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2nd Ballot

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Phil Henry
API 520 Task Force Chair

Sizing, Selection, and Installation of Pressure-relieving Devices

Part I—Sizing and Selection

API STANDARD 520, PART I
TENTH EDITION, OCTOBER 2020



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Foreword

API Standard 520, *Sizing, Selection, and Installation of Pressure-relieving Devices*, is the result of several years' work by engineers in the petroleum industry. The information in this standard is intended to supplement the information contained in Section VIII—*Pressure Vessels*, of the ASME *Boiler and Pressure Vessel Code*. The recommendations presented in this publication are not intended to supersede applicable laws and regulations.

Users of this standard are reminded that no publication of this type can be complete, nor can any written document be substituted for qualified engineering analysis.

The verbal forms used to express the provisions in this document are as follows.

Shall: As used in a standard, "shall" denotes a minimum requirement in order to conform to the standard.

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The current edition of this standard, published in two parts, has been updated with respect to the practices generally used in the installation of all devices covered in the previous editions; the current edition also contains additional information based on revisions suggested by many individuals and several organizations.

The First Edition of this standard was initially released as a recommended practice in 1955. The Second Edition was published in two parts: Part I, *Design*, in 1960 and Part II, *Installation*, in 1963. The Third Edition of Part I was issued in November 1967 and reaffirmed in 1973. The Fourth Edition was issued in December 1976, the Fifth Edition was issued in July 1990, the Sixth Edition was issued in March 1993, the Seventh Edition was issued in January 2000, the Eighth Edition was issued in December 2008, and the Ninth Edition was issued in July 2014.

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Generally, API standards are reviewed and revised, reaffirmed, or withdrawn at least every five years. A one-time extension of up to two years may be added to this review cycle. Status of the publication can be ascertained from the API Standards Department, telephone (202) 682-8000. A catalog of API publications and materials is published annually by API, 200 Massachusetts Avenue, Suite 1100, Washington, DC 20001.

Suggested revisions are invited and should be submitted to the Standards Department, API, 200 Massachusetts Avenue, Suite 1100, Washington, DC 20001, standards@api.org.

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Sizing, Selection, and Installation of Pressure-relieving Devices

Part I—Sizing and Selection

1 Scope

This standard applies to the sizing and selection of pressure-relief devices (PRDs) used in refineries, chemical facilities, and related industries for equipment that has a maximum allowable working pressure (MAWP) of 15 psig (103 kPag) or greater. The pressure-relief devices covered in this standard are intended to protect unfired pressure vessels and related equipment against overpressure from operating and fire contingencies.

This standard includes basic definitions and information about the operational characteristics and applications of various pressure-relief devices. It also includes sizing procedures and methods based on steady-state flow of Newtonian fluids.

Pressure-relief devices protect a vessel against overpressure only; they do not protect against structural failure when the vessel is exposed to extremely high temperatures such as during a fire. See API 521 for information about appropriate ways of reducing pressure and restricting heat input.

Atmospheric and low-pressure storage tanks covered in API 2000 and pressure vessels used for the transportation of products in bulk or shipping containers are not within the scope of this standard.

The rules for overpressure protection of fired vessels are provided in ASME BPVC, Section I and are not within the scope of this standard.

2 Normative References

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

API Standard 520, *Sizing, Selection, and Installation of Pressure-relieving Devices, Part II—Installation*

API Standard 521, *Pressure-relieving and Depressuring Systems*

API Standard 526, *Flanged Steel Pressure-relief Valves*

API Standard 527, *Seat Tightness of Pressure-relief Valves*

API Standard 2000, *Venting Atmospheric and Low-pressure Storage Tanks*

ASME Boiler and Pressure Vessel Code (BPVC)¹, *Section I: Power Boilers*

ASME Boiler and Pressure Vessel Code (BPVC), *Section VIII: Pressure Vessels, Division 1: Rules for Construction of Pressure Vessels*

ASME Boiler and Pressure Vessel Code (BPVC) Code Case 2203², *Omission of Lifting Device Requirements for Pressure Relief Valves on Air, Water Over 140 °F, or Steam Service*

ASME B31.1, *Power Piping*

ASME B31.3, *Process Piping*

ASME PTC 25, *Pressure Relief Devices*

¹ American Society of Mechanical Engineers, Two Park Avenue, New York, New York 10016, www.asme.org.

² Code Cases are temporary in nature and may not be acceptable in all jurisdictions. The user should verify the current applicability of the referenced Code Cases.

3 Terms, Definitions, Acronyms, and Abbreviations

3.1 Terms and Definitions

For the purposes of this document, the following definitions apply. Many of the terms and definitions are taken from ASME PTC 25.

3.1.1

accumulation

The pressure increase over the MAWP of the vessel, expressed in pressure units or as a percentage of MAWP or design pressure. Maximum allowable accumulations are established by applicable codes for emergency operating and fire contingencies.

3.1.2

actual orifice area/actual discharge area

The cross-sectional area (based on the measured diameter) within the pressure-relief device flow path that limits the fluid flow through the pressure-relief device.

NOTE The value is normally measured and recorded as part of the certification test by an independent organization following the procedures specified in the device's code of construction.

3.1.3

backpressure

The pressure that exists at the outlet of a pressure-relief device as a result of the pressure in the discharge system. Backpressure is the sum of the superimposed and built-up backpressures.

3.1.4

balanced pressure-relief valve

A spring-loaded pressure-relief valve that incorporates a bellows or other means for minimizing the effect of backpressure on the operational characteristics of the valve.

3.1.5

blowdown

The difference between the set pressure and the closing pressure of a pressure-relief valve, expressed as a percentage of the set pressure or in pressure units.

3.1.6

bore area/nozzle area/nozzle throat area/throat area

The minimum cross-sectional flow area of a nozzle in a pressure-relief valve.

3.1.7

built-up backpressure

The increase in pressure at the outlet of a pressure-relief device that develops as a result of flow after the pressure-relief device opens.

3.1.8

burst pressure

The value of the upstream static pressure minus the value of the downstream static pressure just prior to when the disk bursts. When the downstream pressure is atmospheric, the burst pressure is the upstream static gauge pressure.

3.1.9

burst pressure tolerance

The variation around the marked burst pressure at the specified disk temperature in which a rupture disk will burst.

3.1.10**capacity/relieving capacity**

The flow rate of a fluid through a pressure-relief device or a pressure-relief system under a given set of conditions and fluid properties.

3.1.11**certified capacity/certified relieving capacity**

The capacity of a pressure-relief device determined using the certification test fluid (commonly air, steam, or water), at the certification test overpressure, with the certified coefficient of discharge, and with the actual orifice area, all in accordance with the applicable code of construction.

NOTE 1 It does not include any derating factors based on the physical installation such as a rupture disk upstream of a pressure-relief valve or backpressure on a balanced bellows valve. This capacity is provided by the pressure-relief device vendor and is stamped on the pressure-relief device nameplate.

NOTE 2 The certification overpressure for ASME BPVC, Section VIII valves is typically the greater of 10 % or 3 psi.

3.1.12**certified coefficient of discharge**

The published value for the ratio of the measured relieving capacity to the theoretical relieving capacity of an ideal nozzle, multiplied by a capacity derating factor if required by the code of construction.

NOTE This value is determined by an independent organization following the capacity certification requirements in the device's code of construction.

3.1.13**chatter**

The opening and closing of a pressure-relief valve at a very high frequency (on the order of the natural frequency of the valve's spring mass system).

3.1.14**closing pressure**

The value of decreasing inlet static pressure at which the valve disc reestablishes contact with the seat or at which lift becomes zero as determined by seeing, feeling, or hearing.

3.1.15**cold differential test pressure****CDTP**

The pressure at which a pressure-relief valve is adjusted to open on the test stand. The CDTP includes corrections for the service conditions of backpressure or temperature or both.

3.1.16**conventional pressure-relief valve**

A spring-loaded pressure-relief valve whose operational characteristics are directly affected by changes in the backpressure.

3.1.17**curtain area**

The area of the cylindrical or conical discharge opening between the seating surfaces above the nozzle seat created by the lift of the disc.

3.1.18**cycling**

The relatively low frequency (a few cycles per second to a few seconds per cycle) opening and closing of a pressure-relief valve.

3.1.19**design pressure**

Pressure, together with the design temperature, used to determine the minimum permissible thickness or physical characteristic of each vessel component as determined by the vessel design rules. The design pressure is selected by the user to provide a suitable margin above the most severe pressure expected during normal operation at a coincident temperature. It is the pressure specified on the purchase order. This pressure may be used in place of the MAWP in all cases where the MAWP has not been established. The design pressure is equal to or less than the MAWP.

3.1.20**dual certified pressure-relief valves**

Pressure-relief valves that are both vapor flow certified and liquid flow certified where dual certification is achieved without making any modifications or adjustments to the relief device when switching fluids during the flow testing.

3.1.21**effective coefficient of discharge**

The value for the ratio of the estimated relieving capacity to the theoretical relieving capacity of an ideal nozzle.

NOTE API 520 provides effective coefficients of discharge.

3.1.22**effective discharge area/effective orifice area**

A nominal cross-sectional area within the pressure-relief device flow path that limits the fluid flow through the pressure-relief device.

NOTE API 526 provides effective orifice areas for a range of valve sizes in terms of letter designations, "D" through "T" that allow calculations to be performed per the preliminary sizing equations.

3.1.23**flutter**

The abnormal, rapid reciprocating motion of the moveable parts of a pressure-relief valve, during which the disk does not contact the seat or the upper stop.

3.1.24**huddling chamber**

An annular chamber located downstream of the seat of a pressure-relief valve for the purpose of assisting the valve to achieve lift.

3.1.25**inlet size**

The nominal pipe size (NPS) of the device at the inlet connection, unless otherwise designated.

3.1.26**leak test pressure**

The specified inlet static pressure at which a seat leak test is performed.

3.1.27**lift**

The actual travel of the disc from the closed position when a valve is relieving.

3.1.28**lot of rupture disks**

Disks manufactured at the same time and of the same size, material, thickness, type, heat, and manufacturing process, including heat treatment.

3.1.29**manufacturing design range**

The pressure range in which the rupture disk is marked. Manufacturing design ranges are usually catalogued by the manufacturer as a percentage of the specified burst pressure. Catalogued manufacturing design ranges may be modified by agreement between the user and the manufacturer.

3.1.30**marked burst pressure/rated burst pressure**

The burst pressure established by tests for the specified temperature and marked on the disk tag by the manufacturer. The marked burst pressure may be any pressure within the manufacturing design range unless otherwise specified by the customer. The marked burst pressure is applied to all of the rupture disks of the same lot.

3.1.31**maximum allowable working pressure****MAWP**

The maximum gauge pressure permissible at the top of a completed vessel in its normal operating position at the designated coincident temperature specified for that pressure. The pressure is the least of the values for the internal or external pressure as determined by the vessel design rules for each element of the vessel using actual nominal thickness, exclusive of additional metal thickness allowed for corrosion and loadings other than pressure. The MAWP is the basis for the pressure setting of the pressure-relief devices that protect the vessel. The MAWP is normally greater than the design pressure but can be equal to the design pressure when the design rules are used only to calculate the minimum thickness for each element and calculations are not made to determine the value of the MAWP.

3.1.32**maximum operating pressure**

The maximum pressure expected during normal system operation.

3.1.33**minimum net flow area**

The calculated net area after a complete burst of a rupture disk with appropriate allowance for any structural members that may reduce the net flow area through the rupture disk device.

3.1.34**modulating pressure-relief valve**

A pressure-relief valve that opens and flows in proportion to the inlet pressure for some or all parts of the valve's operating range from set pressure to overpressure at full lift.

3.1.35**nonfragmenting rupture disk**

A rupture disk designed and manufactured to be installed upstream of other piping components. Nonfragmenting rupture disks do not impair the function of pressure-relief valves when the disk ruptures.

3.1.36**nonreclosing pressure-relief device**

A pressure-relief device that remains open after operation. A manual resetting means may be provided.

3.1.37**normal cubic meters per minute, Nm³/min**

SI unit for volumetric flow rate of gas at a temperature of 0 °C and an absolute pressure of 101.3 kPa, expressed in cubic meters per minute.

3.1.38**opening pressure**

The value of increasing inlet static pressure at which there is a measurable lift of the disc or at which discharge of the fluid becomes continuous, as determined by seeing, feeling, or hearing.

3.1.39**operating ratio of a pressure-relief valve**

The ratio of maximum system operating pressure to the set pressure.

3.1.40**operating ratio of a rupture disk**

The ratio of the maximum system operating pressure to a pressure associated with a rupture disk (see Figure 27 and Figure 29). For marked burst pressures above 40 psi, the operating ratio is the ratio of maximum system operating pressure to the disk marked burst pressure. For marked burst pressures between 15 psi and 40 psi, the operating ratio is the ratio of maximum system operating pressure to the marked burst pressure minus 2 psi. For marked burst pressures less than 15 psi, [the operating ratio requires additional information provided by the manufacturer](#) ~~the maximum recommended operating ratio is provided by the manufacturer should be determined by consulting the manufacturer.~~

3.1.41**outlet size**

The NPS of the device at the discharge connection, unless otherwise designated.

3.1.42**overpressure**

The pressure increase over the set pressure of the relieving device. Overpressure is expressed in pressure units or as a percentage of set pressure. Overpressure is the same as accumulation only when the relieving device is set to open at the MAWP of the vessel.

3.1.43**pilot-operated pressure-relief valve**

A pressure-relief valve in which the major relieving device or main valve is combined with and controlled by a self-actuated auxiliary pressure-relief valve (pilot).

3.1.44**pin-actuated device**

A nonreclosing pressure-relief device actuated by static pressure and designed to function by buckling or breaking a pin, which holds a piston or a plug, in place. Upon buckling or breaking of the pin, the piston or plug instantly moves to the full open position.

3.1.45**pressure-relief device****PRD**

A device actuated by inlet static pressure and designed to open during emergency or abnormal conditions to prevent a rise of internal fluid pressure in excess of a specified design value. The device also may be designed to prevent excessive internal vacuum. The device may be a pressure-relief valve, a nonreclosing pressure-relief device, or a vacuum-relief valve.

3.1.46**pressure-relief valve****PRV**

A pressure-relief device designed to open and relieve excess pressure and to reclose and prevent the further flow of fluid after normal conditions have been restored.

3.1.47**rated capacity/rated relieving capacity**

The capacity of the pressure-relief device determined using the properties of the actual fluid flowing through the pressure-relief device at the certification test overpressure. The overpressure is specified by the applicable code of construction. This capacity can be determined using the effective coefficient of discharge and effective orifice area, or the certified coefficient of discharge and actual orifice area (see 5.2).

NOTE 1 The certification test overpressure for ASME BPVC, Section VIII valves is typically the greater of 10 % or 3 psi.

NOTE 2 The rated capacity retains the code-required capacity derating.

3.1.48**relief valve**

A spring-loaded pressure-relief valve actuated by the static pressure upstream of the valve. The valve opens normally in proportion to the pressure increase over the opening pressure. A relief valve is used primarily with incompressible fluids.

3.1.49**relieving conditions**

The inlet pressure and temperature on a pressure-relief device during an overpressure condition. The relieving pressure is equal to the valve set pressure (or rupture disk burst pressure) plus the overpressure. The temperature of the flowing fluid at relieving conditions may be higher or lower than the operating temperature.

3.1.50**required capacity/required relieving capacity/required relief rate/required relief load**

The fluid flow rate that is required to pass through the pressure-relief device for a particular overpressure scenario.

3.1.51**rupture disk**

A pressure-containing, pressure- and temperature-sensitive element of a rupture disk device.

3.1.52**rupture disk device**

A nonreclosing pressure-relief device actuated by static differential pressure between the inlet and outlet of the device and designed to function by the bursting of a rupture disk. A rupture disk device includes a rupture disk and a rupture disk holder.

3.1.53**rupture disk holder**

The structure that encloses and clamps the rupture disk in position. Some disks are designed to be installed between standard flanges without holders.

3.1.54**safety relief valve**

A spring-loaded pressure-relief valve that may be used as either a safety or relief valve depending on the application.

3.1.55**safety valve**

A spring-loaded pressure-relief valve actuated by the static pressure upstream of the valve and characterized by rapid opening or pop action. A safety valve is normally used with compressible fluids.

3.1.56**set pressure**

The inlet gauge pressure at which the pressure-relief device is set to open under service conditions.

3.1.57**simmer**

The audible or visible escape of compressible fluid between the seat and disc of a pressure-relief valve that may occur at an inlet static pressure below the set pressure prior to opening.

3.1.58**specified burst pressure**

The burst pressure specified by the user. [See 4.3.6.2.1.](#)

3.1.59**specified disk temperature**

The temperature of the disk when the disk is expected to burst. The specified disk temperature is the temperature the manufacturer uses to establish the marked burst pressure. The specified disk temperature is rarely ever the design temperature of the vessel and may not even be the operating temperature or relief temperature, depending on the relief system configuration.

3.1.60**standard cubic feet per minute****SCFM**

USC unit for volumetric flow rate of gas at a temperature of 60 °F and an absolute pressure of 14.7 psi, expressed in cubic feet per minute.

3.1.61**superimposed backpressure**

The static pressure that exists at the outlet of a pressure-relief device at the time the device is required to operate. Superimposed backpressure is the result of pressure in the discharge system coming from other sources and may be constant or variable.

3.2 Acronyms and Abbreviations

BPVC *Boiler and Pressure Vessel Code*

CDTP cold differential test pressure

HEM Homogeneous Equilibrium Model

MAWP maximum allowable working pressure

NPS nominal pipe size

PRD pressure-relief device

PRV pressure-relief valve

SI International System of units

USC United States customary units

4 Pressure-relief Devices**4.1 General**

This section describes the basic principles, operational characteristics, applications, and selection of PRDs used independently or in combination. These devices include spring-loaded and pilot-operated pressure-relief valves (PRVs), rupture disk devices, and other PRDs. These devices are described in the text and illustrated in Figure 1 through Figure 30.

4.2 Pressure-relief Valves**4.2.1 Spring-loaded Pressure-relief Valves****4.2.1.1 Conventional Pressure-relief Valves**

4.2.1.1.1 A conventional PRV (see Figure 1 and Figure 4) is a self-actuated spring-loaded PRV that is designed to open at a predetermined pressure and protect a vessel or system from excess pressure by removing or relieving fluid from that vessel or system. The valve shown in Figure 4 is available in small sizes, commonly used for thermal relief valve applications. The basic elements of a spring-loaded PRV

include an inlet nozzle connected to the vessel or system to be protected, a movable disc that controls flow through the nozzle, and a spring that controls the position of the disc. Under normal system operating conditions, the pressure at the inlet is below the set pressure and the disc is seated on the nozzle preventing flow through the nozzle.

4.2.1.1.2 Spring-loaded PRVs are referred to by a variety of terms, such as safety valves, relief valves, and safety relief valves. These terms have been traditionally applied to valves for gas/vapor service, liquid service, or multiservice applications, respectively. The more generic term, PRV, is used in the text and is applicable to all three.

4.2.1.1.3 The operation of a conventional spring-loaded PRV is based on a force balance (see Figure 5). The spring load is preset to equal the force exerted on the closed disc by the inlet fluid when the system pressure is at the set pressure of the valve. When the inlet pressure is below the set pressure, the disc remains seated on the nozzle in the closed position. When the inlet pressure exceeds set pressure, the pressure force on the disc overcomes the spring force and the valve opens. When the inlet pressure is reduced to the closing pressure, the valve recloses.

4.2.1.1.4 When the valve is closed during normal operation (see Figure 5, Item A) the system or vessel pressure acting against the disc surface (area A) is resisted by the spring force. As the system pressure approaches the set pressure of the valve, the seating force between the disc and the nozzle approaches zero.

4.2.1.1.5 In vapor or gas service, the valve may “simmer” before it will “pop.” When the vessel pressure closely approaches the set pressure, fluid will audibly move past the seating surfaces into the huddling chamber B. As a result of the restriction of flow between the disc holder and the adjusting ring, pressure builds up in the huddling chamber B (see Figure 5, Item B). Since pressure now acts over a larger area, an additional force, commonly referred to as the expansive force, is available to overcome the spring force. By changing the position of the adjusting ring, the opening in the annular orifice can be altered, thus controlling the pressure buildup in the huddling chamber B. This controlled pressure buildup in the huddling chamber will overcome the spring force causing the disc to move away from the nozzle seat, and the valve will pop open.

4.2.1.1.6 Once the valve has opened, an additional pressure buildup at C occurs (see Figure 5, Item C). This is due to the sudden flow increase and the restriction to flow through another annular orifice formed between the inner edge of the disc holder skirt and the outside diameter of the adjusting ring. These additional forces at C cause the disc to lift substantially at pop.

4.2.1.1.7 Flow is restricted by the opening between the nozzle and the disc until the disc has been lifted from the nozzle seat approximately one quarter of the nozzle diameter. After the disc has attained this degree of lift, flow is then controlled by the bore area rather than by the area between the seating surfaces.

4.2.1.1.8 The valve closes when the inlet pressure has dropped sufficiently below the set pressure to allow the spring force to overcome the summation of forces at A, B, and C. The pressure at which the valve reseats is the closing pressure. The difference between the set pressure and the closing pressure is blowdown.

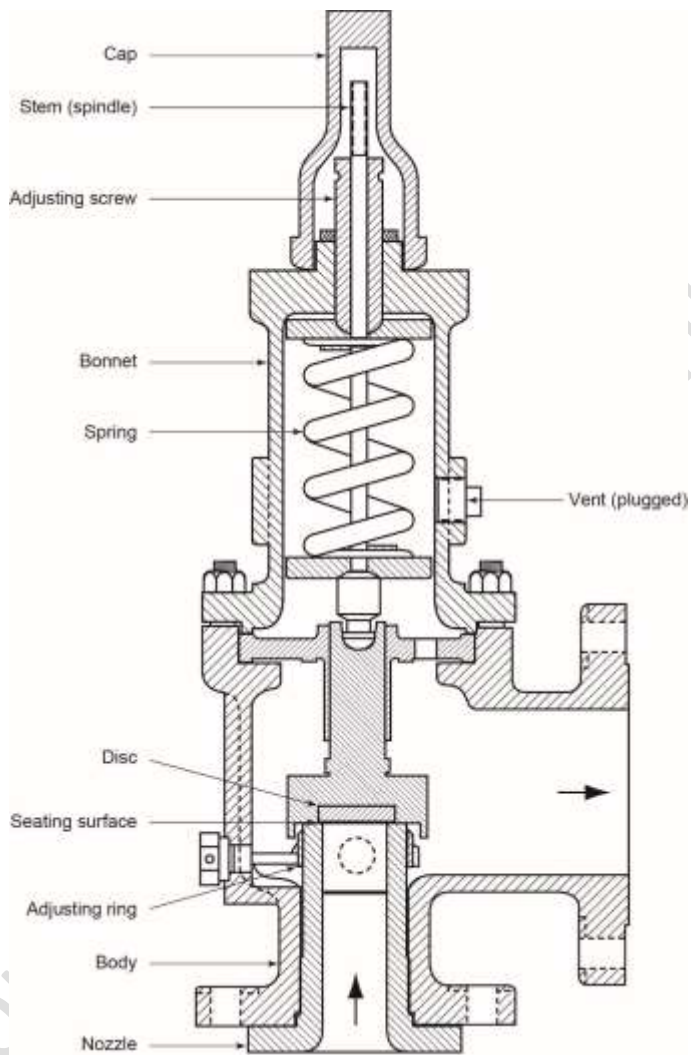


Figure 1—Conventional Pressure-relief Valve with a Single Adjusting Ring for Blowdown Control

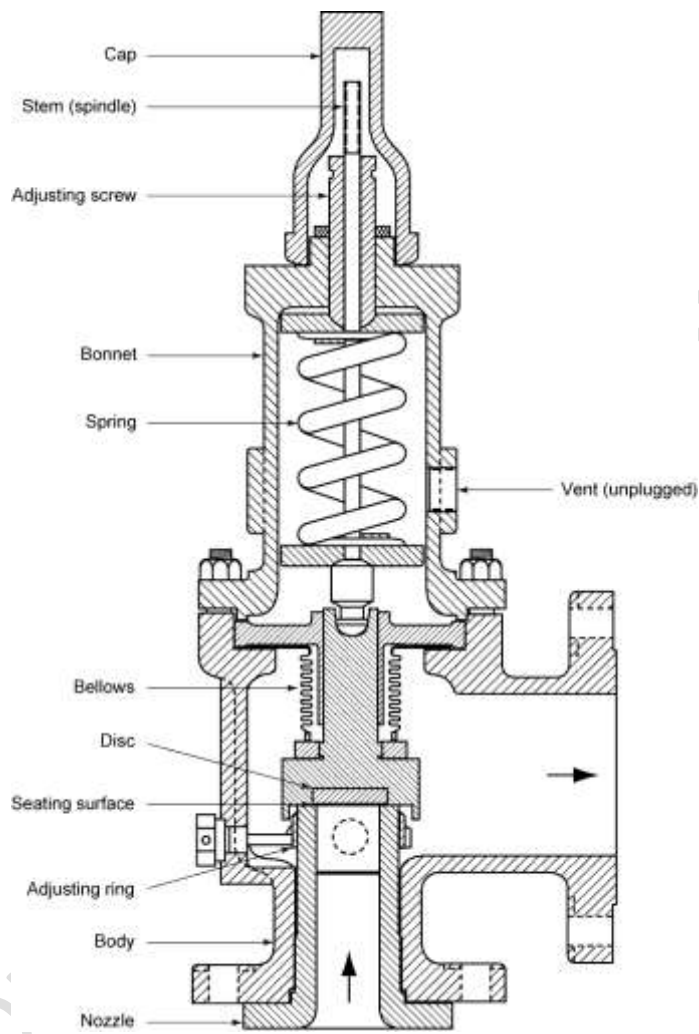


Figure 2—Balanced-bellows Pressure-relief Valve

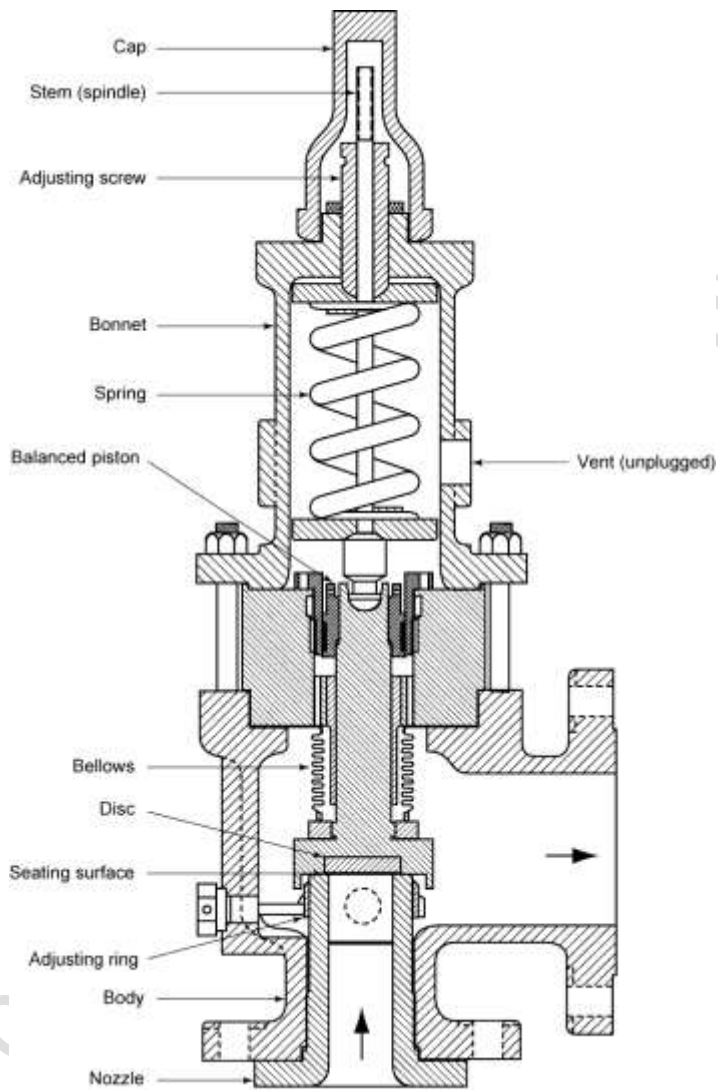


Figure 3—Balanced-bellows Pressure-relief Valve with an Auxiliary Balanced Piston

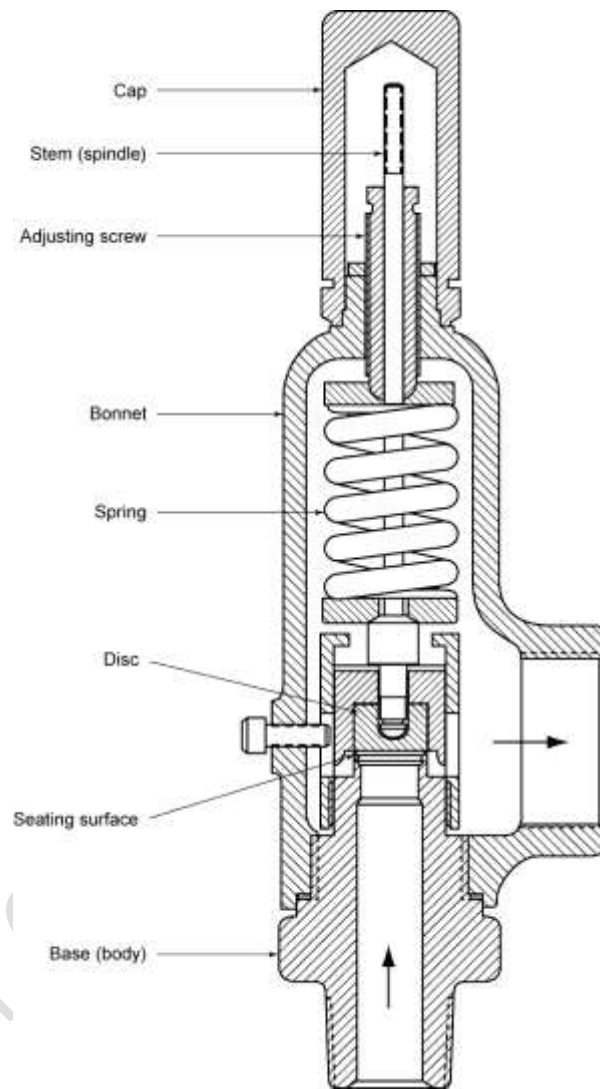


Figure 4—Conventional Pressure-relief Valve with Threaded Connections

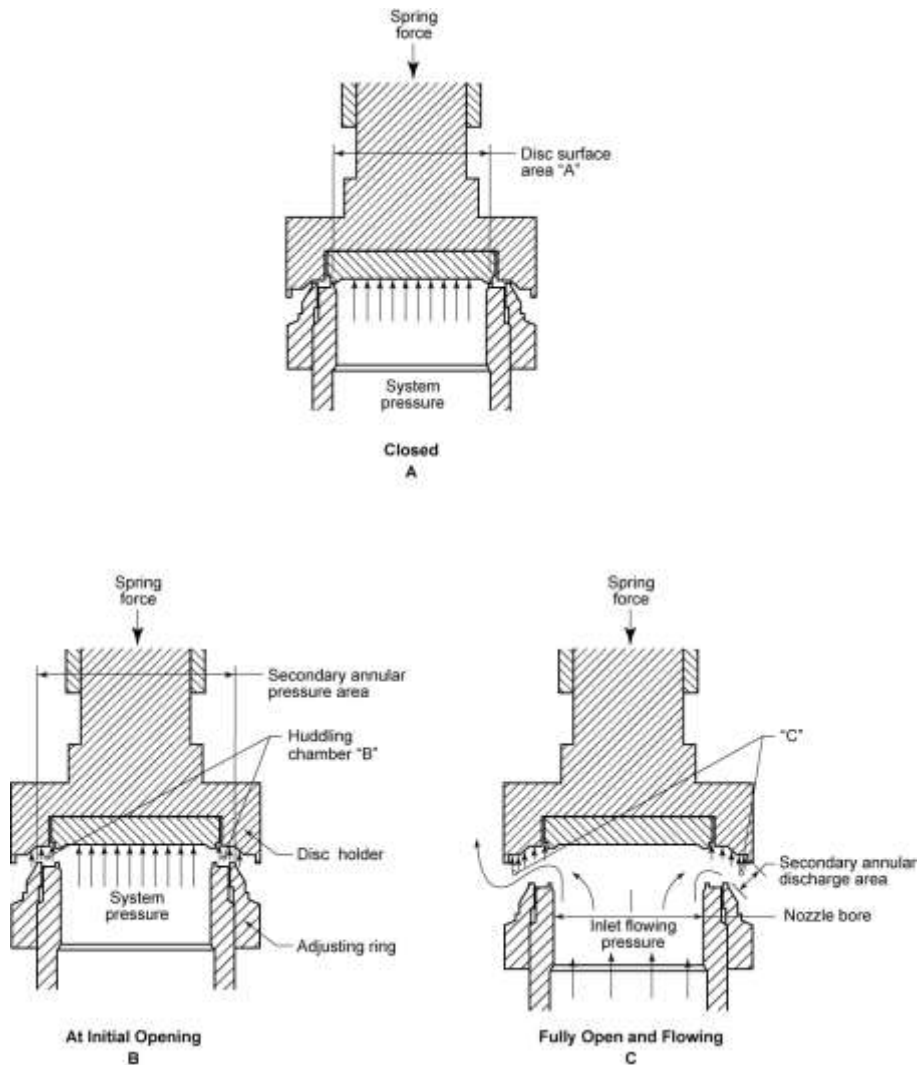


Figure 5—Pressure-relief Valve Operation—Vapor/Gas Service

4.2.1.1.9 Figure 6 shows the disc travel from the set pressure, A, to the maximum relieving pressure, B, during the overpressure incident and to the closing pressure, C, during the blowdown.

