

through UG-136 of the ASME Code except as modified in this subpart.

(b) An unfired steam boiler evaporator or heat exchanger (see § 54.01-10) shall be equipped with protective devices as required by § 54.15-15.

(c) All pressure vessels other than unfired steam boilers shall be protected by pressure-relieving devices that will prevent the pressure from rising more than 10 percent above the maximum allowable working pressure, except when the excess pressure is caused by exposure to fire or other unexpected source of heat.

(d) Where an additional hazard can be created by exposure of a pressure vessel to fire or other unexpected sources of external heat (for example, vessels used to store liquefied flammable gases), supplemental pressure-relieving devices shall be installed to protect against excessive pressure. Such supplemental pressure-relieving devices shall be capable of preventing the pressure from rising more than 20 percent above the maximum allowable working pressure of the vessel. The minimum required relief capacities for compressed gas pressure vessels are given under § 54.15-25. A single pressure-relieving device may be used to satisfy the requirements of this paragraph and paragraph (c) of this section, provided it meets the requirements of both paragraphs.

(e) Pressure-relieving devices should be selected on the basis of their intended service. They shall be constructed, located, and installed so that they are readily accessible for inspection and repair and so arranged that they cannot be readily rendered inoperative.

(f) Where pressure-indicating gages are used, they shall be chosen to be compatible with the pressure to be indicated. The size of the visual display, the fineness of graduations, and the orientation of the display will be considered. In no case shall the upper range of the gage be less than 1.2 times nor more than 2 times the pressure at which the relieving device is set to function.

(g) The Commandant may authorize or require the use of a rupture disk in lieu of a relief or safety valve under

certain conditions of pressure vessel use and design. See § 54.15-13.

(h) Vessels that are to operate completely filled with liquid shall be equipped with liquid relief valves unless otherwise protected against overpressure.

(i) The protective devices required under paragraph (a) of this section shall be installed directly on a pressure vessel except when the source of pressure is external to the vessel, and is under such positive control that the pressure in the vessel cannot exceed the maximum allowable working pressure at the operating temperature except as permitted in paragraphs (c) and (d) of this section.

(j) Pressure-relieving devices shall be constructed of materials suitable for the pressure, temperature, and other conditions of the service intended.

(k) The opening through all pipes and fittings between a pressure vessel and its pressure-relieving device shall have at least the area of the pressure-relieving device inlet, and in all cases shall have sufficient area so as not to unduly restrict the flow to the pressure-relieving device. The opening in the vessel shall be designed to provide direct and unobstructed flow between the vessel and its pressure-relieving device.

(l) Safety devices need not be provided by the pressure vessel manufacturer. However, overpressure protection shall be provided prior to placing the vessel in service.

[CGFR 68-82, 33 FR 18828, Dec. 18, 1968, as amended by CGD 88-032, 56 FR 35822, July 29, 1991; CGD 95-012, 60 FR 48049, Sept. 18, 1995]

**§ 54.15-10 Safety and relief valves (modifies UG-126).**

(a) All safety and relief valves for use on pressure vessels or piping systems shall be designed to meet the protection and service requirements for which they are intended and shall be set to relieve at a pressure which does not exceed the "maximum allowable working pressure" of the pressure vessel or piping system. Relief valves are not required to have huddling chambers for other than steam service. In addition, safety valves used on vessels in which steam is generated shall meet § 52.01-120 of this subchapter except § 52.01-120(a)(9). For steam service

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below 206 kPa (30 psig), bodies of safety valves may be made of cast iron. Safety relief valves used in liquefied compressed gas service shall meet subpart 162.017 or 162.018 in subchapter Q (Specifications) of this chapter as appropriate.

(b) Pilot-valve control or other indirect operation of safety valves is not permitted unless the design is such that the main unloading valve will open automatically at not over the set pressure and will discharge its full rated capacity if some essential part of the pilot or auxiliary device should fail. All other safety and relief valves shall be of the direct spring loaded type.

(c) Safety and relief valves for steam or air service shall be provided with a substantial lifting device so that the disk can be lifted from its seat when the pressure in the vessel is 75 percent of that at which the valve is set to blow.

(d) Safety and relief valves for service other than steam and air need not be provided with a lifting device although a lifting device is desirable if the vapors are such that their release will not create a hazard.

(e) If the design of a safety or relief valve is such that liquid can collect on the discharge side of the disk, the valve shall be equipped with a drain at the lowest point where liquid can collect (for installation, see UG-134 of section VIII of the ASME Code).

(f) Cast iron may be employed in the construction of relief valves for pressures not exceeding 125 pounds per square inch and temperatures not exceeding 450 °F. Seats or disks of cast iron are prohibited.

(g) The spring in a relief valve in service for pressures up to and including 250 pounds per square inch shall not be reset for any pressure more than 10 percent above or 10 percent below that for which the relief valve is marked. For higher pressures, the spring shall not be reset for any pressure more than 5 percent above or 5 percent below that for which the relief valve is marked.

(h) The rated relieving capacity of safety and relief valves for use on pressure vessels shall be based on actual flow test data and the capacity shall be

certified by the manufacturer in accordance with one of the following:

(1) 120 percent of the valve set pressure for valves rated in accordance with Compressed Gas Association Standard S-1.2.5.2.

(2) 110 percent of the valve set pressure for valves rated in accordance with UG-131 of section VIII of the ASME Code.

(3) 103 percent of the valve set pressure for steam in accordance with PG-69 of the ASME Code.

[CGFR 68-82, 33 FR 18828, Dec. 18, 1968, as amended by CGD 81-79, 50 FR 9436, Mar. 8, 1985]

**§ 54.15-13 Rupture disks (modifies UG-127).**

(a) Paragraph UG-127 of the ASME Code provides for the use of rupture disks in series with spring loaded safety or relief valves.

(b) For certain pressure vessels containing substances which may render a relief or safety valve inoperative, or where the installation of a valve is considered impractical, the Commandant may authorize or require the use of a rupture disk in parallel with or in lieu of a spring loaded safety or relief valve. These rupture disks shall:

(1) Comply with the general provisions of § 54.15-5 except as noted otherwise in this section;

(2) Have a capacity for discharge such that the volume of release is sufficient to prevent the internal pressure from exceeding 120 percent of the "maximum allowable working pressure" with the pressure vessel exposed to fire conditions (see § 54.15-25); and,

(3) Operate at a pressure level which does not produce fatigue failure of the disk. The normal maximum operating pressure multiplied by 1.3 shall not exceed the nominal disk burst pressure. (Notice that this restriction for protection of the rupture disk will usually require operation below the "maximum allowable working pressure" of the pressure vessel and therefore should be considered in design.)

(c) All disks shall be oriented so that if rupture occurs, the disk fragments and pressure vessel discharge will be directed away from operating personnel and vital machinery.