

IP-2013-07-001

Requirements For The Acceptance Of Used Pressure Vessels For Use Within The Province Of Saskatchewan

In order for a used pressure vessel to be accepted for pressure service in the Province of Saskatchewan, the following conditions must be satisfied:

Design Survey Requirements:

All pressure vessels must possess a Saskatchewan CRN** and must have been designed and manufactured in accordance with ASME Section VIII, Division I and CSA B51 (Canadian Boiler, Pressure Vessel and Pressure Piping Code). If the vessel does not have a Saskatchewan CRN, legible detailed design drawings (material specifications, dimensions, thicknesses, design data, and weld details must be included), calculations and a copy of the manufacturer's data report are required to be submitted to the Codes and Standards Compliance office for review and acceptance. Calculations to justify the structural integrity of the vessel may be performed to the original edition of the code of construction used at the time of manufacture and must take into account internal/external pressures and nozzle reinforcement on the complete pressure envelope, custom manufactured flanges (Non-ANSI), external loadings and saddle support design (if over 37,000 litres volume).

If original drawings are not available, as-built drawings of the vessel will be accepted based on the following limitations:

- i) All welds (internal and external) and dimensions must be verified by the local inspector.
- ii) All components of the pressure vessel not listed on the original manufacturer's data report or identified by required ANSI/MSS SP-25 markings must be removed and replaced. This may include nozzles, flanges, couplings, manways, firetubes, gas domes, saddle supports, etc. Replacement of these components will be handled as an alteration to the original design and will require the submission of design drawings and support calculations.

If a Saskatchewan CRN is issued, the local inspector will re-stamp the nameplate. **THE OWNER/OPERATOR OF THE VESSEL IS NOT PERMITTED TO ALTER THE VESSELS NAMEPLATE IN ANY MANNER. UNAUTHORIZED ALTERATIONS OF THE NAMEPLATE MAY RESULT IN THE VESSEL BEING CONDEMNED FOR PRESSURE SERVICE.**

If the pressure vessel already possesses a Saskatchewan CRN, acceptance of the vessel is handled by the local inspector as indicated below.

All pressure vessels manufactured outside of Canada must have been registered with the National Board at the time of manufacture.

Local Inspector's Requirements

A copy of the manufacturer's data report for the vessel in question is required. Final acceptance of the vessel is based upon a physical inspection (internal and/or external) performed by the local inspector. If the vessel's physical condition is in question, further NDE and/or a hydrostatic test may be ordered. Previous inspection reports issued by other provinces and recent NDE results may be beneficial. Excessive corrosion/erosion or other physical defects may result in rejection. If a deficiency is detected then the vessel will have to be repaired to a satisfactory condition before being accepted for use.

If there are any further questions or concerns, feel free to contact the office at (306) 798-7111.

****The alternative to CRN (data report) registration option per clause 24 of the Regulations may be granted if the requirements are met.**