Nutrien	Fort Saskatchewan Nitrogen Operations **PIPING MATERIAL SPECIFICATION**	Line Class **9S1DU** **REV** **3**

SERVICE	STEAM, BFW, BOILER PIPING	**INSPECTION**	CLASS II PER TECH STD P8-1TS
CORROSION ALLOWANCE	1.65 MILLIMETERS 0.065 INCHES	**BUTTWELD CONSTRUCTION**	IV PER TECH P4-6TS
TEMP LIMIT	593 °C (1099.4) °F **MAX**	**RATING**	ASME B16.5 CLASS 900, RF
PRESSURE	SEE PT RATING TABLE	**MATERIAL**	1.25CR-S/EFW
COLOR	TECH STD P1-3TS	**STRESS RELIEF**	SEE NOTE 925
VALVE TRIM	FULL H.F.	**ASME STANDARD**	B31.1 (2022)
FLUID CATEGORY			

Item	Notes	Size (NPS)	Sch/Rating	Ends	Description	COMM CODE	REV
PIPE	222						
		1/2 - 3	160	PE	1-1/4CR-1/2MO,SMLS,ASME SA335-P11	DQ1001	2
		4 - 8	120	PE	1-1/4CR-1/2MO,SMLS,ASME SA335-P11	DQ1001	2
		10 - 10	140	PE	1-1/4CR-1/2MO,SMLS,ASME SA335-P11	DQ1001	2
		12 - 24	CALC	PE	1-1/4CR-1/2MO,SMLS,ASME SA335-P11	DQ1001	2
		26 - 48	CALC	PE	1-1/4CR-1/2MO,EFW,ASME SA691 1-1/4CR,CL. 13	DQ1103	2
NIPPLES							
IN-LINE		1/2 - 2	160	PE	1-1/4CR-1/2MO,SMLS,ASME SA335-P11	DQ1301	2
BRANCH		1/2 - 2	160	PE	1-1/4CR-1/2MO,SMLS,ASME SA335-P11	DQ1301*	2
SWAGE (CONC)	875	1/2 - 2	160	PE	1-1/4CR-1/2MO,ASME SA234-WP11-S,MSS SP-95	DQ1603	2
SWAGE (ECC)	875	1/2 - 2	160	PE	1-1/4CR-1/2MO,ASME SA234-WP11-S,MSS SP-95	DQ1604	2
IN-LINE	311, 935	1/2 - 2	XXS	TE	1-1/4CR-1/2MO,SMLS,ASME SA335-P11	DQ1301	2
BRANCH	311, 935	1/2 - 2	XXS	TE	1-1/4CR-1/2MO,SMLS,ASME SA335-P11	DQ1301*	2
SWAGE (CONC)	311, 875, 935	1/2 - 2	XXS	TE	1-1/4CR-1/2MO,ASME SA234-WP11-S,MSS SP-95	DQ1603	2
SWAGE (ECC)	311, 875, 935	1/2 - 2	XXS	TE	1-1/4CR-1/2MO,ASME SA234-WP11-S,MSS SP-95	DQ1604	2
FITTINGS	223						
SOCKOLET	877	1/2 - 2	3000	WELD	1-1/4CR-1/2MO,ASME SA182-F11,FLAT TYPE	DQ3907	2
90 ELL		1/2 - 2	3000	SOCW	1-1/4CR-1/2MO,ASME SA182-F11,ASME B16.11	DQ4001	2
45 ELL		1/2 - 2	3000	SOCW	1-1/4CR-1/2MO,ASME SA182-F11,ASME,B16.11	DQ4002	2
TEE		1/2 - 2	3000	SOCW	1-1/4CR-1/2MO,ASME SA182-F11,ASME,B16.11	DQ4003	2
TEE (RED)		1/2 - 2	3000	SOCW	1-1/4CR-1/2MO,ASME SA182-F11,ASME,B16.11	DQ4003*	2
PLUG	311, 935	1/2 - 2		THRD	1-1/4CR-1/2MO,ASME SA182-F11,ROUND HEAD,ASME B16.11	DQ5001	2
COUPLING		1/2 - 2	3000	SOCW	1-1/4CR-1/2MO,ASME SA182-F11,ASME,B16.11	DQ4005	2
COUPLING (RED)		1/2 - 2	3000	SOCW	1-1/4CR-1/2MO,ASME SA182-F11,ASME,B16.11	DQ4005*	2
