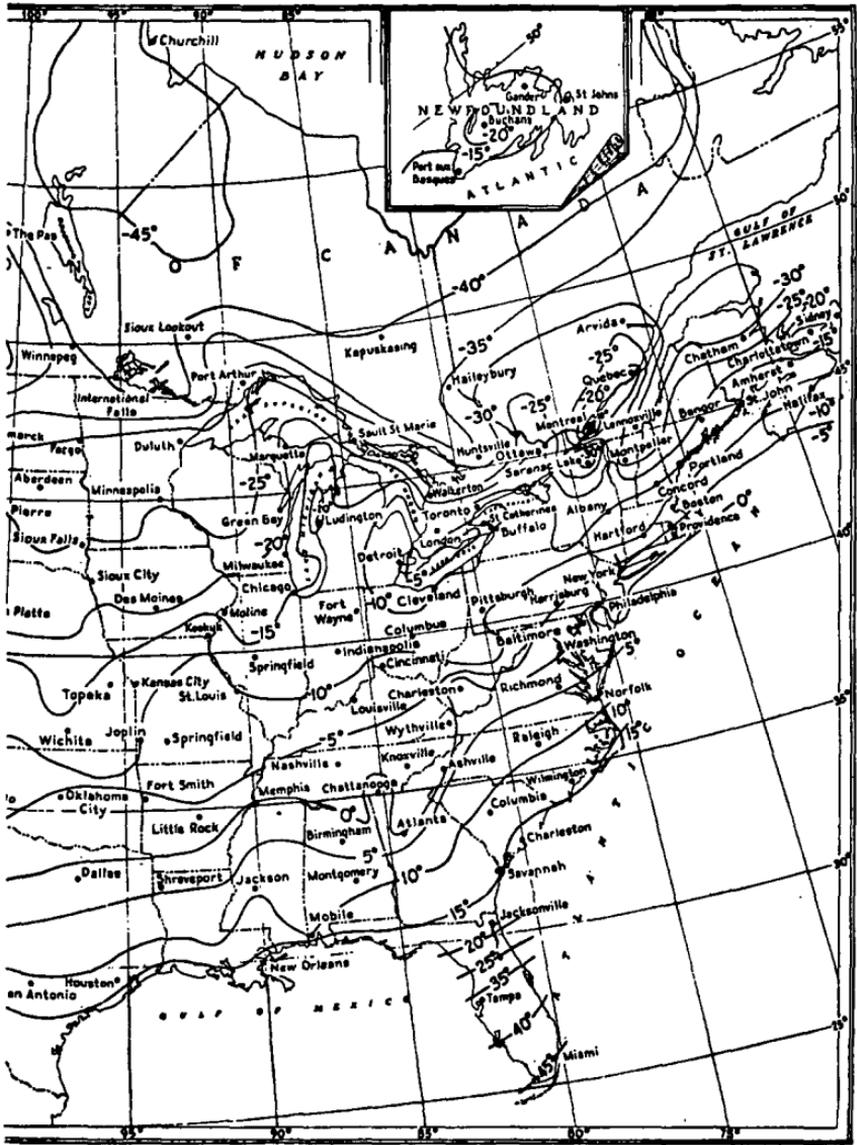


Table 10-1.4(a)
Thousands of British Thermal Units Lost Per Hour From
Elevated Steel Tanks

Based on minimum water temperature of 42°F and a
 wind velocity of 12 mph.

(See Table 10-1.4(b) for wood tanks and Table 10-1.4(c) for steel standpipes)

*To determine capacity of heater needed, find the minimum mean atmospheric
 temperature for one day from the Isothermal Map, Figure 10-1.4,
 and note the corresponding heat loss below.*

TANK CAPACITIES—THOUSANDS U. S. GALLONS												
Atmo- spheric Temper- ature Deg. F	Heat (Btu) Loss Per Sq. Ft. Tank Radiating Surface	Square feet of tank surface*									Add Btu Per Lineal Ft. Uninsulated Steel Riser	
		25	30	40	50	75	100	150	200	250	3 ft. dia.	4 ft. dia.
		1210	1325	1550	1800	2370	2845	3705	4470	5240		
Btu Lost per hour, Thousands												
35	32.3	40	43	51	59	77	92	120	145	168	50	69
30	46.1	56	62	72	83	110	132	171	207	242	144	192
25	61.5	75	82	96	111	146	175	228	275	323	255	340
20	77.2	94	103	120	139	183	220	287	346	405	380	506
15	93.6	114	125	146	169	222	267	347	419	491	519	692
10	110.9	135	147	172	200	263	316	411	496	582	670	893
5	128.9	156	171	200	233	306	367	478	577	676	820	1092
0	148.5	180	197	231	268	352	423	551	664	779	982	1309
-5	168.7	205	224	262	304	400	480	626	755	884	1152	1536
-10	190.7	231	253	296	344	452	543	707	853	1000	1329	1771
-15	213.2	258	283	331	384	506	607	790	954	1118	1515	2020
-20	236.8	287	314	368	427	562	674	878	1059	1241	1718	2291
-25	262.3	318	348	407	473	622	747	972	1173	1375	1926	2568
-30	288.1	349	382	447	519	683	820	1068	1288	1510	2145	2860
-35	316.0	383	419	490	569	749	900	1171	1413	1656	2381	3174
-40	344.0	417	456	534	620	816	979	1275	1538	1803	2620	3494
-50	405.6	491	538	629	731	962	1154	1503	1814	2126	3139	4186
-60	470.8	570	624	730	848	1116	1340	1745	2105	2467	3702	4936

