

ASME SECTION VIII DIV. 1



Materials

[UCS-5] General

- All carbon and low alloy steel material used for pressure vessels shall be as per ASME II and limited to Table UCS-23 except as permitted in UG-10 & UG-11

[UCS 6 to UCS-12] These paragraphs explain the materials similar to UCS-5 requirements, therefore, not discussed.

Design

[UCS-16 to UCS-33] Not discussed

Table UCS-23
Carbon and Low Alloy Steel

Item No.	Spec/Class	Item No.	Spec/Class	Item No.	Spec/Class
SA-50	-	SA-503	A, B, C, D, E, F	SA-504	A, B, C, D, E, F, G, H, I, J, K, L, M, N, O, P, Q, R, S, T, U, V, W, X, Y, Z
SA-501	SA-501, SA-502, SA-503	SA-504	A, B, C, D, E, F	SA-505	SA-505, SA-506
SA-502	-	SA-505	SA-505, SA-506, SA-507, SA-508, SA-509, SA-510, SA-511, SA-512, SA-513, SA-514, SA-515, SA-516, SA-517, SA-518, SA-519, SA-520, SA-521, SA-522, SA-523, SA-524, SA-525, SA-526, SA-527, SA-528, SA-529, SA-530, SA-531, SA-532, SA-533, SA-534, SA-535, SA-536, SA-537, SA-538, SA-539, SA-540, SA-541, SA-542, SA-543, SA-544, SA-545, SA-546, SA-547, SA-548, SA-549, SA-550, SA-551, SA-552, SA-553, SA-554, SA-555, SA-556, SA-557, SA-558, SA-559, SA-560, SA-561, SA-562, SA-563, SA-564, SA-565, SA-566, SA-567, SA-568, SA-569, SA-570, SA-571, SA-572, SA-573, SA-574, SA-575, SA-576, SA-577, SA-578, SA-579, SA-580, SA-581, SA-582, SA-583, SA-584, SA-585, SA-586, SA-587, SA-588, SA-589, SA-590, SA-591, SA-592, SA-593, SA-594, SA-595, SA-596, SA-597, SA-598, SA-599, SA-600, SA-601, SA-602, SA-603, SA-604, SA-605, SA-606, SA-607, SA-608, SA-609, SA-610, SA-611, SA-612, SA-613, SA-614, SA-615, SA-616, SA-617, SA-618, SA-619, SA-620, SA-621, SA-622, SA-623, SA-624, SA-625, SA-626, SA-627, SA-628, SA-629, SA-630, SA-631, SA-632, SA-633, SA-634, SA-635, SA-636, SA-637, SA-638, SA-639, SA-640, SA-641, SA-642, SA-643, SA-644, SA-645, SA-646, SA-647, SA-648, SA-649, SA-650, SA-651, SA-652, SA-653, SA-654, SA-655, SA-656, SA-657, SA-658, SA-659, SA-660, SA-661, SA-662, SA-663, SA-664, SA-665, SA-666, SA-667, SA-668, SA-669, SA-670, SA-671, SA-672, SA-673, SA-674, SA-675, SA-676, SA-677, SA-678, SA-679, SA-680, SA-681, SA-682, SA-683, SA-684, SA-685, SA-686, SA-687, SA-688, SA-689, SA-690, SA-691, SA-692, SA-693, SA-694, SA-695, SA-696, SA-697, SA-698, SA-699, SA-700, SA-701, SA-702, SA-703, SA-704, SA-705, SA-706, SA-707, SA-708, SA-709, SA-710, SA-711, SA-712, SA-713, SA-714, SA-715, SA-716, SA-717, SA-718, SA-719, SA-720, SA-721, SA-722, SA-723, SA-724, SA-725, SA-726, SA-727, SA-728, SA-729, SA-730, SA-731, SA-732, SA-733, SA-734, SA-735, SA-736, SA-737, SA-738, SA-739, SA-740, SA-741, SA-742, SA-743, SA-744, SA-745, SA-746, SA-747, SA-748, SA-749, SA-750, SA-751, SA-752, SA-753, SA-754, SA-755, SA-756, SA-757, SA-758, SA-759, SA-760, SA-761, SA-762, SA-763, SA-764, SA-765, SA-766, SA-767, SA-768, SA-769, SA-770, SA-771, SA-772, SA-773, SA-774, SA-775, SA-776, SA-777, SA-778, SA-779, SA-780, SA-781, SA-782, SA-783, SA-784, SA-785, SA-786, SA-787, SA-788, SA-789, SA-790, SA-791, SA-792, SA-793, SA-794, SA-795, SA-796, SA-797, SA-798, SA-799, SA-800, SA-801, SA-802, SA-803, SA-804, SA-805, SA-806, SA-807, SA-808, SA-809, SA-810, SA-811, SA-812, SA-813, SA-814, SA-815, SA-816, SA-817, SA-818, SA-819, SA-820, SA-821, SA-822, SA-823, SA-824, SA-825, SA-826, SA-827, SA-828, SA-829, SA-830, SA-831, SA-832, SA-833, SA-834, SA-835, SA-836, SA-837, SA-838, SA-839, SA-840, SA-841, SA-842, SA-843, SA-844, SA-845, SA-846, SA-847, SA-848, SA-849, SA-850, SA-851, SA-852, SA-853, SA-854, SA-855, SA-856, SA-857, SA-858, SA-859, SA-860, SA-861, SA-862, SA-863, SA-864, SA-865, SA-866, SA-867, SA-868, SA-869, SA-870, SA-871, SA-872, SA-873, SA-874, SA-875, SA-876, SA-877, SA-878, SA-879, SA-880, SA-881, SA-882, SA-883, SA-884, SA-885, SA-886, SA-887, SA-888, SA-889, SA-890, SA-891, SA-892, SA-893, SA-894, SA-895, SA-896, SA-897, SA-898, SA-899, SA-900, SA-901, SA-902, SA-903, SA-904, SA-905, SA-906, SA-907, SA-908, SA-909, SA-910, SA-911, SA-912, SA-913, SA-914, SA-915, SA-916, SA-917, SA-918, SA-919, SA-920, SA-921, SA-922, SA-923, SA-924, SA-925, SA-926, SA-927, SA-928, SA-929, SA-930, SA-931, SA-932, SA-933, SA-934, SA-935, SA-936, SA-937, SA-938, SA-939, SA-940, SA-941, SA-942, SA-943, SA-944, SA-945, SA-946, SA-947, SA-948, SA-949, SA-950, SA-951, SA-952, SA-953, SA-954, SA-955, SA-956, SA-957, SA-958, SA-959, SA-960, SA-961, SA-962, SA-963, SA-964, SA-965, SA-966, SA-967, SA-968, SA-969, SA-970, SA-971, SA-972, SA-973, SA-974, SA-975, SA-976, SA-977, SA-978, SA-979, SA-980, SA-981, SA-982, SA-983, SA-984, SA-985, SA-986, SA-987, SA-988, SA-989, SA-990, SA-991, SA-992, SA-993, SA-994, SA-995, SA-996, SA-997, SA-998, SA-999, SA-1000		

