TANK INSPECTION REPORT

{company\_name}

{overview\_pic}

{insp\_campaign}

{tank\_no}

{location}

{insp\_date}

Table of Contents

[1 Introduction 3](#_Toc129712203)

[2 Scope of work 3](#_Toc129712204)

[2.1 Inspection NDT and surveys carried out 3](#_Toc129712205)

[2.2 NDT and survey equipment used 3](#_Toc129712206)

[2.3 Equipment/Technique description 3](#_Toc129712207)

[3 History of tank (inspection and repairs) 4](#_Toc129712208)

[4 Tank data 4](#_Toc129712209)

[5 API checklist 5](#_Toc129712210)

[6 Visual inspection 5](#_Toc129712211)

[7 Thickness 6](#_Toc129712212)

[a. Roof thickness 6](#_Toc129712213)

[b. Roof nozzle thickness 6](#_Toc129712214)

[c. Shell thickness 6](#_Toc129712215)

[d. Shell nozzle thickness 6](#_Toc129712216)

[e. Bottom thickness 7](#_Toc129712217)

[f. Annular thickness 7](#_Toc129712218)

[g. Critical zone thickness 7](#_Toc129712219)

[h. Projection plate thickness 7](#_Toc129712220)

[i. Piping thickness 7](#_Toc129712221)

[j. Coil thickness 8](#_Toc129712222)

[k. Sump thickness 8](#_Toc129712223)

[l. MFL bottom 8](#_Toc129712224)

[m. MFL annular 9](#_Toc129712225)

[8 Evaluation 9](#_Toc129712226)

[a. Shell settlement 9](#_Toc129712227)

[b. Shell tilt or plumbness survey 11](#_Toc129712228)

[c. Shell buckling 11](#_Toc129712229)

[d. Local deviation 12](#_Toc129712230)

[e. Roundness 12](#_Toc129712231)

[f. Grounding connection 12](#_Toc129712232)

# Introduction

At the request of {company\_name} for an {insp\_campaign} inspection of

tank {tank\_no} was carried out. The inspection was conducted by a team of inspectors under supervision of certified API 653 inspector. The inspection was carried out on {insp\_date}.

# Scope of work

The {insp\_campaign} inspection in accordance with the API 653 code was

carried out. Paragraph 2.1 summarizes the scope of works carried out. Paragraphs 2.2 displays the details of NDT and survey equipment used. Paragraph 2.3 gives a short

explanation of the techniques used.

## Inspection NDT and surveys carried out

## NDT and survey equipment used

## Equipment/Technique description

The following equipment/techniques are normally used during tank inspections:

**Ultrasonic Thickness Measurements (UTM)**

UTM is one of the techniques used to determine the condition and wall thickness of e.g. the tank shell, bottom, and nozzles. Normally the purpose is to detect erosion/corrosion problems in an early stage. If measurements are repeatedly made on a same location, after a certain amount of time corrosion speeds can be determined and for example be used for Risk Based Inspection purposes.

**Equipment**

Dexon has a big assortment of equipment that can be used for UTM measurement ranging from handheld thickness gauges to more sophisticated A- and B-scan equipment. Most likely to be used is the Panametrics 36/37 DL or other model equipment, which can compensate for the thickness of paint layers and has a B-scan presentation. In addition to that a Dexon operator will have the availability of calibration blocks in at least three different materials (Carbon steel, Stainless Steel and Duplex).

**Magnetic Flux Hand Scan**

The Hand Scan System is designed to compliment the MFL 2000 and Floormap VS2i floorscanners. The latest generation of permanent magnets allows localized magnetic saturation of the floor area under test.

**Equipment**

Dexon has a wide range of equipment that can be used for Magnetic Flux Hand Scan, any signal above the operator controllable threshold is displayed as both a visual and audible alarm. Its low profile and extendable handle allow scanning in otherwise inaccessible areas at storage tanks such as the shell to annular area and under pipe work or heater coils.

