

Specifications	Minimum tensile strength (p.s.i.) welded condition <sup>1</sup>	Minimum elongation in 2 inches (percent) weld metal (longitudinal)
ASTM A 240/A 240M (incorporated by reference; see § 171.7 of this subchapter), Type 304L .....	70,000	30
ASTM A 240/A 240M (incorporated by reference; see § 171.7 of this subchapter), Type 316L .....	70,000	30

<sup>1</sup> Maximum stresses to be used in calculations.

(2)(i) High alloy steels used to fabricate tank must be tested in accordance with the following procedures in ASTM Specification A262 titled, "Standard Practices for Detecting Susceptibility to Intergranular Attack in Austenitic Stainless Steel," and must exhibit corrosion rates not exceeding the following:

Test procedures	Material	Corrosion rate i.p.m.
Practice B .....	Types 304L and 316L ..	0.0040
Practice C .....	Type 304L .....	0.0020

(ii) Type 304L and 316L test specimens must be given a sensitizing treatment prior to testing.

(d) All attachments welded to tank shell must be of approved material which is suitable for welding to the tank.

[Amdt. 179-10, 36 FR 21344, Nov. 6, 1971, as amended by Amdt. 179-32, 48 FR 27707, June 16, 1983; Amdt. 179-47, 58 FR 50237, Sept. 24, 1993; Amdt. 179-52, 61 FR 28679, June 5, 1996; Amdt 179-52, 61 FR 50255, Sept. 25, 1996; 66 FR 45186, Aug. 28, 2001; 67 FR 51660, Aug. 8, 2002]

**§ 179.100-8 Tank heads.**

(a) The tank head shape shall be an ellipsoid of revolution in which the major axis shall equal the diameter of the shell adjacent to the head and the minor axis shall be one-half the major axis.

(b) Each tank head made from steel which is required to be "fine grain" by the material specification, which is hot formed at a temperature exceeding 1700 °F., must be normalized after forming by heating to a temperature between 1550° and 1700 °F., by holding at that temperature for at least 1 hour per inch of thickness (30-minute minimum), and then by cooling in air. If

the material specification requires quenching and tempering, the treatment specified in that specification must be used instead of the one specified above.

[29 FR 18995, Dec. 29, 1964. Redesignated, 32 FR 5606, Apr. 5, 1967 and amended by Amdt. 179-12, 39 FR 15038, Apr. 30, 1974]

**§ 179.100-9 Welding.**

(a) All joints shall be fusion-welded in compliance with the requirements of AAR Specifications for Tank Cars, appendix W. Welding procedures, welders and fabricators shall be approved.

(b) [Reserved]

[29 FR 18995, Dec. 29, 1964, as amended at 65 FR 58632, Sept. 29, 2000]

**§ 179.100-10 Postweld heat treatment.**

(a) After welding is complete, steel tanks and all attachments welded thereto must be postweld heat treated as a unit in compliance with the requirements of AAR Specifications for Tank Cars, appendix W.

(b) For aluminum tanks, postweld heat treatment is prohibited.

(c) Tank and welded attachments, fabricated from ASTM A 240/A 240M (incorporated by reference; see §171.7 of this subchapter), Type 304L or Type 316L materials do not require postweld heat treatment, but these materials do require a corrosion resistance test as specified in §179.100-7(c)(2).

[Amdt. 179-10, 36 FR 21345, Nov. 6, 1971, as amended by Amdt. 179-47, 58 FR 50238, Sept. 24, 1993; Amdt. 179-52, 61 FR 28679, June 5, 1996; 67 FR 51660, Aug. 8, 2002]

**§ 179.100-12 Manway nozzle, cover and protective housing.**

(a) Manway nozzles must be of approved design of forged or rolled steel for steel tanks or of fabricated aluminum alloy for aluminum tanks, with access opening at least 18 inches inside diameter, or at least 14 inches by 18 inches around or oval. Nozzle must be welded to the tank and the opening reinforced in an approved manner in compliance with the requirements of AAR Specifications for Tank Cars, appendix E, Figure E10.

(b) Manway cover shall be machined to approved dimensions and be of forged or rolled carbon or alloy steel,