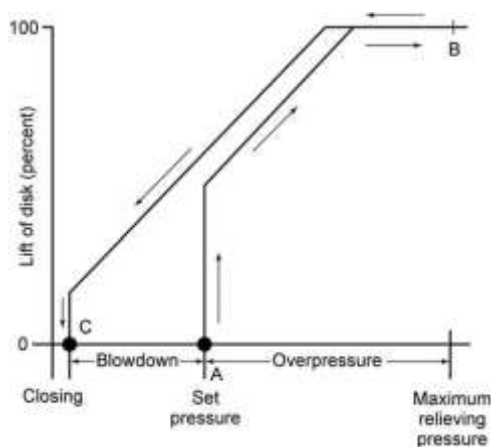


Figure 6—Typical Relationship Between Lift of Disk in a Pressure-relief Valve and Vessel Pressure

4.2.1.2 Spring-loaded Pressure-relief Valves Designed for Liquid Service Applications

4.2.1.2.1 Liquid service valves do not pop in the same manner as vapor service valves (see Figure 7), since the expansive forces produced by vapor are not present in liquid flow. Liquid service valves typically rely on reactive forces to achieve lift.

4.2.1.2.2 When the valve is closed, the forces acting on the valve disc are the same as those applied by vapor until a force balance is reached and the net force holding the seat closed approaches zero. From this point on, the force relationship is totally different.

4.2.1.2.3 At initial opening, the escaping liquid forms a very thin sheet of fluid, as seen in Figure 7, Item A, expanding radially between the seating surfaces. The liquid strikes the reaction surface of the disc holder and is deflected downward, creating a reactive (turbine) force tending to move the disc and holder upward. These forces typically build very slowly during the first 2 % to 4 % of overpressure.

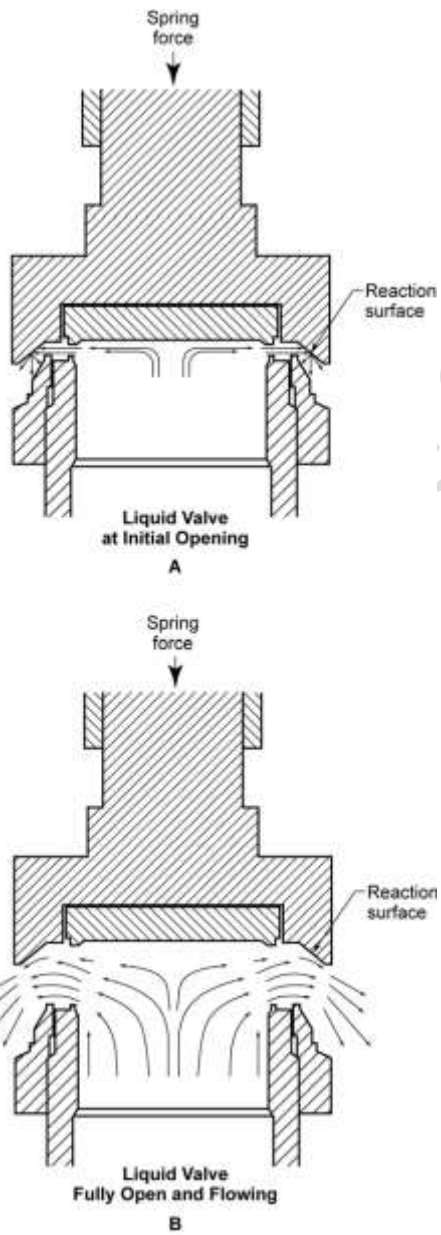


Figure 7—Pressure-relief Valve Operation—Liquid Service

4.2.1.2.4 As the flow gradually increases, the velocity head of the liquid moving through the nozzle also increases. These momentum forces, combined with the reactive forces of the radially discharging liquid as it is deflected downward from the reaction surface (see Figure 7, Item B), are substantial enough to cause the valve to go into lift. Typically, the valve will suddenly surge to 50 % to 100 % lift at 2 % to 6 % overpressure. As the overpressure increases, these forces continue to grow, driving the valve into full lift. Liquid service valves, capacity certified in accordance with the ASME Code, are required to reach rated capacity at 10 % or less overpressure.

4.2.1.2.5 In the closing cycle, as the overpressure decreases, momentum and reactive forces decrease, allowing the spring force to move the disc back into contact with the seat.

4.2.1.2.6 Historically, many PRVs used in liquid applications were safety relief or relief valves designed for compressible (vapor) service. Many of these valves, when used in liquid service, required high overpressure (25 %) to achieve full lift and stable operation, since liquids do not provide the expansive forces that vapors do. Where liquid PRVs were required to operate within the accumulation limit of 10 %, a conservative factor of 0.6 was applied to the valve capacity when sizing the valves. Consequently, many installations were oversized and instability often resulted. The criteria used for sizing this type of valve may be found in 5.9.

4.2.1.2.7 Rules have been incorporated into the ASME Code, as well as other international standards that address performance of liquid service valves at 10 % overpressure and require a capacity certification. PRVs designed for liquid service have been developed that achieve full lift, stable operation, and rated capacity at 10 % overpressure in compliance with the requirements. Blowdown is adjustable in some designs. Some valves are designed so that they operate on liquid and gas. Such valves may, however, exhibit different operational characteristics, depending on whether the flow stream is liquid, gas, or a combination of the two. Many PRVs designed for liquid service, for example, will have a much longer blowdown (typically 20 %) on gas than on liquid service. Additionally, some variation in set pressure may occur if the valve is set on liquid and required to operate on gas or vice versa.

4.2.1.2.8 The rules for sizing PRVs designed for liquid service are given in 5.8. If a capacity on gas service is required, 5.6.3 or 5.6.4 should be used for the preliminary sizing calculation. Capacity certification data (certified coefficients of discharge and actual orifice areas) for sizing on liquid and gas service is obtained from the manufacturer for use in final sizing and application of the valve.

4.2.1.2.9 Spring-loaded PRVs designed for liquid (or liquid and gas) applications and that are balanced to minimize the effects of backpressure are recommended for two-phase applications when the fluid being relieved may be liquid, gas, or a multiphase mixture. Many manufacturers recommend that valves designed for liquid or liquid-and-gas service be used if the mass percentage of the two-phase mixture at the valve inlet is 50 % vapor or less. In addition, if the ratio of liquid to gas in the flow stream is not certain, a valve specifically designed for liquid service or for service on liquid and gas should be used.

4.2.1.2.10 PRVs designed for liquid and gas service should be specified for the fluid to which the valve is normally exposed. For example, if a liquid and gas service valve is located in the vapor region of a vessel containing a liquid level, the valve should be specified for gas service. The valve's certified capacity stamped on the nameplate will be in SCFM of air. If a liquid and gas service valve is located on the liquid side of a heat exchanger, then the valve should be specified in liquid service. This valve will have a certified capacity stamped in gallons per minute of water.

4.2.1.2.11 In some applications, the valve may be required to relieve a liquid or a gas depending on the condition causing the overpressure (e.g. heat exchanger tube rupture). In this application, a valve designed for liquid service or one designed for liquid and gas service is recommended.

4.2.1.2.12 The user is cautioned that vapor certified relief valves relieving liquid are more prone to chatter than liquid certified relief valves relieving liquid. It has been observed on PRV test stands that vapor certified PRVs relieving liquid at very low overpressures (where flow rate is about 5 % of PRV rated capacity) will flow without much flutter, but at higher overpressures the PRV disk may lift abruptly resulting in unstable valve operation. Vapor certified valves relieving liquid may exhibit stable flow where overpressure is high (20 % or higher) or where the valve lift is mechanically limited. Liquid certified valves were designed to solve the observed instability problems with liquid relief.

4.2.1.3 Balanced Pressure-relief Valves

4.2.1.3.1 A balanced PRV is a spring-loaded PRV that incorporates a bellows or other means of balancing the valve disc to minimize the effects of backpressure on the performance characteristics of the valve (see Figure 2 and Figure 3).

4.2.1.3.2 When a superimposed backpressure is applied to the outlet of a conventional spring-loaded PRV, a pressure force is applied to the valve disc that is additive to the spring force. This added force increases the pressure at which an unbalanced PRV will open. If the superimposed backpressure is variable, then the pressure at which the valve will open will vary (see Figure 8).

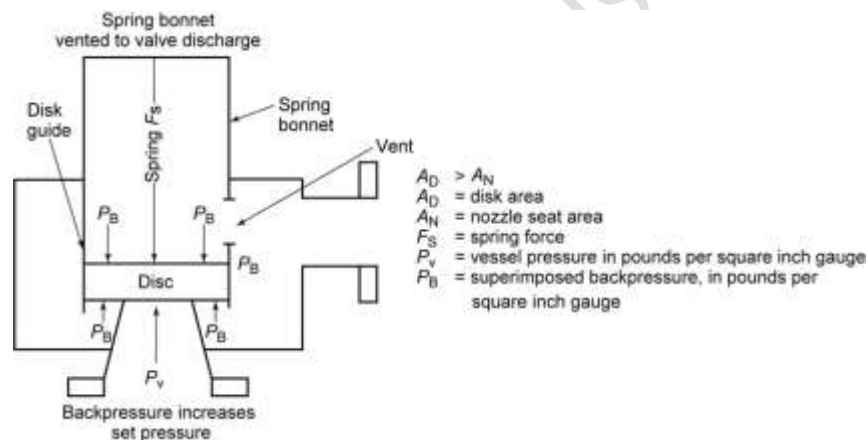


Figure 8—Typical Effects of Superimposed Backpressure on the Opening Pressure of Conventional Pressure-relief Valves

4.2.1.3.3 In a balanced-bellows PRV, a bellows is attached to the disc holder with an effective bellows area, A_B , approximately equal to or greater than the seating area of the disc, A_N (see Figure 9). This isolates an area on the disc, approximately equal to the disc seat area, from the backpressure. If the bellows area, A_B , were identical to the area of the disc, A_N , the variable backpressure would not affect the PRV opening pressure. However, considerations concerning the bellows manufacturing tolerances and the possible variations of opening pressure with backpressure lead to the use of bellows with minimum effective bellows area A_B greater than or equal to A_N . This ensures that backpressure does not increase the opening pressure of the balanced PRV. With the addition of a bellows, therefore, the opening pressure of the PRV will remain constant or decrease with increases in backpressure. This change in opening pressure corresponds to the variation within the bellows manufacturing tolerance. The magnitude of this effect is normally acceptable. Where opening pressures are reduced due to backpressures, the closing pressures will also be reduced resulting in longer blowdown. Consult the manufacturer when there are concerns about backpressure effects on opening pressure.

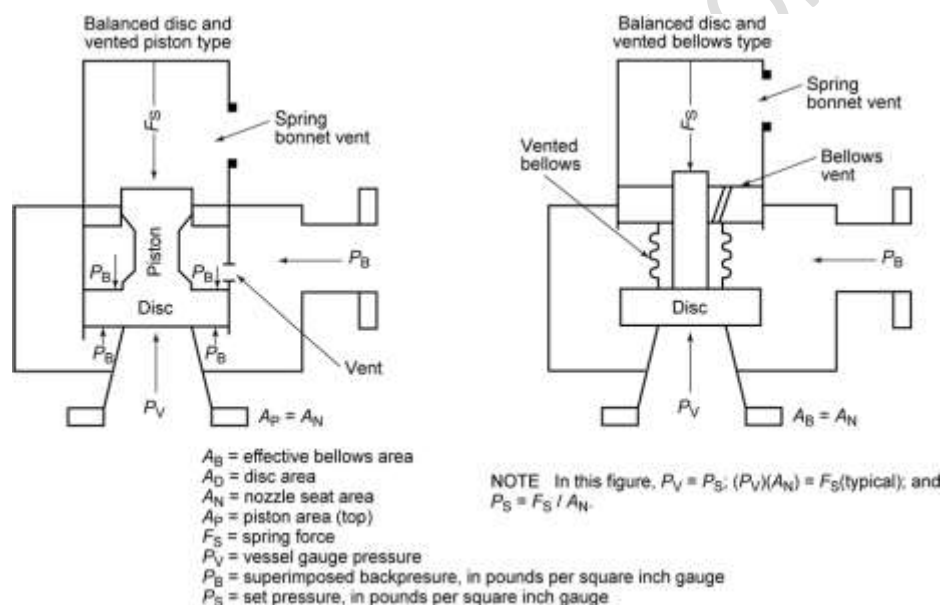


Figure 9—Typical Effects of Backpressure on the Set Pressure of Balanced Pressure-relief Valves

4.2.1.3.4 The internal area of the bellows in a balanced-bellows spring-loaded PRV is referenced to atmospheric pressure in the valve bonnet. It is important that the bonnet of a balanced PRV be vented to the atmosphere for the bellows to perform properly. If the valve is located where atmospheric venting would present a hazard or is not permitted by regulations, the vent shall be piped to a safe location that is free of backpressure that may affect the PRV opening pressure.

4.2.1.3.5 Other means of balancing a spring-loaded PRV such as a sealed piston are used in some valve designs. These designs perform in a manner similar to the balanced bellows design.

4.2.1.3.6 When the superimposed backpressure is constant, the spring load can be reduced to compensate for the effect of backpressure on set pressure, and a balanced valve is not required. When the superimposed backpressure is not constant, there are cases where superimposed backpressure is not always constant and such cases, the design shall include account for the variation/variability in the superimposed backpressure in the design.

4.2.1.3.7 Balanced PRVs are typically used where the built-up backpressure (backpressure caused by flow through the downstream piping after the PRV lifts) is too high for a conventional pressure-relief (see 5.3.3.1). A detailed discussion of backpressure and its effects on PRV performance and capacity can be found in 5.3.

4.2.1.3.8 Balanced PRVs may also be used as a means to isolate the guide, spring, bonnet, and other top works parts within the valve from the relieving fluid. This may be important if there is concern that the fluid will cause corrosive damage to these parts.

4.2.1.3.9 It is important to remember that the bonnet of a balanced PRV shall be vented to atmosphere at all times. Note that there is a potential for freezing of atmospheric moisture inside the bonnet in cold service due to auto-refrigeration or cold ambient temperatures.

4.2.1.4 Pressure-relief Valve Lift Levers & Gags

4.2.1.4.1 A relief valve may have a plain or packed lifting lever. Lifting levers are required by the ASME Code in air, steam, and hot water services. If the purchaser wants to waive this requirement for ASME relief valves, then ASME Code Case 2203 shall be specified on the specification sheet. Note that ASME Code Case 2203 should be specified on the specification sheet, if the purchaser wants to waive this requirement. A packed lifting lever is used when there is backpressure due to closed discharge systems or when there is an overpressure scenario that might relieve hot liquid.

4.2.1.4.2 A test gag shall can only be used during hydrostatic testing of the protected equipment and shall be removed and replaced with a plug during normal operation.

4.2.1.5 Pressure-relief Valve Trim Selection

4.2.1.5.1 PRV trim selection is an important factor when designing relief system installations to minimize the potential for instability (see API 520, Part II for discussion on instability).

4.2.1.5.2 Common types of certified PRVs include ASME vapor certified PRVs, ASME liquid certified PRVs, and PRVs that are dual certified.

4.2.1.5.3 Although guidance can be provided by the valve manufacturer, it is up to the user to select the appropriate valve trim. This selection shall should be clearly specified on the purchase datasheet (e.g. see the Pressure-relief Valve Specification Datasheet provided in Annex D). It is important that the user understands how different trims perform within the range of relief conditions that the PRVs could experience. Particular attention should be paid to vapor certified valves that have applicable liquid relief scenarios.

4.2.1.5.4 Table 1 summarizes some of the performance characteristics of these valve designs. Table 2 summarizes the valve trim for different relief media and inlet piping design criteria.

Table 1—Spring-loaded Pressure-relief Valve Performance Characteristics as a Function of Valve Trim

Characteristic	Vapor Certified PRV	Liquid Certified PRV	Dual Certified PRV
Liquid relief	Capacity is not certified but can be estimated using guidance in 5.9 (may need up to 25 % overpressure to achieve full lift)	Capacity is certified	Capacity is certified
Vapor relief	Capacity is certified	Capacity is not certified, and is not addressed herein See manufacturer for estimated capacity	Capacity is certified
Range of blowdown available (see manufacturer for PRV-specific blowdown values; see NOTE)	Up to 10 % for vapor, and Up to 10 % for liquid	Up to 25 % for vapor Typically up to 12 % for liquids; some vendors may offer higher blowdowns	Up to 25 % for vapor Typically up to 12 % for liquids; some vendors may offer higher blowdowns
Tendency to chatter in liquid service	Increased	Neutral	Neutral
Effect of medium on the opening characteristic	PRV set on gas or vapor but relieving liquid may open 3 % to 5 % higher	PRV set on liquid but relieving vapor may open 3 % to 5 % lower	Minor effect (i.e. within code tolerances)
Effect of required valve overpressure vs. set medium	Any shift up or down in the opening point may result in a similar shift in the point at which full lift is achieved		

NOTE These are typical values obtained from valve manufacturers. User is cautioned to fully understand the impact on operations when blowdown exceeds the operating margin.

Table 2—Design Guidance for Pressure-relief Valve Trim Options

Relief Medium	Certified PRV Trim	PRV Inlet Line Pressure Drop Hydraulic Calculation Basis Options		Comments
		Use PRV Rated Capacity	Use Required Relief Load	
Vapor	Vapor or Dual	✓	NOTE 1	
Vapor	Liquid	✓	NOTE 1	Caution (NOTE 2)
Liquid	Vapor	NOTE 3	NOTE 3	Caution (NOTE 3)
Liquid	Liquid or Dual	✓	NOTE 1	
Two phase	Liquid, Vapor, or Dual	✓	NOTE 1	
Supercritical	Liquid, Vapor, or Dual	✓	NOTE 1	
NOTE 1 May be used if PRV exhibits modulating behavior.				
NOTE 2 Application not recommended if vapor is the controlling sizing case, and the valve is not certified for vapor. Where vapor loads are not controlling, the capacity of the PRV relieving vapor will need to be estimated; see manufacturer for guidance. See Table 1 for blowdown characteristics.				
NOTE 3 Application not recommended if liquid is the controlling sizing case, since the valve is not certified for liquid. Where liquid loads are not controlling, the capacity of the PRV relieving liquid will need to be estimated using the noncertified liquid PRV sizing equation; see 5.9. When calculating inlet line pressure drop, required rate may be used if PRV exhibits modulating behavior. See Table 1 for overpressure characteristics.				

4.2.2 Pilot-operated Pressure-relief Valves

4.2.2.1 General

4.2.2.1.1 A pilot-operated PRV consists of the main valve, which normally encloses a floating unbalanced piston assembly, and an external pilot (see Figure 10 through Figure 14). The piston is designed to have a larger area on the top than on the bottom. Up to the set pressure, the top and bottom areas are exposed to the same inlet operating pressure. Because of the larger area on the top of the piston, the net force holds the piston tightly against the main valve nozzle. As the operating pressure increases, the net seating force increases and tends to make the valve tighter. This feature allows most pilot-operated valves to be used where the maximum expected operating pressure is higher than the percentage shown in Figure 15. At the set pressure, the pilot vents the pressure from the top of the piston; the resulting net force is now upward causing the piston to lift, and process flow is established through the main valve. After the overpressure incident, the pilot will close the vent from the top of the piston, thereby re-establishing pressure, and the net force will cause the piston to reseal.

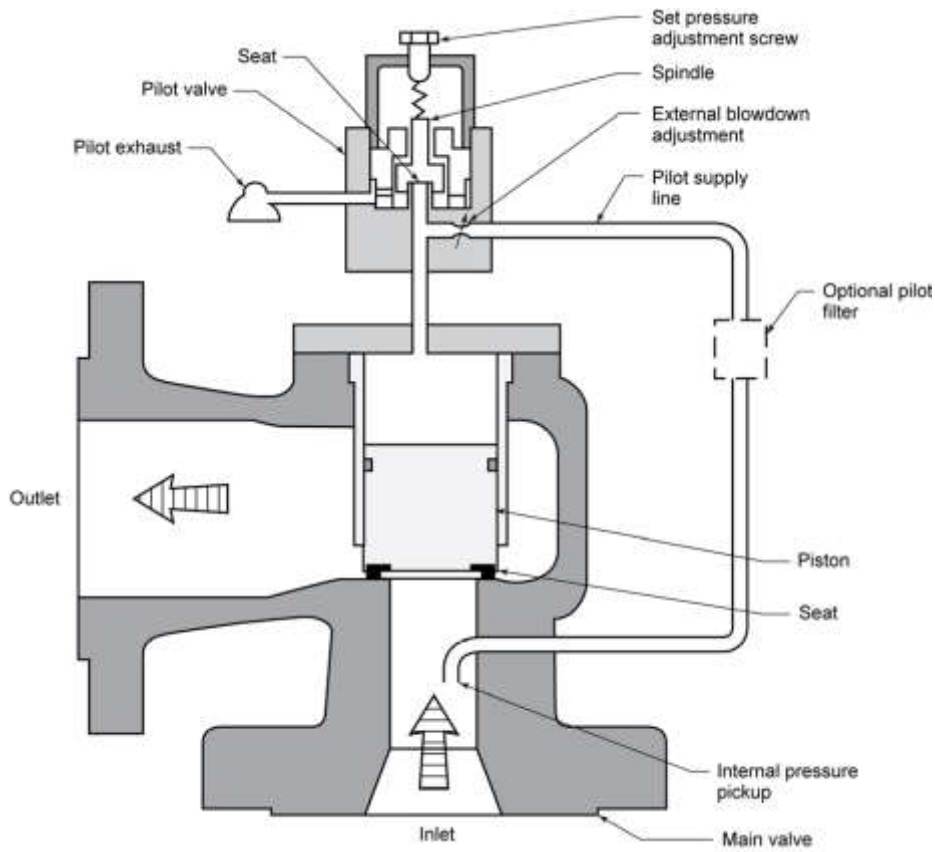


Figure 10—Pop-action Pilot-operated Valve (Flowing Type)

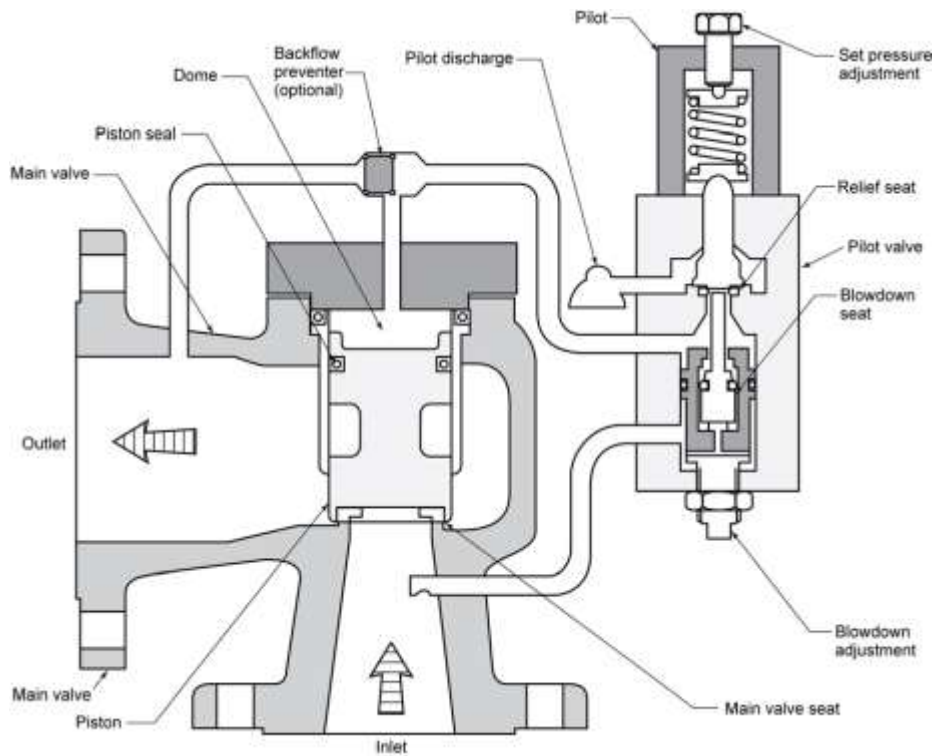


Figure 11—Pop-action Pilot-operated Valve (Nonflowing Type)

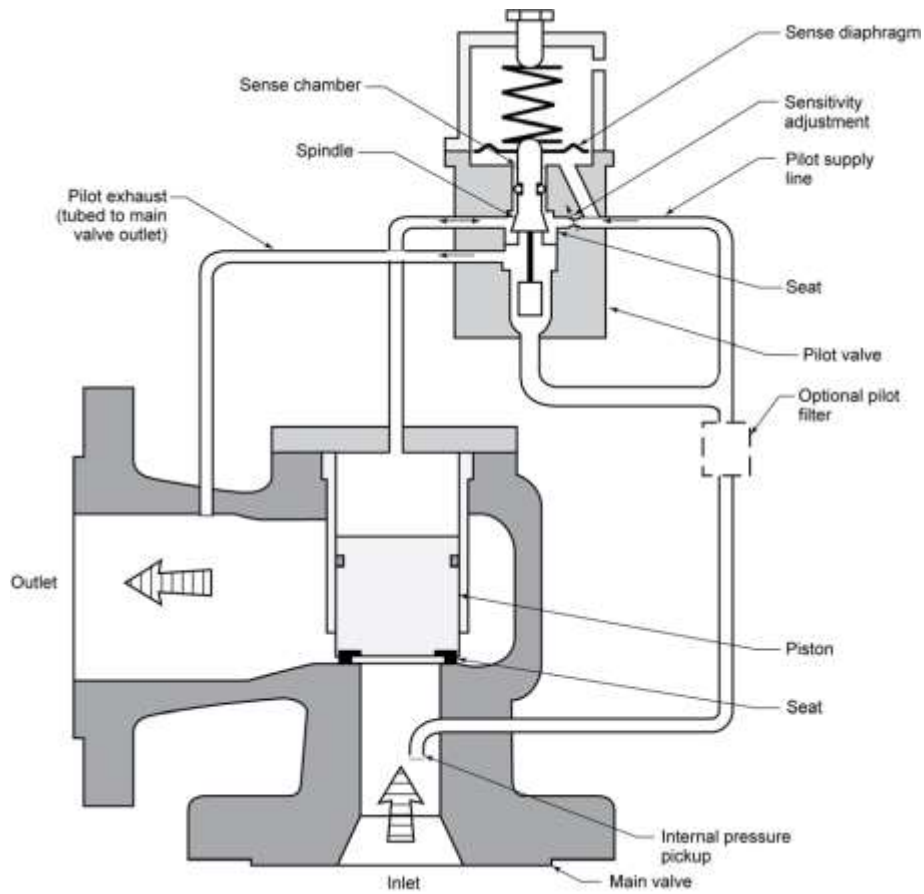


Figure 12—Modulating Pilot-operated Valve (Flowing Type)

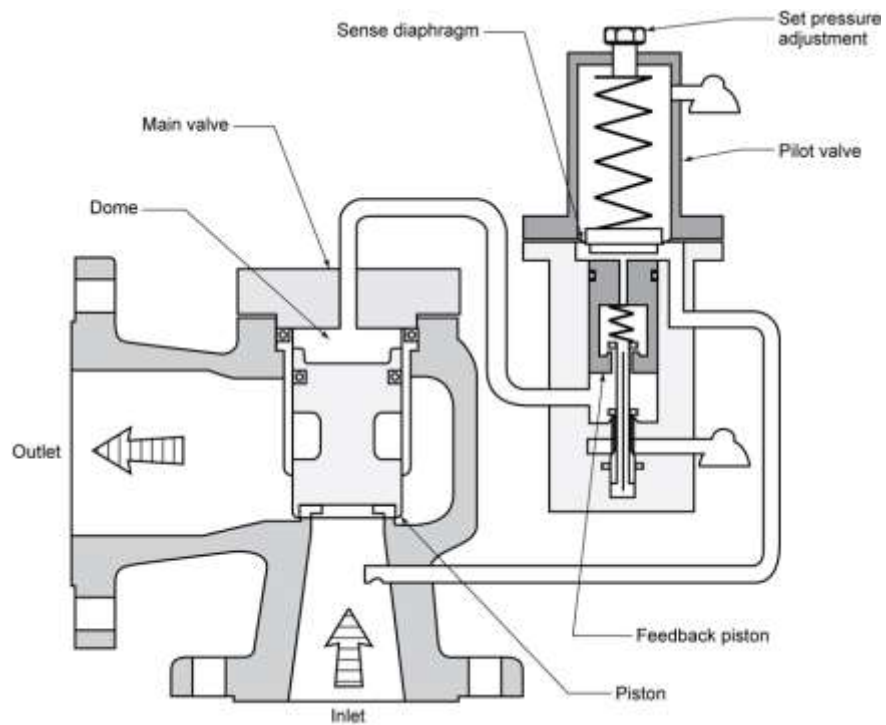


Figure 13—Pilot-operated Relief Valve with a Nonflowing Modulating Pilot Valve

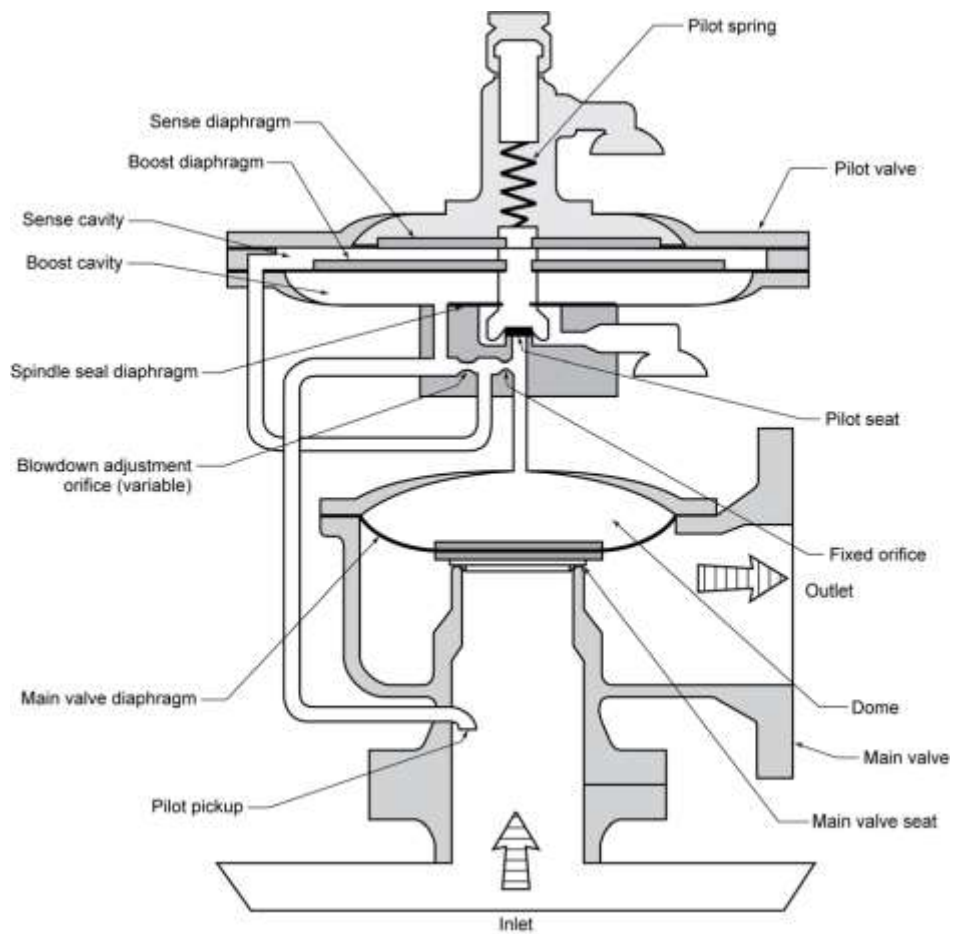
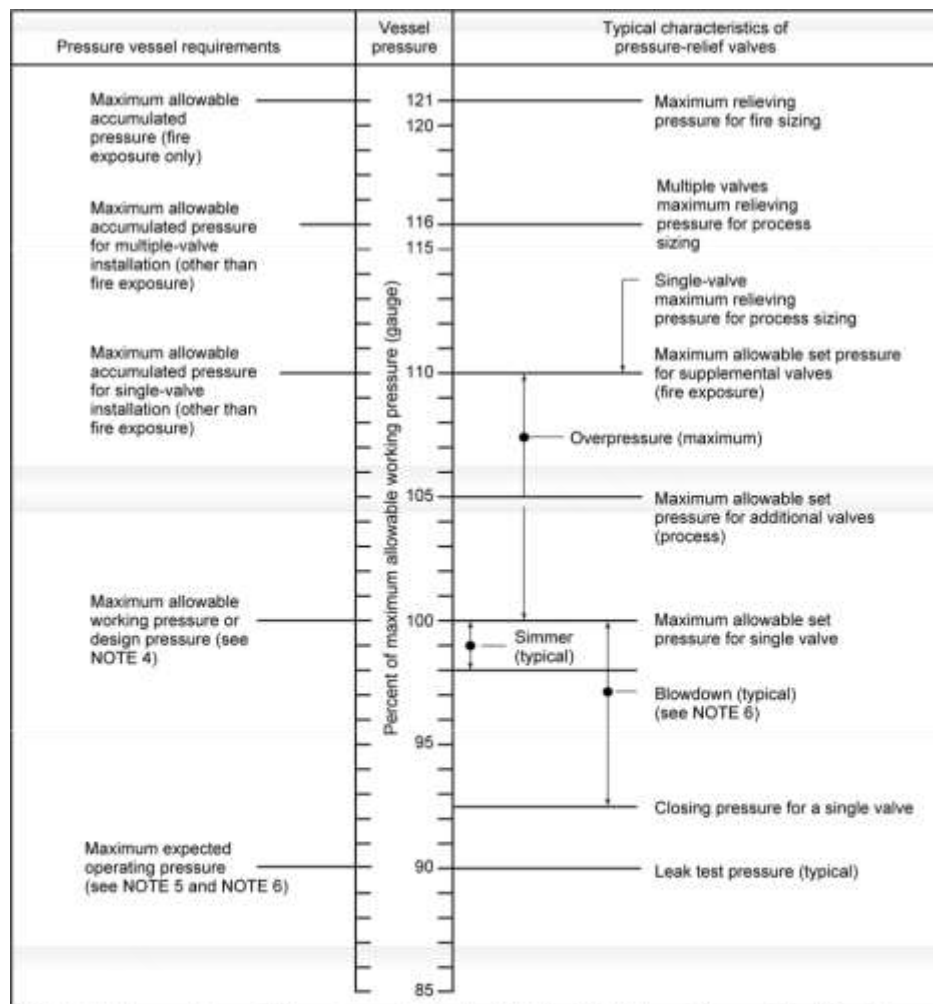


Figure 14—Low-pressure Pilot-operated Valve (Diaphragm Type)



NOTE 1 This figure conforms with the requirements of Section VIII of the ASME *Boiler and Pressure Vessel Code* for MAWPs greater than 30 psig.