*These numbers are square feet of tank radiating surfaces used for each capacity to compute the tabulated heat loss values and are typical for tanks with D/4 ellipsoidal roofs and bottoms.

NOTE TO TABLE 10-1.4(a): Heat loss for a given capacity with a different tank radiating surface than shown above shall be obtained by multiplying the radiating surface by the tabulated heat loss per square foot for the atmospheric temperature involved. The minimum radiator surface area shall be the wetted tank steel surface area plus the top water surface area. For tanks with large steel plate risers the heat loss from the riser shall be added to that from the tank. The riser loss per linear foot shall be as tabulated above.

Table 10-1.4(b)
Thousands of British Thermal Units Lost Per Hour From
Elevated Wood Tanks

Based on minimum water temperature of 42°F and a
 wind velocity of 12 mph.

(See Table 10-1.4(a) for elevated steel tanks and Table 10-1.4(c) for
 steel standpipes)

*To determine capacity of heater needed, find the minimum mean atmospheric
 temperature for one day from the Isothermal Map, Figure 10-1.4,
 and note the corresponding heat-loss below.*

TANK CAPACITIES—THOUSANDS U. S. GALLONS									
Atmospheric Temperature Degrees F.	10	15	20	25	30	40	50	75	100
35	8	10	11	13	14	19	21	28	33
30	11	14	16	19	21	27	31	40	49
25	15	20	21	25	28	36	42	54	65
20	19	25	27	32	35	46	54	69	83
15	24	31	34	39	44	57	66	85	102
10	28	36	40	46	51	68	78	100	121
5	33	43	47	54	60	78	92	117	142
0	38	49	53	62	69	90	106	135	164
- 5	43	56	61	71	79	103	120	154	187
-10	49	63	69	80	89	116	136	174	211
-15	54	71	77	89	100	130	153	195	236
-20	61	79	86	99	111	145	169	217	262
-25	68	87	95	110	123	160	188	240	291
-30	74	96	104	121	135	176	206	264	319
-35	81	105	115	133	148	193	226	289	350
-40	88	114	125	144	162	210	246	317	382
-50	104	135	147	170	190	246	290	372	450
-60	122	157	171	197	222	266	307	407	490

Table 10-1.4(c)
Thousands of British Thermal Units Lost Per Hour From
Steel Suction Tanks and Standpipes and
Embankment-Supported Rubberized-Fabric Tanks

Based on minimum water temperature of 42°F and a
 wind velocity of 12 mph.

(See Tables 10-1.4(a) and 10-1.4(b) for elevated steel or wood tanks.)

*To determine capacity of heater needed, find the minimum mean atmospheric
 temperature for one day from the Isothermal Map, Figure 10-1.A,
 and note the corresponding heat loss below.*

		TANK CAPACITIES—THOUSANDS U. S. GALLONS									
Atmo- spheric Temperature Deg. F	Heat (Btu) Loss Per Sq. Ft. Tank Ra- diating Surface	100	125	150	200	250	300	400	500	750	1000
		Square feet of tank surface*									
		2610	3030	3505	4175	4795	5360	6375	7355	9650	11740
		Btu Lost per hour, Thousands									
35	32.3	85	98	114	135	155	175	206	238	312	380
30	46.1	121	140	162	193	222	248	294	340	445	542
25	61.5	161	187	216	257	295	330	393	453	594	722
20	77.2	202	234	271	323	371	414	493	568	745	907
15	93.6	245	284	329	391	449	502	597	689	904	1099
10	110.9	290	337	389	463	532	595	707	816	1071	1302
5	128.9	337	391	452	539	619	691	822	949	1244	1514
0	148.5	388	450	521	620	713	796	947	1093	1434	1744
-5	168.7	441	512	592	705	809	905	1076	1241	1628	1981
-10	190.7	498	578	669	797	915	1023	1216	1403	1841	2239
-15	213.2	557	646	748	891	1023	1143	1360	1569	2058	2503
-20	236.8	619	718	830	989	1136	1270	1510	1742	2286	2781
-25	262.3	685	795	920	1096	1258	1406	1673	1930	2532	3080
-30	288.1	752	873	1010	1203	1382	1545	1837	2119	2781	3383
-35	316.0	825	958	1108	1320	1516	1694	2015	2325	3050	3710
-40	344.0	898	1043	1206	1437	1650	1844	2193	2531	3320	4039
-50	405.6	1059	1229	1422	1694	1945	2175	2586	2984	3915	4762
-60	470.8	1229	1427	1651	1966	2258	2524	3002	3463	4544	5528

*These numbers are square feet of radiating surface used for each capacity to compute the tabulated heat loss values and are typical for cone roof reservoirs on grade.