COUPLING	311, 935	1/2 - 2	6000	THRD	1-1/4CR-1/2MO,ASME SA182-F11,ASME B16.11	DQ5205	2
COUPLING (RED)	311, 935	1/2 - 2	6000	THRD	1-1/4CR-1/2MO,ASME SA182-F11,ASME B16.11	DQ5205*	2
CAP		1/2 - 2	3000	SOCW	1-1/4CR-1/2MO,ASME SA182-F11,ASME,B16.11	DQ4007	2
CAP	311, 935	1/2 - 2	6000	THRD	1-1/4CR-1/2MO,ASME SA182-F11,ASME B16.11	DQ5207	2
REDUCING INSERT		1/2 - 2	3000	SOCW	1-1/4CR-1/2MO,ASME SA182-F11,MSS SP-79	DQ4009	2
UNION-X	KK	1/2 - 2			UNIONS NOT PERMITTED (USE FLANGES)	DQ401X	
SOCKOLET		1/2 - 48	3000	WELD	1-1/4CR-1/2MO,ASME SA182-F11	DQ3902	2
THREADOLET	304, 311, 935	1/2 - 48	3000	WELD	1-1/4CR-1/2MO,ASME SA182-F11	DQ3903	2
SW LATROLET		1/2 - 48	3000	WELD	1-1/4CR-1/2MO,ASME SA182-F11	DQ3914	2
THRD LATROLET	304, 311, 935	1/2 - 48	3000	WELD	1-1/4CR-1/2MO,ASME SA182-F11	DQ3918	2
SW ELBOLET		1/2 - 48	3000	WELD	1-1/4CR-1/2MO,ASME SA182-F11	DQ3913	2
THRD ELBOLET	304, 311, 935	1/2 - 48	3000	WELD	1-1/4CR-1/2MO,ASME SA182-F11	DQ3917	2
SOLID BAR PLUG	637	3/4 - 3/4		SOCW	1-1/4CR-1/2MO,ASME SA182-F11,ROUND TYPE,ASME B16.11	DQ4213	2
WELDOLET	877	1½ - 4		WELD	1-1/4CR-1/2MO,ASME SA182-F11,FLAT TYPE	DQ3906	2
REDUCER (CONC)		1½ - 48		WELD	1-1/4CR-1/2MO,ASME SA234-WP11-S,ASME B16.9	DQ3006	2
REDUCER (ECC)		1½ - 48		WELD	1-1/4CR-1/2MO,ASME SA234-WP11-S,ASME B16.9	DQ3007	2
WELDOLET		1½ - 48		WELD	1-1/4CR-1/2MO,ASME SA182-F11	DQ3901	2
BW ELBOLET		1½ - 48		WELD	1-1/4CR-1/2MO,ASME SA182-F11	DQ3911	2
BW LATROLET		1½ - 48		WELD	1-1/4CR-1/2MO,ASME SA182-F11	DQ3912	2
90 ELL		3 - 24		WELD	1-1/4CR-1/2MO,ASME SA234-WP11-S,ASME B16.9	DQ3001	2
90 ELL (SR)	428	3 - 24		WELD	1-1/4CR-1/2MO,ASME SA234-WP11-S,ASME B16.28	DQ3002	2
45 ELL		3 - 24		WELD	1-1/4CR-1/2MO,ASME SA234-WP11-S,ASME B16.9	DQ3003	2
TEE		3 - 24		WELD	1-1/4CR-1/2MO,ASME SA234-WP11-S,ASME B16.9	DQ3004	2

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3	31-May-2024	Revised Code Year ASME B31.1-2022	S.Sarkar	T. King	**9S1DU**	Page 1 of 3
2	5-Apr-2023	Add Notes 922/925/935/936, Rev Code Yr, CA, P/T Tbl, Str Rlf, SA Mat'l, Pipe Sch, Err Fix	K. Kang	T. King		
1	16-Jun-2016	Added FP Valve Note, General Cleanup	J. Tomkins	J. Tomkins		
0	22-Feb-2016	Initial Issue as Agrium Spec	H. Qureshi	J. Tomkins		