GENERAL NOTE: Material shall be steel unless otherwise specified. For complete details see the above table as contained in Section II, Part B, Subpart 1 (see UCS-5).

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Katrin Zwirgmaier



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web bolt torque is calculated for a flanged assembly using the following equation applied torque $t_k f d^{12}$ in fps unit where t torque in ft lb k dimensionless nut factor or tightening factor f axial force in pounds d nominal bolt diameter in inches in the metric system torque applied $t_k d f 1000$ where t torque in n m f bolt load in n

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web easy handling bolt numbering shall be done clockwise around the flange with the following sequence the table below shows the torque sequence for flanges with 4 to 32 bolts number of bolt studbolt tightening sequence to follow 4 bolt flange 1 3 2 4 8 bolt flange 1 5 3 7 2 6 4 8 12 bolt flange 1 7 4 10 2 8 5 11 3 9 6 12 16 bolt

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web for flanges with 12 or more bolts 1 st round 20 percent of final torque 2 nd round 40 percent of final torque 3 rd round 80 percent of final torque 4 th round 100 percent of final torque final round clockwise or counter clockwise around the flange please take note the above bolt tightening sequences are the most

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web jan 27 2021 the gasket type and arrangement of the flange connection are both critical to choosing which tightening sequence an assembler can use this article which is intended for supervisors engineers or anyone else who oversees bolted flange assembly or maintenance will discuss different torque sequences

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web number of bolt stud bolt tightening sequence to follow 4 bolt flange 1 3 2 4 8 bolt flange 1 5 3 7 2 6 4 8 12 bolt flange 1 7 4 10 2 8 5 11 3 9 6 12 16 bolt flange 1 9 5 13 3 11 7 15 2 10 6 14 4 12 8 16 20 bolt flange 1 11 6 16 3 13 8 18 5 15 10 20 2 12 7 17 4 14 9 19 24 bolt flange

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web ensure the bolt lengths allow for a minimum of 2 3 threads protruding beyond the top of the nut when tightened bolts must be tightened according to the below sequence options assemble bolts hand tight maximum 30 of final tightening torque as per below cross pattern sequences

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web step 1 liberally lubricate all load bearing surfaces including threads and flat washers then install and finger tighten all fasteners number the bolts flange according to the bolt torque sequence step 2 set the torque wrench to 1 3 of the target torque value and tighten in an order bolts 1 2 3 4 until all have been tightened

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web welcome to this interactive flange bolting calculator from hytorc the program computes recommended torque values bolting patterns tool selection and pump pressure settings for standard asme b16 5 and api 6a flanges under normal assembly conditions

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web tightening sequence the first pass lightly tighten the first bolt then move directly across or 180 degrees for the second bolt then move 1 4 turn around the circle or 90 degrees for the third bolt and directly across for the fourth continue this sequence until all bolts are tightened when tightening a four bolt flange use a criss cross

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web dec 17 2020 bolt tightening sequence why it matters to complete a flange joint securely it is essential to control the

stress variation in the flange joint components in the case of the gasket this needs to be compressed evenly across the flange face if you were to tighten adjacent bolts when those opposite remain loose the result will be

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web jan 10 2016 twelve bolt tightening sequence sequential order 1 2 3 4 5 6 7 8 9 10 11 12 rotation order 1 5 9 3 7 11 2 6 10 4 8 12 sixteen bolt tightening sequence sequential order 1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 rotation order 1 9 5 13 3 11 7 15 2 10 6 14 4 12 8 16 twenty bolt tightening sequence

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