# History of tank (inspection and repairs)

{new\_page}

# Tank data

|  |  |
| --- | --- |
| Status | {applicable\_status} |
| Type of tank | {roof\_type} |
| Product | {product\_code} |
| Product specific gravity | {g} |
| Diameter (m) | {diameter\_m} |
| Height (m) | {tank\_height\_m} |
| Safe fill height (m) | {max\_liquid\_level\_m} |
| Design code | {inspection\_code} |
| Date constructed | {installation\_date} |
| Date and type of last inspection |  |
| Bottom nominal thickness (mm) | {bottom\_nominal\_thk\_mm} |
| Annular nominal thickness (mm) | {annular\_nominal\_thk\_mm} |
| Roof nominal thickness (mm) | {roof\_nominal\_thk\_mm} |

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| Shell Course | Nominal  Thickness  (mm) | Height  (mm) | Tank Material | Material  Type |
| {#shell\_course}{course\_no} | {t\_nom\_plate\_mm} | {height\_of\_course\_m} | {mat\_spec} | {mat\_type}{/shell\_course} |

{new\_page}

# API checklist

{#checklist\_generic}

|  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- |
| {header\_content} | | Rating | | | | | | Comments: |
| OK | Minor Observation | Evaluation Required | Monitoring Required | Not Acceptable | Not Applicable |
| {#sub\_header}{subheader\_content} | | | | | | | | |
| {#topic}{no} | {topic} | {#result}{OK} | {MinorObservation} | {EvaluationRequired} | {MonitoringRequired} | {NotAcceptable} | {NotApplicable} | {comments}{/result}{/topic}{/subheader} |
| Remarks And Recommendations: | | | | | | | | |
| {#remark\_desc}{remark}{/remark\_desc} | | | | | | | | |

{/checklist\_generic}

{new\_page}

# Visual inspection

{#picture\_log}

| Overview | Close-up view |
| --- | --- |
| {overview\_pic} | {close\_up\_view\_pic} |
| Findings | Recommendation |
| {findings} | {recommendation} |

{/picture\_log}

{new\_page}

# Thickness

### Roof thickness

| Roof  Plate No | TP  Name | TP  Desc | Tnom  (mm) | Tmin  (mm) | Inspection Date | Tactual  (mm) | CR  (mm/yr) | RL  (yrs) |
| --- | --- | --- | --- | --- | --- | --- | --- | --- |
| {#roof\_thk}{roof\_no} | {tp\_name} | {tp\_desc} | {t\_nom} | {t\_req} | {inspection\_date} | {t\_actual} | {scr} | {rl}{/roof\_thk} |

{new\_page}

### Roof nozzle thickness

| Roof  Nozzle No | TP  Name | TP  Desc | Tnom  (mm) | Tmin  (mm) | Inspection Date | Tactual  (mm) | CR  (mm/yr) | RL  (yrs) |
| --- | --- | --- | --- | --- | --- | --- | --- | --- |
| {#roofnz\_thk}{roofnz\_no} | {tp\_name} | {tp\_desc} | {t\_nom} | {t\_req} | {inspection\_date} | {t\_actual} | {scr} | {rl}{/roofnz\_thk} |

{new\_page}

### Shell thickness

| Shell  Course | Plate  No | TP  Name | TP  Desc | Tnom  (mm) | Tmin  (mm) | Inspection Date | Tactual  (mm) |
| --- | --- | --- | --- | --- | --- | --- | --- |
| {#shell\_thk}{course\_no} | {plate\_no} | {tp\_name} | {tp\_desc} | {t\_nom} | {t\_req} | {inspection\_date} | {t\_actual}{/shell\_thk} |

{new\_page}

### Shell nozzle thickness

| Shell  Nozzle No | TP  Name | TP  Desc | Tnom  (mm) | Tmin  (mm) | Inspection Date | Tactual  (mm) | CR  (mm/yr) | RL  (yrs) |
| --- | --- | --- | --- | --- | --- | --- | --- | --- |
| {#shellnz\_thk}{shellnz\_no} | {tp\_name} | {tp\_desc} | {t\_nom} | {t\_req} | {inspection\_date} | {t\_actual} | {scr} | {rl}{/shellnz\_thk} |

