

Tonka Technical Bulletin



ASME Stamp Industry Seal of Approval

TONKA EQUIPMENT COMPANY

Background

Vessels with American Society of Mechanical Engineers or ASME stamp affixed are certified as built to ASME standards (which are safer, more durable, and constructed by properly trained and skilled personnel). Operators and owners don't need to worry about manufacturing techniques, weld designs, material selection or vessel integrity. The ASME Stamp means that an independent inspector has examined the source steel records, the weld designs and has verified through inspection and observation and testing that all ASME design and manufacturing requirements have been met.

Having an ASME Stamp affixed to the vessel is the only way to verify compliance with the ASME code. The Code Symbol and Stamp are valid in all 50 states, all provinces of Canada, and are recognized throughout the world.



Recommended by AWWA

As described in the AWWA publication, "Filter Troubleshooting and Design Handbook"¹:

"It is recommended that the tank shell and heads be designed and constructed according to Section IX of the ASME Boiler Code. The code requires a testing and inspection process that helps ensure the integrity and serviceability of the filter. Tanks designed, tested, and inspected according to this process will have a permanent metal tag or code stamp affixed to a bracket on the side of the tank."

¹Author: Richard P. Beverly. Pages 274 – 275 excerpted, 2005

Mandatory ASME – Documented Results for the Life of the Vessel

Actual report on design, source steel, fabrication, testing and inspection – kept on file by ASME and Fabricator

FORM U-1A MANUFACTURERS' DATA REPORT FOR PRESSURE VESSELS
(Alternate Form for single Chamber, Completely Shop-Fabricated Vessels Only)
as requested by the provisions of the ASME Code rules, Section VIII, Division 1

1. Manufactured and certified by Wheeler Tank Mfg., Inc. - 4001 N. 4th Ave., Sioux Falls, SD 57105
(name and address of manufacturer)

2. Manufactured for TONKA EQUIPMENT 13305 WATERTOWER CIRCLE PLYMOUTH, MN 55441
(name and address of purchaser)

3. Location of installation Unknown
(name and address)

4. Type: VERT TANK 09544 09545 N/A 00034104 14197 14198 2009
(ref's. serial no.) (CRM) (drawing no.) (Mat'l. Bd. no.) (year built)

5. The chemical and physical properties of all parts meet the requirements of material specifications of the ASME BOILER AND PRESSURE VESSEL CODE. The design, construction and workmanship conform to ASME Code, Section VIII, Division 1: 2007
(year) (address) (code state no.) (special service per 80-1201d)

6. Shell: SA 516 GR 70 .1875 0 4'-0" 6'-0"
(mat'l. spec. no., grade) (nom. thickness) (corr. allow. (in.)) (dia. ID (ft. & in.)) (length overall) (ft. & in.)

7. Seams: TYPE 1 NONE 70% N/A N/A TYPE 1 NONE
(long. welded, dbl., engl., (RT (spot (ref. (ft.)) (RT temp. (°F)) (time (hr.)) (girth welded, dbl., (RT (spot, partial, (no. of (lap, butt)) or full)) or full)) courses)

8. Heads: (a) SA 516 GR 70 (b) SA 516 GR 70
(mat'l. spec. no., grade)

Location (top, bottom, ends)	Minimum Thickness (")	Corrosion Allowance	Crown Radius	Knuckle Radius	Elliptical Ratio	Conical Apex Angle	Nonisobothical Radius	Flat Diameter	Side to Pressure (convex or concave)
(a) TOP	.1687	0	38.4	4.8	N/A	N/A	N/A	N/A	CONCAVE
(b) BOTTOM	.1687	0	38.4	4.8	N/A	N/A	N/A	N/A	CONCAVE

If removable, bolts used (describe other fastenings): N/A
(Mat'l., spec. no., qt., size, no.)

9. MAMP: 100 at max. temp. 200. Min design metal temp. -20 at 100. Hydro., pneu. or comb. test pressure 130.
(psi) (°F) (psi)

10. Nozzles, inspection and safety valve openings:

Purpose (inlet, outlet, drain, etc.)	No.	Dia. or Size (in.)	Type	Mat'l.	Non-Thickness	Reinforcement (Mat'l.)	How Attached	Location
INSPECTION	1	14 X 18	MH	SA 675-70	.75	N/A	UW 16.1 (i)	TOP
OUTLET	1	2"	FLG/NOZ	SA 53-B	.154	N/A	UW 16.1 (i)	BOTTOM
INLET	1	2"	FLG/NOZ	SA 53-B	.154	N/A	UW 16.1 (i)	SHELL
VENT	1	1"	CPLG	SA 105	3,000#	N/A	UW 16.1 y-2	TOP
UNK.	1	1"	CPLG	SA 105	3,000#	N/A	UW 16.1 y-2	SHELL

11. Supports: Skirt NO Lugs 5 Legs 4 Other N/A Attached TP, SHL, BOT UW 16.1 (i)
(See or Not) (See-1) (See-1) (Describe)

12. Remarks: Manufacturer's Partial Data Reports properly identified and signed by Commissioned Inspectors have been furnished for the following items of the report: N/A
(Name of part, item number, Mfg's. name and identifying stamp)

IMPACT TEST EXEMPT PER UG 20 (F) 1-5

CERTIFICATE OF SHOP COMPLIANCE

We certify that the statements made in this report are correct and that all details of design, material, construction, and workmanship of this vessel conform to the ASME Code for Pressure Vessels, Section VIII, Division 1.
"U" Certificate of Authorization No. 3542 Expires 02/02, 2012
Date 12/30/09 Co. name: Wheeler Tank Mfg., Inc. Signed: *[Signature]*
(Manufacturer) (Representative)

CERTIFICATE OF SHOP INSPECTION

Vessel constructed by WHEELER TANK MFG., INC. at SIOUX FALLS, SD
I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State or Province of SOUTH DAKOTA and employed by H S B 1 & I have inspected the component described in this Manufacturer's Data Report on 12/30/09, and state that, to the best of my knowledge and belief, the Manufacturer has constructed this pressure vessel in accordance with ASME Code, Section VIII, Division 1. By signing this certificate neither the inspector nor his employer makes any warranty, expressed or implied, concerning the pressure vessel described in this Manufacturer's Data Report. Furthermore, neither the inspector nor his employer shall be liable in any manner for any personal injury or property damage or a loss of any kind arising from or connected with this inspection.
Date: 12/30/09 Signed: *[Signature]* Commissions: *[Signature]*
(Authorized Inspector) (Mat'l Board (incl. endorsements), State, Prov. and No.)

- Fabricator ID - ASME Certified shops only
- Owner
- Type Tank and Shop Certification No
- ASME Code Citation
- Material of Construction - include source steel certification reference
- Fabrication/Joint Efficiency - design information
- Tank Geometry
- Design Criteria - set by owner
- Penetration and Attachment References to ASME detailed welding procedures
- Supports and Other Details (E.g., seismic, etc.)
- Shop and Individual Accountability / Certification
- Independent ASME Inspector (Individual Accountability)

Actual ASME "Stamp" – Affixed to finished vessel prior to shipment



TONKA EQUIPMENT COMPANY

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