NOTE TO TABLE 10-1.4(c): Heat loss for a given capacity with a different radiating surface than shown above shall be obtained by multiplying the radiating surface by the tabulated heat loss per square foot for the atmospheric temperature involved. The minimum radiation surface area shall be the wetted surface exposed to atmosphere plus the top water surface area. No heat loss shall be figured for tank bottoms resting on grade.

10-1.6 Heat Insulation. All heaters shall be insulated to prevent excessive heat losses. When the tank heater is the only source of heat in a valve pit or other heater room enough of the heater or steam pipe may be left bare to keep the temperature of the air above freezing.

***10-1.7 Heater Water-Circulating Pipes.** The size of heater water-circulating pipes for wood and steel tanks shall be not less than 2 inches in diameter and shall be not less than shown in Table 10-1.7. The installation of the hot and cold water circulating pipes shall be in accordance with 10-1.7.1, and 10-1.7.2. If the circulating pipes pass through the roof or water-proofed or concrete floors, the intersections shall be made watertight. (See 8-1.1.)

Table 10-1.7
Minimum Size in Inches of Circulating Pipes Required for
Elevated Steel Tanks. Tank Capacity (U. S. Gallons)

Minimum One-Day mean Temp. Degrees F.	15,000	20,000	25,000	30,000	40,000	50,000	60,000	75,000	100,000	150,000
+10	2	2	2	2	2	2	2	2	2	2½
+ 5	2	2	2	2	2	2	2	2	2	2½
0	2	2	2	2	2	2	2	2	2½	2½
- 5	2	2	2	2	2	2	2	2	2½	2½
-10	2	2	2	2	2	2	2	2½	2½	2½
-15	2	2	2	2	2	2	2½	2½	2½	3
-20	2	2	2	2	2	2½	2½	2½	2½	3
-25	2	2	2	2	2½	2½	2½	2½	3	3
-30	2	2	2	2	2½	2½	2½	2½	3	3
-35	2	2	2	2½	2½	2½	2½	3	3	3
-40	2	2	2	2½	2½	2½	2½	3	3	3

10-1.7.1 Hot-Water Pipe. Copper tubing, steel conforming to 2-2, or brass (85% copper) pipe shall be used throughout. If the tank is elevated, the hot-water pipe shall be placed near the discharge pipe inside of the frostproof casing. The pipe shall pitch upward at all points and shall have a four-elbow swing-joint or adequately supported, brass expansion-joint located either just above the heater or just below the tank bottom. The hot water shall discharge inside the tank through a tee fitting of the nominal pipe size, at about one-third the height of the tank. The pipe shall be adequately braced, inside the tank and also at points not over 25 feet apart throughout its length, providing enough play to allow for expansion. Listed indicating valve of the nominal pipe size shall be placed in the pipe near the heater.

10-1.7.2 Cold-Water Pipe. The cold-water return-pipe shall be connected to the discharge pipe or tank side at a point that will assure circulation throughout the entire portion of the discharge pipe subject to freezing. An accurate thermometer graduated at least as low as 30°F shall be placed in the cold-water pipe at a point where it will register the temperature of the coldest water in the system. A listed indicating valve of the same size of the pipe shall be placed in the cold-water pipe at the point of connection to the discharge pipe or tank side. A 2-inch drain pipe discharging at a visible point shall be connected into the cold-water return-pipe between the heater and the cold-water controlling valve to permit flushing water from the tank through the hot-water pipe, heater and drain for clean-out purposes. The drain pipe shall be arranged as specified in Fig. B-8-1 and as shown in Fig. B-8-2.

10-1.8 Relief Valve. A listed relief valve shall be provided in the water chamber or pipe between the hot and cold-water valves of any water heater. The relief valve shall be carefully adjusted to open at a pressure of 120 pounds per square inch except that the opening pressure shall not be greater than the allowable working pressure of the heater nor less than the maximum static or filling pressure to which it may be subjected. If the heater is close to stock that might be damaged by water the relief shall be piped to a safe point.

10-1.9 Operation.

***10-1.9.1** The thermometer shall be observed daily, and the supply of heat shall be regulated to maintain the temperature at 42°F. Lower temperatures are dangerously near the freezing point and shall not be permitted. Excessively high temperatures, moreover, are detrimental to the equipment, particularly wood tanks and the paint in steel tanks.

10-1.9.2 Steam pressures shall be regulated by throttling the steam valve or by means of an automatic regulating device of dependable make. A very small flow of steam shall constantly pass by the automatic regulating device so that circulation will not cease entirely when the regulator bulb is in a circulating pipe not exposed to atmospheric temperature.