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FITTINGS (CONT.)	223						
TEE (RED)		3 - 24		WELD	1-1/4CR-1/2MO,ASME SA234-WP11-S,ASME B16.9	DQ3004*	2
CAP		3 - 30		WELD	1-1/4CR-1/2MO,ASME SA234-WP11-S,ASME B16.9	DQ3005	2
90 ELL		26 - 48		WELD	1-1/4CR-1/2MO,ASME SA234-WP11-W,W/100% X-RAY,B16.9	DQ3101	2
90 ELL (SR)	428	26 - 48		WELD	1-1/4CR-1/2MO,ASME SA234-WP11-W,W/100% X-RAY,B16.28	DQ3102	2
45 ELL		26 - 48		WELD	1-1/4CR-1/2MO,ASME SA234-WP11-W,W/100% X-RAY,B16.9	DQ3103	2
TEE		26 - 48		WELD	1-1/4CR-1/2MO,ASME SA234-WP11-W,W/100% X-RAY,B16.9	DQ3104	2
TEE (RED)		26 - 48		WELD	1-1/4CR-1/2MO,ASME SA234-WP11W,W/100% X-RAY,B16.9	DQ3104*	2
REDUCER (ECC)		26 - 48		WELD	1-1/4CR-1/2MO,ASME SA234-WP11-W,W/100% X-RAY,B16.9	DQ3106	2
REDUCER (CONC)		26 - 48		WELD	1-1/4CR-1/2MO,ASME SA234-WP11-W,W/100% X-RAY,B16.9	DQ3107	2
ELLIPTICAL HEAD	401	32 - 48		WELD	1-1/4CR-1/2MO,ASME SA387-11,CL.1,(2:1 AXIS RATIO)	DQ3401	2
VALVES							
GLOBE	900, 935	1/2 - 2	1500	T/SW	1 1/4CR BODY W/ FULL H.F. TRIM	V6FAJC87	2
GATE	510	1/2 - 2	1500	RF	1 1/4CR BODY W/ FULL H.F. TRIM	VAFGJCP7	
GATE	499	1/2 - 2	1500	SOCW	1 1/4CR BODY W/ FULL H.F. TRIM ,F.P.	VDFBJCX7	
GATE		1/2 - 2	1500	SOCW	1 1/4CR BODY W/ FULL H.F. TRIM	VDFGJCX7	
GATE	501, 935	1/2 - 2	1500	T/SW	1 1/4CR BODY W/ FULL H.F. TRIM	VEFGJC87	2
GATE		3 - 24	900	WELD	1 1/4CR BODY W/ FULL H.F. TRIM ,PSB	VCEUJCMW	
GLOBE		1/2 - 2	1500	SOCW	1 1/4CR BODY W/ FULL H.F. TRIM ,NEEDLE	VJF4JCX7	
GLOBE		1/2 - 2	1500	SOCW	1 1/4CR BODY W/ FULL H.F. TRIM	VJFAJCX7	
GLOBE		3 - 3	900	WELD	1 1/4CR BODY W/ FULL H.F. TRIM ,PSB	VHEUJCMW	
GLOBE		4 - 8	900	WELD	1 1/4CR BODY W/ FULL H.F. TRIM ,G.O. ,PSB	VHEUJC1W	
CHECK		1/2 - 2	1500	SOCW	1 1/4CR BODY W/ FULL H.F. TRIM ,SWING,H OR V	VSFAJCU7	
CHECK		3 - 24	900	WELD	1 1/4CR BODY W/ FULL H.F. TRIM ,TILT,H/V,PSC	VREJJCYD	
FLANGES	612						
SOCKET WELD		1/2 - 2	1500	RF	1-1/4CR-1/2MO,ASME SA182-F11,ASME B16.5,STD FIN	DQ2405	2
BLIND		1/2 - 2	1500	RF	1-1/4CR-1/2MO,ASME SA182-F11,ASME B16.5,STD FIN	DQ2705	2
PAIR WN ORIFICE	637	2 - 2	1500	RF	1-1/4CR,ASME SA182-F11,B16.36,3/4" SW TAPS,STD FIN	DQ2805	2
WELD NECK		3 - 24	900	RF	1-1/4CR-1/2MO,ASME SA182-F11,ASME B16.5,STD FIN	DQ2004	2
BLIND		3 - 24	900	RF	1-1/4CR-1/2MO,ASME SA182-F11,ASME B16.5,STD FIN	DQ2704	2