{new\_page}

### Bottom thickness

| Bottom  Plate No | TP  Name | TP  Desc | Tnom  (mm) | Tmin  (mm) | Inspection Date | Tactual  (mm) | CR  (mm/yr) | RL  (yrs) |
| --- | --- | --- | --- | --- | --- | --- | --- | --- |
| {#bottom\_thk}{bottom\_no} | {tp\_name} | {tp\_desc} | {t\_nom} | {t\_req} | {inspection\_date} | {t\_actual} | {scr} | {rl}{/bottom\_thk} |

{new\_page}

### Annular thickness

| Annular  Plate No | TP  Name | TP  Desc | Tnom  (mm) | Tmin  (mm) | Inspection Date | Tactual  (mm) | CR  (mm/yr) | RL  (yrs) |
| --- | --- | --- | --- | --- | --- | --- | --- | --- |
| {#annular\_thk}{annular\_no} | {tp\_name} | {tp\_desc} | {t\_nom} | {t\_req} | {inspection\_date} | {t\_actual} | {scr} | {rl}{/annular\_thk} |

{new\_page}

### Critical zone thickness

| Critical Zone  Plate No | TP  Name | TP  Desc | Tnom  (mm) | Tmin  (mm) | Inspection Date | Tactual  (mm) | CR  (mm/yr) | RL  (yrs) |
| --- | --- | --- | --- | --- | --- | --- | --- | --- |
| {#critical\_thk}{plate\_no} | {tp\_name} | {tp\_desc} | {t\_nom} | {t\_req} | {inspection\_date} | {t\_actual} | {scr} | {rl}{/critical\_thk} |

{new\_page}

### Projection plate thickness

| TP  Name | TP  Desc | Tnom  (mm) | Tmin  (mm) | Inspection Date | Tactual  (mm) | CR  (mm/yr) | RL  (yrs) |
| --- | --- | --- | --- | --- | --- | --- | --- |
| {#projection\_thk}{tp\_name} | {tp\_desc} | {t\_nom} | {t\_req} | {inspection\_date} | {t\_actual} | {scr} | {rl}{/ projection\_thk} |

{new\_page}

### Piping thickness

| Piping No | CML  No | Part | TP  Name | TP  Desc | Tnom  (mm) | Tmin  (mm) | Inspection Date | Tactual  (mm) | CR  (mm/yr) | RL  (yrs) |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| {#piping\_thk}{piping\_no} | {cml\_no} | {part} | {tp\_name} | {tp\_desc} | {t\_nom} | {t\_req} | {inspection\_date} | {t\_actual} | {scr} | {rl}{/piping\_thk} |

{new\_page}

### Coil thickness

| Coil No | CML  No | Part | TP  Name | TP  Desc | Tnom  (mm) | Tmin  (mm) | Inspection Date | Tactual  (mm) | CR  (mm/yr) | RL  (yrs) |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| {#coil\_thk}{coil\_no} | {cml\_no} | {part} | {tp\_name} | {tp\_desc} | {t\_nom} | {t\_req} | {inspection\_date} | {t\_actual} | {scr} | {rl}{/coil\_thk} |

{new\_page}

### Sump thickness

| Sump No | CML  No | Location | TP  Name | TP  Desc | Tnom  (mm) | Tmin  (mm) | Inspection Date | Tactual  (mm) | CR  (mm/yr) | RL  (yrs) |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| {#sump\_thk}{sump\_no} | {cml\_no} | {location} | {tp\_name} | {tp\_desc} | {t\_nom} | {t\_req} | {inspection\_date} | {t\_actual} | {scr} | {rl}{/sump\_thk} |