10-1.9.3 When circulating systems are temporarily shut off, circulation shall be started and run for not less than two hours to insure that the water in the pipe is not assuming room temperature while the water in the tank is in danger of freezing. Valves in circulating pipes shall be wide open when the heater is in operation.

10-1.9.3.1 Avoid explosion or rupture hazard to heater by shutting off or removing the source of heat when both hot water and cold water valves are shut for any reason. A relief valve will not compensate for this precaution.

10-1.9.4 All air shall be blown from steam heaters, radiators, and traps by means of the air valve or vent on radiator or trap when first admitting steam.

***10-2 Methods of Heating.**

***10-2.1** When tanks are located where the lowest mean temperature for one day is less than 5°F as shown by the Isothermal Map, Figure 10-1.4, a gravity circulating method of heating elevated tanks or water storage tanks installed on or below grade shall be employed or for special situations as covered in 10-2.1.1 or 10-2.1.2.

10-2.1.1 For elevated tanks with unprotected risers 3 feet or more in diameter having tower heights under 100 feet (*see* 7-1.2), standpipes and on grade suction tanks, a steam heated vertical radiator system may be used. For tower heights over 100 feet a steam heated vertical radiator system may also be used except that an open-ended pipe sleeve similar to that shown in Figure B-10-3 shall be used.

10-2.1.2 For suction tanks and standpipes having flat bottoms supported near ground level, immersed steam coils may be used if the tank is kept filled so that the steam coils are continuously submerged.

10-2.2 Where the lowest mean temperature for one day is 5°F or above as shown by the Isothermal Map, Figure 10-1.4, and only intermittent heating is required for elevated tanks having unprotected risers less than 3 feet in diameter, the method of heating may be water circulation, immersed steam coils, or by blowing steam from an adequate supply directed into the water. Suction tanks, standpipes and elevated tanks having risers 3 feet or more in diameter need no provision for heat.

10-2.3 Where the lowest mean temperature for one day is above 15°F as shown on the Isothermal Map, Figure 10-1.4, the method of heating tanks with frostproof risers less than 3 feet in diameter shall be a steam loop or radiator, or thermostatically controlled electric strip heaters, inside the frostproof casing.

10-3 Types of Heaters.

***10-3.1 Steam Water Heaters.** A steam water heater may consist of a cast-iron or steel shell through which water circulates around steam tubes or coils of brass or copper. Galvanized steel or iron steam tubes are permitted but are not advised because of their more rapid depreciation and poorer heat-transfer qualities. The shell and tubes shall be designed to withstand a test pressure of at least two and one-half times the permissible working pressure and not less than 300 pounds per square inch and shall be so tested before shipment. Heaters shall have a bolted flange on at least one end to facilitate taking apart for inside cleaning.

Heaters designed so that water passes through the tubes or coils surrounded by steam are practical for ease of cleaning. However, such heaters shall be well insulated unless it is desired to use the heat loss for heating the valve pit or other housing.

10-3.1.1 Steam Supply. Steam water heaters shall be connected to a reliable steam supply with a pressure preferably not less than 10 pounds per square inch and not over 50 pounds per square inch. The steam pipes shall have an area at least equivalent to that of 1 inch nominal size pipe for each heater supplied, and shall run direct from the boiler heater if possible. A globe valve shall be placed in the line near the heater and a steam gage shall be provided preferably between the valve and the heater. When the heater is connected to a vacuum system the layout shall have the approval of the maker of the heating specialties and in all cases a final approval shall be obtained from the authority having jurisdiction.

10-3.1.2 Steam Return. The steam return shall be arranged to quickly relieve the heater of condensate. The area of the return-pipe shall be at least equivalent to the area of $\frac{3}{4}$ inch nominal size pipe for each heater served. A reliable steam-trap of adequate size and equipped with an air-vent and preferably a water-gage shall be provided near the heater whenever the return is not by gravity or to a vacuum system. Excessive lifts from the trap shall be avoided. A $\frac{3}{4}$ inch or larger bypass with a globe valve normally kept shut shall be provided around the trap. A globe valve shall also be placed on each side of the trap between the bypass connections.

10-3.1.2.1 A gravity return may be used only when the heater is located well above the boiler water-level and when the steam pressure at the heater plus the static head of water in the return pipe between the heater and the boiler water-level is greater than the steam pressure at the boiler.

10-3.1.2.2 Whenever it becomes necessary to return the condensate to a vacuum heating system, the layout shall have the approval of the makers of the heating specialties as well as a final approval by the authority having jurisdiction.

10-3.1.3 Multiple Heaters. If two or more heaters are used, they shall be placed at one level and shall be connected in parallel with symmetrical piping and with a relief valve and controlling valves in the water lines of each. A globe valve shall be placed in each steam supply line.