NOTE 2 The pressure conditions shown are for pressure-relief valves installed on a pressure vessel.

NOTE 3 Allowable set-pressure tolerances will be in accordance with the applicable codes.

NOTE 4 The maximum allowable working pressure is equal to or greater than the design pressure for a coincident design temperature.

NOTE 5 The operating pressure may be higher or lower than 90 %.

NOTE 6 Section VIII, Division 1, Appendix M of the ASME Code should be referred to for guidance on blowdown and pressure differentials.

Figure 15—Pressure Level Relationships for Pressure-relief Valves

4.2.2.1.2 The main valve of the pilot-operated PRV can use a diaphragm in lieu of a piston to provide the unbalanced moving component of the valve. A disc, which normally closes the main valve inlet, is integral with a flexible diaphragm (see Figure 14). The external pilot serves the same function to sense process pressure, vent the top of the diaphragm at set pressure, and reload the diaphragm once the process pressure is reduced. As with the piston valve, the seating force increases proportionally with the operating pressure because of the differential exposed area of the diaphragm.

4.2.2.1.3 The lift of the main valve piston or diaphragm, unlike a conventional or balanced spring-loaded valve, is not affected by built-up backpressure. This allows for even higher pressures in the relief discharge manifolds.

4.2.2.1.4 The pilot vent can be either directly exhausted to atmosphere or to the main valve outlet depending upon the pilot's design and user's requirement. Only a balanced type of pilot, where set pressure is unaffected by backpressure, should be installed with its exhaust connected to a location with varying pressure (such as to the main valve outlet). Slight variations in backpressure may be acceptable for unbalanced pilots.

4.2.2.2 Backflow Prevention

A backflow preventer shall be installed when the possibility exists of developing a pressure on the discharge side of a valve that exceeds the inlet pressure of the valve. The higher discharge pressure can cause sufficient upward force on the diaphragm or piston to open the valve and cause flow reversal. The backflow preventer allows the discharge pressure to provide a net downward force on the diaphragm or piston to keep the valve closed (see Figure 11). The proper operation of the backflow preventer is critical to further ensuring no flow reversal occurs in the valve. The selection of the material and seals in the backflow preventer should be consistent with the pilot-operated PRV. Some examples where the protected system pressure can be less than the discharge pressure are:

- the protected equipment can be depressured and isolated (e.g. to prepare for maintenance) while lined up to an active flare header;
- a vacuum may be present at the inlet connection due to unusual operating conditions or during start-up;
- the valve is connected to a downstream pressure vessel where pressure may vary ~~from time to time~~ in excess of the pressure in the upstream system;
- the discharge of multiple PRVs is combined into a single manifold or vent system, creating superimposed backpressure in excess of the current upstream system pressure.

4.2.2.3 Pilot Types

4.2.2.3.1 The pilot that operates the main valve can be either a pop-action or modulating action pilot. The pop-action pilot, as shown in Figure 16, causes the main valve to lift fully at set pressure without overpressure. This immediate release of pressure provides extremely high opening and closing forces on the main valve seat. This opening action is typically not recommended for liquid services to avoid valve instability.

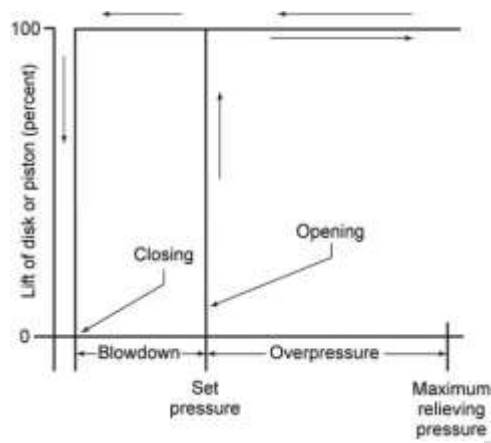


Figure 16—Typical Relationship Between Lift of Disk or Piston and Vessel Pressure in a Pop-action Pilot-operated Pressure-relief Valve

4.2.2.3.2 The modulating pilot, as shown in Figure 17, opens the main valve only enough to satisfy the required relieving capacity and can be used in gas, liquid, or two-phase flow applications. A modulating pilot-operated valve, in contrast to a pop-action valve, limits the amount of relieving fluid to only the amount required to prevent the pressure from exceeding the allowable accumulation. Since a modulating pilot only releases the required relieving rate, the calculation of built-up backpressure may be based on the required relieving rate instead of the rated capacity of the valve corrected for the actual overpressure. The modulating pilot valve also can reduce interaction with other pressure control equipment in the system during an upset condition, reduce unwanted atmospheric emissions, and reduce the noise level associated with discharge to the atmosphere.

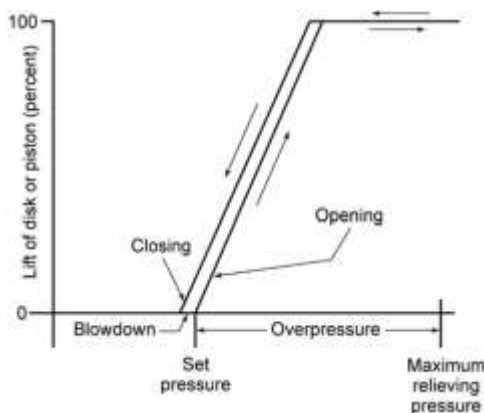


Figure 17—Typical Relationship Between Lift of Disk or Piston and Vessel Pressure in a Modulating-action Pilot-operated Pressure-relief Valve

4.2.2.3.3 The pilots may be either a flowing or nonflowing type. The flowing type allows process fluid to continuously flow through the pilot when the main valve is open; the nonflowing type does not. The nonflowing pilot type is generally recommended for most services to reduce the possibility of hydrate formation (icing) or solids in the lading fluid affecting the pilot's performance.

4.2.2.4 Application and Limitations of Pilot-operated Pressure-relief Valves

4.2.2.4.1 Pilot-operated PRVs are available for use in liquid and vapor services. Operating characteristics of some pilot-operated PRVs are unaffected by the state of fluid (liquid or gas), and these types are recommended for two-phase flow applications.

4.2.2.4.2 Similar to soft seated spring-loaded valves, most main valves and their pilots contain nonmetallic components, and process temperature and fluid compatibility can limit their use. In addition, as with all PRDs, fluid characteristics such as susceptibility to polymerization or fouling, viscosity, the presence of solids, and corrosiveness should be considered. The manufacturer should be consulted to ensure that the proposed application is compatible with available valves.

4.2.2.5 Pilot-operated Pressure-relief Valve Accessories

4.2.2.5.1 General

A variety of accessories and options are available for pilot-operated PRVs to provide additional functions. The following is a list of ~~some of~~ the more common accessories—some of which may not be available for all valve models.

4.2.2.5.2 Field Test Connection

Pilot-operated PRVs may be readily tested for verification of set pressure during normal system operation with this accessory. This field test is typically done via pressure from an independent source such as a nitrogen bottle, where the source gas is slowly admitted through a metering valve. The pilot and main valve dome are pressurized simulating an increased system pressure. The field test pressure will actuate the pilot and may or may not actuate the main valve. The valve manufacturer can provide details.

4.2.2.5.3 Backflow Preventer

This accessory, sometimes called a “vacuum block,” prevents a pilot-operated valve from reverse flow when the pressure at the outlet flange (superimposed backpressure) is greater than the current system pressure. Reverse flow can occur with any standard type or design of pilot-operated PRV when sufficient reverse differential pressure exists. A backflow preventer permits the introduction of outlet pressure into the dome of the main valve, thereby holding the piston firmly on the nozzle, overcoming the effect of a reverse differential pressure.

4.2.2.5.4 Pilot Supply Filter

A pilot supply filter protects the pilot from particulate matter in the flow stream. This accessory, installed in the pilot supply line, has expanded the service applications for pilot-operated PRVs. The user is cautioned that in services prone to plugging, frequent maintenance of the filter may be required to achieve the benefits. For applications with excessive particulate matter, other methods such as the addition of a purge system may be required.

4.2.2.5.5 Pressure Spike Snubber

A pressure spike snubber is recommended for use on compressible or incompressible lading fluid installations where instantaneous pressure spikes or pulsations approach or exceed the simmer or set pressure and may cause inadvertent valve wear and actuation (e.g. downstream of positive displacement rotating equipment). The device dampens these transient pressure rises before they reach the sensing chambers of the pilot without affecting the valve's set pressure.

4.2.2.5.6 Remote Pressure Sense Connection

This optional feature permits the pilot to sense system pressure at a location that most accurately reflects the actual operating pressure of the protected system. It can also be used to eliminate the false system pressure indication that will occur during relieving conditions due to pressure losses in the inlet piping. The addition of a remote pilot sense line allows the pilot to correctly sense system pressure and to keep the valve from rapid cycling or chattering due to high inlet piping pressure losses. Rated relieving capacity corrected for the actual overpressure will be proportionately reduced whenever there is inlet pressure loss to the valve.

4.2.2.5.7 Manual or Remote Unloader

An unloader permits the main valve to be opened either manually or remotely to depressurize the system. Its use has no effect on the sealed pressure settings. Either a manual, pneumatic, or solenoid operated valve is connected to the main valve dome. Opening this valve vents the dome pressure faster than it can

be recharged by the pilot supply allowing the piston to lift. When permitted by code, the manual unloader may be substituted for a mechanical lift lever.

4.2.2.5.8 Pilot Lift Lever

This accessory is provided for those applications where the mechanical lifting of the pilot is required for verification of valve operation. Lifting of the pilot spindle will permit the main valve to lift when the system pressure is at least equal to or greater than 75 % of the set pressure. The ASME *Code* requires the use of this device or a manual unloader for air, hot water over 140 °F (60 °C), and steam applications, unless ASME *BPVC* Case 2203 has been used to eliminate the need for a lifting lever.

4.2.2.5.9 Pilot Valve Isolation

There are several designs that use an inert fluid to isolate all or part of the pilot valve portion of the pilot-operated PRV from the service conditions. This may allow the pilot-operated PRV to be considered in applications where plugging and fouling might otherwise be a concern (e.g. where there is a potential for polymerization, high viscosity fluids, presence of solids, or corrosiveness). These isolation systems shall be are designed to provide the inert fluid to protect the critical parts of the pilot valve during normal operating conditions and also when the pilot valve operates during an overpressure event. The user should contact the manufacturer to discuss the various isolation options available with a particular pilot design and what isolation options would be suitable for the specific service condition. The user should advise the manufacturer of any local codes or regulations that affect the application and the suitability of a particular pilot valve isolation system.

4.2.3 Cold Differential Test Pressure

4.2.3.1 The actual service conditions under which a PRV is required to open may be different from the conditions at which the PRV is set to operate on a test stand. To compensate for this effect, a cold differential test pressure (CDTP) is specified for adjusting the set pressure of the valve on the test stand. The CDTP may include a correction for actual service conditions of backpressure and/or temperature.

4.2.3.2 A temperature correction factor may be applied when the PRV temperature is significantly different from the ambient temperature. The magnitude of the correction factor and the minimum temperature at which it may be applied is dependent on the PRV model. The correction factor shall be obtained from the PRV manufacturer and is often available in their Installation, Operation, and Maintenance manuals. The correction factor is normally provided as a multiplier to the set pressure.

4.2.3.3 The temperature used for the correction factor should be based on the temperature at the inlet to the relief valve at its normal service (nonrelieving) conditions. The temperature at the valve may not be equal to the operating temperature of the process due to valve's physical location, collection of noncondensable vapors below the valve inlet, isolation from the process by a rupture disk, or heat tracing of the valve. The factor compensates for variations in spring load due to thermal growth in valve components as well as changes in the spring material properties. Compensation may also be required for service below -75 °F (-60 °C). A conventional PRV, operating with a superimposed backpressure, normally requires a correction factor to compensate for the superimposed backpressure. In this case, the required set pressure minus the superimposed backpressure is equal to the CDTP. This change accounts for the additional closing force exerted on the valve disk by the backpressure. In the case of a balanced spring-loaded PRV, the change in closing force due to the superimposed backpressure is negligible and no correction is required.

4.2.3.4 When the CDTP is to include a correction for backpressure and temperature, the differential pressure is calculated and then multiplied by the temperature correction to determine the CDTP.

4.2.3.5 Pilot-operated PRVs (see 4.2.2) may require a CDTP when used in high temperature or backpressure service. The valve manufacturer provides backpressure and temperature limits and required correction factor.

4.2.4 Restricted Lift Pressure-relief Valves

4.2.4.1 API 526 Table 1 shows a 21 % to 78 % increase in effective orifice area from one lettered orifice to the next lettered orifice. In some applications, the user may desire less capacity than the next size orifice area would provide. A reduction in the pressure relief valve rated capacity can be achieved by restricting the lift. A restricted lift pressure relief valve has a reduced flow area, resulting in a lower rated capacity for the valve. A lower rated capacity, based on the reduced lift, will lower the inlet and outlet piping pressure losses and reduce the acoustic effects.

4.2.4.2 ASME BPVC, Section VIII prohibits restricting the lift to a value less than 30 % of the full rated lift, or less than 0.080 in.

4.2.4.3 The final relief device design shall meet the requirements of the applicable code or standard. For ASME Code applications, the restriction of the relief device lift shall be performed only by the valve Manufacturer or Assembler.

4.2.4.4 The nameplate on restricted lift relief devices shall be stamped to identify the reduced lift value and the certified capacity based on that reduced lift value. The final selected orifice letter designation shall include the suffix "-RL" on the specification sheet.

4.2.4.5 Restricted lift versions of the PRVs in API 526 Table 3 through Table 30 may be specified by providing the manufacturer with a required capacity and the maximum desired rated capacity. The manufacturer shall determine the lift that will provide a rated capacity within these two values. See Figure 18 for some options for restricting lift in spring-loaded pressure relief valves. Consult the manufacturer for more information on restricted lift designs. Prior to making a final selection, the purchaser shall confirm that the restricted lift relief device meets the design requirements (see example in Annex F).

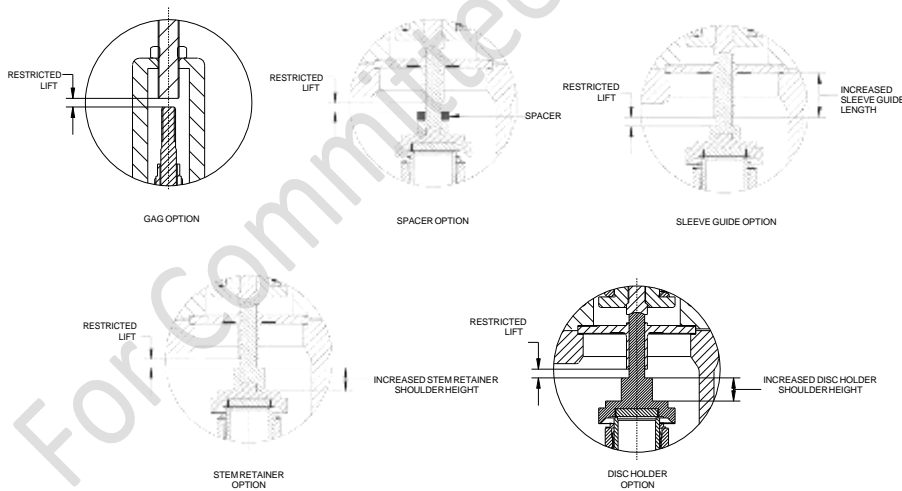


Figure 18—Different Options for Restricting Lift in Spring-loaded Pressure-relief Valves

4.3 Rupture Disk Devices

4.3.1 General

4.3.1.1 Rupture disk devices are nonreclosing PRDs used to protect vessels, piping, and other pressure-containing components from excessive pressure and/or vacuum. Rupture disks are used in single and multiple relief device installations. They are also used as redundant PRDs.

4.3.1.2 With no moving parts, rupture disks are simple, reliable, and faster acting than other PRDs. Rupture disks react quickly enough to relieve some types of pressure spikes. Because of their light weight, rupture disks can be made from high alloy and corrosion resistant materials that are not practical in PRVs.

4.3.1.3 Rupture disks can be specified for systems with vapor (gas) or liquid pressure-relief requirements. Also, rupture disk designs are available for highly viscous fluids. The use of rupture disk devices in liquid service should be carefully evaluated to ensure that the design of the disk is suitable for liquid service. The user should consult the manufacturer for information regarding liquid service applications.

4.3.1.4 Rupture disk devices often have different opening characteristics as a function of the fluid state against the disk at the time of bursting. To account for the resulting differences in the resistance to flow, certified K_r values are stated in terms of K_{rg} (gas), K_{rl} (liquid), or K_{rgl} (gas or liquid). In application, use the following guidelines.

- When the fluid initiating rupture (in contact with rupture disk) is compressible, rupture disks rated with K_{rg} or K_{rgl} should be used.
- When the fluid initiating rupture (in contact with rupture disk) is incompressible, rupture disks rated with K_{rl} or K_{rgl} should be used.

4.3.1.5 The rupture disk is also a temperature-sensitive device. Burst pressures can vary significantly with the temperature of the rupture disk device. This temperature may be different from the normal fluid operating temperature. As the temperature at the disk increases, the burst pressure usually decreases. Since the effect of temperature depends on the rupture disk design and material, the manufacturer should be consulted for specific applications. For these reasons, the rupture disk shall be specified at the pressure and temperature the disk is expected to burst.

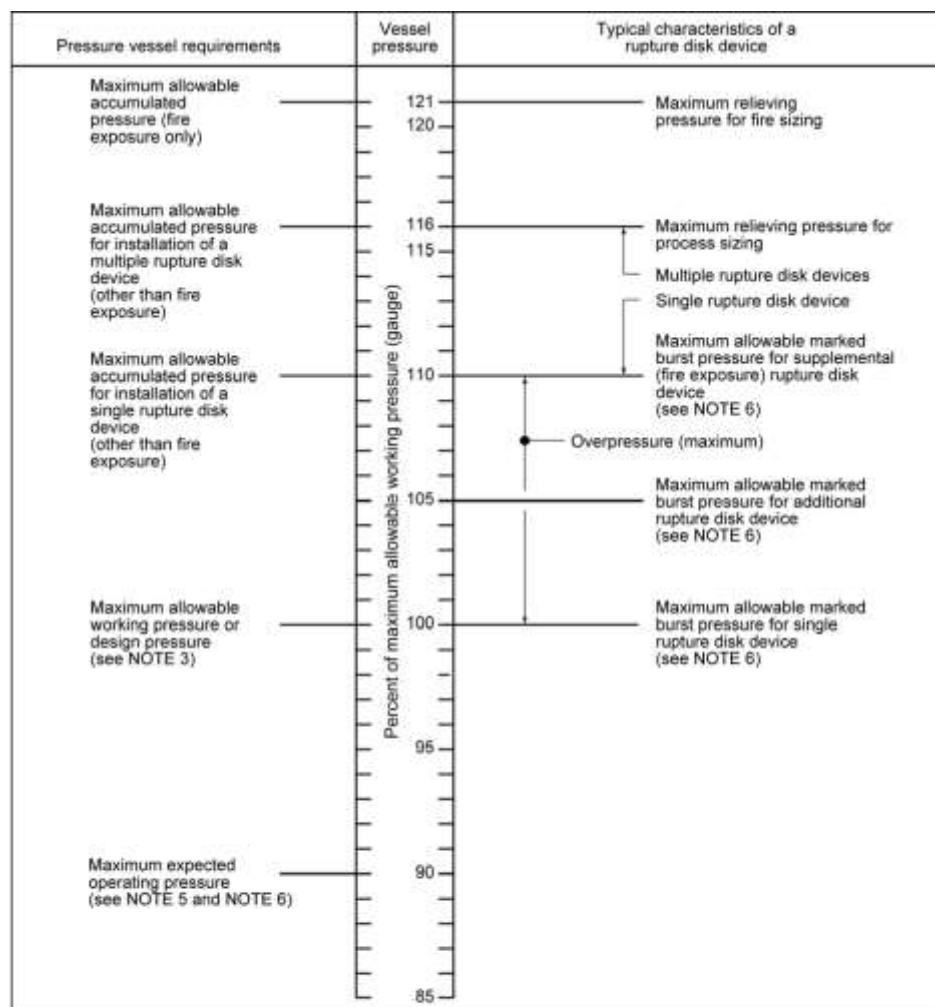
4.3.1.6 It is the user's responsibility to avoid damaging the disk during installation and ensure that the disk and holder are properly oriented relative to the flow. A damaged or improperly oriented disk may burst considerably higher than its marked burst pressure, depending on the style of the disk. Contact the manufacturer for information about the effects of damage or improper orientation for a specific style of disk.

4.3.1.7 ~~The end user shall follow the Manufacturer's~~ [provide bolting requirements](#) and tightening procedures ~~during for~~ installation. Improper torque can also affect the disk's burst pressure.

4.3.2 Application of Rupture Disks

4.3.2.1 Single, Multiple, and Fire Applications

Rupture disks can be used in any application requiring overpressure protection where a nonreclosing device is suitable. This includes single, multiple, and fire applications as specified in UG-134 of the ASME Code. Figure 19 provides the pressure level relationships between rupture disks and the protected equipment in accordance with the ASME Code.



NOTE 1 This figure conforms with the requirements of Section VIII of the ASME *Boiler and Pressure Vessel Code* for MAWPs greater than 30 psig.

NOTE 2 The pressure conditions shown are for rupture disk devices installed on a pressure vessel.

NOTE 3 The margin between the maximum allowable working pressure and the operating pressure must be considered in the selection of a rupture disk.

NOTE 4 The allowable burst pressure tolerance will be in accordance with the applicable code.

NOTE 5 The operating pressure may be higher or lower than 90 % depending on the rupture disk design.

NOTE 6 The marked burst pressure of the rupture disk may be any pressure at or below the maximum allowable marked burst pressure.

Figure 19—Pressure Level Relationships for Rupture Disk Devices

4.3.2.2 Rupture Disk Device at the Inlet of a Pressure-relief Valve

4.3.2.2.1 The ASME Code also allows for the use of rupture disks in combination with PRVs (see Figure 20). Rupture disks are used upstream of PRVs to seal the system to meet emissions standards, to provide corrosion protection for the valve, and to reduce valve maintenance.

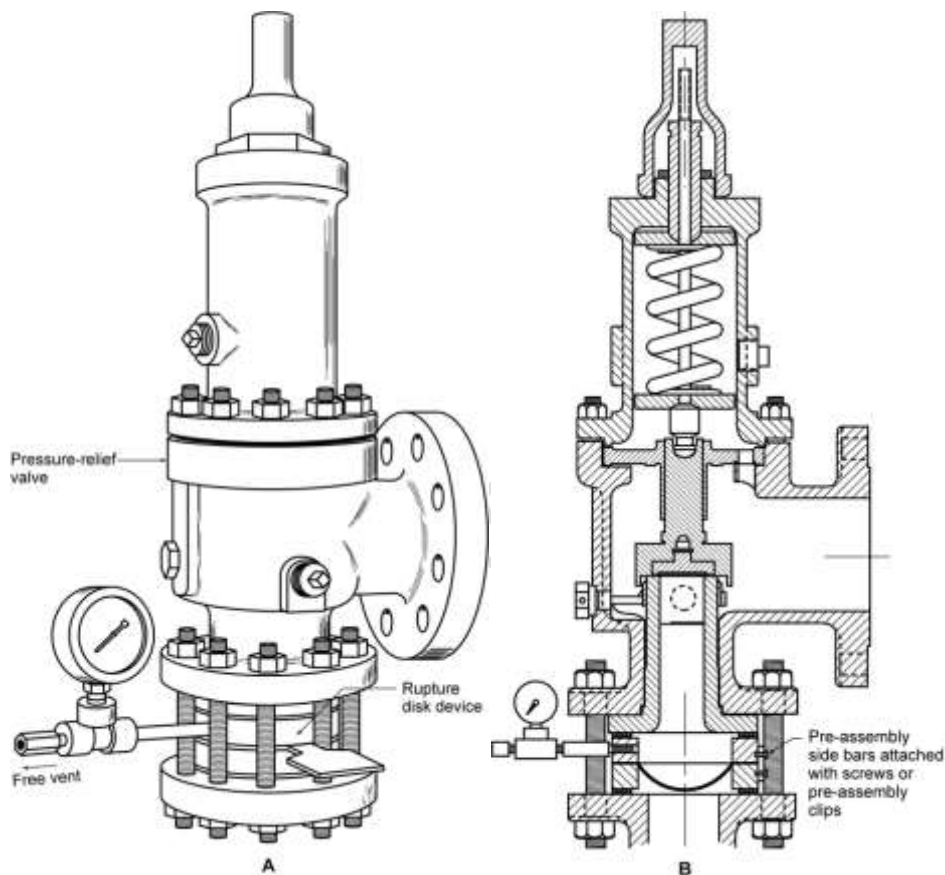


Figure 20—Rupture Disk Device in Combination with a Pressure-relief Valve

4.3.2.2.2 When a rupture disk device is installed at the inlet of a PRV, the devices are considered to be close coupled, and the specified burst pressure and set pressure should be the same nominal value. When installed in liquid service, it is especially important for the disk and valve to be close coupled to reduce shock loading on the valve.

4.3.2.2.3 The space between the rupture disk and the PRV shall have a free vent, pressure gauge, trycock, or suitable telltale indicator as required in UG-127 of the ASME Code. A nonvented space with a pressure gauge without alarms or other devices is not recommended as a suitable telltale indicator. Users are warned that a rupture disk will not burst in tolerance if backpressure builds up in a nonvented space between the disk and the PRV, which will occur if leakage develops in the rupture disk due to corrosion or other cause (see API 520, Part II).

4.3.2.3 Rupture Disk Device at the Outlet of a Pressure-relief Valve

A rupture disk device may be installed on the outlet of a PRV to protect the valve from atmospheric or downstream fluids. The valve shall be designed so that it will open at its proper pressure setting regardless of any backpressure that may accumulate between the valve and rupture disk. See UG-127 of the ASME Code for other requirements and considerations.

4.3.2.4 Rupture Disk Devices in Series

4.3.2.4.1 Rupture disks may be installed in series using two distinct rupture disk holders separated by a spool piece. Typically, the intermediate spool piece is quite short, rarely exceeding 2 pipe diameters. Rupture disks may also be installed in series using a "Double Disk Assembly." A double disk assembly is most commonly manufactured from three pieces: the inlet, the "mid-flange," and the outlet. The double disk assembly may be configured for either tension-loaded (forward-acting) or compression-loaded (reverse-buckling) rupture disks.

4.3.2.4.2 Regardless of whether a double disk assembly or two rupture disk devices in series are used, it is important to remember that rupture disks are pressure differential devices and, accordingly, the space between the two disks shall be monitored or vented to ensure that no captive pressure in the intervening space is allowed to elevate the burst pressure of the upstream disk to an unsafe value. The vapor space between the disks shall have a free vent, pressure gauge, trycock, or suitable telltale indicator for monitoring of pressure buildup (see API 520, Part II). This gives the user an indication that replacement of the rupture disk is required.

4.3.2.4.3 The ASME Code allows rupture disks installed in a double disk assembly to be tested to obtain a single K_r value for the device. If two rupture disk devices in series are used, each rupture disk K_r value must be considered when sizing the relief system.

4.3.2.4.4 Rupture disks may be installed in series for highly corrosive applications where any corrosion paths (e.g. pinholes) in the upstream disk will be contained by the downstream disk preventing any hazardous product releases. If the first disk develops a leak due to corrosion, the second disk will contain the fluid. Both rupture disks are typically specified at the same burst pressure.

4.3.2.4.5 Rupture disks may be installed in series to prevent any superimposed backpressure (constant or variable) from elevating the burst pressure of the upstream disk. The burst pressure of the upstream disk is typically specified at the desired system relief pressure, whereas the burst pressure of the downstream disk is specified at a lower value to account for superimposed backpressure. Since some rupture disks designs are better equipped to withstand backpressure, the rupture disk manufacturer should be consulted to ensure that the rupture disk device is suitable for the application.

4.3.2.5 Highly Viscous Applications

Rupture disk designs are available for processes with high viscosity fluid, including nonabrasive slurries, where fluid flow is directed across the rupture disk inlet to prevent product buildup that may otherwise adversely affect rupture disk performance. The disk manufacturer should be consulted for details in these applications.

4.3.3 Types of Rupture Disks

4.3.3.1 General

There are three major rupture disk types:

— forward-acting, tension-loaded;

- reverse-acting, compression-loaded;
- graphite, shear-loaded.

4.3.3.2 Forward-acting Solid Metal Rupture Disks

A forward-acting rupture disk is a formed (domed), solid metal disk designed to burst at a rated pressure applied to the concave side (see Figure 21). This rupture disk typically has an angular seat design and provides a satisfactory service life when operating pressures are up to 70 % of the marked burst pressure of the disk (70 % operating ratio). Consult the manufacturer for the actual recommended operating ratio for the specific disk under consideration. If vacuum or backpressure conditions are present, the disk can be furnished with a support to prevent reverse flexing. These disks have a random opening pattern and are considered fragmenting designs that are not suitable for installation upstream of a PRV.