{new\_page}

### MFL bottom

| Plate No | Tnom  (mm) | %Metal Loss  (Top side) | %Metal Loss  (Bottom side) | Remaining Thk Top Side  (mm) | Remaining Thk Bottom Side  (mm) | X  (mm) | Y  (mm) | Type of Repair | Width  (mm) | Length  (mm) | Thick  (mm) | Radius  (mm) | Repair Status |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| {#mfl\_bottom}{ plate\_no} | {t\_nom} | {metal\_loss\_top} | {metal\_loss\_bottom} | {lowest\_remaining\_thk\_top} | {lowest\_remaining\_thk\_bottom} | {defect\_x} | {defect\_y} | {type\_of\_repair} | {repair\_width} | {repair\_length} | {repair\_thick} | {repair\_radius} | {repair\_status}{/mfl\_bottom} |

### MFL annular

| Plate No | Tnom  (mm) | %Metal Loss  (Top side) | %Metal Loss  (Bottom side) | Remaining Thk Top Side  (mm) | Remaining Thk Bottom Side  (mm) | X  (mm) | Y  (mm) | Type of Repair | Width  (mm) | Length  (mm) | Thick  (mm) | Radius  (mm) | Repair Status |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| {#mfl\_annular}{plate\_no } | {t\_nom} | {metal\_loss\_top} | {metal\_loss\_bottom} | {lowest\_remaining\_thk\_top} | {lowest\_remaining\_thk\_bottom} | {defect\_x} | {defect\_y} | {type\_of\_repair} | {repair\_width} | {repair\_length} | {repair\_thick} | {repair\_radius} | {repair\_status}{/mfl\_annular} |

{new\_page}

# Evaluation

### Shell settlement

Tank Settlement Survey

- There must be at least 8 settlement points. The maximum spacing of settlement point is 32 ft. (9.7536 m) around the circumference.

- Points shall be equally spaced around the tank shell. There must be at least 4 equally spaced diametrical measurements.

- Measurements can best be taken at (every) vertical weld (with equal distance) of bottom shell coarse.

- Count welds from entry manhole in CW direction.

- If there is no projection plate staff on top first strake.



Datum Point Location

Settlement surveys are in general not carried out on small diameter tanks because, due to less weight of the product, the tanks are less susceptible to developing issues with settlement. Several internationally used specifications specify to carry out settlement surveys only for tanks with a diameter bigger than 9.75 m. If API 653 acceptance criteria are calculated for small diameter tanks the acceptance range will be very tight due to the small arc length between measurement points.

The acceptance criteria as per API 653 for this tank was found to be unacceptable. The results were also compared to the European tank inspection standard EEMUA 159. When the settlement is compared to the European standard the result is found to be within acceptance.

Measured data

| Survey location at the Tank  (Mark on shell map) | Distance between survey location  (mm) | Cumulative  distance around tank  (mm) | Relative Level /  Distance from Datum Point\* (mm) |
| --- | --- | --- | --- |
| {#shell\_settlement\_point}{location} |  | {cumulative} | {relative\_value}{/shell\_settlement\_point} |

Determination of acceptable differential settlement

| Data Point | Circumferential Distance | Reduced Level | Theta Radians | Theta Degrees | Relative Level | y | Difference (Ui) | Out of Plane Deflection (Si) | Deviation | Difference(2) | Deviation(2) |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| {#shell\_settlement\_api}{location} | {cumulative} | {reduced\_level} | {theta\_radians} | {theta\_degrees} | {relative\_value} | {y} | {difference\_value} | {out\_of\_plane} | {deviation\_value} | {difference\_2\_value} | {deviation\_2\_value}{/shell\_settlement\_api} |

{new\_page}

The value R calculation

| Sum of (Deviation)²(Syy) | Sum of (Different)²(SSE) | R² = (Syy-SSE)/Syy |
| --- | --- | --- |
| {#shell\_settlement\_api\_sum}{syy} | {sse} | {r\_2}{/shell\_settlement\_api\_sum} |