10-3.2 Gas-Fired Water Heaters. A gas-fired water heater of sufficient strength to resist the water pressure may be used. The heater shall be of a type listed by a recognized testing laboratory and shall have a permanent marking showing the input ratings in Btu per hour. The heater and accessories shall be installed in accordance with the manufacturer's recommendations and provided with approved combustion safeguards.

10-3.2.1 The gas-fired water heater shall be equipped to prevent abnormal discharge of gas, in event of ignition failure or accidental flame extinguishment, by automatic means specifically approved for the heater.

10-3.2.2 A high-limit switch shall be provided in the hot water pipe close to the heater, to shut off the gas supply automatically when the water temperature exceeds 190°F.

10-3.2.3 Thermostatic control of the burner with temperature response element shall be located in the coldest water affected by atmospheric temperature, maintaining a minimum water temperature of at least 42°F.

10-3.3 Oil-Fired Water Heaters. An oil-fired water heater of sufficient strength to resist the water pressure may be used. The heater shall be of a type listed by a recognized testing laboratory and shall have a permanent marking showing the input rating in Btu per hour.

10-3.3.1 The heater and accessories shall be installed in accordance with the manufacturer's recommendations and provided with approved combustion safeguards.

10-3.3.2 The heater shall be equipped to prevent abnormal discharge of oil at the burner, in event of ignition failure or accidental flame extinguishment, by automatic means specifically approved for the heater.

10-3.3.3 A high limit switch shall be provided in the hot water pipe close to the heater to shut off the oil supply automatically when the water temperature exceeds 190° F.

10-3.3.4 Thermostatic control of the burner with temperature response element shall be located in the coldest water affected by atmospheric temperature, maintaining a minimum water temperature of at least 42° F.

10-3.3.5 The oil tank shall be buried outside the heater house.

10-3.4 Coal-burning Water Heaters. A coal-burning water heater of sufficient strength to resist the water pressure may be used. Water circulates through a chamber or series of chambers or through brass pipe-coils around and over the fire. The heater and accessories shall be installed in accordance with the manufacturer's recommendations and provided with approved combustion safeguards.

10-3.5 Electric Water Heaters. An electric water heater of sufficient strength to resist the water pressure may be used. A water circulating pump shall be used in conjunction with electric heating elements. A single water heater or boiler of adequate capacity may be used. However, to avoid sudden peak demands on the electric service multiple heaters shall be installed, in parallel (*see 10-3.1.3*) with the various thermostatic controls set at different temperatures. With all of the heater elements in operation, the system shall have adequate capacity to maintain a minimum water temperature of at least 42° F. Thermostatic control with temperature response element shall be located in the coldest water affected by atmospheric temperature.

10-3.5.1 In the hot water pipe close to the heater, there shall be a manual reset high-limit control thermostat that disconnects all ungrounded electrical conductors to the heater in the event that the water temperature exceeds the temperature of the high-limit thermostat (approximately 190° F).

10-3.5.2 Electric heaters and accessories shall be of a type listed by a recognized testing laboratory; shall have a permanent marking showing the kilowatt capacity; and, shall be installed in accordance with the manufacturer's recommendations. The installation of all electrical wiring shall comply with NFPA 70-1975 *National Electrical Code*.

10-3.6 Vertical Steam Radiators. A vertical steam radiator shown in B-10-3 but without the open-ended pipe sleeve around the radiator heater is reasonably well adapted to heating elevated tanks with larger risers for tower heights under 100 feet (*see 7-1.2*) suction tanks and standpipes. For tower heights over 100 feet a steam heated vertical radiator system may also be used except that an open-ended pipe sleeve similar to that shown in Fig. B-10-3 shall be used. Except for suction tanks not over 25 feet high, an accurate angle socket thermometer with at least a 6-inch stem and calibrated as low as 30° F shall be permanently inserted through the plate or standpipe and as far from the heating unit as possible. The radiator shall consist of a steam pipe of sufficient size to convey the steam required under worst conditions but never less than 1½ inch, contained within a watertight condensing chamber of copper tubing, cast iron, steel or brass pipe, or suction tank and shall have sufficient area to maintain the temperature of the coldest water at not less than 42° F (*A-10-3.1*). For radiator heaters without surrounding pipe sleeve (explained below), surface water temperatures shall be ascertained by means of an approved temperature detecting device. This device shall have the temperature response element secured in a position about 3 feet below the permanent fire service water level. If long distance thermometers are used, the external tubing shall be supported substantially at about 12 foot intervals and the indicating dial located conveniently near grade in a substantial weatherproof cabinet. For a high structure without a permanent fire service water level, a circulating type of heating system or radiator heater with sleeve shall be used with socket thermometer located in the coldest water.