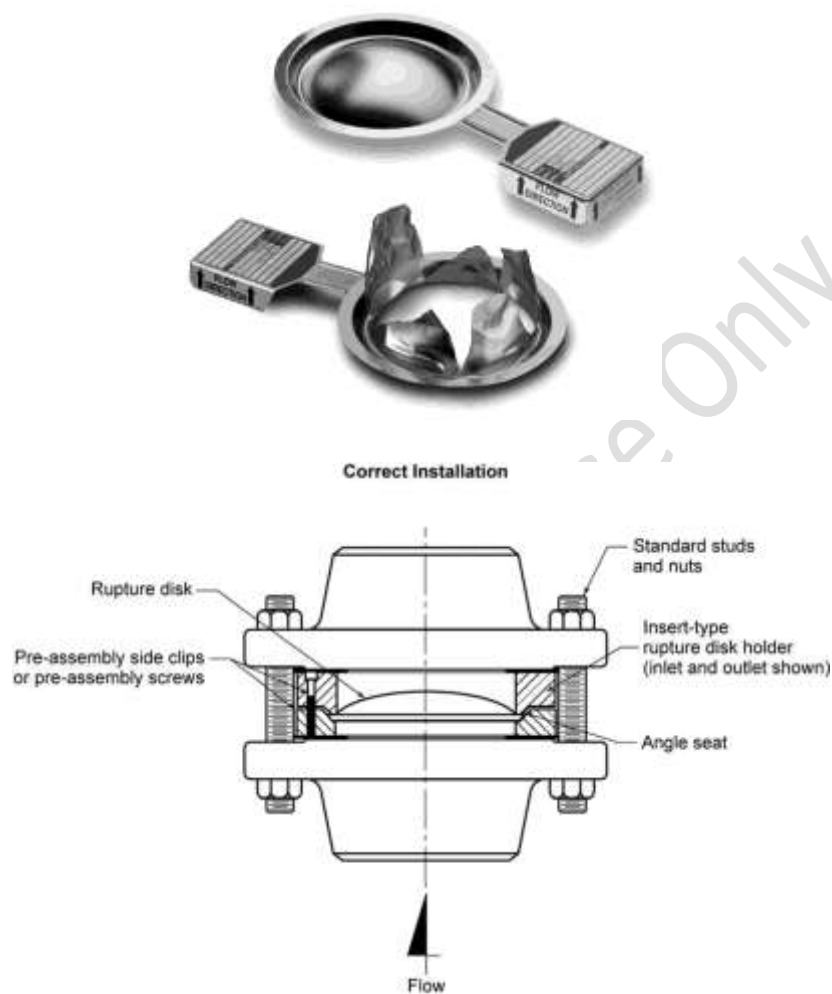


Figure 21—Forward-acting Solid Metal Rupture Disk

4.3.3.3 Forward-acting Scored Rupture Disks

The scored forward-acting rupture disk is a formed (domed) disk designed to burst along scored lines at a rated pressure applied to the concave side (see Figure 22). Some designs provide satisfactory service life when operating pressures are up to 85 % to 90 % of the marked burst pressure of the disk (85 % to 90 % operating ratio). Consult the manufacturer for the actual recommended operating ratio for the specific disk under consideration. Most designs withstand vacuum conditions without a vacuum support. If backpressure conditions are present, the disk can be furnished with a support to prevent reverse flexing. Because the score lines control the opening pattern, this type of disk can be

manufactured to be nonfragmenting and is acceptable for installation upstream of a PRV. The scored, forward-acting rupture disk is manufactured from thicker material than nonscored designs with the same burst pressure, and it provides additional resistance to mechanical damage.

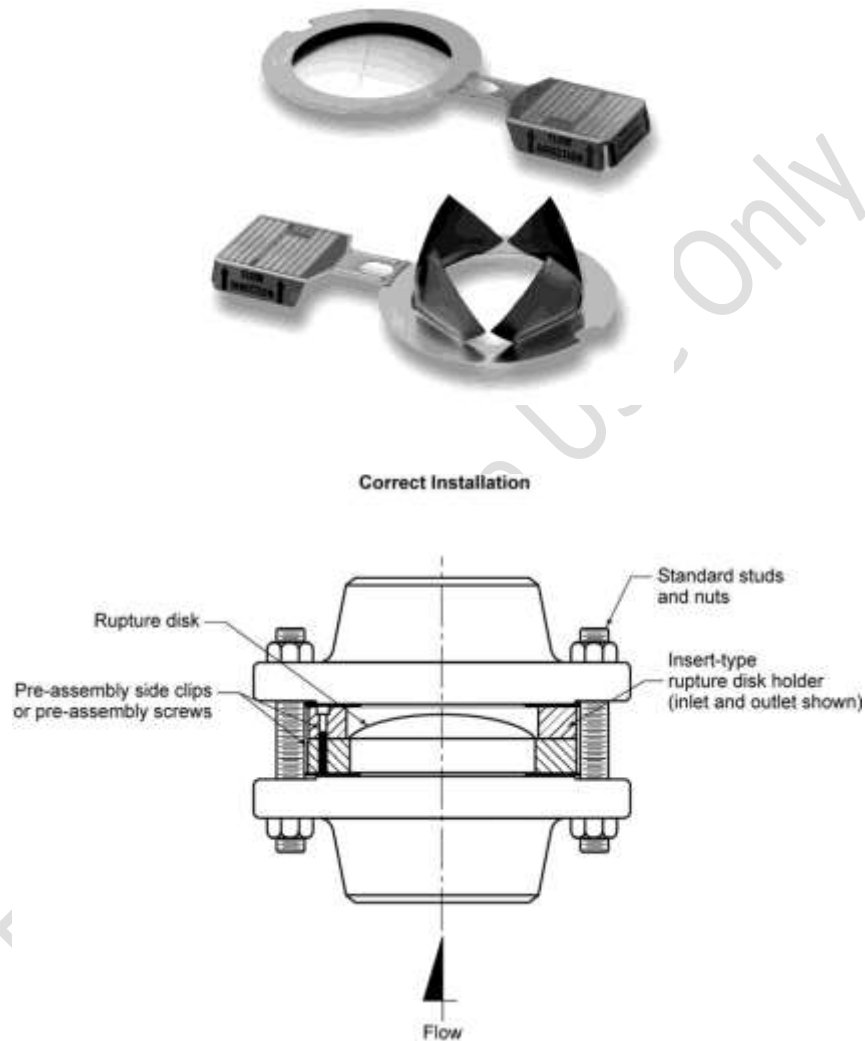


Figure 22—Forward-acting Scored Rupture Disk

4.3.3.4 Forward-acting Composite Rupture Disks

4.3.3.4.1 A forward-acting composite rupture disk is a flat or domed multipiece construction disk (see Figure 23). The domed composite rupture disk is designed to burst at a rated pressure applied to the concave side. The flat composite rupture disk may be designed to burst at a rated pressure in either or both directions. Some designs are nonfragmenting and acceptable for use upstream of a PRV.

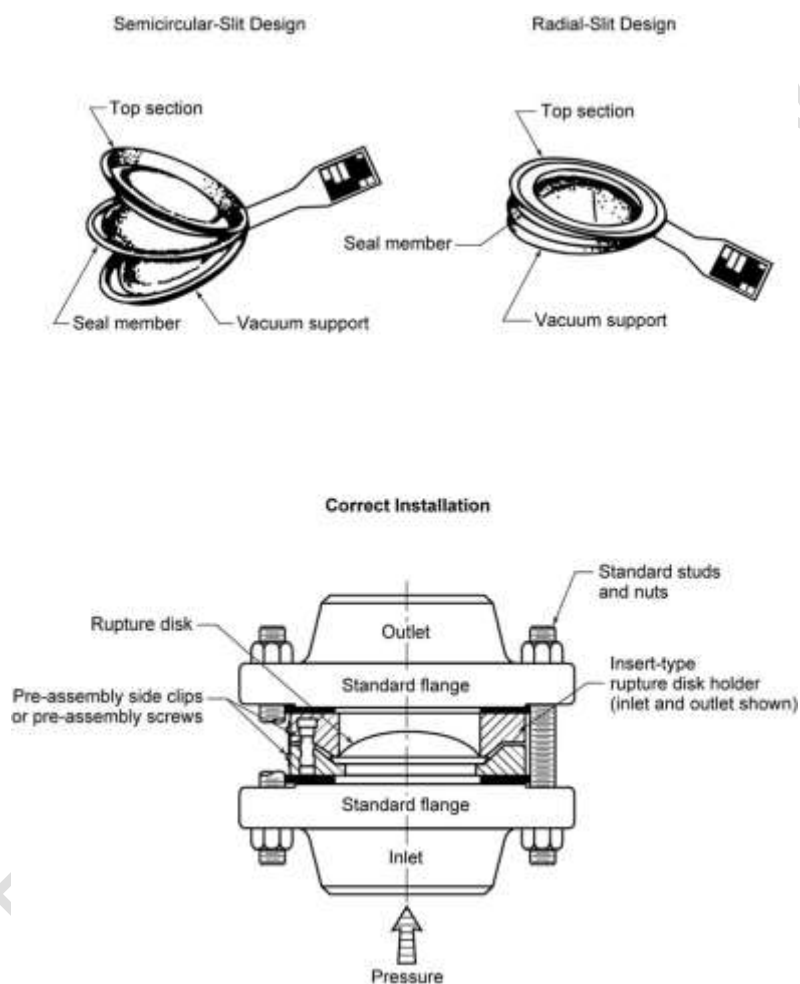


Figure 23—Forward-acting Composite Rupture Disk

4.3.3.4.2 The domed composite rupture disk is available in flat seat or angular seat design. The burst pressure is controlled by the combination of slits and tabs in the top section and a metallic or nonmetallic seal member under the top section. Composite rupture disks are generally available in burst pressures lower than those of forward-acting, nonscored rupture disks. Composite rupture disks may offer a longer service life as a result of the corrosion resistant properties of the seal material selected.

4.3.3.4.3 The slits and tabs in the top section provide a predetermined opening pattern for the rupture disk. If vacuum or backpressure conditions are present, composite disks can be furnished with a support to prevent reverse flexing (see Figure 23). A domed, composite rupture disk generally provides satisfactory service life when the operating pressure is 80 % or less of the marked burst pressure (80 % operating ratio). Consult the manufacturer for the actual recommended operating ratio for the specific disk under consideration.

4.3.3.4.4 A flat composite rupture disk is available for the protection of low-pressure vessels or the isolation of equipment such as exhaust headers or the outlet side of a PRV. This disk usually comes complete with gaskets and is designed to be installed between companion flanges rather than within a specific rupture disk holder. Flat composite rupture disks generally provide satisfactory service life when operating pressures are 50 % or less of the marked burst pressure (50 % operating ratio). Consult the manufacturer for the actual recommended operating ratio for the specific disk under consideration.

4.3.3.5 Reverse-acting Rupture Disks

4.3.3.5.1 A reverse-acting rupture disk typically is a formed (domed) solid metal disk designed to reverse and burst at a rated pressure applied on the convex side. Reverse-acting rupture disks are designed to open by such methods as shear knife blades, tooth rings, or scored lines (see Figure 24 and Figure 25).

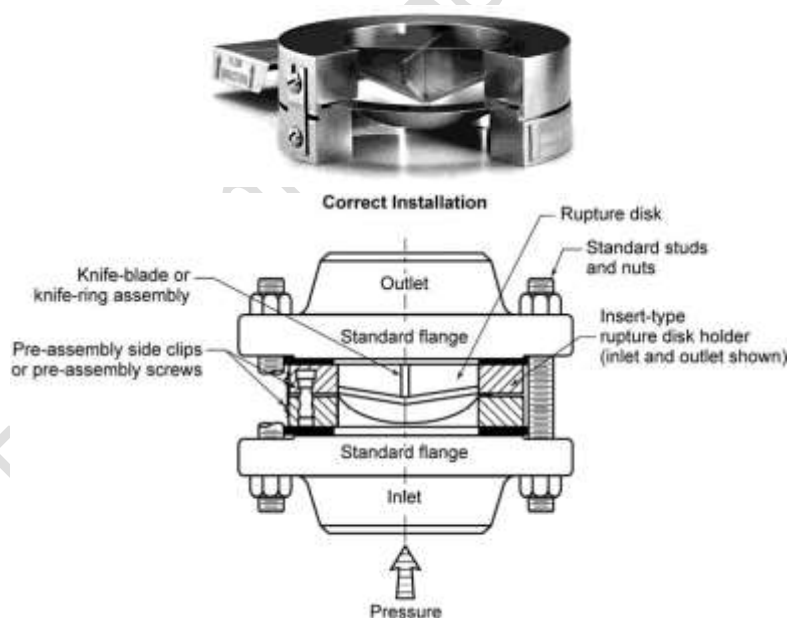


Figure 24—Reverse-acting Rupture Disk with Knife Blades

4.3.3.5.2 Reverse-acting rupture disks may be manufactured as nonfragmenting and are suitable for installation upstream of PRVs. These disks provide satisfactory service life when operating pressures are 90 % or less of marked burst pressure (90 % operating ratio). Some types of reverse-buckling disks are designed to be exposed to pressures up to 95 % of the marked burst pressure. Consult the manufacturer for the actual recommended operating ratio for the specific disk under consideration. Because a reverse-acting rupture disk is operated with pressure applied on the convex side, thicker disk materials may be used, thereby lessening the effects of corrosion, eliminating the need for vacuum support, and providing longer service life under pressure/vacuum cycling conditions and pressure fluctuations.

4.3.3.5.3 Knife blades installed in holders should be constructed of corrosion-resistant material and shall be inspected periodically to ensure sufficient sharpness to open the disk. Dull or damaged knife blades may prevent proper opening of the disk.

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4.3.3.6 Graphite Rupture Disks

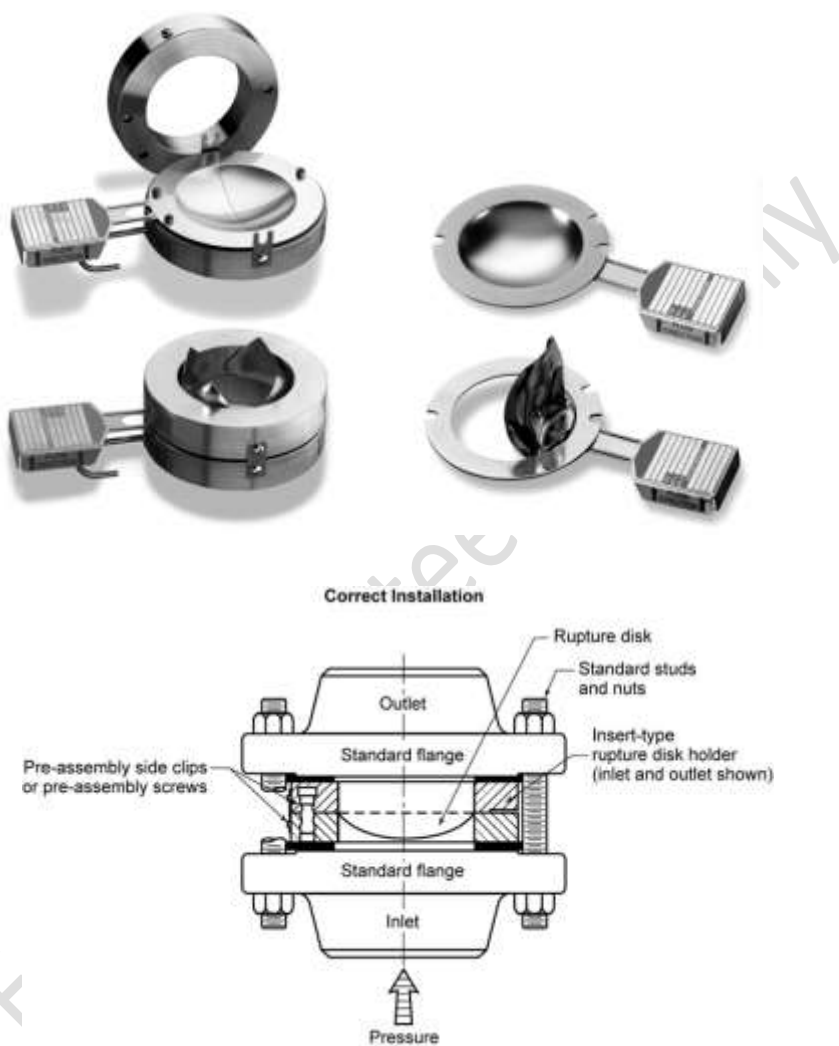


Figure 25—Reverse-acting Scored Rupture Disk

4.3.3.6.1 Graphite rupture disks are typically machined from a bar of fine graphite that has been impregnated with a sealing compound to seal the porosity of the graphite matrix (see Figure 26). The disk operates on a pressure differential across the center diaphragm or web portion of the disk. Graphite rupture disks provide a satisfactory service life when operating pressures are up to 80 % of the marked burst pressure (80 % operating ratio) and can be used in both liquid and vapor service. Consult the manufacturer for the actual recommended operating ratio for the specific disk under consideration.

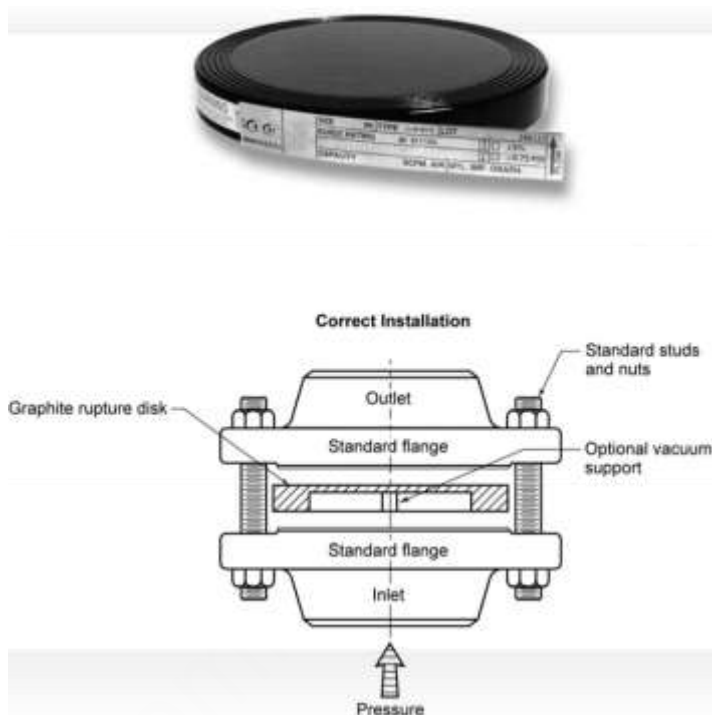


Figure 26—Graphite Rupture Disk

4.3.3.6.2 If vacuum or backpressure conditions are present, the disk can be furnished with a support to prevent reverse flexing. These disks have a random opening pattern and are considered fragmenting designs that are not suitable for installation upstream of a PRV. A metallic ring called armoring is often added to the outside diameter of the disk to help support uneven piping loads and minimize the potential for cracking of the outer graphite ring and blowout of process fluid.

4.3.4 Rupture Disk Holders

Rupture disk holders are used to clamp the rupture disk in place and effect a leak-tight, metal-to-metal seal. The seating area of the holders is typically unique to specific manufacturers and styles of rupture disks. Rupture disk holders are available in a variety of configurations, including full bolting, weldneck, threaded, etc. The most common configuration is the insert type that fits between standard pipe flanges,

and the outside diameter of the holder fits inside the flange studs. Rupture disk holders are available in a variety of materials and coatings. The specified materials selected-should ~~be selected to be~~ compatible with process fluids. The outlet holder material may be different from the inlet holder based on frequency and duration of exposure to process and downstream fluids.

4.3.5 Rupture Disk Accessories

A variety of accessories are available for use with rupture disks in various applications. The following provides a brief description of some of these components and their application.

- a) Rupture indicators and sensors—These devices typically provide an electrical or mechanical signal that can indicate the opening and/or leakage of a rupture disk or PRV.
- b) Alarm monitors—Alarm monitors are available to monitor rupture disk indicators or sensors. Alarm monitors are available with intrinsically safe circuits.
- c) Heat shields—Heat shields are generally installed upstream of the rupture disk in high-temperature processes to reduce the temperature at the rupture disk.
- d) Baffle plates—When venting to atmosphere, baffle plates can be used to deflect process discharge away from personnel and equipment. Baffle plates are also commonly used to assist in absorbing the recoil forces of an activating rupture disk.

4.3.6 Rupture Disk Selection and Specification

4.3.6.1 General

4.3.6.1.1 Rupture disk selection is based on the operating parameters of the system in which it is installed. These parameters are specified by the purchaser when purchasing rupture disks. These parameters include, but are not limited to:

- MAWP of vessel or piping;
- fluid state (vapor, liquid, or multiphase);
- range of operating pressures and operating temperature;
- cyclic or pulsating service;
- required relieving capacity or maximum resistance coefficient;
- corrosiveness of upstream and downstream environment;
- vacuum or backpressure conditions;
- location upstream or downstream of a PRV;
- single or multiple devices.

4.3.6.1.2 The following rupture disk parameters are selected or determined based on the above system operating parameters:

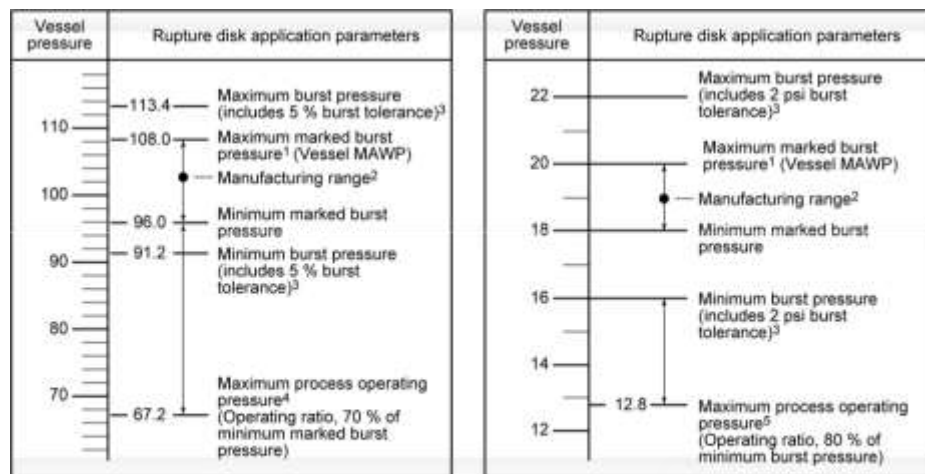
- burst pressure and temperature (see Figure 27);
- operating ratio, manufacturing design range, and burst tolerance (see Figure 28);
- disk type, material, and construction;
- disk and holder size (based on required flow per 5.12).

4.3.6.2 Rupture Disk Selection

4.3.6.2.1 Rupture disk types and basic performance characteristics are described in 4.3.3 and may be used as a basis for selection. The relationship between system pressures and the operating characteristics of a rupture disk device are shown in Figure 27. Since the marked burst pressure of a rupture disk can be anywhere within its manufacturing design range, the user is cautioned to make sure that the upper limit of the manufacturing design range does not exceed the MAWP of the equipment being protected. As shown in Figure 28, when the disk has a positive manufacturing design range, the marked burst pressure of the disk can actually be greater than the specified pressure.

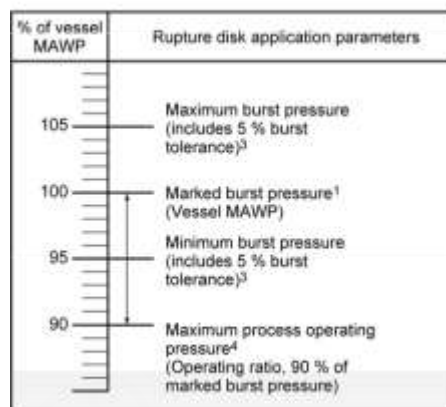
4.3.6.2.2 The marked burst pressure may be greater than or less than the specified burst pressure but shall be within the manufacturing design range. The user is cautioned to consider manufacturing design range, superimposed backpressure, and specified temperature when determining a specified burst pressure.

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A. Example of a rupture disk with a specified burst pressure of 100 psig, manufacturing range of +8/-4 %, burst tolerance of ± 5 %, and a 70 % operating ratio.

C. Example of a rupture disk with a specified burst pressure of 20 psig, manufacturing range of +0/-10 %, burst tolerance of ± 2 psi, and an 80 % operating ratio.



B. Example of a rupture disk with a specified burst pressure of 100 psig, zero manufacturing range, burst tolerance of ± 5 %, and a 90 % operating ratio.

NOTE 1 See Figure 19 for limits on marked burst pressure.

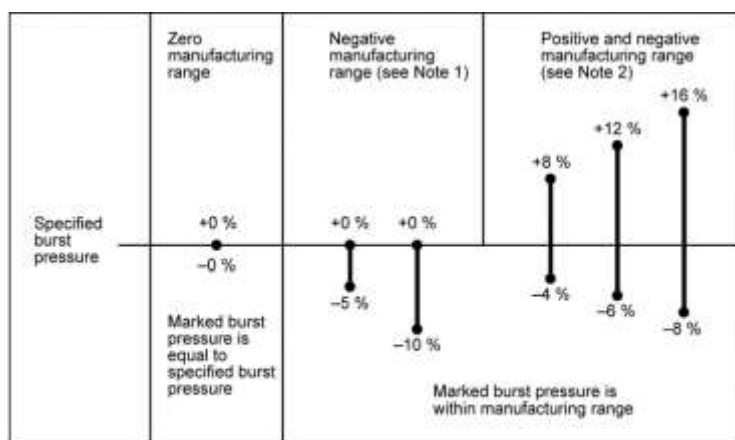
NOTE 2 Marked burst pressure may be any pressure within the manufacturing range, see Figure 28.

NOTE 3 For marked burst pressures above 40 psig, the burst tolerance is ± 5 %. For marked burst pressures at 40 psig and below, the burst tolerance is ± 2 psi.

NOTE 4 For marked burst pressures above 40 psig, the maximum process operating pressure is calculated by multiplying the minimum marked burst pressure by the operating ratio.

NOTE 5 For marked burst pressures at 40 psig and below, the maximum process operating pressure is calculated by subtracting the burst tolerance from the minimum marked burst pressure, then multiplying the difference by the operating ratio.

Figure 27—Rupture Disk Application Parameters Assuming No Superimposed Backpressure



NOTE 1 The marked burst pressure will not exceed the specified burst pressure.

NOTE 2 Positive manufacturing range may result in a marked burst pressure exceeding the specified burst pressure.

Figure 28—Common Types of Manufacturing Ranges and Corresponding Burst Pressure Marking

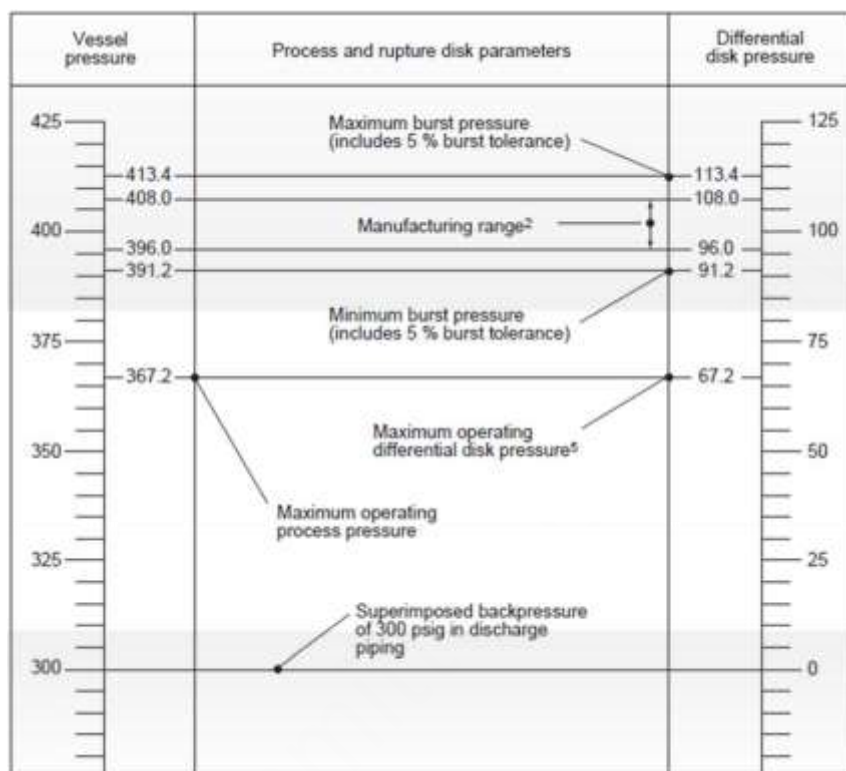
4.3.6.2.3 The maximum pressure at which a rupture disk may be marked to burst is the upper limit of its manufacturing design range. The minimum pressure at which a rupture disk may be marked to burst is the lower limit of its manufacturing design range. Figure 27 provides graphical examples of common relationships between burst pressure, manufacturing design range, burst tolerance, and operating pressure.

4.3.6.2.4 Rupture disk selection is an iterative and sometimes complex process. The procedure given below may be used for rupture disk selection where there is no superimposed backpressure. Consult the manufacturer for assistance if needed.

- Select the upper limit of the manufacturing design range. This is typically based on the MAWP of the protected equipment as determined by the ASME Code or process requirements. In some applications, such as in multiple or supplemental device installation (see 5.4.2 and 5.4.3), the upper limit of the manufacturing design range may exceed the MAWP of the protected equipment.
- Determine the specified burst pressure by subtracting the positive portion of the manufacturing design range, as listed in the manufacturer's catalog, from the upper limit of the manufacturing design range.
- Determine the lower limit of the manufacturing design range by subtracting the negative portion of the manufacturing design range, as listed in the manufacturer's catalog, from the specified burst pressure.
- Determine the operating ratio by dividing the maximum operating pressure by the lower limit of the manufacturing design range.
- When calculating the operating ratio for disks with specified burst pressures between 15 psig and 40 psig (103 kPag and 276 kPag), subtract the burst tolerance of 2 psi (14 kPa) from the lower limit of the manufacturing design range prior to calculating the operating ratio. Since some rupture disks are offered in extremely low pressures well below 15 psig (103 kPag), users are advised to verify burst tolerances and manufacturing design ranges applicable to those pressures.
- Select a rupture disk based on the specified burst pressure and the manufacturing design range, and compare the operating ratio with the manufacturer's maximum recommended operating ratio as listed in the product catalog. If the operating ratio exceeds the manufacturer's maximum recommended operating ratio, select a smaller manufacturing design range, if available, for that disk style or change disk style and repeat Steps a) through e).

4.3.6.2.5 Superimposed backpressure significantly complicates the design and selection process of the rupture disk device. Figure 29 provides an example of a rupture disk with superimposed backpressure. ~~The burst pressure shall include the superimposed backpressure when selecting the specified burst pressure and determining the effect on the operating ratio.~~ **Caution:** ~~The consequences shall be considered. Undesired disk activation could occur if in the event the superimposed backpressure is inadvertently reduced below that which was used to specify the disk, since this could result in undesired disk activation.~~

4.3.6.2.6 For most closed systems, the superimposed backpressure normally varies between some minimum and maximum pressure. For the particular rupture disk device being designed, the superimposed backpressure does not normally include the pressure caused by other relief devices venting into the closed system unless that pressure would cause the relief pressure to exceed the code allowed accumulated pressure. However, the backpressure, caused by the venting of other relief devices, still needs to be considered when specifying the disk and may result in additions such as a vacuum or backpressure support to protect the disk.



NOTE 1 This figure is an example of a rupture disk with a:

- a) specified burst pressure of 100 psi;
- b) manufacturing range of +8/-4 %;
- c) burst pressure tolerance of ± 5 %;
- d) operating ratio of 70 % ($0.7 \times 96.0 \text{ psi} = 67.2 \text{ psi}$);
- e) superimposed backpressure of 300 psig;
- f) vessel MAWP equal to or greater than 408 psig.

NOTE 2 The disk used in this figure is intended to be identical with the disk in Figure 27A. The disks are interchangeable. The disk in this figure (and in Figure 27A) may be marked anywhere in the manufacturing range, from 96 psi to 108 psi.

NOTE 3 The superimposed backpressure in this example is larger than normally encountered to amplify the difference between vessel pressure and differential pressure across the rupture disk.

NOTE 4 The differential disk pressure is equal to the vessel pressure minus the superimposed backpressure.

NOTE 5 The user is cautioned not to exceed the maximum operating differential disk pressure throughout the process cycle, including start-up and shutdown.

Figure 29—Rupture Disk Application Parameters with Superimposed Backpressure

4.3.6.3 Rupture Disk Device Specification

Accurately and completely documenting the process conditions and rupture disk device specifications is a key element in selecting the proper rupture disk. Annex A provides a rupture disk device specification sheet and step-by-step guidance for completing the specification sheet.