PAIR WN ORIFICE	637	3 - 24	900	RF	1-1/4CR,ASME SA182-F11,B16.36,3/4" SW TAPS,STD FIN	DQ2804	2
WELD NECK		26 - 48	900	RF	1 1/4CR-1/2MO,ASME SA182-F11,API 605,STD FIN	DQ2104	2
BLIND		26 - 48	900	RF	1 1/4CR-1/2MO,ASME SA182-F11,API 605,STD FIN	DQ2774	2
GASKETS	701						
SPIRAL WOUND		1/2 - 24			1/8" 316 SS WINDING W/FLEX GRAPH FILLER, B16.47-B	R4DF1	
SPIRAL WOUND		26 - 48			1/8" 316 SS WINDING W/FLEX GRAPH FILLER	R4PF1	
BOLTING							
STUD BOLTS	605	1/2 - 48			ASME SA193 GR B16 STUD W/ ASME SA194 GR 4 NUTS	CB7015	2
MISCELLANEOUS							
STEAM TRAP	S33	1/2 - 1	6000	SOCW	1-1/4 CHROME BODY, SARCO TD62, 981 PSIG @ 842F	DQ8993	
SPACER		1/2 - 2	1500	RF	1-1/4CR-1/2MO,PER TECH STD P36-1TS,STD FIN	DQ8214	
CIRCULAR BLANK		1/2 - 2	1500	RF	1-1/4CR-1/2MO,PER TECH STD P36-1TS,STD FIN	DQ8213	
FIGURE 8	861	1/2 - 2	1500	RF	1-1/4CR-1/2MO,PER TECH STD P36-1TS,STD FIN	DQ8215	
Y-STRAINER	860	1/2 - 2	1500	SOCW	1-1/4CR BODY W/304 SS SCREEN "L",TECH STD P25-2TS	DQ8612	
Y-STRAINER		1/2 - 2	1500	SOCW	1-1/4CR BODY W/304 SS SCREEN "G",TECH STD P25-2TS	DQ8611	
BRANCH WELD		1/2 - 48			BRANCH WELD W/PAD-ALLOY	CB9820	
BRANCH WELD		1/2 - 48			BRANCH WELD-ALLOY	CB9812	
SHOP/FIELD BW		1/2 - 48			BUTT WELD-ALLOY	CB9811	
FIGURE 8		3 - 12	900	RF	1-1/4CR-1/2MO,PER TECH STD P36-1TS,STD FIN	DQ8212	
SPACER		3 - 24	900	RF	1-1/4CR-1/2MO,PER TECH STD P36-1TS,STD FIN	DQ8211	
CIRCULAR BLANK		3 - 24	900	RF	1-1/4CR-1/2MO,PER TECH STD P36-1TS,STD FIN	DQ8210	
NON-STANDARD							
	II, 922, 935	1/4 - 3/8	XS		1-1/4CR-1/2MO,SMLS,ASME SA335-P11	DQ1001	2
SWAGE (CONC)	II, 922, 935	1/4 - 3/8	XS		1-1/4CR-1/2MO,ASME SA234-WP11-S,MSS SP-95	DQ1603	2
SWAGE (ECC)	II, 922, 935	1/4 - 3/8	XS		1-1/4CR-1/2MO,ASME SA234-WP11-S,MSS SP-95	DQ1604	2
PLUG	II, 311, 935	1/4 - 3/8		THRD	1-1/4CR-1/2MO,ASME SA182-F11,ROUND HEAD,ASME B16.11	DQ5001	2
WELD NECK	II	1/2 - 24	1500	RF	1-1/4CR-1/2MO,ASME SA182-F11,ASME B16.5,STD FIN	DQ2005	2
	II	2½ - 2½	160	PE	1-1/4CR-1/2MO,SMLS,ASME SA335-P11	DQ1001	2
FIGURE 8	II	3 - 12	1500	RF	1-1/4CR-1/2MO,PER TECH STD P36-1TS,STD FIN	DQ8215	
CIRCULAR BLANK	II	3 - 24	1500	RF	1-1/4CR-1/2MO,PER TECH STD P36-1TS,STD FIN	DQ8213	
SPACER	II	3 - 24	1500	RF	1-1/4CR-1/2MO,PER TECH STD P36-1TS,STD FIN	DQ8214	