10-3.6.1 The radiator shall be supplied from a reliable source with preferably at least 10 pounds steam pressure. (*See A-10-3.1 for low pressure steam.*) If steam pressure in excess of 100 pounds is available on the heater, a reducing valve shall be placed in the steam supply pipe near the boiler header and a relief valve set at 100 pounds shall be installed between the reducing valve and the heater. The steam-supply pipe shall be at least 1½ inch in size, but of sufficient size to furnish the required quantity of steam, and shall have a steam gage with siphon at a convenient location. Except in the case of a radiator heater supplied by a separately fired boiler located above grade near the tank (B-10-4) the steam supply and a return connection at least ¾-inch in size from the base of the condensing chamber shall be provided with a trap arrangement as shown in Fig. B-10-6. Other arrangements for disposing of condensate are acceptable provided approval is first obtained from the authority having jurisdiction.

10-3.6.2 If a separately fired boiler, located above grade near the tank, supplies steam to the radiator, the inner pipe shall contain several $\frac{1}{4}$ -inch holes below the water level of the boiler. The steam supply pipe shall pitch upwards from the top of the nearby boiler to a connection to the inner pipe in the radiator, as shown in Fig. B-10-4.

10-3.6.3 For all radiator heaters the inner pipe shall extend to within about 1 foot of the top of the condensing chamber. The radiator or sleeve, and reduced extension of the sleeve up into the main tank shall be adequately supported and braced at points not over 25 feet apart.

10-3.7 Heating with Hot Water. Hot water as a heating element in coils or shell of a heater designed for steam shall not be used unless special permission to do so is obtained from the authority having jurisdiction, and in all such cases the complete detailed design of the heater; together with information regarding the temperature of the hot water, shall be submitted to the authority having jurisdiction and approval received before the equipment is installed.

10-3.8 Steam Coils Inside Tanks.

10-3.8.1 The coil shall consist of at least $1\frac{1}{4}$ -inch brass or copper pipe or 2 inch steel pipe. Pipe shall be pitched to drain and shall be supplied with steam preferably at not less than 10 pounds pressure, through a pipe of sufficient size to furnish the required quantity of steam from a reliable source. A globe valve and a steam gage with siphon shall be placed in the steam-supply line. The coil shall be substantially supported and, together with the supply and return pipes, shall have adequate provision for expansion. The return shall be connected to a steam trap. If the tank is elevated, the steam pipes shall be placed inside the frostproof casing around the discharge pipe. (*See note of caution in 10-1.5.*) The coil shall contain a sufficient area of heating surface explained in A-10-3.1 to maintain the temperature of the coldest water at not less than 42° F. The coil shall be placed within a distance of approximately three (3) feet from the shell, and shall be sized for a maximum steam velocity of 8000 feet per minute so that the pressure drop does not exceed $\frac{1}{2}$ the initial inlet pressure.

10-3.8.2 The surface water temperatures for elevated tanks and for standpipes and suction tanks shall be ascertained by means of an approved temperature detecting device. This device shall have the temperature response element secured in a position about 3 feet below the permanent fire service water

level. If long distance thermometers are used, the external tubing shall be supported substantially at about 12 foot intervals and the indicating dial located conveniently near grade in a substantial weatherproof cabinet. For a high structure without a permanent fire service water level, a circulating type of heating system or radiator heater with sleeve shall be used with socket thermometer located in the coldest water. For any excepting to these provisions, approval from the authority having jurisdiction shall first be obtained.

10-3.9 Direct Discharge of Steam. When blowing steam from an adequate supply directly into the tank, a pipe not less than 1 inch in diameter shall be used, in which case the steam pipe shall extend inside the frostproof casing, through the bottom to a point above the maximum water level, then horizontally a short distance, with an air vent and a check valve to keep the water from siphoning back and thence downward to a point three or four feet below the normal fire-service water level. The section of the pipe inside the tank shall be of brass or copper securely braced. A $\frac{1}{2}$ inch drip valve shall be provided at the base of the steam pipe.

10-4 Tank Insulation. When permitted by the authority having jurisdiction, tanks may be insulated to conserve energy. Insulation materials shall be approved, and installed with protection against fire, exposure, corrosion and weather. Heating requirements shall be based on design information in *The Handbook of Fundamentals*, 1972, as published by the American Society of Heating, Refrigerating and Air Conditioning Engineers. Outside winter design temperatures shall be taken from Figure 10-1.4. Heat Loss Calculations shall be based on an average water temperature of 55° F.

Appendix A

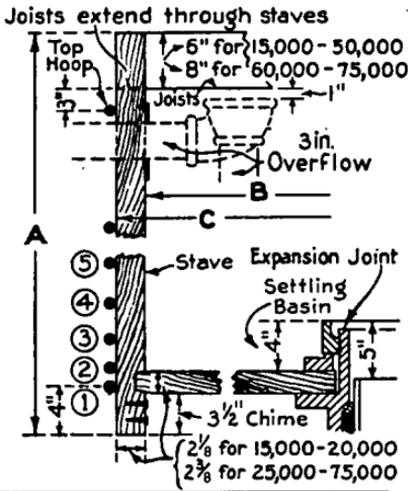
This Appendix is not a part of this NFPA Standard, but is included for information purposes only.