4.4 Pin-actuated Devices

4.4.1 General

Pin-actuated PRDs are nonreclosing devices consisting of a moving disc exposed to the pressure system, and an external mechanism housing a pin that is mechanically linked to the disc. Pins may be loaded in tension (breaking pins) or in compression (buckling pins; see Figure 30). The pin restrains the movement of the disc until the specified set pressure is reached. At this point, the pin fails and the disc opens.

4.4.2 Buckling Pin Devices

4.4.2.1 General

4.4.2.1.1 Buckling pin devices, as shown in Figure 30, are compression-loaded, pin-actuated devices and are the most extensively used type of pin-actuated device. Compression-loaded buckling pin devices are very stable and well suited to applications that have both cyclic operating conditions, and an operating pressure to set pressure ratio greater than or equal to 90 %.

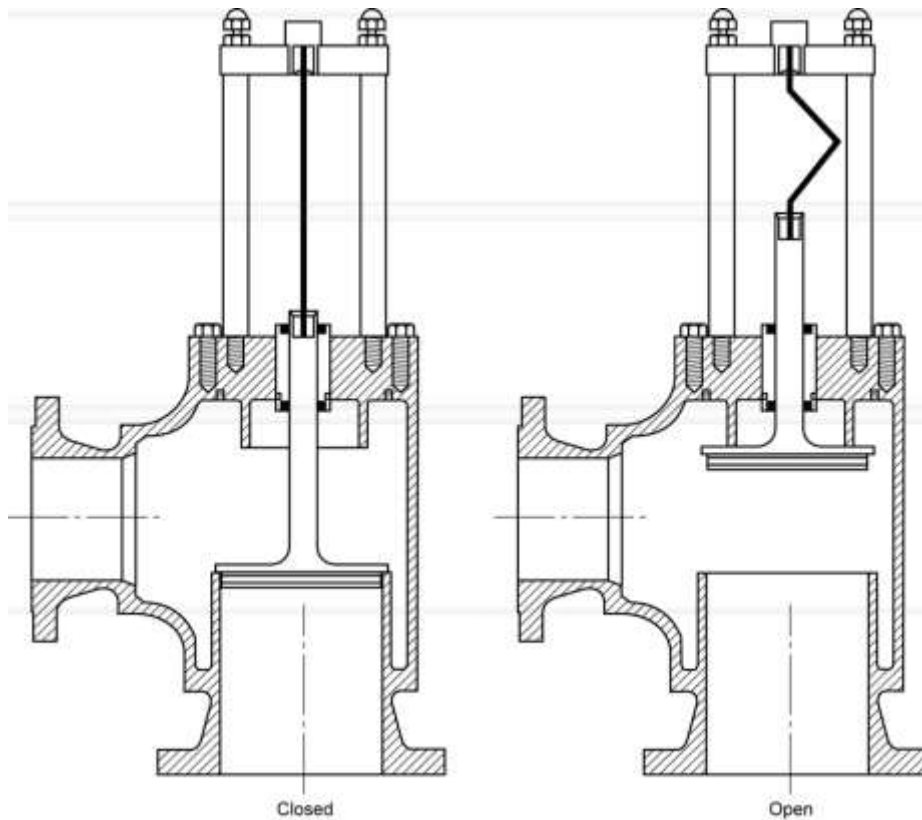


Figure 30—Buckling Pin Valve

4.4.2.1.2 Buckling pin devices may be sensitive to differential pressures. Operating conditions on both sides of the device need to be reviewed between the user and the manufacturer.

4.4.2.1.3 See UG-127(b) and UG-138 of the ASME Code for sizing, application, and minimum requirements for buckling pin devices.

4.4.2.2 Set Pressure and Temperature

4.4.2.2.1 The set pressure of the pin-actuated device should be determined by the user, and an agreed set pressure tolerance on either side of the nominal set pressure should be established with the manufacturer.

4.4.2.2.2 The wetted parts of the device shall be designed to meet the process temperature to ensure that acceptable materials are selected. However, since the pin is external to the process, the pin is not exposed to the process temperature conditions but rather to the external ambient conditions. Therefore, the pin shall be designed based on the external ambient temperature to ensure that the set pressure of the device is correctly established.

4.4.2.2.3 Compression-loaded buckling pins have a low sensitivity to temperature. However, if a pin device will see service over a wide range of ambient temperatures, or outside of an ambient temperature range, then advice concerning change in set pressure should be sought from the manufacturer. In some cases, it may be recommended to conduct specific temperature testing of pins before delivery of the device.

4.4.2.3 Leak Tightness

4.4.2.3.1 The buckling pin device typically uses elastomer seals. The seal material should be carefully chosen to satisfy both the chemical conditions and the anticipated service temperatures. It is recommended that the leak tightness of the device be tested per API 527 before shipment by the manufacturer.

4.4.2.3.2 If the application is vacuum service and/or backpressure exists, the manufacturer needs to be notified to ensure proper sealing under such conditions.

4.4.2.4 Marking and Tagging

The buckling pin device shall be clearly marked to indicate the direction of flow, set pressure, nominal size, serial number and model or type designation, and the manufacturer. Each pin, or tag attached to each pin, should be marked with manufacturer, lot number, device model or type, set pressure, and pin/device identifier. The lot number should appear on the manufacturer's certification report, together with the serial number of the device or the device identifier for which the pins have been calibrated.

4.4.3 Breaking Pin Devices

4.4.3.1 A breaking pin device is a nonreclosing PRD with a movable disc held in the closed position by a pin loaded in tension. When pressure reaches the set pressure of the device, the pin breaks and the disc opens. Breaking pin devices are generally used in combination with a PRV where valve tightness is of concern, for example, in corrosive or vibrating environments such as on fluid transport vessels.

4.4.3.2 Breaking pin devices are designed to operate at a specified differential pressure. If pressure is allowed to build up on the downstream side of the breaking pin device, the opening pressure will be increased. Therefore, the space between a breaking pin device and a PRV shall be provided with a gauge, trycock, free vent, or suitable telltale indicator to detect any buildup of pressure in that cavity (see API 520, Part II).

4.4.3.3 See UG-127(b) and UG-138 of the ASME *BPVC*, Section VIII, Division 1 for sizing, application, and minimum requirements for breaking pin devices.

4.5 Open Flow Paths or Vents

A flow path or vent that is open directly or indirectly to the atmosphere may be used as the sole relief device to protect vessels, piping, and other equipment from excessive pressure and/or vacuum. With proper analysis to determine the calculated capacity (see 5.13), open flow paths or vents can be specified for systems with vapor (gas) and/or liquid relief requirements.

4.6 Other Types of Devices

Other PRDs not described in this section are occasionally specified in refineries and related industries. Users should consult the manufacturer for information about designs and special applications.

5 Procedures for Sizing

5.1 Determination of Relief Requirements

5.1.1 To establish the size and design of a PRD for any application, the designer shall first determine the conditions for which overpressure protection may be required.

5.1.2 The contingencies that can cause overpressure shall be evaluated in terms of the pressures generated and the rates at which fluids are required to be relieved. The process flow diagram, material balance, piping and instrument diagrams, equipment specification sheets, and design basis for the facility are needed to calculate the individual relieving rates for each PRD. Process equipment vendor data are also helpful if available.

5.1.3 API 521 lists a number of common operational conditions for which overpressure protection may be required. This list is by no means complete; the design of each plant shall include any unique features in addition to those listed. API 521 provides a detailed discussion of relief requirements for these emergency operating conditions. API 521 also provides a detailed discussion of the relief requirements for the special case of fire.

5.1.35.1.4 [API 521 provides details for the determination of relief requirements.](#)

5.2 API Effective Area and Effective Coefficient of Discharge

5.2.1 PRVs may be initially sized using the equations presented in 5.6 through 5.11 as appropriate for vapors, gases, liquids, or two-phase fluids. These equations utilize effective coefficients of discharge and effective areas that are independent of any specific valve design. In this way, the designer can determine a preliminary PRV size.

5.2.2 The designer can use API 526 to select a PRV. API 526 is a purchase specification for steel flanged valves. This standard lists specific valve configurations specified by inlet/outlet size and flange configuration, materials of construction, pressure/temperature limits, inlet and outlet center to face dimensions, and effective orifice designation. When a valve is specified per this standard, the orifice size is expressed in terms of a letter designation ranging from the smallest, "D," to the largest, "T." An effective area is specified for each letter orifice.

5.2.3 Sections 5.6 through 5.11 provide sizing information that may be used for the initial selection of a PRV from the incremental D through T orifice sizes specified in API 526. The effective orifice areas listed in API 526 and the effective coefficient of discharge used for the initial selection are nominal values not directly related to a specific valve design.

5.2.4 The certified coefficient of discharge for a PRV, as determined per the applicable certification standards, is generally less than the effective coefficient of discharge used in API 520 (particularly for vapor service valves where the effective coefficient of discharge is 0.975). This is true of valves certified per the rules of the ASME Code, where the average coefficient from a series of valve test results is multiplied by 0.9 to establish a certified coefficient of discharge. For this reason, the actual orifice area for most valve designs is greater than the effective orifice area specified for that valve size per API 526. This allows the rated capacity of most valve designs to meet or exceed the effective capacity for preliminary sizing determined per the API 520 calculations.

5.2.5 The effective orifice area and the effective coefficient of discharge should not be used for final PRV selection. The actual orifice area and the certified coefficient of discharge ~~shall~~ should be used to verify the rated capacity of the PRV corrected for the actual overpressure. In no case shall an effective orifice area be used with a certified coefficient of discharge for calculating the capacity of a PRV. Similarly, an actual orifice area shall not be used in conjunction with an effective coefficient of discharge.

5.2.6 In summary, the effective orifice size and effective coefficient of discharge specified in API standards are assumed values intended for initial selection of a PRV size from configurations specified in API 526, independent of an individual valve manufacturer's design. In most cases, the actual orifice area and the certified coefficient of discharge for an API letter orifice valve are designed so that the rated capacity corrected for actual overpressure meets or exceeds the rated capacity calculated using the methods presented in API 520 (i.e. using the effective orifice area and effective coefficient of discharge). There are, however, a number of valve designs where this is not so. When the PRV is selected, therefore, the actual orifice area and certified coefficient of discharge for that valve should be used to verify the rated capacity of the selected valve, corrected for the actual overpressure, and to verify that the valve has sufficient capacity to satisfy the application.

5.3 Backpressure

5.3.1 General

5.3.1.1 Pressure existing at the outlet of a PRV is defined as backpressure. Regardless of whether the valve is vented directly to atmosphere or the discharge is piped to a collection system, the backpressure may affect the operation of the PRV. Effects due to backpressure may include variations in opening pressure, reduction in flow capacity, instability, or a combination of all three.

5.3.1.2 Backpressure that is present at the outlet of a PRV when it is required to operate is defined as superimposed backpressure. This backpressure can be constant if the valve outlet is connected to a process vessel or system that is held at a constant pressure. In most cases, however, the superimposed backpressure will be variable as a result of changing conditions existing in the discharge system.

5.3.1.3 Backpressure that develops in the discharge system after the PRV opens is defined as built-up backpressure. Built-up backpressure occurs due to pressure drop in the discharge system as a result of flow from the PRV. Short tail pipes that vent directly to the atmosphere typically result in lower built-up backpressures than long discharge systems. However, choked flow can occur at the outlet of even short tail pipes vented directly to atmosphere, resulting in a high built-up backpressure. For this reason, the built-up backpressure shall be evaluated for all systems, regardless of the outlet piping configuration.

5.3.1.4 The magnitude of the backpressure that exists at the outlet of a PRV, after it has opened, is the total of the superimposed and the built-up backpressure.

5.3.2 Effects of Superimposed Backpressure on Pressure-relief Valve Opening

5.3.2.1 Superimposed backpressure at the outlet of a conventional spring-loaded PRV acts to hold the valve disc closed with a force additive to the spring force. The actual spring setting can be reduced by an amount equal to the superimposed backpressure to compensate for this (see 4.2.3 for a discussion of CDTF). However, if the amount of variable superimposed backpressure is small, a conventional valve could be used, provided:

- a) the bench set pressure (CDTF) has been appropriately compensated for superimposed backpressure, and
- b) the maximum pressure during relief does not exceed the code allowed limits for accumulation in the equipment being protected.

5.3.2.2 Balanced PRVs (see 4.2.1.3) utilize a bellows or piston to minimize or eliminate the effect of superimposed backpressure on set pressure. Many pilot-operated PRVs have pilots that are vented to atmosphere or are balanced to maintain set pressure in the presence of variable superimposed backpressure. Balanced spring-loaded or pilot-operated PRVs should be considered if the superimposed backpressure is variable.

5.3.2.3 For example, conventional valves are often used when the outlet is piped into a relief header without compensating the set pressures for the superimposed backpressure caused by other relieving devices. This approach can be used, provided the allowable accumulation is not exceeded during the release.

5.3.3 Effects of Backpressure on Pressure-relief Valve Operation and Flow Capacity

5.3.3.1 Conventional Pressure-relief Valves

5.3.3.1.1 Conventional PRVs show unsatisfactory performance when excessive backpressure develops during a relief incident, due to the flow through the valve and outlet piping. The built-up backpressure opposes the lifting force that is holding the valve open.

5.3.3.1.2 Excessive built-up backpressure can cause the valve to operate in an unstable manner. This instability may occur as flutter or chatter. Chatter refers to the abnormally rapid reciprocating motion of the PRV disc where the disc contacts the PRV seat during cycling. This type of operation may cause damage to the valve and interconnecting piping. Flutter is similar to chatter except that the disc does not come into contact with the seat during cycling.

5.3.3.1.3 In a conventional PRV application, the allowable built-up backpressure is equal to the allowable overpressure. Both of these values are referenced to the PRV's set pressure, not to its CDP. See Equation (1).

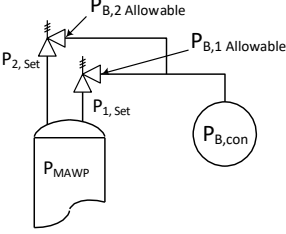
$$P_{B, \text{Allowable}} = AOP = MAWP \times (1 + \%AA) - P_{\text{set}} \quad (1)$$

where

$P_{B, \text{Allowable}}$	is the allowable built-up backpressure, psi;
AOP	is the allowable overpressure, psi;
MAWP	is the maximum allowable working pressure, psig;
%AA	is the allowable accumulation (%);
P_{set}	is the PRV set pressure, psig.

5.3.3.1.4 An example of the allowable backpressures for a multiple relief device installation, where the PRV is set lower than the MAWP and compensated for constant superimposed backpressure, is provided in Table 3.

Table 3—Example of Allowable Backpressures for a Multiple Conventional Pressure-relief Valve Installation

		Scenarios	
		Nonfire	Fire
$P_{B,CON}$	psig	25	25
$CDTP_1$	psig	70	70
$CDTP_2$	psig	75	75
$P_{1,set}$	psig	95	95
$P_{2,set}$	psig	100	100
%AA		16.0 %	21.0 %
MAWP	psig	100	100
AOP_1	psi	21	26
AOP_2	psi	16	21
$P_{B,1 \text{ Allowable}}$	psi	21.0	26.0
$P_{B,2 \text{ Allowable}}$	psi	16.0	21.0

Nomenclature:

- $P_{B,CON}$ = constant superimposed backpressure
- CDTP = cold differential test pressure (no temperature correction included in the example)
- P_{set} = set pressure
- %AA = % allowable accumulation
- MAWP = maximum allowable working pressure
- AOP = allowable overpressure
- $P_{B,Allowable}$ = allowable built-up backpressure (excluding constant superimposed backpressure)

5.3.3.1.5 When the downstream piping is designed within the above backpressure criteria, no backpressure capacity correction ($K_b = 1.0$) is required in the valve sizing equations, for gases at critical flow or for liquids. When the backpressure is expected to exceed these specified limits, a balanced or pilot-operated PRV should be specified.

NOTE The built-up backpressure limitations discussed above do not necessarily apply to valves with open bonnet design due to the nature of their design. Consult the manufacturer for guidance.

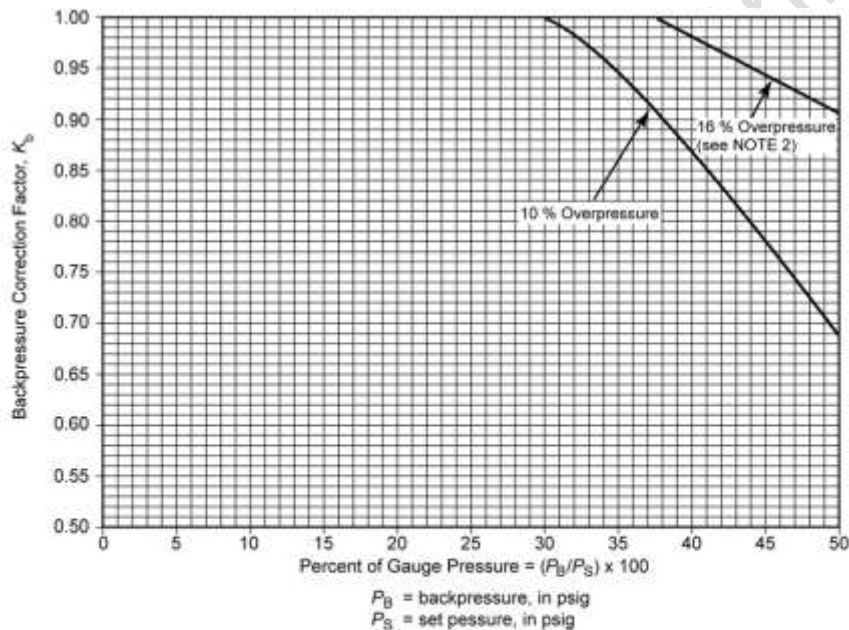
5.3.3.2 Balanced Pressure-relief Valves

5.3.3.2.1 A balanced PRV can be used where the built-up backpressure is too high for conventional PRVs or where the superimposed backpressure varies widely compared to the set pressure. Balanced valves can typically be applied where the total backpressure (superimposed plus built-up) does not exceed approximately 50 % of the set pressure. The specific manufacturer can will provide the backpressure limitation of a particular valve design. With a balanced valve, high backpressure will tend to produce a closing force on the unbalanced portion of

the disc. This force may result in a reduction in lift and an associated reduction in flow capacity. Capacity correction factors, called backpressure correction factors, are provided by manufacturers to account for this reduction in flow. Typical backpressure correction factors may be found for compressible fluid service in Figure 31 and for incompressible fluid (liquid) service in Figure 32. For liquid service applications, the factor shown in Figure 32 is applicable for all overpressures. For compressible fluid service, however, the factor may vary depending on whether the allowable overpressure is 10 %, 16 %, or 21 %.

NOTE The backpressure correction factors from Figure 31 and Figure 32 are suitable for the preliminary sizing procedures found in this document. If more accurate calculations are required, they should be completed using the manufacturers' actual charts along with the certified coefficient of discharge and actual orifice area (see 5.2.6).

In some applications, set pressure may be significantly less than MAWP allowing for overpressures in excess of those specified above. In such cases, the manufacturer should be consulted for guidance.

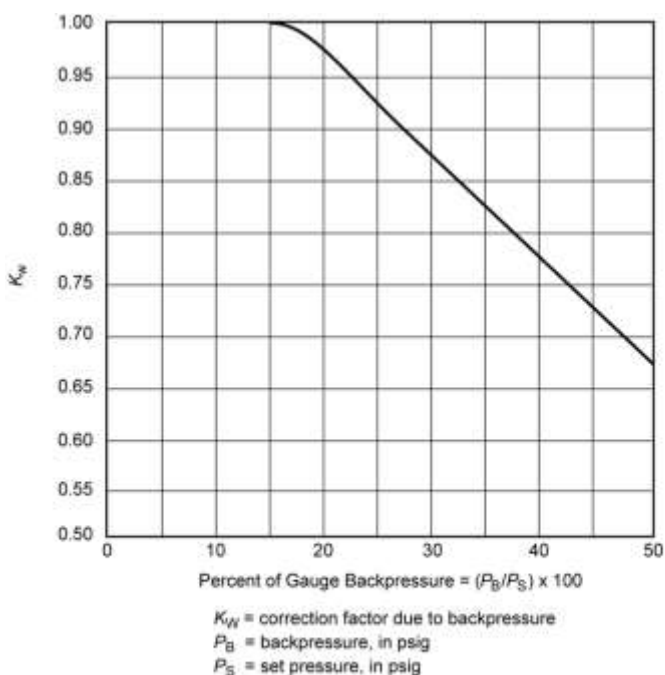


NOTE 1 The curves above represent a compromise of the values recommended by a number of relief valve manufacturers and may be used when the make of the valve or the critical flow pressure point for the vapor or gas is unknown. When the make of the valve is known, the manufacturer should be consulted for the correction factor. These curves are for set pressures of 50 psig and above. They are limited to backpressure below critical flow pressure for a given set pressure. For set pressures below 50 psig or for subcritical flow, the manufacturer must be consulted for values of K_b .

NOTE 2 See 5.3.3.

NOTE 3 For 21 % overpressure, K_b equals 1.0 up to $P_B/P_S = 50$ %.

Figure 31—Backpressure Correction Factor, K_b , for Balanced Spring-loaded Pressure-relief Valves (Vapors and Gases)



NOTE The curve above represents values above recommended by various manufacturers. This curve may be used when the manufacturer is not known. Otherwise, the manufacturer should be consulted for the applicable correction factor.

Figure 32—Capacity Correction Factor, K_W , Due to Backpressure on Balanced Spring-loaded Pressure-relief Valves in Liquid Service

5.3.3.2.2 In most applications, the allowable overpressure is 10 % and the backpressure correction factor for 10 % overpressure shall be used. In the special case of multiple valve installations, the low set valve may operate at overpressures up to 16 %. A backpressure correction factor for 16 % overpressure may be used for that low set valve. The high set valve is actually operating at a maximum overpressure of 10 % (assuming the high set valve is set at 105 % of the MAWP), however, and the backpressure correction factor for 10 % overpressure shall be used for that high set valve. A supplemental valve used for an additional hazard created by exposure to fire (see 5.4.3.4) may be set to open at 10 % above MAWP. In this case, the backpressure correction factor for 10 % overpressure shall be used because the valve is actually operating at 10 % overpressure, even though the accumulation is at 21 %. When calculating the rated capacity for the first (nonfire) valve at 21 % overpressure, a backpressure correction factor of 1.0 may be used for backpressures up to 50 % of set pressure (see Figure 31, NOTE 3).

5.3.3.2.3 The backpressure correction factors specified in Figure 31 and Figure 32 are applicable to balanced spring-loaded PRVs with backpressures up to 50 % of set pressure.

5.3.3.2.4 When backpressures in compressible fluid applications (does not include multiphase applications) exceed approximately 50 % of set pressure, the flow is subcritical. Nonetheless, the K_b curves (both those in Figure 31 and Manufacturer provided curves) are intended to be used with the critical flow formulas found in 5.6.3, even if the flow is subcritical. The curves in Figures 31 and 32 cannot be extrapolated and therefore the PRV manufacturer shall be consulted when backpressures exceed approximately 50 % of set pressure to obtain backpressure correction factors or any special limitations on valve operation.

5.3.3.3 Pilot-operated Pressure-relief Valves

For pilot-operated PRVs, the valve lift is not affected by backpressure. For compressible fluids at critical flow conditions, a backpressure correction factor of 1.0 should be used for pilot-operated PRVs.

5.3.4 Effects of Backpressure and Header Design on Pressure-relief Valve Sizing and Selection

5.3.4.1 For conventional PRVs connected to a flare header, there are several considerations that affect PRV sizing and selection. The PRV discharge line and flare header shall be designed so that the built-up backpressure does not exceed the allowable limits as specified in 5.3.3. In addition, the flare header system shall be designed in order to ensure that the superimposed backpressure, caused by venting or relief from another source, will not prevent PRVs from opening at a pressure adequate to protect equipment per the ASME Code or applicable code. Once the superimposed, built-up, and total backpressures are calculated based on a pressure drop analysis of the discharge system, they should be specified on the datasheet for the PRV under consideration.

5.3.4.2 Total backpressure may affect the capacity of the PRV. Sizing a balanced PRV is a two-step process. The PRV is sized using a preliminary backpressure correction factor, K_b . The correction factor could either be set initially equal to 1.0 or can be based on an assumed total backpressure. Once a preliminary valve size and capacity is determined, the discharge line and header size can be determined based on pressure drop calculations. The final size, capacity, backpressure, and backpressure correction factor, K_b , can then be calculated. The backpressure should be included on the datasheet for the PRV under consideration.

5.3.4.3 For a pilot-operated PRV, neither the set pressure nor the capacity is typically affected by backpressure, for compressible fluids at critical flow conditions. Tail pipe and flare header sizing are typically based on other considerations.

5.3.4.4 Outlet pipe sizing and flare header sizing are discussed in more detail in API 520, Part II and API 521.

5.4 Relieving Pressure

5.4.1 General

5.4.1.1 Relieving pressure, shown as P_1 in the various sizing equations, is the inlet pressure of the PRD at relieving conditions. The relieving pressure is the total of set pressure plus overpressure. The examples cited in this section for the determination of relieving pressure refer to PRVs; however, they are also applicable to nonreclosing PRDs (see Figure 15 and Figure 19 for pressure level relationships for these types of devices). The effects of inlet pressure drop on specification of relieving pressure for PRV sizing can be neglected if the inlet pressure drop does not exceed 3 % of set pressure.

5.4.1.2 The allowable overpressure is established from the accumulation permitted by the applicable code. The allowable overpressure may vary for different applications depending on the relationship of the set pressure to the MAWP of the vessel or system that is protected.

5.4.1.3 The discussion in this section generally cites the ASME Code as the applicable code. Unless stated otherwise, citations refer only to Section VIII of the ASME Code. The designer should be aware of revisions to the ASME Code. If pertinent revisions occur, the discussion in this section should be adjusted accordingly by the designer. Adjustments may also be required by the designer if other (non-ASME) codes apply.

5.4.1.4 Sections 5.4.2 through 5.4.3 discuss methods of determining the relieving pressure for PRDs. In applications where these paragraphs do not apply, alternate accumulations are sometimes specified, as required by other codes or the equipment manufacturer.

5.4.1.5 Table 4 summarizes the maximum accumulation and set pressure for PRDs specified in accordance with the ASME Code.

5.4.2 Operating Contingencies

5.4.2.1 Single Device Installation

5.4.2.1.1 In accordance with the requirements of the ASME Code, accumulated pressure shall be limited to 110 % of the MAWP in vessels that are protected by a single PRD sized for operating (nonfire) contingencies. The set pressure of the device shall not exceed the MAWP.

Table 4—Set Pressure and Accumulation Limits for Pressure-relief Devices

Contingency	Single Device Installations		Multiple Device Installations	
	Maximum Set Pressure %	Maximum Accumulated Pressure %	Maximum Set Pressure %	Maximum Accumulated Pressure %
Nonfire Case				
First relief device	100	110	100	116
Additional device(s)	—	—	105	116
Fire Case				
First relief device	100	121	100	121
Additional device(s)	—	—	105	121
Supplemental device	—	—	110	121
NOTE All values are percentages of the MAWP.				

5.4.2.1.2 The allowable accumulation is 3 psi (21 kPa) when the MAWP is between 15 psig and 30 psig (103 kPag and 207 kPag) in accordance with the ASME Code.

5.4.2.1.3 Table 5 shows an example determination of relieving pressure for a single device whose set pressure is less than or equal to the vessel's MAWP.

Table 5—Example Determination of Relieving Pressure for Operating Contingencies for a Single Relief Device Installation

Characteristic	Value
Relief Device Set Pressure Equal to MAWP	
Protected vessel MAWP, psig (kPag)	100.0 (689)
Maximum accumulated pressure, psig (kPag)	110.0 (758)
Relief device set pressure, psig (kPag)	100.0 (689)
Allowable overpressure, psi (kPa)	10.0 (69)
Barometric pressure, psia (kPa)	14.7 (101)
Relieving pressure, P_1 , psia (kPa)	124.7 (860)
Relief Device Set Pressure Less Than MAWP	
Protected vessel MAWP, psig (kPag)	100.0 (689)
Maximum accumulated pressure, psig (kPag)	110.0 (758)
Relief device set pressure, psig (kPag)	90.0 (621)
Allowable overpressure, psi (kPa)	20.0 (138)
Barometric pressure, psia (kPa)	14.7 (101)
Relieving pressure, P_1 , psia (kPa)	124.7 (860)
NOTE The above examples assume a barometric pressure of 14.7 psia (101.3 kPa). The barometric pressure corresponding to site elevation should be used.	

5.4.2.2 Multiple Device Installation

5.4.2.2.1 A multiple device installation requires the combined capacity of two or more PRDs to alleviate a given overpressure contingency.

5.4.2.2.2 In accordance with the requirements of the ASME Code, accumulated pressure shall be limited to 116 % of the MAWP in vessels that are protected by multiple PRDs sized for operating (nonfire) contingencies. The set pressure of the first device shall not exceed the MAWP. The set pressure of the additional device or devices shall not exceed 105 % of the MAWP.

5.4.2.2.3 The allowable accumulation is 4 psi (28 kPa) when the MAWP is between 15 psig and 30 psig (103 kPag and 207 kPag).

5.4.2.2.4 Table 6 shows an example determination of the relieving pressure for a multiple device installation in which the set pressure of the first device is equal to the MAWP of the vessel, and the set pressure of the additional device is 105 % of the vessel's MAWP.

Table 6—Example Determination of Relieving Pressure for Operating Contingencies for a Multiple Relief Device Installation

Characteristic	Value
First Relief Device (Set Pressure Equal to MAWP)	
Protected vessel MAWP, psig (kPag)	100.0 (689)
Maximum accumulated pressure, psig (kPag)	116.0 (800)
Relief device set pressure, psig (kPag)	100.0 (689)
Allowable overpressure, psi (kPa)	16.0 (110)
Barometric pressure, psia (kPa)	14.7 (101)
Relieving pressure, P_1 , psia (kPa)	130.7 (901)
Additional Relief Device (Set Pressure Equal to 105 % of MAWP)	
Protected vessel MAWP, psig (kPag)	100.0 (689)
Maximum accumulated pressure, psig (kPag)	116.0 (800)
Relief device set pressure, psig (kPag)	105.0 (724)
Allowable overpressure, psi (kPa)	11.0 (76)
Barometric pressure, psia (kPa)	14.7 (101)
Relieving pressure, P_1 , psia (kPa)	130.7 (901)
NOTE The above examples assume a barometric pressure of 14.7 psia (101.3 kPa). The barometric pressure corresponding to site elevation should be used.	

5.4.3 Fire Contingencies

5.4.3.1 General

5.4.3.1.1 In accordance with the requirements of the ASME Code, accumulated pressure shall be limited to 121 % of the MAWP in vessels that are protected by PRDs sized for fire contingencies. This applies to single, multiple, and supplemental device installations.

5.4.3.1.2 Single or multiple devices sized for fire may also be utilized for relieving requirements attributed to operating (nonfire) contingencies, provided that the constraint of 110 % and 116 % (of the MAWP) accumulated pressure for the nonfire contingencies is observed.

5.4.3.2 Single Device Installation

5.4.3.2.1 Where a vessel is protected by a single device sized for fire, the set pressure shall not exceed the MAWP.

5.4.3.2.2 Table 7 shows an example determination of relieving pressure for a single device whose set pressure is less than or equal to the vessel's MAWP.

Table 7—Example Determination of Relieving Pressure for Fire Contingencies for a Single Relief Device Installation

Characteristic	Value
Relief Device Set Pressure Equal to MAWP	
Protected vessel MAWP, psig (kPag)	100.0 (689)
Maximum accumulated pressure, psig (kPag)	121.0 (834)
Relief device set pressure, psig (kPag)	100.0 (689)
Allowable overpressure, psi (kPa)	21.0 (145)
Barometric pressure, psia (kPa)	14.7 (101)
Relieving pressure, P_1 , psia (kPa)	135.7 (936)
Relief Device Set Pressure Less Than MAWP	
Protected vessel MAWP, psig (kPag)	100.0 (689)
Maximum accumulated pressure, psig (kPag)	121.0 (834)
Relief device set pressure, psig (kPag)	90.0 (621)
Allowable overpressure, psi (kPa)	31.0 (214)
Barometric pressure, psia (kPa)	14.7 (101)
Relieving pressure, P_1 , psia (kPa)	135.7 (936)
NOTE The above examples assume a barometric pressure of 14.7 psia (101.3 kPa). The barometric pressure corresponding to site elevation should be used.	

5.4.3.3 Multiple Device Installation

5.4.3.3.1 A multiple device installation requires the combined capacity of two or more devices to alleviate overpressure. The set pressure of the first device to open shall not exceed the MAWP. The set pressure of the last device to open shall not exceed 105 % of the MAWP.