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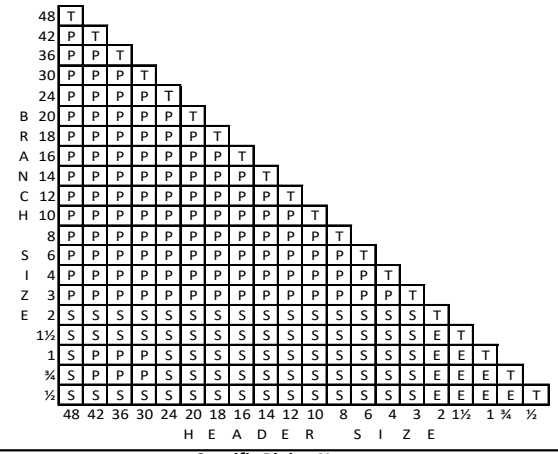
Nutrien	Fort Saskatchewan Nitrogen Operations **PIPING MATERIAL SPECIFICATION**	Line Class **9S1DU** **REV** **3**

Branch Connection Legend, Notes & Chart	**REV**
Legend	
B - BRANCH WELD	
C - COUPLING	
D - THREDOLET	
E - REDUCING TEE	
M - TEE WITH REDUCING INSERT	
N - NIPOLET	
P - BRANCH WELD WITH REINFORCING PAD	813
S - SOCKOLET	
T - TEE	
W - WELDOLET	
X - DO NOT USE	
F - FIL WND REINF BRANCH	
G - FIL WND W OR W/O RED	
L - ANG BRANCH/LATERAL	
Y - TEE W/RED. BUSHING	
Z - TEE W/BUTTWELD RED.	
R - SADDLE REDUCING TEE	
Q - TEE W/2 OR MORE RED.	

Chart



PT RATING TABLE ASME B16.5 (2020) - SEE NOTES 001/936		**REV**
Temperature	Pressure	
-29C (-20F)		
TO 38C (100F)	158.18 (2250)	
93C (200F)	158.18 (2250)	
149C (300F)	152.22 (2165)	
204C (400F)	146.23 (2080)	2
260C (500F)	140.27 (1995)	
316C (600F)	127.59 (1815)	
343C (650F)	124.07 (1765)	
371C (700F)	119.86 (1705)	
399C (750F)	112.13 (1595)	
427C (800F)	107.21 (1525)	
454C (850F)	102.64 (1460)	
482C (900F)	94.91 (1350)	
510C (950F)	67.15 (955)	
538C (1000F)	45.7 (650)	
566C (1050F)	30.23 (430)	
593C (1100F)	20.39 (290)	
621C (1150F)		
649C (1200F)		

Specific Piping Notes

II. USE OF NON-STANDARD COMPONENTS TO BE REVIEWED AND APPROVED BY THE PIPING DESIGN WORKGROUP LEADER.

KK. COMMODITY WILL NOT BE TRANSFERRED TO KELWAY. THIS IS A DUMMY CODE USED AS A WARNING OF PIPE CLASS RESTRICTIONS.

001. THE FIRST PRESSURE IS GIVEN IN KG/CM2 (GAGE), AND THE SECOND PRESSURE, SHOWN IN PARENTHESES, IS GIVEN IN PSIG.

222. WHERE PIPE SCHEDULE IS SHOWN UNDER, "SCH/RAT", IT IS ADEQUATE FOR THE FULL FLANGE RATING. WHERE "CALC" IS SHOWN, THE PRESSURE LIMIT MAY BE LOWER THAN THE FLANGE RATING.

223. ALL BUTTWELD COMPONENT THICKNESSES SHALL MATCH PIPE THICKNESS.

304. THREADED OUTLET REINFORCED BRANCH WELD FITTINGS TO BE USED ONLY FOR THERMOWELL AND HYDROSTATIC TEST CONNECTIONS.

311. THREADED JOINTS ARE ONLY PERMITTED AT TERMINAL OF VENT, DRAIN AND HYDROSTATIC CONNECTIONS, AT INSTRUMENT TAKE-OFF POINTS, OR OTHER LOCATIONS APPROVED BY MAINTENANCE ENGINEERING.

401. WHEN CAPS ARE REQUIRED ABOVE 30 INCH SIZE, ELLIPTICAL HEADS WITH 2:1 AXIS RATIO SHALL BE USED.

428. USE OF SHORT RADIUS ELBOWS SHOULD BE REVIEWED AND APPROVED BY SYSTEMS & PIPING MECHANICAL.

499. USE FULL PORT VALVES AT INLET AND DISCHARGE OF PSV'S AND IN PUMP SUCTIONS WHERE PRESSURE DROP IS CRITICAL, USE FULL PORT VALVES WHERE RODDING OUT IS REQUIRED.