A-2-7.13 Corrosion Prevention. In lieu of future painting, the following methods of corrosion prevention may be used subject to the approval of the authority having jurisdiction.

(a) An approved cathodic system of corrosion protection, designed to protect all wetted surfaces, including that of the riser, may be used. Anodes shall be of suitable material and construction, approved by the authority having jurisdiction. Aluminum alloy 2107-T4, and high silicon cast iron with a maximum of 14.35 percent silicon are considered suitable materials. All anodes shall be provided with approved containment devices to prevent any portions thereof from separating and falling. All such containment devices shall be securely fastened to pin insulators hung from the roof of the tank. To insure continued reliable operation of such cathodic protection equipment, the owner shall make arrangements with the supplier for annual inspections and maintenance of the equipment.

(b) Chemical water additives, designed to inhibit corrosion on metal surfaces may be used. The chemicals used shall be non-toxic, nonstaining, and odorless. The additives should be introduced into the water filling the tank in the recommended proportions to maintain corrosion resistant properties. A chemical proportioning pump may be used for this purpose. To insure that the proper chemical balance is being maintained, semiannual chemical analysis of the water should be made.

A-3-1.4. The condition known as air-lock can occur when a pressure tank and a gravity tank are connected into the sprinkler system through a common riser if the gravity water-pressure at the gravity-tank check valve is less than the air pressure trapped in the pressure tank and common riser by a column of water in the sprinkler system after water has been drained from the pressure tank. For instance, if the pressure tank is kept $\frac{2}{3}$ full of water with an air pressure of 75 pounds per square inch as usual, and a sprinkler opens 35 feet or more above the point where the common tank-riser connects to the sprinkler system, the pressure tank drains, leaving an air pressure of 15 pounds per square inch balanced by a column of water of equal pressure (35-foot head) in the sprinkler system, and the gravity-tank check valve is held closed unless the water pressure from the gravity tank is more than 15 pounds per square inch (35-foot head).



TANK DIMENSIONS				
Net Capacity (Gallons)	Stave Length A	Inside Diam. B	Outside Diam. C	Approx. Outside Circ.
15,000	14'-0"	14'-2 1/2"	14'-7"	45'-9 3/4"
20,000	16'-0"	15'-3 1/2"	15'-8"	49'-2 3/4"
25,000	16'-0"	17'-0 1/2"	17'-6"	54'-11 3/4"
30,000	18'-0"	17'-6 1/2"	18'-0"	56'-6 1/2"
40,000	20'-0"	19'-1 1/2"	19'-7"	61'-6 1/4"
50,000	20'-0"	21'-6 1/2"	22'-0"	69'-1 1/2"
60,000	20'-0"	23'-6 1/2"	24'-0"	75'-4 3/4"
75,000	24'-0"	23'-10 1/2"	24'-4"	76'-5 1/4"

Number of Hoop starting at bottom.	Net Capacity (U.S. Gallons)							
	15,000	20,000	25,000	30,000	40,000	50,000	60,000	75,000
29								3
28								21 ↑
27								21 ↑
26								19 ↓
25								16 ↓
24							3	14 ↓
23								12 ↓
22								12 ↓
21								12 ↓
20								12 ↓
19								12 ↓
18								12 ↓
17								12 ↓
16								12 ↓
15								12 ↓
14								12 ↓
13								12 ↓
12								12 ↓
11								12 ↓
10								12 ↓
9								12 ↓
8								12 ↓
7								12 ↓
6								12 ↓
5								12 ↓
4								12 ↓
3								12 ↓
2								12 ↓
1								12 ↓

Bottom of Stave.

Fig. A-4-5.3. Hoop Schedules for Wood Tanks. Dimensions are for cylindrical tanks.

Air-lock can be prevented by increasing the volume of water and decreasing the air pressure in the pressure tank, so that little or no air pressure remains after water has been exhausted. For instance, if the pressure tank is kept $\frac{4}{5}$ full of water, with an air pressure of 60 pounds per square inch, the air pressure remaining in the tank after water has been drained is zero, and the gravity-tank check valve opens as soon as the pressure at that point from the pressure tank drops below the static head from the gravity tank.

Under normal conditions, air-lock may be conveniently prevented in new equipment by connecting the gravity tank and pressure tank discharge pipes together 45 feet or more below the bottom of the gravity tank and placing the gravity-tank check valve at the level of this connection.

A-4-5.6 Example: A 1 inch hoop 13.5 feet down from the top of a 22 foot diameter tank. What is the allowable spacing? Enter table in Fig. A-4-5.3 at 13.5 foot depth, follow the dash line vertically to 22 foot diameter, then horizontally to 1 inch hoop, then vertically out of the diagram at 8.9 inch spacing. One-half the sum of the actual distances to the next hoop above and below should not exceed 8.9 inch plus the tolerance.