5.4.3.3.2 Table 8 shows an example determination of relieving pressure for a multiple device installation in which the set pressure of the first device is equal to the vessel's MAWP, and the set pressure of the additional device is 105 % of the vessel's MAWP.

5.4.3.4 Supplemental Device Installation

5.4.3.4.1 A supplemental device installation provides relieving capacity for an additional hazard created by exposure to fire or other unexpected sources of external heat. The set pressure of a supplemental device for fire shall not exceed 110 % of the MAWP.

Table 8—Example Determination of Relieving Pressure for Fire Contingencies for a Multiple Relief Device Installation

Characteristic	Value
First Relief Device (Set Pressure Equal to MAWP)	
Protected vessel MAWP, psig (kPag)	100.0 (689)
Maximum accumulated pressure, psig (kPag)	121.0 (834)
Relief device set pressure, psig (kPag)	100.0 (689)
Allowable overpressure, psi (kPa)	21.0 (145)
Barometric pressure, psia (kPa)	14.7 (101)
Relieving pressure, P_1 , psia (kPa)	135.7 (936)
Additional Relief Device (Set Pressure Equal to 105 % of MAWP)	
Protected vessel MAWP, psig (kPag)	100.0 (689)
Maximum accumulated pressure, psig (kPag)	121.0 (834)
Relief device set pressure, psig (kPag)	105.0 (724)
Allowable overpressure, psi (kPa)	16.0 (110)
Barometric pressure, psia (kPa)	14.7 (101)
Relieving pressure, P_1 , psia (kPa)	135.7 (936)
NOTE The above examples assume a barometric pressure of 14.7 psia (101.3 kPa). The barometric pressure corresponding to site elevation should be used.	

5.4.3.4.2 Supplemental devices are used only in addition to devices sized for operating (nonfire) contingencies.

5.4.3.4.3 Table 9 shows an example determination of relieving pressure for a supplemental device installation in which the set pressure of the first (nonfire) device does not exceed the vessel's MAWP (see 5.4.1 for determination of relieving pressure), and the set pressure of the supplemental device is 110 % of the vessel's MAWP.

5.5 Development of Sizing Equations

5.5.1 The assumption of isentropic nozzle flow for a homogeneous fluid provides a standard theoretical framework for PRV sizing equations. See Annex B for more information regarding the assumptions and/or simplifications that are made to the isentropic nozzle flow equation, which have resulted in the analytical equations presented in 5.6 through 5.11.

5.5.2 Annex C provides additional information on the development of the sizing equations for two-phase flow.

Table 9—Example Determination of Relieving Pressure for Fire Contingencies for a Supplemental Valve Installation

Characteristic	Value
First Relief Device (Set Pressure Equal to MAWP)	
Protected vessel MAWP, psig (kPag)	100.0 (689)
Maximum accumulated pressure, psig (kPag)	121.0 (834)
Relief device set pressure, psig (kPag)	100.0 (689)
Allowable overpressure, psi (kPa)	21.0 (145)
Barometric pressure, psia (kPa)	14.7 (101)
Relieving pressure, P_1 , psia (kPa)	135.7 (936)
Supplemental Relief Device (Set Pressure Equal to 110 % of MAWP)	
Protected vessel MAWP, psig (kPag)	100.0 (689)
Maximum accumulated pressure, psig (kPag)	121.0 (834)
Relief device set pressure, psig (kPag)	110.0 (758)
Allowable overpressure, psi (kPa)	11.0 (76)
Barometric pressure, psia (kPa)	14.7 (101)
Relieving pressure, P_1 , psia (kPa)	135.7 (936)
NOTE The above examples assume a barometric pressure of 14.7 psia (101.3 kPa). The barometric pressure corresponding to site elevation should be used.	

5.6 Sizing for Gas or Vapor Relief

5.6.1 Applicability

The sizing equations for PRDs in vapor or gas service provided in this section assume that the pressure-specific volume relationship along an isentropic path is well described by the expansion relation:

$$Pv^k = \text{constant} \quad (2)$$

where

P is the pressure, psia (Pa);

v is the specific volume at P , ft³/lb (m³/kg);

k is the ideal gas specific heat ratio at the relieving temperature (see B.3.2.2).

Years of experience with this basis indicates that this approach has provided satisfactory results over a wide range of conditions. Commonly, for real gas behavior, the nonideality of the fluid has been taken into consideration through the use of the compressibility factor Z and the use of the isentropic expansion exponent n in place of the ideal gas k (see B.3.1). ~~If a calculated Z is not available, a value of 1 may be conservatively assumed.~~ However, the validity of the use of the ideal gas k may diminish as the vapor or gas approaches the thermodynamic critical locus, such as at very high pressures or as the vapor, gas, or supercritical fluid exhibits more liquid-like behavior. One indicator of this behavior is when the reduced volume (v_R) of the fluid is less than two (2.0) at the inlet pressure ^[17]. The reduced volume is expressed as:

$$v_R = v / v_c \quad (3)$$

where

v is the specific volume of the relief fluid at the inlet to the device, ft³/lb (m³/kg);

v_R is the reduced volume, dimensionless;

v_c is the critical specific volume of the relief fluid, ft³/lb (m³/kg).

Although many simulation tools can provide the critical specific volume, in some cases it may be necessary to calculate it from other critical fluid properties. In these cases, the determination of the critical volume should include the critical compressibility factor to ensure that the nonideality of the fluid at this point is considered, as in the following equation:

$$v_c = Z_c \times R_u \times T_c / (M \times P_c) \quad (4)$$

where

Z_c is the critical compressibility factor;

T_c is the critical temperature, °R (K);

P_c is the critical pressure, psia (Pa);

M is the molecular weight, lb/lb-mole (kg/kg-mole);

R_u is the universal gas constant = 10.73 psia·ft³/lb-mole·°R (8.314 Pa·m³/kg-mole·K).

NOTE The determination of the critical properties of a mixture is complex, and the user should use appropriate thermodynamic techniques. The use of a mole fraction average approximation is not appropriate.

Another indicator that the vapor or gas may be in one of these regions is a compressibility factor, Z , less than approximately 0.8^[16], or greater than approximately 1.1. It is important to note that the replacement of the ideal gas specific heat ratio, k , with the calculated isentropic expansion coefficient, n , in the gas sizing equation (see B.3.1) may not be sufficient to correct for the deviation from ideal gas behavior the further this deviation progresses.

There are two expressions used to derive the analytical gas sizing equation: the isentropic expansion relationship as given in Equation (2), and the critical flow pressure ratio as given in Equation (5). The assumptions used in both expressions contribute to poor prediction of the maximum mass flux and relief area in the gas sizing equations when the conditions do not reflect an ideal gas.

In such cases, use of the direct integration method (see Annex B) using an appropriate thermodynamic model is recommended to provide more accurate results^[16]. To ensure the most appropriate sizing results, users should establish the limits of applicability for their own systems.

5.6.2 Critical Flow Behavior

5.6.2.1 If a compressible gas is expanded across a nozzle, an orifice, or the end of a pipe, its velocity and specific volume increase with decreasing downstream pressure. For a given set of upstream conditions (using the example of a nozzle), the mass rate of flow through the nozzle will increase until a limiting velocity is reached in the nozzle. It can be shown that the limiting velocity is the velocity of sound in the flowing fluid at that location. The flow rate that corresponds to the limiting velocity is known as the critical flow rate.

5.6.2.2 The absolute pressure ratio of the pressure at the nozzle exit at sonic velocity (P_{cf}) to the inlet pressure (P_1) is called the critical pressure ratio. P_{cf} is known as the critical flow pressure.

5.6.2.3 Under critical flow conditions, the actual pressure at the nozzle exit of the PRD cannot fall below the critical flow pressure even if a much lower pressure exists downstream. At critical flow, the expansion from nozzle pressure to downstream pressure takes place irreversibly with the energy dissipated in turbulence into the surrounding fluid.

5.6.2.4 The critical flow pressure ratio in absolute units may be estimated using the ideal gas relationship in Equation (5), provided the expansion law, $P_1 V^k = \text{constant}$, is a good approximation of the pressure/specific volume relationship [18]:

$$\frac{P_{cf}}{P_1} = \left[\frac{2}{k+1} \right]^{\frac{k}{k-1}} \quad (5)$$

where

P_{cf} is the critical flow nozzle pressure;

P_1 is the upstream relieving pressure;

k is the ratio of specific heats (C_p/C_v) for an ideal gas at relieving temperature.

The ideal gas specific heat ratio is independent of pressure. Most process simulators will provide real gas specific heats that should not be used in the above equation because the real gas specific heat ratio does not provide a good representation of the isentropic expansion coefficient (see Annex B).

5.6.2.5 The sizing equations for PRDs in vapor or gas service fall into two general categories depending on whether the flow is critical or subcritical. If the pressure downstream of the nozzle is less than, or equal to, the critical flow pressure, P_{cf} , then critical flow will occur, and the procedures in 5.6.3 should be applied. If the downstream pressure exceeds the critical flow pressure, P_{cf} , then subcritical flow will occur, and the procedures in 5.6.4 or 5.6.5 should be applied. See Table 10 for typical critical flow pressure ratio values.

Table 10—Properties of Gases

Gas	Molecular Weight	Ideal Gas Specific Heat Ratio ($k = C_p/C_v$) at 60 °F and One Atmosphere	Ideal Gas Critical Flow Pressure Ratio at 60 °F and One Atmosphere	Ideal Gas Specific Gravity at 60 °F and One Atmosphere	Critical Constants		Condensation Temperature One Atmosphere °F (°C)
					Pressure psia (kPa)	Temperature °F (°C)	
Methane ^a	16.04	1.31	0.54	0.554	673 (4640)	−116 (−82)	−259 (−162)
Ethane ^a	30.07	1.19	0.57	1.058	718 (4950)	90 (32)	−128 (−89)
Ethylene ^a	28.03	1.24	0.57	0.969	742 (5116)	50 (10)	−155 (−104)
Propane ^a	44.09	1.13	0.58	1.522	617 (4254)	206 (97)	−44 (−42)
Propylene	42.08	1.15	0.58	1.453	667 (4599)	197 (92)	−54 (−48)
Isobutane ^a	58.12	1.10	0.59	2.007	529 (3647)	273 (134)	11 (−12)
n-Butane ^a	58.12	1.09	0.59	2.007	551 (3799)	304 (151)	31 (−1)
1-Butene	56.10	1.11	0.59	1.937	586 (4040)	296 (147)	21 (−6)
Isopentane ^a	72.15	1.08	0.59	2.491	483 (3330)	369 (187)	82 (28)
n-Pentane ^a	72.15	1.08	0.59	2.491	490 (3378)	386 (197)	97 (36)
1-Pentene ^a	70.13	1.08	0.59	2.421	510 (3930)	377 (192)	86 (30)
n-Hexane ^a	86.18	1.06	0.59	2.973	437 (3013)	454 (234)	156 (69)
Benzene	78.11	1.12	0.58	2.697	714 (4923)	552 (289)	176 (80)
n-Heptane ^a	100.20	1.05	0.60	3.459	397 (2737)	513 (267)	209 (98)
Toluene	92.13	1.09	0.59	3.181	590 (4068)	604 (318)	231 (111)
n-Octane ^a	114.22	1.05	0.60	3.944	362 (2496)	564 (296)	258 (126)
n-Nonane	128.23	1.04	0.60	4.428	332 (2289)	610 (321)	303 (151)
n-Decane	142.28	1.03	0.60	4.912	304 (2096)	632 (333)	345 (174)
Air	28.96	1.40	0.53	1.000	547 (3771)	−221 (−141)	−313 (−192)
Ammonia	17.03	1.30	0.53	0.588	1636 (11,280)	270 (132)	−28 (−33)
Carbon dioxide	44.01	1.29	0.55	1.519	1071 (7384)	88 (31)	−109 (−78)
Hydrogen	2.02	1.41	0.52	0.0696	188 (1296)	−400 (−240)	−423 (−253)
Hydrogen sulfide	34.08	1.32	0.53	1.176	1306 (9005)	213 (101)	−77 (−61)
Sulfur dioxide	64.04	1.27	0.55	2.212	1143 (7881)	316 (158)	14 (−10)
Steam	18.01	1.33	0.54	0.622	3206 (22,104)	706 (374)	212 (100)

^a Estimated.

5.6.3 Sizing for Critical Flow

5.6.3.1 General

5.6.3.1.1 PRDs in gas or vapor service that operate at critical flow conditions (see 5.6.2) may be sized using Equation (6) through Equation (11). Each of the equations may be used to calculate the required discharge area, A , to achieve a required flow rate through a PRD. A PRV that has a discharge area equal to or greater than the calculated value of A is then chosen for the application. Note that the equations presented here can be used for preliminary sizing when effective values for area and coefficient of discharge are used and for final sizing when actual areas and certified coefficients of discharge are used.

In USC units:

$$A = \frac{W}{CK_d P_1 K_b K_c} \sqrt{\frac{TZ}{M}} \quad (6)$$

$$A = \frac{V \sqrt{TZM}}{6.32 CK_d P_1 K_b K_c} \quad (7)$$

$$A = \frac{V \sqrt{TZG_v}}{1.175 CK_d P_1 K_b K_c} \quad (8)$$

In SI units:

$$A = \frac{W}{CK_d P_1 K_b K_c} \sqrt{\frac{TZ}{M}} \quad (9)$$

$$A = \frac{2.676 \times V \sqrt{TZM}}{CK_d P_1 K_b K_c} \quad (10)$$

$$A = \frac{14.41 \times V \sqrt{TZG_v}}{CK_d P_1 K_b K_c} \quad (11)$$

where

A is the required discharge area of the device, in.² (mm²) (see 5.2);

W is the required flow through the device, lb/h (kg/h);

C is a function of the ratio of the ideal gas specific heats ($k = C_p/C_v$) of the gas or vapor at inlet relieving temperature.

The coefficient, C , is determined as follows.

In USC units [for use in Equation (6) through Equation (8) only]:

$$C = 520 \sqrt{k \left(\frac{2}{k+1} \right)^{\frac{(k+1)}{(k-1)}}} \quad (12)$$

In SI units [for use in Equation (9) through Equation (11) only]:

$$C = 0.03948 \sqrt{k \frac{2}{k+1} \frac{(k+1)}{(k-1)}} \quad (13)$$

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The ideal gas specific heat ratio is independent of pressure. Most process simulators will provide real gas specific heats that should not be used in the above equation; otherwise, the PRD may be undersized. The value of C can be obtained from Figure 33, Figure 34, or Table 11. For ideal gases, where k cannot be established, it is suggested that a conservative value of C equal to 315 (0.0239) be used. The units for C are as follows.

In USC units:

$$\frac{\sqrt{\text{lb}_m \times \text{lb-mole} \times ^\circ\text{R}}}{\text{lb}_f \times \text{hr}}$$

In SI units:

$$\frac{\sqrt{\text{kg} \times \text{kg-mole} \times \text{K}}}{\text{mm}^2 \times \text{hr} \times \text{kPa}}$$

K_d is the coefficient of discharge; for preliminary sizing, use the following effective values:

- 0.975, when a PRV is installed with or without a rupture disk in combination;
- 0.62, when a PRV is not installed and sizing is for a rupture disk in accordance with 5.12.1.2;

P_1 is the upstream relieving pressure, psia (kPa); this is the set pressure plus the allowable overpressure (see 5.4) plus atmospheric pressure;

K_b is the capacity correction factor due to backpressure; this can be obtained from the manufacturer's literature or estimated for preliminary sizing from Figure 31. The backpressure correction factor applies to balanced bellows valves only. For conventional and pilot-operated valves, use a value for K_b equal to 1.0 (see 5.3). See 5.6.4 for conventional valve applications with backpressure of a magnitude that will cause subcritical flow;

K_c is the combination correction factor for installations with a rupture disk upstream of the PRV (see 5.12.2);

- equals 1.0 when a rupture disk is not installed;
- equals 0.9 when a rupture disk is installed in combination with a PRV and the combination does not have a certified value;

T is the relieving temperature of the inlet gas or vapor, $^\circ\text{R}(^\circ\text{F} + 460)$ [$\text{K}(^\circ\text{C} + 273)$];

Z is the compressibility factor for the deviation of the actual gas from a perfect gas, evaluated at inlet relieving conditions;

M is the molecular weight of the gas or vapor at inlet relieving conditions; various handbooks carry tables of molecular weights of materials, but the composition of the flowing gas or vapor is seldom the same as that listed in tables. This value should be obtained from the process data. Table 10 lists values for some common fluids, $\text{lb}_m/\text{lb-mole}$ ($\text{kg}/\text{kg-mole}$);

V is the required flow through the device, SCFM (Nm^3/min);

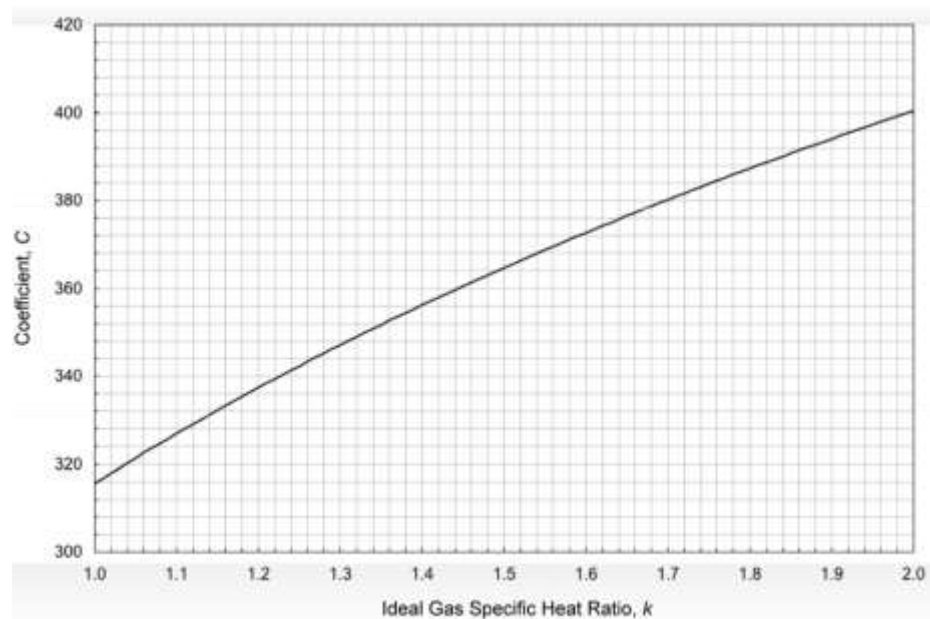
G_v is the specific gravity of gas at standard conditions referred to air at standard conditions (normal conditions); in other words, $G_v = 1.00$ for air at 14.7 psia and 60 $^\circ\text{F}$ (101.325 kPa and 0 $^\circ\text{C}$).

Table 11—Values of Coefficient C

k	C		k	C		k	C		k	C	
	USC	SI		USC	SI		USC	SI		USC	SI
1.00	315	0.0239	1.26	343	0.0261	1.51	365	0.0277	1.76	384	0.0292
1.01	317	0.0240	1.27	344	0.0261	1.52	366	0.0278	1.77	385	0.0292
1.02	318	0.0241	1.28	345	0.0262	1.53	367	0.0279	1.78	386	0.0293
1.03	319	0.0242	1.29	346	0.0263	1.54	368	0.0279	1.79	386	0.0293
1.04	320	0.0243	1.30	347	0.0263	1.55	369	0.0280	1.80	387	0.0294
1.05	321	0.0244	1.31	348	0.0264	1.56	369	0.0280	1.81	388	0.0294
1.06	322	0.0245	1.32	349	0.0265	1.57	370	0.0281	1.82	389	0.0295
1.07	323	0.0246	1.33	350	0.0266	1.58	371	0.0282	1.83	389	0.0296
1.08	325	0.0246	1.34	351	0.0266	1.59	372	0.0282	1.84	390	0.0296
1.09	326	0.0247	1.35	352	0.0267	1.60	373	0.0283	1.85	391	0.0297
1.10	327	0.0248	1.36	353	0.0268	1.61	373	0.0283	1.86	391	0.0297
1.11	328	0.0249	1.37	353	0.0268	1.62	374	0.0284	1.87	392	0.0298
1.12	329	0.0250	1.38	354	0.0269	1.63	375	0.0285	1.88	393	0.0298
1.13	330	0.0251	1.39	355	0.0270	1.64	376	0.0285	1.89	393	0.0299
1.14	331	0.0251	1.40	356	0.0270	1.65	376	0.0286	1.90	394	0.0299
1.15	332	0.0252	1.41	357	0.0271	1.66	377	0.0286	1.91	395	0.0300
1.16	333	0.0253	1.42	358	0.0272	1.67	378	0.0287	1.92	395	0.0300
1.17	334	0.0254	1.43	359	0.0272	1.68	379	0.0287	1.93	396	0.0301
1.18	335	0.0254	1.44	360	0.0273	1.69	379	0.0288	1.94	397	0.0301
1.19	336	0.0255	1.45	360	0.0274	1.70	380	0.0289	1.95	397	0.0302
1.20	337	0.0256	1.46	361	0.0274	1.71	381	0.0289	1.96	398	0.0302
1.21	338	0.0257	1.47	362	0.0275	1.72	382	0.0290	1.97	398	0.0302
1.22	339	0.0258	1.48	363	0.0276	1.73	382	0.0290	1.98	399	0.0303
1.23	340	0.0258	1.49	364	0.0276	1.74	383	0.0291	1.99	400	0.0303
1.24	341	0.0259	1.50	365	0.0277	1.75	384	0.0291	2.00	400	0.0304
1.25	342	0.0260	—	—	—	—	—	—	—	—	—

NOTE 1 Values of C in USC units apply to Equation (6), Equation (7), and Equation (8) only.

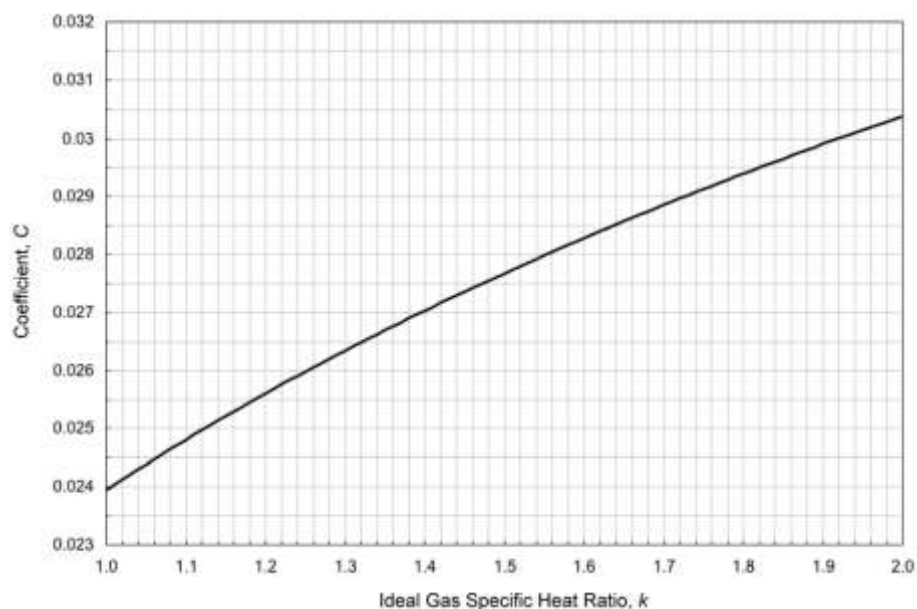
NOTE 2 Values of C in SI units apply to Equation (9), Equation (10), and Equation (11) only.



NOTE 1 The equation for this curve is $C = 520 \sqrt{k \left(\frac{2}{k+1} \right)^{\frac{(k+1)}{(k-1)}}$

NOTE 2 The units for the coefficient C are $\frac{\sqrt{\text{lb}_m \times \text{lb} - \text{mole} \times ^\circ\text{R}}}{\text{lb}_f \times \text{hr}}$

Figure 33—Curve for Evaluating Coefficient C in the Flow Equation from the Specific Heat Ratio, Assuming Ideal Gas Behavior (USC Units)



NOTE 1 The equation for this curve is $C = \frac{0.03948}{k+1} \sqrt{k \frac{2}{k-1} \frac{(k+1)}{(k-1)}}$

NOTE 2 The units for the coefficient C are $\frac{\sqrt{\text{kg} \times \text{kg} - \text{mole} \times K}}{\text{mm}^2 \times \text{hr} \times \text{kPa}}$

Figure 34—Curve for Evaluating Coefficient C in the Flow Equation from the Specific Heat Ratio, Assuming Ideal Gas Behavior (SI Units)

5.6.3.1.2 Whereas ideal gas law behavior (with compressibility factor, Z , included) is generally acceptable for the majority of refinery applications, Annex B should be referred to for unusual situations in which deviation from ideal behavior is significant.

5.6.3.2 Example 1

5.6.3.2.1 In this example, the following relief requirements are given.

- Required hydrocarbon vapor flow, W , caused by an operational upset, of 53,500 lb/h (24,270 kg/h).
- The hydrocarbon vapor is a 50/50 (by mole) mixture of n-butane (C_4) and propane (C_3). The molecular weight of the vapor, M , is 51.
- Relieving temperature, T , of 627 °R (167 °F) (348 K).
- PRV set at 75 psig (517 kPag), which is the design pressure of the equipment.
- Backpressure of 14.7 psia (0 psig) [101.325 kPa (0 kPag)].
- Overpressure of 10 %.

5.6.3.2.2 In this example, the following data are derived.

- a) Relieving pressure, P_1 , of $75 \times 1.1 + 14.7 = 97.2$ psia (670 kPa).
- b) Calculated compressibility, Z , of 0.90 (if a calculated compressibility is not available, a Z value of 1.0 should be used).
- c) Critical flow pressure (from Table 10) of $97.2 \times 0.585 = 56.9$ psia (42.2 psig) (392 kPa).

NOTE Since the backpressure [0 psig (0 kPag)] is less than the critical flow pressure [42.2 psig (291 kPag)], the PRV sizing is based on the critical flow equation [see Equation (6) and 5.6.1 and 5.6.2].

- d) $C_p/C_v = k$ (from Table 10) of 1.11. From Table 11, $C = 328$ (0.0249).

NOTE For this example problem, k was obtained from Table 10 at standard conditions, which ~~will~~ could result in a conservative answer. If the k value is known at the relieving temperature, use this value instead. In this case, the ideal gas specific heat ratio is a good approximation of the isentropic exponent for the purposes of this calculation. See Annex B for further discussion.

- e) Capacity correction due to backpressure, K_b , of 1.0.
- f) Capacity correction for rupture disk, $K_c = 1.0$.

5.6.3.2.3 For preliminary sizing, the effective coefficient of discharge, K_d , of 0.975 can be used. The size of a single PRV is calculated using Equation (6) or Equation (9) as follows.

In USC units:

$$A = \frac{53,500 \cdot 328}{\times 0.975 \times 97.2 \times 1.0 \times 1.0} \sqrt{\frac{627 \times 0.90}{51}} = 5.73 \text{ in.}^2 \quad (14)$$

In SI units:

$$A = 0.0249 \times \frac{24,270}{\times 0.975 \times 670 \times 1.0 \times 1.0} \sqrt{\frac{348 \times 0.90}{51}} = 3698 \text{ mm}^2 \quad (15)$$

5.6.3.2.4 See API 526 for selection of the proper orifice size. API 526 provides standard effective orifice areas in terms of letter designations. For this example, a "P" size orifice was selected since it has an effective orifice area of 6.38 in.² (4116 mm²). ~~(Alternatively, a combination of two or more valves could be selected to provide the relief area.)~~

5.6.3.2.5 A completed PRV specification sheet for this example is provided in Figure 35 (a blank specification sheet is provided in Annex D).

SPRING-LOADED PRESSURE-RELIEF VALVE SPECIFICATION SHEET		Sheet Number _____ Page _____ of _____	
		Requisition Number _____	
		Job Number _____	
		Date _____	
		Revision Number _____	
		By _____	
GENERAL			
1. Item Number: <i>Example 1</i>		3. Service, Line, or Equip. Number: _____	
2. Tag Number: _____		4. Design Code or Standard: _____	
BASIS OF SELECTION			
5. Code: ASME VIII <input checked="" type="checkbox"/> Stamp Required: Yes <input checked="" type="checkbox"/> No <input type="checkbox"/>		7. Fire <input type="checkbox"/> Other <input checked="" type="checkbox"/> Specify: _____	
Other <input type="checkbox"/> Specify: _____		8. Rupture Disk: Yes <input type="checkbox"/> No <input checked="" type="checkbox"/>	
6. Comply with API 526: Yes <input checked="" type="checkbox"/> No <input type="checkbox"/>			
VALVE DESIGN			
9. Design Type: <i>XXXX</i>		13. Bonnet Type: Open <input type="checkbox"/> Closed <input checked="" type="checkbox"/>	
Conventional <input checked="" type="checkbox"/> Bellows <input type="checkbox"/> Balanced Piston <input type="checkbox"/>		14. Seat Type: Metal-to-Metal <input checked="" type="checkbox"/> Resilient <input type="checkbox"/>	
10. Trim Type: Liquid <input type="checkbox"/> Vapor <input checked="" type="checkbox"/> Dual <input type="checkbox"/>		15. Seat Tightness: API 527 <input checked="" type="checkbox"/>	
11. Restricted Lift: Yes <input type="checkbox"/> No <input checked="" type="checkbox"/>		Other <input type="checkbox"/> Specify: _____	
12. Nozzle Type: Full <input checked="" type="checkbox"/> Semi <input type="checkbox"/>			
Other <input type="checkbox"/> Specify: _____			
CONNECTIONS			
16. Inlet Size: <i>4</i> Rating: <i>150</i> Facing: <i>RP</i>		18. Other <input type="checkbox"/> Specify: _____	
17. Outlet Size: <i>6</i> Rating: <i>150</i> Facing: <i>RF</i>			
MATERIALS			
19. Body: _____		25. Spring: _____ Washer: _____	
20. Bonnet: _____		26. Bellows: <i>N/A</i>	
21. Seat (Nozzle): _____ Disk: _____		27. Balanced Piston: <i>N/A</i>	
22. Resilient Seal: _____		28. Comply with NACE: Yes <input type="checkbox"/> No <input checked="" type="checkbox"/>	
23. Guide: _____		29. Internal Gasket Materials: _____	
24. Adjusting Ring(s): _____		30. Other <input type="checkbox"/> Specify: _____	
ACCESSORIES			
31. Cap: Screwed <input type="checkbox"/> Bolted <input checked="" type="checkbox"/>		34. Bug Screen: Yes <input type="checkbox"/> No <input checked="" type="checkbox"/>	
32. Lifting Lever: Plain <input type="checkbox"/> Packed <input type="checkbox"/> None <input checked="" type="checkbox"/>		35. Other <input type="checkbox"/> Specify: _____	
33. Test Gag: Yes <input type="checkbox"/> No <input checked="" type="checkbox"/>			
SERVICE CONDITIONS			
36. Fluid and State: <i>Hydrocarbon Vapor</i>		45. Operating Temperature and Units: <i>100 °F</i>	
37. Required Capacity per Valve and Units: <i>53,500 lb/hr</i>		46. Relieving Temperature and Units: <i>167 °F</i>	
38. Mass Flux and Basis: _____		47. Built-up Backpressure and Units: _____	
39. Molecular Weight or Specific Gravity: <i>51</i>		48. Superimposed Backpressure and Units: <i>0 psig</i>	
40. Viscosity at Flowing Temperature and Units: <i>--</i>		49. Cold Differential Test Pressure and Units: _____	
41. Operating Pressure and Units: <i>50 psig</i>		50. Allowable Overpressure in Percent or Units: <i>10</i>	
42. Set Pressure and Units: <i>75 psig</i>		51. Compressibility Factor, Z: <i>0.90</i>	
43. Blowdown: Standard <input checked="" type="checkbox"/> Other <input type="checkbox"/>		52. Ratio of Specific Heats: <i>1.11</i>	
44. Latent Heat of Vaporization and Units: _____			
SIZING AND SELECTION			
53. Calculated Orifice Area (in square inches): <i>5.73</i>		56. Manufacturer: <i>*</i>	
54. Selected Effective Orifice Area (in square inches): <i>6.38</i>		57. Model Number: <i>*</i>	
55. Orifice Designation (letter): <i>P</i>		58. Vendor Calculations Required: Yes <input checked="" type="checkbox"/> No <input type="checkbox"/>	
GENERAL NOTES			
59. _____			

NOTE The user should indicate items to be completed by the manufacturer with an asterisk (*).