501. THREADED BY SOCKETWELD (T/SW) VALVES SHALL BE USED FOR VENT, DRAIN AND INSTRUMENT CONNECTIONS ONLY.

510. TO BE USED WHEN MATING FLANGED VALVES TO FLANGED NOZZLES.

605. DIMENSIONS FOR FLANGES, GASKETS AND BOLTING LARGER THAN NPS 24 AND UP TO NPS 60 SHALL BE PER ASME B16.47, SERIES B (API 605)

612. THE USE OF FLANGES SHALL BE MINIMIZED; WELDED CONNECTIONS SHALL BE USED IN ORDER TO ELIMINATE THE PROBABILITY OF LEAKS.

637. ORIFICE FLANGES SHALL HAVE SOCKETWELD TAPS PER ASME B16.36 AND PER JOB STANDARD M21-1J WHEN SPECIFIED. USE SOLID BAR PLUG FOR UNUSED ORIFICE TAP.

701. ALLOW 1/8" BETWEEN FLANGES FOR GASKETS.

813. A PAD HAS BEEN SELECTED TO PROVIDE REINFORCEMENT FOR THIS BRANCH CONNECTION SUBJECT TO THE MOST SEVERE COINCIDENT CONDITION OF INTERNAL PRESSURE AND FLUID TEMPERATURE SEEN IN THIS SPECIFICATION. HOWEVER, THE SPECIFIC PRESSURETEMPERATURE CONDITION FOR THIS CONNECTION MAY ELIMINATE THE NEED FOR REINFORCEMENT

860. TO BE USED FOR AIR, GAS OR STEAM SERVICE

861. TO BE USED FOR LIQUID SERVICE.

875. THE USE OF SWAGE NIPPLES IS NOT PERMITTED WHEN THE LARGE END EXCEEDS NPS 2.

877. FLAT O-LETS SHOULD ONLY BE USED FOR CONCENTRIC WELD CONNECTIONS; I.E. - WELDED TO CAP AT BOTTOM OF DRIP/BOOT LEG.

900. TO BE USED ONLY WHERE SHOWN ON THE PIPING AND INSTRUMENT DIAGRAMS (P&ID'S).

922. IF THREADED, THIS ITEM DOES NOT MEET THE SPECIFIED CORROSION ALLOWANCE OF THIS SPECIFICATION.

925. PWHT IS REQUIRED FOR WT > 12.7MM-0.50IN. PWHT PER B31.1 FOR WT ≤ 12.7MM-0.50IN, BUT APPROVAL FROM MAINTENANCE ENGINEERING IS REQUIRED TO USE EXEMPTIONS IN TABLE 132.2-1.

935. THREADED COMPONENTS SHALL ONLY BE USED FOLLOWING THE LIMITATIONS LAID OUT IN ASME B31.1 PARAGRAPH 114.2.

936. RATINGS IN THE PRESSURE-TEMPERATURE TABLE HAVE BEEN UPDATED TO MEET ASME B16.5-2020.

S33. SELECTION OF STEAM TRAPS BY SYSTEMS (OR OTHER VENDOR'S EQUIV.):

(1) LOW PRESSURE STEAM, SARCO UTD-52L (DW8992)

(2) MED PRESSURE STEAM, SARCO TD-62 (DQ8993)

(3) HIGH PRESSURE STEAM, SARCO TD-120 (DT8995)

(4) HIGH PRESSURE STEAM, TLV HR150A (DT8996)

(5) L.P. PROCESS SS, SARCO FT-46-10 (FL8991)

(6) L.P. PROCESS CS, SARCO UTDL-52L (DW8992)

(7) LOW PRESSURE STEAM, SARCO FT450-4.5(CB8991), FT450-10(CB8992), FT450-14(CB8993), FT450-21(CB8994).

(8) M.P. PROCESS SS, SARCO FT-46-21 (FL8992)

(9) DRAIN TRAPS, SPIRAX SARCO FA450-4.5(CB8891), FA450-10(CB8892), FA450-14(CB8893), FA450-21(CB8894).

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