Settlement acceptance determination

|  |  |  |  |
| --- | --- | --- | --- |
| API653, Paragraph B.3 – Determination of the permissible Out-of-Plane settlement | | | |
| The optimal cosine curve is valid | | The optimal cosine curve is invalid | |
| ft = (L² x Y x 11) / 2 x E x H | | in = min[K x x (D / H) x (Y / E) , 4.0] | |
| L: Arc length between measurement points | {l\_value} ft. | K: API 653 | {k\_value} |
| Y: Yield strength | {yield} lbf/in2 | : Effective settlement arc | {s\_arc} ft. |
| E: Youngs Modulus | {e} lbf/in2 | D: Tank inside diameter | {diameter\_ft} ft. |
| H: Tank Height | {tank\_height\_ft} ft. | H: Tank Height | {tank\_height\_ft} ft. |
| n: Number of measurement points | {points} | Y: Yield strength | {yield} lbf/in2 |
|  | {s\_value} mm | E: Youngs Modulus | {e} lbf/in2 |
|  |  | n: Number of measurement points | {points} |
|  |  |  | {s\_max\_mm} mm |
| API653, Paragraph B.2.2.4 – Determination of predicted Out-of-Plane settlement | | | |
| S or Si = Ui – (0.5Ui – 1 + 0.5 Ui + 1) | | | |
|  | | {ui\_max} | |
|  | | {ui\_before\_max} | |
|  | | {ui\_next\_max} | |
| S | | {st\_value} | |
| R² | | {r\_2} | |
| Predicted deflection | | {predicted\_tilt} | |
| at | | {direction\_degrees\_cw\_pi} | |

{new\_page}

Acceptance per API 653

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| Acceptance Criteria | Cosine Curve | (mm) | S (mm) | Inspection Result |
| - | Valid | {s\_value} | {st\_value} | {insp\_result} |
| Invalid | {s\_max\_mm} | {st\_value} | {insp\_result\_invalid} |

{new\_page}

### Shell tilt or plumbness survey

Plumbness Evaluation

The measurements were made 4 directions around the circumference of the tank for tank diameter 1-12 m. and 8 directions for tank diameter > 12 m.

Shape, rectangle, polygon

Description automatically generated

Acceptance criteria per API 653:

1. For FR and EFR, the maximum of out-of-verticality at the tank shell should not exceed 1/100th of the tank height.

2. For IFR, the maximum of out-of-verticality at the tank shell should not exceed 1/200th of the tank height.

Acceptable where St < S

Not acceptable where St > S

| Measurement Location | Bottom of Tank | Top of Tank | Deviation | | S - mm | St - mm | Result |
| --- | --- | --- | --- | --- | --- | --- | --- |
| {#plumbness}{eval\_location} | {bottom\_tank} | {top\_tank} | {deviation} | {in\_out\_ward} | {s\_value} | {st} | {result}{/plumbness} |

{new\_page}

### Shell buckling

| Course – Plate No | Measured Height  (m) | Theoretical Shape Diameter  (mm) | Deviation  (mm) | Radius Tolerance  (mm) | Inspection  Result |
| --- | --- | --- | --- | --- | --- |
|  |  |  |  |  |  |

### Local deviation

| No | Deviation Type | Between Plate | And plate | Deviation  (mm) | Radius Tolerance  (mm) | Inspection  Result |
| --- | --- | --- | --- | --- | --- | --- |
|  |  |  |  |  |  |  |

### Roundness

| Point No | Distance Above Bottom  (m) | Radius Measured Value  (mm) | Relative to nom.  (mm) | Radius Tolerance  (mm) | Inspection  Result |
| --- | --- | --- | --- | --- | --- |
|  |  |  |  |  |  |

### Grounding connection

| Grounding Connection No | The measured resistance to ground (ohms) | Note |
| --- | --- | --- |
|  |  |  |

| Grounding Connection Detail | |
| --- | --- |
| Total Resistance (ohms) |  |
| Acceptance Criteria (ohms) |  |
| Result |  |
| Measurement Summary |  |

### MRT

| Bottom Plate | | Annular Plate | |
| --- | --- | --- | --- |
| RTbc |  | RTbc |  |
| RTip |  | RTip |  |
| Or |  | Or |  |
| StPr |  | StPr |  |
| UPr |  | UPr |  |
| Age of Tank |  | Age of Tank |  |
| MRT |  | MRT |  |
| tmin |  | tmin |  |
| Result |  | Result |  |
| Recommendation |  | Recommendation |  |