Figure 35—Sample of Completed Pressure-relief Valve Specification Sheet

5.6.4 Sizing for Subcritical Flow: Gas or Vapor

5.6.4.1 Conventional and Pilot-operated Pressure-relief Valves

When the ratio of backpressure to inlet pressure exceeds the critical pressure ratio P_{ct}/P_1 , the flow through the PRD is subcritical (see 5.6.2). Equation (16) through Equation (21) may be used to calculate the required discharge area for a conventional PRV that has its spring setting adjusted to compensate for superimposed backpressure. Equation (16) through Equation (21) may also be used for sizing a pilot-operated PRV. Note that the equations presented here can be used for preliminary sizing when effective values for area and coefficient of discharge are used and for final sizing when actual areas and certified coefficients of discharge are used.

In USC units:

$$A = \frac{W}{735 \times F_2 K_d K_c} \sqrt{\frac{TZ}{M \times P_1(P_1 - P_2)}} \quad (16)$$

$$A = \frac{V}{4645 \times F_2 K_d K_c} \sqrt{\frac{TZM}{P_1(P_1 - P_2)}} \quad (17)$$

$$A = \frac{V}{864 \times F_2 K_d K_c} \sqrt{\frac{TZG_v}{P_1(P_1 - P_2)}} \quad (18)$$

In SI units:

$$A = \frac{17.9 \times W}{F_2 K_d K_c} \sqrt{\frac{TZ}{M \times P_1(P_1 - P_2)}} \quad (19)$$

$$A = \frac{47.95 \times V}{F_2 K_d K_c} \sqrt{\frac{TZM}{P_1(P_1 - P_2)}} \quad (20)$$

$$A = \frac{258 \times V}{F_2 K_d K_c} \sqrt{\frac{TZG_v}{P_1(P_1 - P_2)}} \quad (21)$$

where

A is the required discharge area of the device, in.² (mm²) (see 5.2);

W is the required flow through the device, lb/h (kg/h);

F_2 is the coefficient of subcritical flow; see Figure 36 for values, or use Equation (22).

$$F_2 = \sqrt{\frac{\left(\frac{k}{k-1} \right) \left(\frac{2}{k} \right) \left[1 - r^{\left(\frac{k-1}{k} \right)} \right]}{\left(\frac{k}{k-1} \right) \left[1 - r \right]}} \quad (22)$$

- k is the ratio of the specific heats (C_p/C_v) for an ideal gas at relieving temperature; the ideal gas specific heat ratio is independent of pressure. Most process simulators can provide real gas specific heats, which should not be used in Equation (22) because the real gas specific heat ratio does not provide a good representation of the isentropic expansion coefficient (see Annex B);
- r is the ratio of backpressure to upstream relieving pressure, P_2/P_1 ;
- K_d is the coefficient of discharge; for preliminary sizing, use the following effective values:
- 0.975, when a PRV is installed with or without a rupture disk in combination;
 - 0.62, when a PRV is not installed and sizing is for a rupture disk in accordance with 5.12.1.2;
- K_c is the combination correction factor for installations with a rupture disk upstream of the PRV (see 5.12.2); use the following values for the combination correction:
- 1.0, when a rupture disk is not installed;
 - 0.9, when a rupture disk is installed in combination with a PRV and the combination does not have a certified value;
- T is the relieving temperature of the inlet gas or vapor, $^{\circ}\text{R}(^{\circ}\text{F} + 460)$ [$\text{K}(^{\circ}\text{C} + 273)$];
- Z is the compressibility factor for the deviation of the actual gas from a perfect gas, evaluated at relieving inlet conditions;
- M is the molecular weight of the gas or vapor; various handbooks carry tables of molecular weights of materials, but the composition of the flowing gas or vapor is seldom the same as that listed in the tables; this value may be obtained from the process data; Table 10 lists values for some common fluids, lbm/lb-mole (kg/kg-mole);
- P_1 is the upstream relieving pressure, psia (kPa); this is the set pressure plus the allowable overpressure (see 5.4) plus atmospheric pressure;
- P_2 is the backpressure, psia (kPa);
- V is the required flow through the device, SCFM (Nm^3/min);
- G_v is the specific gravity of gas at standard conditions referred to air at standard conditions (normal conditions), i.e. $G_v = 1.00$ for air at 14.7 psia and 60 $^{\circ}\text{F}$ (101.325 kPa and 0 $^{\circ}\text{C}$).

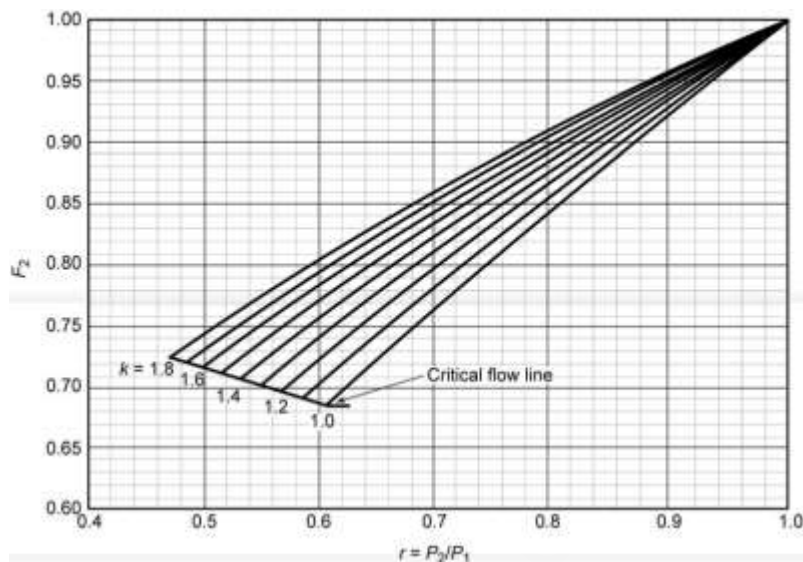


Figure 36—Values for F_2 for Subcritical Flow

5.6.4.2 Example 2

5.6.4.2.1 In this example, the following relief requirements are given.

- Required hydrocarbon vapor flow, W , caused by an operational upset, of 53,500 lb/h (24,270 kg/h).
- The hydrocarbon vapor is a 50/50 (by mole) mixture of n-butane (C_4) and propane (C_3). The molecular weight of the vapor, M , is 51.
- Relieving temperature, T , of 627 °R (167 °F) (348 K).
- PRV set at 75 psig (517 kPag), which is the design pressure of the equipment.
- Constant backpressure of 55 psig (379 kPa).
- For a conventional valve, the spring setting of the valve is adjusted according to the amount of constant superimposed backpressure obtained. In this example, the CDTP is 20 psig (138 kPa).
- Overpressure of 10 %.

5.6.4.2.2 In this example, the following data are derived.

- Relieving pressure, P_1 , of $75 \times 1.1 + 14.7 = 97.2$ psia (670 kPa).
- Calculated compressibility, Z , of 0.90 (if a calculated compressibility is not available, a value for Z of 1.0 should be used).

- c) Critical backpressure (from Table 10) of $97.2 \times 0.585 = 56.9$ psia (42.2 psig) [392 kPa (291 kPag)].
- d) Since the backpressure [55 psig (379 kPag)] is greater than the critical backpressure [42.2 psig (291 kPag)], the PRV sizing is based on the subcritical flow equation [see Equation (16)].
- e) Permitted built-up backpressure of $0.10 \times 75 = 7.5$ psi (51.7 kPa).
- f) The actual built-up backpressure was used.
- g) [Permitted Total](#) backpressure of $55 + 7.5 + 14.7 = 77.2$ psia (532 kPa).
- h) $C_p/C_v = k$ (from Table 10) of 1.11.
- i) For this example problem, k was obtained from Table 10 at standard conditions.
- j) $P_2/P_1 = 77.2/97.2 = 0.794$.
- k) Coefficient of subcritical flow, F_2 , of 0.86 (from Figure 36).
- l) Capacity correction for rupture disk, $K_c = 1.0$.

5.6.4.2.3 For preliminary sizing, the effective coefficient of discharge, K_d , of 0.975 can be used. The size of a single PRV is derived from Equation (16) as follows:

$$A = \frac{53,500}{735 \times 0.86 \times 0.975 \times 1.0} \sqrt{\frac{627 \times 0.9}{51 \times 97.2 \times (97.2 - 77.2)}} = 6.55 \text{ in.}^2 \text{ (4226 mm}^2\text{)} \quad (23)$$

5.6.4.2.4 For selection of the proper orifice size, see API 526. For this example, a "Q" size orifice was selected since it has an effective orifice area of 11.05 in.² (7129 mm²).

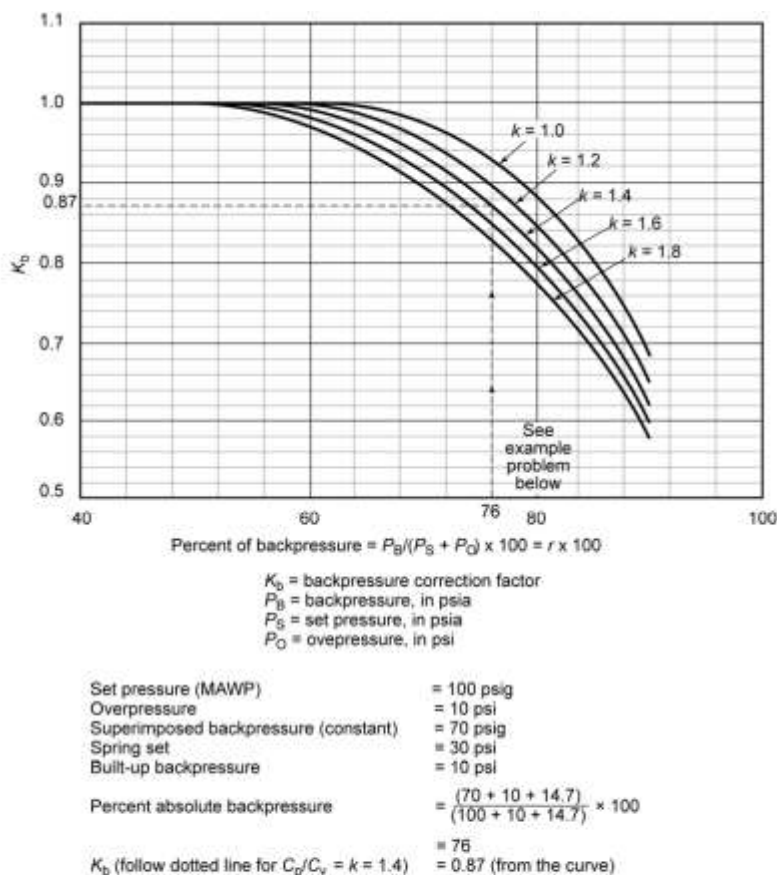
5.6.4.3 Balanced Pressure-relief Valves

Balanced PRVs should be sized using Equation (6) through Equation (11) in 5.6.3.1.1. The backpressure correction factor in this application accounts for flow velocities that are subcritical as well as the tendency for the disc to drop below full lift (the use of subcritical flow equations are appropriate only where full lift is maintained). The backpressure correction factor, K_b , for this application should be obtained from the manufacturer.

5.6.5 Alternate Sizing Procedure for Conventional and Pilot-operated Valves in Subcritical Flow

5.6.5.1 General

As an alternative to using the subcritical flow equations given in 5.6.4, the critical flow Equation (6) through Equation (11), presented in 5.6.3, may be used to calculate the required effective discharge area of a conventional or pilot-operated PRV used in subcritical service. The area obtained using this alternate sizing procedure is identical to the area obtained using the subcritical flow equations. In this alternate method, the capacity correction factor due to backpressure, K_b , is derived by setting the subcritical flow equation (see 5.6.4) equal to the critical flow equation (see 5.6.3) and algebraically solving for K_b . A graphical presentation of the capacity correction factor, K_b , is given in Figure 37. This alternate sizing procedure allows the designer to use the critical flow equation to calculate the same area obtained with the subcritical flow equation provided K_b is obtained from Figure 37 (instead of a K_b value of 1.0 when the critical flow equations of 5.6.3 are used).



NOTE This chart is typical and suitable for use only when the make of the valve or the actual critical flow pressure point for the vapor or gas is unknown; otherwise, the valve manufacturer should be consulted for specific data. This correction factor should be used only in the sizing of conventional (nonbalanced) PRVs that have their spring setting adjusted to compensate for the superimposed backpressure. It should not be used to size balanced type valves.

Figure 37—Constant Backpressure Correction Factor, K_b , for Conventional Pressure-relief Valves

Note that this method is used only for the sizing of pilot-operated PRVs and conventional (nonbalanced) PRVs that have their spring settings adjusted to compensate for the superimposed backpressure. This method should not be used to size balanced type valves.

5.6.5.2 Example 3

5.6.5.2.1 In this example, the following relief requirements are given.

- a) Required hydrocarbon vapor flow, W , caused by an operational upset, of 53,500 lb/h (24,270 kg/h).
- b) The hydrocarbon vapor is a mixture of n-butane (C_4) and propane (C_3). The molecular weight of the mixture, M , is 51.
- c) Relieving temperature, T , of 627 °R (167 °F) [348 K (75 °C)].
- d) PRV set at 75 psig (517 kPag), which is the design pressure of the equipment.
- e) Constant backpressure of 55 psig (379 kPag).
- f) For a conventional valve, the spring setting of the valve is adjusted according to the amount of constant superimposed backpressure obtained. In this example, the CDTP is 20 psig (138 kPag).

5.6.5.2.2 In this example, the following data are derived.

- a) Permitted accumulation of 10 %.
- b) Relieving pressure, P_1 , of $75 \times 1.1 + 14.7 = 97.2$ psia (670 kPa).
- c) Calculated compressibility, Z , of 0.90 (if a calculated compressibility is not available, a value for Z of 1.0 should be used).
- d) Critical backpressure (from Table 10) of $97.2 \times 0.585 = 56.9$ psia (42.2 psig) [392 kPa (291 kPag)].

NOTE Since the backpressure [55 psig (379 kPag)] is greater than the critical backpressure [42.2 psig (291 kPag)], the sizing of the PRV is based on subcritical flow. The backpressure correction factor, K_b , should be determined using Figure 37 when the critical flow formulas are used [see Equation (6) through Equation (11)].

- e) Built-up backpressure of $0.10 \times 75 = 7.5$ psi (51.7 kPa).
- f) Total backpressure of $55 + 7.5 + 14.7 = 77.2$ psia (532 kPa).
- g) $C_p/C_v = k$ of 1.11.

NOTE For this example problem, k was obtained from Table 10 at standard conditions.

- h) $P_2/P_1 = 77.2/97.2 = 0.794$.
- i) Backpressure correction factor, K_b , of 0.88 (from Figure 37).
- j) Coefficient determined from an expression of the ratio of the specific heats of the gas or vapor at inlet relieving conditions, C , of 328 (0.0249) (from Table 11).
- k) Capacity correction for rupture disk, $K_c = 1.0$.

5.6.5.2.3 For preliminary sizing, the effective coefficient of discharge, K_d , of 0.975 can be used. The size of the PRV is derived from Equation (6) as follows:

$$A = \frac{53,500}{328 \times 0.975 \times 97.2 \times 0.88 \times 1.0} \sqrt{\frac{627 \times 0.90}{51}} = 6.51 \text{ in.}^2 \text{ (4197 mm}^2\text{)} \quad (24)$$

NOTE This area requirement is roughly the same as that obtained using the subcritical flow Equation (16). See the example in 5.6.4.2.

5.7 Sizing for Steam Relief

5.7.1 General

PRDs in steam service that operate at critical flow conditions may be sized using Equation (25) and Equation (26). Note that the equations presented here can be used for preliminary sizing when effective values for area and coefficients of discharge are used and for final sizing when actual areas and certified coefficients of discharge are used.

In USC units:

$$A = \frac{W}{51.5 \times P_1 K_d K_b K_c K_N K_{SH}} \quad (25)$$

In SI units:

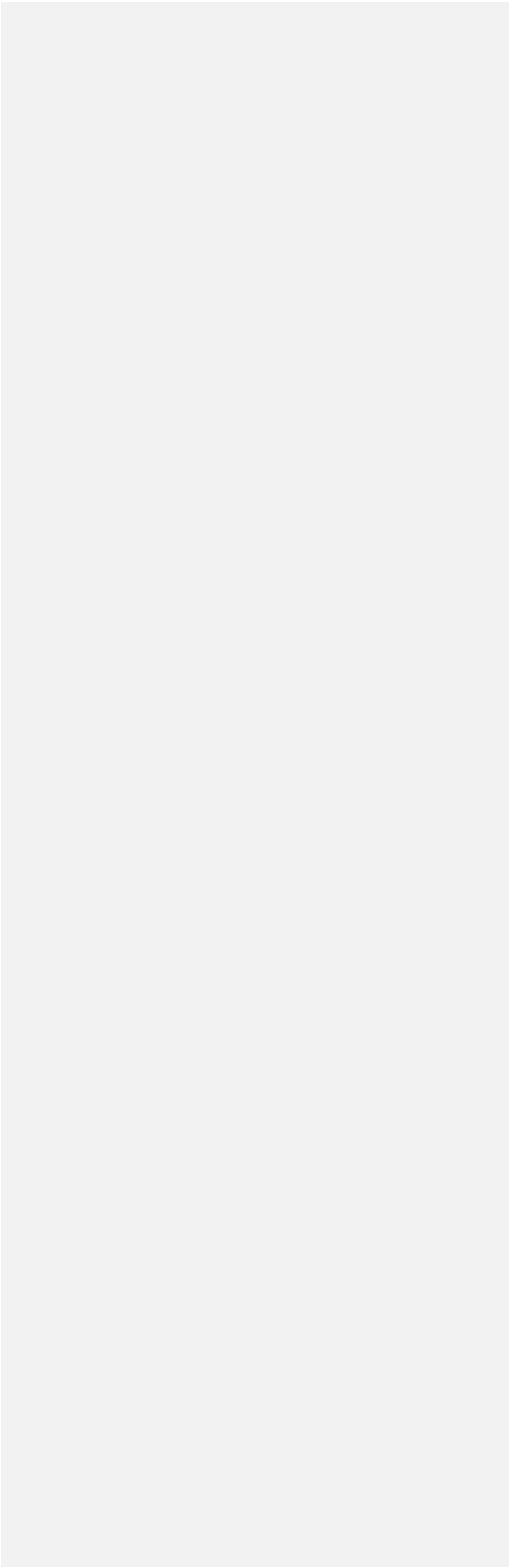
$$A = \frac{190.5 \times W}{P_1 K_d K_b K_c K_N K_{SH}} \quad (26)$$

where

- A is the required discharge area, in.² (mm²) (see 5.2);
- W required flow rate, lb/h (kg/h);
- P_1 is the upstream relieving pressure, psia (kPa); this is the set pressure plus the allowable overpressure (see 5.4) plus the atmospheric pressure;
- K_d is the coefficient of discharge; for preliminary sizing, use the following effective values:
 - 0.975, when a PRV is installed with or without a rupture disk in combination;
 - 0.62, when a PRV is not installed and sizing is for a rupture disk in accordance with 5.12.1.2;
- K_b is the capacity correction factor due to backpressure; this can be obtained from the manufacturer's literature or estimated from Figure 31. The backpressure correction factor applies to balanced bellows valves only. For conventional valves, use a value for K_b equal to 1.0 (see 5.3). See 5.6.4 for conventional valve applications that involve superimposed backpressure of a magnitude that will cause subcritical flow;
- K_c is the combination correction factor for installations with a rupture disk upstream of the PRV (see 5.12.2);
 - the combination correction factor is 1.0, when a rupture disk is not installed;
 - the combination correction factor is 0.9, when a rupture disk is installed in combination with a PRV and the combination does not have a certified value;
- K_N is the correction factor for the Napier equation ^[2] as shown in Equation (27), Equation (28),

and Equation (29).

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$$K_N = 1.0 \quad (27)$$

where

$$P_1 \leq 1500 \text{ psia (10,339 kPa)}.$$

In USC units:

$$K_N = \frac{0.1906 \times P_1 - 1000}{0.2292 \times P_1 - 1061} \quad (28)$$

where

$$P_1 > 1500 \text{ psia (10,339 kPa) and } \leq 3200 \text{ psia (22,057 kPa)}.$$

In SI units:

$$K_N = \frac{0.02764 \times P_1 - 1000}{0.03324 \times P_1 - 1061} \quad (29)$$

where

$$P_1 > 1500 \text{ psia (10,339 kPa) and } \leq 3200 \text{ psia (22,057 kPa)};$$

K_{SH} is the superheat correction factor; this can be obtained from Table 12 or Table 13. For saturated steam at any pressure, $K_{SH} = 1.0$. For temperatures above 1200 °F, use the critical vapor sizing Equation (6) through Equation (11).

Table 12—Superheat Correction Factors, K_{SH} (USC Units)

Relieving Pressure psia	Relieving Temperature, °F, of Superheated Steam																
	400	450	500	550	600	650	700	750	800	850	900	950	1000	1050	1100	1150	1200
50	0.987	0.957	0.930	0.905	0.882	0.861	0.841	0.823	0.805	0.789	0.774	0.759	0.745	0.732	0.719	0.708	0.696
100	0.998	0.963	0.935	0.909	0.885	0.864	0.843	0.825	0.807	0.790	0.775	0.760	0.746	0.733	0.720	0.708	0.697
150	0.984	0.970	0.940	0.913	0.888	0.866	0.846	0.826	0.808	0.792	0.776	0.761	0.747	0.733	0.721	0.709	0.697
200	0.979	0.977	0.945	0.917	0.892	0.869	0.848	0.828	0.810	0.793	0.777	0.762	0.748	0.734	0.721	0.709	0.698
250	...	0.972	0.951	0.921	0.895	0.871	0.850	0.830	0.812	0.794	0.778	0.763	0.749	0.735	0.722	0.710	0.698
300	...	0.968	0.957	0.926	0.898	0.874	0.852	0.832	0.813	0.796	0.780	0.764	0.750	0.736	0.723	0.710	0.699
350	...	0.968	0.963	0.930	0.902	0.877	0.854	0.834	0.815	0.797	0.781	0.765	0.750	0.736	0.723	0.711	0.699
400	0.963	0.935	0.906	0.880	0.857	0.836	0.816	0.798	0.782	0.766	0.751	0.737	0.724	0.712	0.700
450	0.961	0.940	0.909	0.883	0.859	0.838	0.818	0.800	0.783	0.767	0.752	0.738	0.725	0.712	0.700
500	0.961	0.946	0.914	0.886	0.862	0.840	0.820	0.801	0.784	0.768	0.753	0.739	0.725	0.713	0.701
550	0.962	0.952	0.918	0.889	0.864	0.842	0.822	0.803	0.785	0.769	0.754	0.740	0.726	0.713	0.701
600	0.964	0.958	0.922	0.892	0.867	0.844	0.823	0.804	0.787	0.770	0.755	0.740	0.727	0.714	0.702
650	0.968	0.958	0.927	0.896	0.869	0.846	0.825	0.806	0.788	0.771	0.756	0.741	0.728	0.715	0.702
700	0.958	0.931	0.899	0.872	0.848	0.827	0.807	0.789	0.772	0.757	0.742	0.728	0.715	0.703
750	0.958	0.936	0.903	0.875	0.850	0.828	0.809	0.790	0.774	0.758	0.743	0.729	0.716	0.703
800	0.960	0.942	0.906	0.878	0.852	0.830	0.810	0.792	0.774	0.759	0.744	0.730	0.716	0.704
850	0.962	0.947	0.910	0.880	0.855	0.832	0.812	0.793	0.776	0.760	0.744	0.730	0.717	0.704
900	0.965	0.953	0.914	0.883	0.857	0.834	0.813	0.794	0.777	0.760	0.745	0.731	0.718	0.705
950	0.969	0.958	0.918	0.886	0.860	0.836	0.815	0.796	0.778	0.761	0.746	0.732	0.718	0.705
1000	0.974	0.959	0.923	0.890	0.862	0.838	0.816	0.797	0.779	0.762	0.747	0.732	0.719	0.706
1050	0.960	0.927	0.893	0.864	0.840	0.818	0.798	0.780	0.763	0.748	0.733	0.719	0.707
1100	0.962	0.931	0.896	0.867	0.842	0.820	0.800	0.781	0.764	0.749	0.734	0.720	0.707
1150	0.964	0.936	0.899	0.870	0.844	0.821	0.801	0.782	0.765	0.749	0.735	0.721	0.708
1200	0.966	0.941	0.903	0.872	0.846	0.823	0.802	0.784	0.766	0.750	0.735	0.721	0.708
1250	0.969	0.946	0.906	0.875	0.848	0.825	0.804	0.785	0.767	0.751	0.736	0.722	0.709
1300	0.973	0.952	0.910	0.878	0.850	0.826	0.805	0.786	0.768	0.752	0.737	0.723	0.709
1350	0.977	0.958	0.914	0.880	0.852	0.828	0.807	0.787	0.769	0.753	0.737	0.723	0.710
1400	0.982	0.963	0.918	0.883	0.854	0.830	0.808	0.788	0.770	0.754	0.738	0.724	0.710
1450	0.987	0.968	0.922	0.886	0.857	0.832	0.809	0.790	0.771	0.754	0.739	0.724	0.711
1500	0.993	0.970	0.926	0.889	0.859	0.833	0.811	0.791	0.772	0.755	0.740	0.725	0.711
1550	0.972	0.930	0.892	0.861	0.835	0.812	0.792	0.773	0.756	0.740	0.726	0.712
1600	0.973	0.934	0.894	0.863	0.836	0.813	0.792	0.774	0.756	0.740	0.726	0.712
1650	0.973	0.936	0.895	0.863	0.836	0.812	0.791	0.772	0.755	0.739	0.724	0.710
1700	0.973	0.938	0.895	0.863	0.835	0.811	0.790	0.771	0.754	0.738	0.723	0.709
1750	0.974	0.940	0.896	0.862	0.835	0.810	0.789	0.770	0.752	0.736	0.721	0.707

Table 12—Superheat Correction Factors, K_{SH} (USC Units) (continued)

Relieving Pressure psia	Relieving Temperature, °F, of Superheated Steam																
	400	450	500	550	600	650	700	750	800	850	900	950	1000	1050	1100	1150	1200
1800	0.975	0.942	0.897	0.862	0.834	0.810	0.788	0.768	0.751	0.735	0.720	0.705
1850	0.976	0.944	0.897	0.862	0.833	0.809	0.787	0.767	0.749	0.733	0.718	0.704
1900	0.977	0.946	0.898	0.862	0.832	0.807	0.785	0.766	0.748	0.731	0.716	0.702
1950	0.979	0.949	0.898	0.861	0.832	0.806	0.784	0.764	0.746	0.729	0.714	0.700
2000	0.982	0.952	0.899	0.861	0.831	0.805	0.782	0.762	0.744	0.728	0.712	0.698
2050	0.985	0.954	0.899	0.860	0.830	0.804	0.781	0.761	0.742	0.726	0.710	0.696
2100	0.988	0.956	0.900	0.860	0.828	0.802	0.779	0.759	0.740	0.724	0.708	0.694
2150	0.956	0.900	0.859	0.827	0.801	0.778	0.757	0.738	0.722	0.706	0.692
2200	0.955	0.901	0.859	0.826	0.799	0.776	0.755	0.736	0.720	0.704	0.690
2250	0.954	0.901	0.858	0.825	0.797	0.774	0.753	0.734	0.717	0.702	0.687
2300	0.953	0.901	0.857	0.823	0.795	0.772	0.751	0.732	0.715	0.699	0.685
2350	0.952	0.902	0.856	0.822	0.794	0.769	0.748	0.729	0.712	0.697	0.682
2400	0.952	0.902	0.855	0.820	0.791	0.767	0.746	0.727	0.710	0.694	0.679
2450	0.951	0.902	0.854	0.818	0.789	0.765	0.743	0.724	0.707	0.691	0.677
2500	0.951	0.902	0.852	0.816	0.787	0.762	0.740	0.721	0.704	0.688	0.674
2550	0.951	0.902	0.851	0.814	0.784	0.759	0.738	0.718	0.701	0.685	0.671
2600	0.951	0.903	0.849	0.812	0.782	0.756	0.735	0.715	0.698	0.682	0.664
2650	0.952	0.903	0.848	0.809	0.779	0.754	0.731	0.712	0.695	0.679	0.664
2700	0.952	0.903	0.846	0.807	0.776	0.750	0.728	0.708	0.691	0.675	0.661
2750	0.953	0.903	0.844	0.804	0.773	0.747	0.724	0.705	0.687	0.671	0.657
2800	0.956	0.903	0.842	0.801	0.769	0.743	0.721	0.701	0.684	0.668	0.653
2850	0.959	0.902	0.839	0.798	0.766	0.739	0.717	0.697	0.679	0.663	0.649
2900	0.963	0.902	0.836	0.794	0.762	0.735	0.713	0.693	0.675	0.659	0.645
2950	0.902	0.834	0.790	0.758	0.731	0.708	0.688	0.671	0.655	0.640
3000	0.901	0.831	0.786	0.753	0.726	0.704	0.684	0.666	0.650	0.635
3050	0.899	0.827	0.782	0.749	0.722	0.699	0.679	0.661	0.645	0.630
3100	0.896	0.823	0.777	0.744	0.716	0.693	0.673	0.656	0.640	0.625
3150	0.894	0.819	0.772	0.738	0.711	0.688	0.668	0.650	0.634	0.620
3200	0.889	0.815	0.767	0.733	0.705	0.682	0.662	0.644	0.628	0.614

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Table 13—Superheat Correction Factors, K_{SH} (SI Units)

Relieving Pressure MPa	Relieving Temperature, °C, of Superheated Steam																	
	205	225	250	275	300	325	350	375	400	425	450	475	500	525	550	575	600	625
0.5	0.991	0.968	0.942	0.919	0.896	0.876	0.857	0.839	0.823	0.807	0.792	0.778	0.765	0.752	0.740	0.728	0.717	0.706
0.75	0.995	0.972	0.946	0.922	0.899	0.878	0.859	0.841	0.824	0.808	0.793	0.779	0.766	0.753	0.740	0.729	0.717	0.707
1	0.985	0.973	0.950	0.925	0.902	0.880	0.861	0.843	0.825	0.809	0.794	0.780	0.766	0.753	0.741	0.729	0.718	0.707
1.25	0.981	0.976	0.954	0.928	0.905	0.883	0.863	0.844	0.827	0.810	0.795	0.781	0.767	0.754	0.741	0.729	0.718	0.707
1.5	0.957	0.932	0.907	0.885	0.865	0.846	0.828	0.812	0.796	0.782	0.768	0.755	0.742	0.730	0.718	0.708
1.75	0.959	0.935	0.910	0.887	0.866	0.847	0.829	0.813	0.797	0.782	0.769	0.756	0.743	0.731	0.719	0.708
2	0.960	0.939	0.913	0.889	0.868	0.849	0.831	0.814	0.798	0.784	0.769	0.756	0.744	0.731	0.720	0.708
2.25	0.963	0.943	0.916	0.892	0.870	0.850	0.832	0.815	0.799	0.785	0.770	0.757	0.744	0.732	0.720	0.709
2.5	0.946	0.919	0.894	0.872	0.852	0.834	0.816	0.800	0.785	0.771	0.757	0.744	0.732	0.720	0.710
2.75	0.948	0.922	0.897	0.874	0.854	0.835	0.817	0.801	0.786	0.772	0.758	0.745	0.733	0.721	0.710
3	0.949	0.925	0.899	0.876	0.855	0.837	0.819	0.802	0.787	0.772	0.759	0.746	0.733	0.722	0.710
3.25	0.951	0.929	0.902	0.879	0.857	0.838	0.820	0.803	0.788	0.773	0.759	0.746	0.734	0.722	0.711
3.5	0.953	0.933	0.905	0.881	0.859	0.840	0.822	0.804	0.789	0.774	0.760	0.747	0.734	0.722	0.711
3.75	0.956	0.936	0.908	0.883	0.861	0.841	0.823	0.806	0.790	0.775	0.761	0.748	0.735	0.723	0.711
4	0.959	0.940	0.910	0.885	0.863	0.842	0.824	0.807	0.791	0.776	0.762	0.748	0.735	0.723	0.712
4.25	0.961	0.943	0.913	0.887	0.864	0.844	0.825	0.808	0.792	0.776	0.762	0.749	0.736	0.724	0.713
4.5	0.944	0.917	0.890	0.866	0.845	0.826	0.809	0.793	0.777	0.763	0.749	0.737	0.725	0.713
4.75	0.946	0.919	0.892	0.868	0.847	0.828	0.810	0.793	0.778	0.764	0.750	0.737	0.725	0.713
5	0.947	0.922	0.894	0.870	0.848	0.829	0.811	0.794	0.779	0.765	0.751	0.738	0.725	0.714
5.25	0.949	0.926	0.897	0.872	0.850	0.830	0.812	0.795	0.780	0.765	0.752	0.738	0.726	0.714
5.5	0.952	0.930	0.899	0.874	0.851	0.831	0.813	0.797	0.780	0.766	0.752	0.739	0.727	0.714
5.75	0.954	0.933	0.902	0.876	0.853	0.833	0.815	0.798	0.782	0.767	0.753	0.739	0.727	0.715
6	0.957	0.937	0.904	0.878	0.855	0.834	0.816	0.798	0.783	0.768	0.753	0.740	0.727	0.716
6.25	0.960	0.940	0.907	0.880	0.856	0.836	0.817	0.799	0.783	0.768	0.754	0.740	0.728	0.716
6.5	0.964	0.944	0.910	0.882	0.859	0.837	0.818	0.801	0.784	0.769	0.754	0.741	0.729	0.716
6.75	0.966	0.946	0.913	0.885	0.860	0.839	0.819	0.802	0.785	0.769	0.755	0.742	0.729	0.717
7	0.947	0.916	0.887	0.862	0.840	0.820	0.802	0.786	0.770	0.756	0.742	0.729	0.717
7.25	0.949	0.919	0.889	0.863	0.842	0.822	0.803	0.787	0.771	0.756	0.743	0.730	0.717
7.5	0.951	0.922	0.891	0.865	0.843	0.823	0.805	0.788	0.772	0.757	0.744	0.730	0.718
7.75	0.953	0.925	0.893	0.867	0.844	0.824	0.806	0.788	0.772	0.758	0.744	0.731	0.719