Tolerances: Design spacing may exceed computed spacing a maximum of $\frac{1}{2}$ inch. Spacing as installed may exceed computed spacing a maximum of 1 inch.

A-7-1.1 Fireproofing Tank Towers. (*See 1-5 for locations where fireproofing is needed.*)

Fireproofing, when necessary, is usually not installed by the tank contractor. One acceptable method of fireproofing of steel columns consists of poured concrete, 2 inches outside of all projecting steel. One method of construction is to wind No. 5 B & S gage steel wire spirally at a pitch of 8 inches around the section and then to erect wooden forms about 6 feet high, filling and tamping before erecting the next 6-foot section.

The best coarse aggregates arranged in order of preference are limestone or calcareous gravel, trap rock, granite, sandstone, and hard coal cinders, less than 1 inch in size. A 1:2:4 mixture of portland cement, clean sand, and one of the above coarse aggregates should be used.

Another method of construction consists of winding 4 or 5 foot lengths of expanded metal around the section, the mesh taking the place of wooden forms and wire ties. The concrete should

be of relatively dry consistency, however, so that it will not escape from the mesh. The mesh should be kept about 1 inch away from the steel by means of spacers so that the concrete will completely surround the steel. Ends of the mesh should be lapped and securely wired together. After the concrete has set, a 1-inch layer of portland cement mortar is trowelled on the outside of the mesh.

Ordinarily columns are so nearly vertical that the weight of concrete fireproofing does not cause significant bending stresses. The vertical load is carried by the foundations. If columns are considerably inclined, reinforcing bars should be placed in the concrete so designed as to make the fireproofing self-supporting.

Fireproofing should extend continuously through floors and roof of a building. The extreme top of the concrete should be thoroughly flashed with asphalt, including all exposed junctions between steel and concrete. Concrete surfaces exposed to freezing temperatures should be coated with special waterproof paint suitable for concrete surfaces, to prevent spalling.

Horizontal struts and compression portal braces should also be encased in solid concrete 2 inches outside of all projecting steel. Wooden forms and wire ties are necessary, and reinforcing rods should be located near the bottom of the section so designed as to make the fireproofing self-supporting. Care should be taken in designing the supports for the forms, as compression members are not usually of sufficient strength to safely resist bending. If any of the struts are used for supporting forms, their strength shall be carefully investigated by a consulting structural engineer.

Cement plaster on metal lath has not been satisfactory out of doors or in moist locations, due to unobserved corrosion of the steel sections.

Diagonal wind rods or tension portal members are not usually fireproofed, being less subject to failure when heated than the compression members. Where very severe exposure exists, 1-inch asbestos covering over heavily painted rods, with exterior covering of painted 8-ounce canvas may be used, but removal and repainting of the steel at about eight-year intervals, is advisable. Special care is needed to make such fireproofing watertight at turnbuckles and clevises. Concrete has been used occasionally but wire ties or coarse rectangular mesh are necessary to prevent serious cracking and deterioration of the fireproofing.

Wooden frostproof casings are not usually fireproofed. A few casings have completely burned away from steel tanks without damaging the tower or tank but necessitating replacement of the riser pipes. Grillage beams under a wood tank might possibly fail in case of a serious fire involving the frostproof casing. Wooden casings, unless given a preservative treatment, usually rot and need replacement at from eight- to fourteen-year intervals. This period would probably not be lengthened by the presence of cement plaster fireproofing.

Noncombustible frostproof casings are desirable for wood tanks. For steel tanks, 3-foot diameter steel risers are satisfactory, and do not require fireproofing. In case of high risers, it is necessary to strengthen the valve pit roof.

Alternate protection for tank towers in lieu of concrete may consist of open sprinklers if water supplies are sufficient and watch service and other conditions are satisfactory to the authority having jurisdiction.

A-8-1.12 Telltale.

General. An approved mercury gage constructed as shown in Figure B-8-6 should be provided to indicate the depth of water in the tank.

Mercury Gage Materials. Pipe and fittings containing mercury should be iron or steel. Brass, copper or galvanized parts, if in contact with mercury, are amalgamated and leaks will result.

Water Pipe. The water pipe to the mercury gage should be 1 inch galvanized throughout, and connected into the discharge pipe on the tank side of the check valve. If possible the pipe should be short and run with a continual upward pitch toward the tank piping without air pockets to avoid false readings. The pipe should be buried well below the frost line, or be located in a heated conduit.

Valves. The valve at the mercury gage should be an approved outside screw and yoke gate valve. An additional approved outside screw and yoke gate valve should be installed close to the discharge pipe when the distance to the mercury gage exceeds 50 feet.

Mercury Catcher. Occasionally, fluctuating water-pressures require a mercury catcher at the top of the gage glass as shown in Figure B-8-6, to prevent loss of mercury. The catcher is not a standard part of the equipment and is not furnished by the gage manufacturer unless especially ordered.