Table 13—Superheat Correction Factors, K_{SH} (SI Units) (continued)

Relieving Pressure MPa	Relieving Temperature, °C, of Superheated Steam																	
	205	225	250	275	300	325	350	375	400	425	450	475	500	525	550	575	600	625
8	0.955	0.928	0.896	0.869	0.846	0.825	0.806	0.789	0.773	0.758	0.744	0.732	0.719
8.25	0.957	0.932	0.898	0.871	0.847	0.827	0.807	0.790	0.774	0.759	0.745	0.732	0.719
8.5	0.960	0.935	0.901	0.873	0.849	0.828	0.809	0.791	0.775	0.760	0.746	0.732	0.720
8.75	0.963	0.939	0.903	0.875	0.850	0.829	0.810	0.792	0.776	0.760	0.746	0.733	0.721
9	0.966	0.943	0.906	0.877	0.852	0.830	0.811	0.793	0.776	0.761	0.747	0.734	0.721
9.25	0.970	0.947	0.909	0.879	0.853	0.832	0.812	0.794	0.777	0.762	0.747	0.734	0.721
9.5	0.973	0.950	0.911	0.881	0.855	0.833	0.813	0.795	0.778	0.763	0.748	0.734	0.722
9.75	0.977	0.954	0.914	0.883	0.857	0.834	0.814	0.796	0.779	0.763	0.749	0.735	0.722
10	0.981	0.957	0.917	0.885	0.859	0.836	0.815	0.797	0.780	0.764	0.749	0.735	0.722
10.25	0.984	0.959	0.920	0.887	0.860	0.837	0.816	0.798	0.780	0.764	0.750	0.736	0.723
10.5	0.961	0.923	0.889	0.862	0.838	0.817	0.799	0.781	0.765	0.750	0.737	0.723
10.75	0.962	0.925	0.891	0.863	0.839	0.818	0.799	0.782	0.766	0.751	0.737	0.724
11	0.963	0.928	0.893	0.865	0.840	0.819	0.800	0.782	0.766	0.751	0.737	0.724
11.25	0.964	0.930	0.893	0.865	0.840	0.819	0.799	0.781	0.765	0.750	0.736	0.723
11.5	0.964	0.931	0.894	0.865	0.840	0.818	0.798	0.780	0.764	0.749	0.735	0.722
11.75	0.965	0.932	0.894	0.865	0.839	0.817	0.797	0.780	0.763	0.748	0.734	0.721
12	0.966	0.933	0.894	0.864	0.839	0.817	0.797	0.779	0.762	0.747	0.733	0.719
12.25	0.967	0.935	0.895	0.864	0.839	0.816	0.796	0.778	0.761	0.746	0.732	0.718
12.5	0.967	0.936	0.896	0.864	0.838	0.816	0.796	0.777	0.760	0.745	0.731	0.717
12.75	0.968	0.937	0.896	0.864	0.838	0.815	0.795	0.776	0.759	0.744	0.729	0.716
13	0.969	0.939	0.896	0.864	0.837	0.814	0.794	0.775	0.758	0.743	0.728	0.715
13.25	0.971	0.940	0.897	0.864	0.837	0.813	0.792	0.774	0.757	0.741	0.727	0.713
13.5	0.972	0.942	0.897	0.863	0.837	0.813	0.792	0.773	0.756	0.740	0.725	0.712
14	0.976	0.946	0.897	0.863	0.835	0.811	0.790	0.771	0.753	0.737	0.723	0.709
14.25	0.978	0.947	0.898	0.862	0.834	0.810	0.789	0.770	0.752	0.736	0.721	0.707
14.5	0.948	0.898	0.862	0.833	0.809	0.787	0.768	0.751	0.734	0.720	0.706
14.75	0.948	0.898	0.862	0.832	0.808	0.786	0.767	0.749	0.733	0.719	0.704
15	0.948	0.899	0.861	0.832	0.807	0.785	0.766	0.748	0.732	0.717	0.703
15.25	0.947	0.899	0.861	0.831	0.806	0.784	0.764	0.746	0.730	0.716	0.702
15.5	0.947	0.899	0.861	0.830	0.804	0.782	0.763	0.745	0.728	0.714	0.700

Table 13—Superheat Correction Factors, K_{SH} (SI Units) (continued)

Relieving Pressure MPa	Relieving Temperature, °C, of Superheated Steam																	
	205	225	250	275	300	325	350	375	400	425	450	475	500	525	550	575	600	625
15.75	0.946	0.899	0.860	0.829	0.803	0.781	0.761	0.743	0.727	0.712	0.698
16	0.945	0.900	0.859	0.828	0.802	0.779	0.759	0.741	0.725	0.710	0.696
16.25	0.945	0.900	0.859	0.827	0.801	0.778	0.757	0.739	0.723	0.708	0.694
16.5	0.945	0.900	0.858	0.826	0.799	0.776	0.756	0.738	0.721	0.706	0.692
16.75	0.944	0.900	0.857	0.825	0.797	0.774	0.754	0.736	0.719	0.704	0.690
17	0.944	0.900	0.856	0.823	0.796	0.773	0.752	0.734	0.717	0.702	0.688
17.25	0.944	0.900	0.855	0.822	0.794	0.771	0.750	0.732	0.715	0.700	0.686
17.5	0.944	0.900	0.854	0.820	0.792	0.769	0.748	0.730	0.713	0.698	0.684
17.75	0.944	0.900	0.853	0.819	0.791	0.767	0.746	0.728	0.711	0.696	0.681
18	0.944	0.901	0.852	0.817	0.789	0.765	0.744	0.725	0.709	0.694	0.679
18.25	0.945	0.901	0.851	0.815	0.787	0.763	0.742	0.723	0.706	0.691	0.677
18.5	0.945	0.901	0.850	0.814	0.785	0.761	0.739	0.720	0.704	0.689	0.674
18.75	0.945	0.901	0.849	0.812	0.783	0.758	0.737	0.718	0.701	0.686	0.671
19	0.946	0.901	0.847	0.810	0.781	0.756	0.734	0.715	0.698	0.683	0.669
19.25	0.948	0.901	0.846	0.808	0.778	0.753	0.732	0.713	0.696	0.681	0.666
19.5	0.950	0.900	0.844	0.806	0.776	0.750	0.729	0.710	0.693	0.677	0.663
19.75	0.952	0.899	0.842	0.803	0.773	0.748	0.726	0.707	0.690	0.674	0.660
20	0.899	0.840	0.801	0.770	0.745	0.723	0.704	0.687	0.671	0.657
20.25	0.899	0.839	0.798	0.767	0.742	0.720	0.701	0.683	0.668	0.654
20.5	0.899	0.837	0.795	0.764	0.738	0.717	0.697	0.680	0.665	0.651
20.75	0.898	0.834	0.792	0.761	0.735	0.713	0.694	0.677	0.661	0.647
21	0.896	0.832	0.790	0.758	0.732	0.710	0.691	0.673	0.658	0.643
21.25	0.894	0.829	0.786	0.754	0.728	0.706	0.686	0.669	0.654	0.640
21.5	0.892	0.826	0.783	0.750	0.724	0.702	0.682	0.665	0.650	0.636
21.75	0.891	0.823	0.779	0.746	0.720	0.698	0.679	0.661	0.646	0.631
22	0.887	0.820	0.776	0.743	0.716	0.694	0.674	0.657	0.641	0.627

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5.7.2 Example 4

5.7.2.1 In this example, the relief requirement, W , is superheated steam at 153,500 lb/h (69,615 kg/h) at 800 °F (427 °C) and 1600 psig (11,032 kPag) set pressure with 10 % accumulation.

NOTE The set pressure is equal to the design pressure in this example.

5.7.2.2 In this example, the following data are derived.

- a) Relieving pressure, P_1 , of $1600 \times 1.1 + 14.7 = 1774.7$ psia (12,236 kPa); relieving temperature 813 °F.
- b) Effective coefficient of discharge, K_d , of 0.975.
- c) Backpressure correction factor, K_b , of 1.0 for conventional valve discharging to atmosphere.
- d) Capacity correction for rupture disk, $K_c = 1.0$, since there is no rupture disk.
- e) Correction factor for the Napier equation, K_N , of 1.01, calculated using Equation (28):

$$K_N = \frac{0.1906 \times P_1 - 1000}{0.2292 \times P_1 - 1061} = \frac{0.1906 \times (1774.7) - 1000}{0.2292 \times (1774.7) - 1061} = 1.01 \quad (30)$$

- f) Superheat steam correction factor, K_{SH} , of 0.855 from Table 12 (see Table 13 for SI units).

5.7.2.3 For preliminary sizing, the effective coefficient of discharge, K_d , of 0.975 can be used. The size of the PRV is derived from Equation (25) as follows:

$$A = \frac{153,500}{51.5 \times 1774.7 \times 0.975 \times (1.0) \times (1.0) \times (1.01) \times (0.855)} = 1.995 \text{ in.}^2 \text{ (1287 mm}^2\text{)} \quad (31)$$

5.7.2.4 For selection of the proper orifice size, see API 526. For this example, a "L" sized orifice was selected since it has an effective orifice area of 2.853 in.² (1841 mm²).

5.8 Sizing for Liquid Relief: Pressure-relief Valves Requiring Capacity Certification

5.8.1 General

5.8.1.1 The sizing equations for PRDs in liquid service provided in this section assume that the liquid is incompressible (i.e. the density of the liquid does not change as the pressure decreases from the relieving pressure to the total backpressure).

5.8.1.2 The ASME Code requires that capacity certification be obtained for PRVs designed for liquid service. The procedure for obtaining capacity certification includes testing to determine the certified coefficient of discharge for the liquid PRVs at 10 % overpressure.

5.8.1.3 Valves in liquid service that are designed in accordance with the ASME Code, which require a capacity certification, may be sized using Equation (32) or Equation (33). Note that the equations presented here can be used for preliminary sizing when effective values for area and coefficients of discharge are used and for final sizing when actual areas and certified coefficients of discharge are used.

In USC units:

$$A = \frac{Q}{38 \times K_d K_w K_c K_v} \sqrt{\frac{G_1}{P_1 - P_2}} \quad (32)$$

In SI units:

$$A = \frac{11.78 \times Q}{K_d K_w K_c K_v} \sqrt{\frac{G_1}{P_1 - P_2}} \quad (33)$$

Commented [KM1]: Note that the formula & is inserted as columns - check the earlier to verify they are done the same way.

where

- A is the required discharge area, in.² (mm²);
- Q is the required relieving capacity at the flowing temperature, U.S. gal/min (L/min);
- K_d is the coefficient of discharge; for preliminary sizing, an effective coefficient of discharge can be used as follows:
- 0.65, when a PRV is installed with or without a rupture disk in combination;
 - 0.62, when a PRV is not installed and sizing is for a rupture disk in accordance with 5.12.1.2.2;
- K_w is the correction factor due to backpressure; if the backpressure is atmospheric, use a value for K_w of 1.0. Balanced bellows valves in backpressure service will require the correction factor determined from Figure 32. Conventional and pilot-operated valves require no special correction (see 5.3);
- K_c is the combination correction factor for installations with a rupture disk upstream of the PRV (see 5.12.2); use the following values for the combination correction factor:
- 1.0, when a rupture disk is not installed;
 - 0.9, when a rupture disk is installed in combination with a PRV and the combination does not have a certified value;
- K_v is the correction factor due to viscosity; where the liquid has a viscosity of 100 cP (0.1 Pa-s) or less, the viscosity correction factor can be set to 1. For viscosities greater than 100 cP (0.1 Pa-s), the factor should be determined from Figure 38 or from Equation (34). This equation is applicable for $Re_L \geq 80$:

$$K_v = \left(\frac{170}{Re_L} + 1 \right)^{-0.5} \quad (34)$$

where

- G_1 is the specific gravity of the liquid at the flowing temperature referred to water at standard conditions;
- P_1 is the upstream relieving pressure, psig (kPag); this is the set pressure plus allowable overpressure;

P_2 is the total backpressure, psig (kPag).

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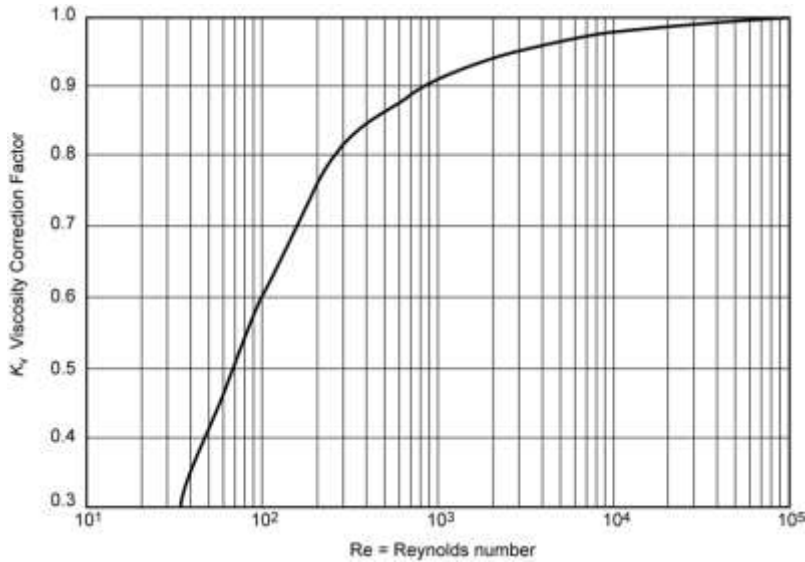


Figure 38—Capacity Correction Factor, K_v , Due to Viscosity

5.8.1.4 When a PRV is sized for viscous liquid service, it should first be sized as if it were for a nonviscous type application (i.e. $K_v = 1.0$) so that a preliminary required discharge area, A_R , can be obtained from Equation (32) or Equation (33). The user is cautioned that the equations presented here may not be applicable for non-Newtonian applications (see 5.10). From the list of API 526 standard orifice sizes or the manufacturer's listing, the next orifice size, A_{selected} , larger than A_R should be chosen to calculate the Reynolds number, Re , from either of the following relationships.

In USC units:

$$Re = \frac{Q(2800 \times G_1)}{\mu \sqrt{A_{\text{selected}}}} \quad (35)$$

or

$$Re = \frac{12,700 \times Q}{U \sqrt{A_{\text{selected}}}} \quad (36)$$

In SI units:

$$Re = \frac{Q(18,800 \times G_1)}{\mu \sqrt{A_{\text{selected}}}} \quad (37)$$

or

$$Re = \frac{85,220 \times Q}{U \sqrt{A_{\text{selected}}}} \quad (38)$$

where

Re is the Reynolds number;

Q is the required relieving capacity at the flowing temperature in U.S. gal/min (L/min);

G_l is the specific gravity of the liquid at the flowing temperature referred to water at standard conditions;

μ is the absolute viscosity at the flowing temperature, centipoise;

A_{selected} is the smallest standard orifice area that exceeds the preliminary area A_R , in.² (mm²); standard orifice sizes from API 526 or the manufacturer's table should be used;

U is the viscosity at the flowing temperature in Saybolt universal seconds.

Equation (36) and Equation (38) are not recommended for viscosities less than 100 Saybolt universal seconds.

5.8.1.5 After the Reynolds number, Re , is determined, the factor K_v is obtained and applied in Equation (32) or Equation (33) to correct the preliminary required discharge area, A_R . If the corrected area exceeds the chosen standard orifice area, A_{selected} , the Reynolds number should be recalculated using the next larger standard orifice size and the value of K_v updated accordingly.

5.8.2 Example 5

5.8.2.1 In this example, the following relief requirements are given.

- Required crude oil flow caused by blocked discharge, Q , of 1800 gal/min (6814 L/min).
- The specific gravity, G_l , of the crude oil is 0.90. The viscosity of the crude oil at the flowing temperature is 2000 Saybolt universal seconds.
- PRV set at 250 psig (1724 kPag), which is the design pressure of the equipment.
- Backpressure is variable from 0 to 50 psig (345 kPag).
- Overpressure of 10 %.

5.8.2.2 In this example, the following data are derived.

- Relieving pressure, P_1 , of $1.10 \times 250 = 275$ psig (1896 kPag).
- Backpressure of $(50/250) \times 100 = 20$ %.
- A balanced bellows valve was selected, since the backpressure is variable. From Figure 32, the backpressure capacity correction factor, $K_w = 0.97$.
- The effective coefficient of discharge for preliminary sizing, $K_d = 0.65$.

5.8.2.3 Sizing first for no viscosity correction ($K_v = 1.0$), the size of the PRV is derived from Equation (32) as follows:

$$A_R = \frac{1800}{38 \times 0.65 \times 0.97 \times 1.0 \times 1.0} \sqrt{\frac{0.90}{275 - 50}} = 4.752 \text{ in.}^2 \text{ (3066 mm}^2\text{)} \quad (39)$$

where

A_R is the required area of the PRV without any viscosity correction.

An area of 6.38 in.² (4116 mm²) using a P orifice is chosen for A_{selected} from API 526.

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5.8.2.4 The Reynolds number, Re , is then calculated using Equation (36).

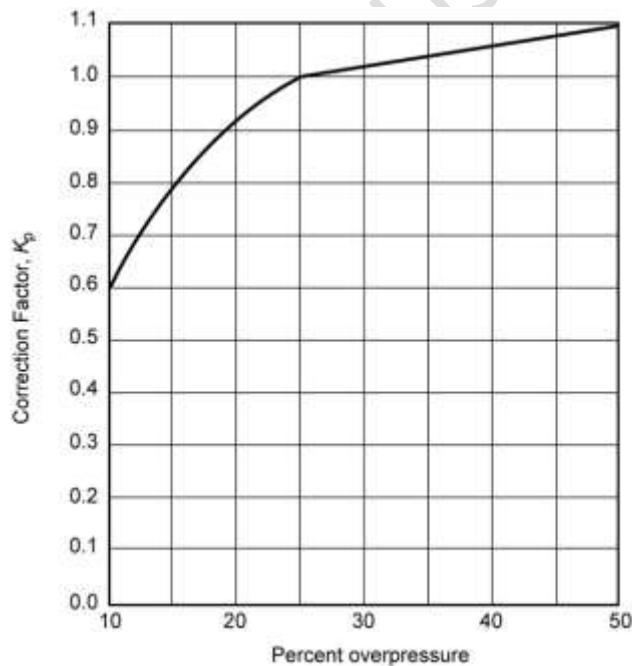
$$Re = \frac{12,700 \times 1800}{2000 \sqrt{6.38}} = 4525 \quad (40)$$

5.8.2.5 From Equation (34), the viscosity correction factor is determined, $K_v = 0.982$; therefore:

$$A = \frac{A_R}{K_v} = \frac{4.752}{0.982} = 4.84 \text{ in.}^2 \quad (3122 \text{ mm}^2) \quad (41)$$

5.9 Sizing for Liquid Relief: Pressure-relief Valves Not Requiring Capacity Certification

5.9.1 Before the ASME Code incorporated requirements for capacity certification, valves were generally sized for liquid service using Equation (42) and Equation (43). This method assumes an effective coefficient of discharge, $K_d = 0.62$, and 25 % overpressure. An additional capacity correction factor, K_p , is needed for relieving pressures other than 25 % overpressure (see Figure 39). This sizing method may be used where capacity certification is not required or was never established.



NOTE The curve above shows that up to and including 25 % overpressure, capacity is affected by the change in lift, the change in the orifice discharge coefficient, and the change in overpressure. Above 25 %, capacity is affected only by the change in overpressure.

Figure 39—Capacity Correction Factors Due to Overpressure for Noncertified Pressure-relief Valves in Liquid Service

5.9.2 This method will typically result in an oversized design where a liquid valve is used for an application with 10 % overpressure (see 4.2.1.2). A K_p correction factor of 0.6 is used (see Figure 39) for this situation.

In USC units:

$$A = \frac{Q}{38 \times K_d K_w K_c K_v K_p} \sqrt{\frac{G_l}{1.25 P_s - P_2}} \quad (42)$$

In SI units:

$$A = \frac{11.78 \times Q}{K_d K_w K_c K_v K_p} \sqrt{\frac{G_l}{1.25 P_s - P_2}} \quad (43)$$

where

- A is the required effective discharge area, in in.² (mm²);
- Q is the required relieving capacity at the flowing temperature, in U.S. gal/min (L/min);
- K_d is the effective coefficient of discharge and shall be 0.62;
- K_w is the correction factor due to backpressure; if backpressure is atmospheric, K_w is equal to 1; balanced bellows valves in backpressure service will require the correction factor determined from Figure 32. Conventional and pilot-operated valves require no special correction (see 5.3);
- K_c is the combination correction factor for installations with a rupture disk upstream of the PRV (see 5.12.2); use a value for K_c equal to 1.0 when a rupture disk does not exist;
- K_v is the correction factor due to viscosity as determined from Figure 38 or Equation (34) (see 5.8.1.4);
- K_p is the correction factor due to overpressure; at 25 % overpressure, K_p is equal to 1.0; for overpressures other than 25 %, K_p is determined from Figure 39;
- G_l is the specific gravity of the liquid at the flowing temperature referred to water at standard conditions;
- P_s is the set pressure in psig (kPag);
- P_2 is the total backpressure in psig (kPag).

5.10 Special Considerations for Non-Newtonian Fluids

5.10.1 The chemical and petroleum industries frequently encounter complex fluids that exhibit non-Newtonian behavior. This is typically manifest as a shear-thinning viscosity and occurs in suspensions of fine solids as well as solutions and melts of high polymers. In laminar flows, the viscosity of these fluids can drop significantly as the shear rate (or shear stress) increases. In turbulent flow, some very high MW polymer solutions exhibit viscoelastic properties that can result in drag reduction, which lowers the flow resistance to below that of the solvent. Thus, the viscosity correction factor, K_v , derived for Newtonian fluids is not reliable for non-Newtonian fluids because the viscosity varies with shear rate.

5.10.2 Due to strong velocity gradients in the curtain area between the valve seat and the disk, high shear rates may exist so that the viscosity of a shear-thinning fluid at that location can be much less than the viscosity at relieving conditions (i.e. in the vessel or other protected equipment)^[3, 4]. The value of the viscosity correction factor might change markedly with the rheological model for the shear-thinning medium^[5]. The use of the viscosity at relieving conditions when calculating the viscosity correction factor is likely to result in significantly oversized PRVs.

5.11 Sizing for Two-phase Liquid/Vapor Relief

5.11.1 A PRD handling a liquid at vapor-liquid equilibrium or a mixed-phase fluid will produce flashing with vapor generation as the fluid moves through the device. The vapor generation shall be taken into account since it may reduce the mass flow capacity of the device.

5.11.2 Recommended methods for sizing PRDs in two-phase service are presented in Annex C. There are currently no PRDs with certified capacities for two-phase flow since there are no testing methods for certification.

5.11.3 A balanced or pilot-operated PRV may be necessary when the increase in backpressure due to flashing or two-phase flow conditions is excessive or cannot be adequately predicted. The actual flow rate through a device can be many times higher if equilibrium is not achieved in the nozzle.

5.11.4 For information about saturated water, see ASME BPVC, Section VIII, Appendix 11.

5.11.5 Liquid flashing across a relief valve may result in low temperatures (auto-refrigeration). Materials of construction shall be adequate for the outlet temperatures involved; in addition, the installation shall preclude the possibility of flow blockage occurring from hydrate or possibly solid formation.

5.12 Sizing for Rupture Disk Devices

5.12.1 Rupture Disk Devices Used Independently

5.12.1.1 General

Rupture disk devices may be used as the primary relief device for gas, vapor, liquid, or multiphase service. The rupture disk size, when used as the sole relieving device, shall be determined as specified in [preferably 5.12.1.23](#) or [alternatively 5.12.1.32](#). Section 5.12.1.2 may only be used when a rupture disk device discharges directly to the atmosphere, is installed within eight pipe diameters from the vessel nozzle entry, has a length of discharge not greater than five pipe diameters, and has nominal diameters of the inlet and outlet discharge piping equal to or greater than the NPS of the device. Section 5.12.1.3 applies in all other cases.

5.12.1.2 Rupture Disk Sizing Using Coefficient of Discharge Method ($K_d = 0.62$)

5.12.1.2.1 The required discharge area, A , in in.² (mm²), can be calculated using the appropriate equation for the flowing fluid. See Equation (6) through Equation (11) for critical gas or vapor flow; Equation (16) through Equation (21) for subcritical gas or vapor flow; Equation (25) and Equation (26) for steam; Equation (32) or Equation (33) for liquid; and Annex C for two-phase flow.

5.12.1.2.2 When using these equations, a coefficient of discharge, K_d , of 0.62 should be used (see 5.12.1.1 for limitations on using this method).

5.12.1.2.3 The nominal size of the rupture disk device selected shall have a minimum net flow area equal to or greater than the required calculated discharge area. Consult the manufacturer for the minimum net flow area of the rupture disk device.

5.12.1.3 Rupture Disk Sizing Using Flow Resistance Method

The calculated size of a pressure-relief system containing a rupture disk device may also be determined by analyzing the total system resistance to flow. This analysis shall use the flow resistance of the rupture disk device, piping and other piping components, entrance and exit losses, elbows, tees, reducers, and valves. The calculation shall be made using accepted engineering practices for determining fluid flow through piping systems. To determine the capacity of the pressure-relief system, the calculated relieving capacity shall be multiplied by a factor of 0.90 or less to allow for uncertainties inherent with this method. In these calculations, flow resistance for rupture disk devices can be obtained from the manufacturer. The flow resistance is expressed in terms of velocity head loss (K_r). ASME Code certified values should be used where available. Refer to 4.3.1.4 for selection of appropriate K_r type.

An example of the flow resistance method is provided in Annex E.

5.12.2 Rupture Disk Devices Used in Combination with Pressure-relief Valves

The capacity of an installation consisting of a rupture disk device in combination with a PRV, where the rupture disk device is located at the valve inlet may be determined by multiplying the ASME stamped valve capacity by the combination capacity factor, K_C . K_C values are certified and published by the National Board of Boiler and Pressure Vessel Inspectors for specific disk/valve combinations. When a disk/valve combination does not have a certified K_C , then a K_C value of 0.90 shall be used provided the flow area is equal to or greater than the inlet of the PRV.

5.13 Sizing for Open Flow Paths or Vents

The capacity of a pressure-relief system containing a flow path or vent open directly or indirectly to the atmosphere may be determined by analyzing the total system resistance to flow. This analysis shall take into consideration the flow resistance of the piping and other piping components, entrance and exit losses, elbows, tees, reducers, and valves. The calculation shall be made using accepted engineering practices for determining fluid flow through piping systems. For pressure vessels within the scope of the ASME Code, this calculated relieving capacity shall be multiplied by a factor of 0.90 or less to allow for uncertainties inherent with this method [see UG-127(d)]. Other international codes and standards may have different requirements.

Annex A (informative)

Rupture Disk Device Specification Sheet

A line-by-line description of the information to be provided on the rupture disk device specification sheet is provided in Table A.1, followed by a typical blank specification sheet shown in Figure A.1.

Table A.1—Rupture Disk Device Specification Sheet Instructions

Line No.	Instructions
1	<i>Item Number:</i> Sequential number from requisition.
2	<i>Tag Number:</i> Number assigned to rupture disk that identifies rupture disk location.
3	<i>Service, Line, or Equipment No.:</i> Number identifying the service, line, or equipment in which the rupture disk is installed.
4	<i>Applicable Codes or Standards:</i> Specify applicable codes or standards (e.g. ASME, API, ISO, etc.) for sizing, marking, burst tolerance, testing, etc.
5	<i>Vessel or Piping Maximum Allowable Working Pressure:</i> This pressure is defined in the ASME Code and is specified by the user for the vessel or piping to be protected. This pressure may also be used to evaluate proper sizing and marking.
6	<i>Fluid:</i> The process media is used by the user to define compatible materials for rupture disks and holders.
7	<i>Fluid State (initiating rupture):</i> Gas (vapor) or liquid. Some disks are designed to burst with vapor only (See 4.3.1.4).
8	<i>Fluid State (relieving conditions):</i> Gas (vapor), liquid, or multiphase flow. Users need this information to calculate flow rates and size the rupture disk device.
9	<i>Required Relieving Capacity:</i> User to document the required relieving capacity and units for the disk specified. See 5.12 for sizing of rupture disk devices.
10	<i>Molecular Weight or Specific Gravity (at relieving temperature):</i> Needed to size relieving system components.
11	<i>Viscosity (at relieving temperature):</i> Needed to size relieving system components if viscous fluid. User to specify units. Viscosity is required for the liquid sizing case only.
12	<i>Compressibility Factor (Z):</i> This factor is used as a constant in disk sizing using the coefficient of discharge method. The compressibility factor is required for vapor sizing cases only.
13	<i>Specific Heat Ratio:</i> This constant is used in disk sizing calculations. The specific heat ratio is required for vapor sizing cases only. This is the ideal gas specific heat ratio. It is independent of pressure. Most process simulators will provide real gas specific heats that should not be used here; otherwise, the rupture disk may be undersized.
14	<i>Normal Maximum Operating Pressure:</i> The maximum pressure at which the system normally operates. This pressure is used to calculate the operating ratio.
15	<i>Normal Maximum Operating Temperature:</i> The maximum temperature at which the system normally operates. This temperature is used to evaluate disk type, material, and performance.

Users of instructions should not rely exclusively on the information contained in this document. Sound business, scientific, engineering, and safety judgment should be used in employing the information contained herein. Where applicable, authorities having jurisdiction should be consulted. Work sites and equipment operations may differ. Users are solely responsible for assessing their specific equipment and premises in determining the appropriateness of applying the instructions.

Table A.1—Rupture Disk Device Specification Sheet Instructions (*continued*)

Line No.	Instructions
16	<i>Pressure Fluctuations (static, cyclic, pulsating):</i> Specify cyclic or pulsating service when applicable. Cyclic service is considered as a large amplitude and low frequency. Cyclic service with vacuum cycles shall be indicated. Pulsating service is considered as small amplitude and high frequency. For certain types of rupture disks, the operating ratio affects the service life in cyclic applications.
17	<i>Superimposed Backpressure:</i> See 3.1.61 for definition. A rupture disk is a differential pressure device; therefore, this pressure needs to be considered when specifying burst pressure. Additionally, superimposed backpressure is used to determine disk type and construction (e.g. vacuum/backpressure supports). For disks vented to atmosphere, the superimposed backpressure is atmospheric pressure and it is constant. See 4.3.6.2.4 for a discussion on the effects of superimposed backpressure on rupture disk selection.
18	<i>Built-up Backpressure:</i> See 3.1.7 for definition. This pressure is used to determine system backpressure.
19	<i>Backpressure:</i> See 3.1.3 for definition.
20	<i>Inlet Vacuum Conditions:</i> Inlet vacuum conditions are used to determine rupture disk type and construction (e.g. vacuum supports). Select and document vacuum units carefully; absolute units have positive values and gauge units have negative values.
21	<i>Outlet Vacuum Conditions:</i> A rupture disk is a differential pressure device; therefore, outlet vacuum needs to be considered when specifying the burst pressure.
22	<i>Disk Located Upstream of Pressure-relief Valve (yes/no):</i> This information is needed to verify proper selection (e.g. 3 % rule) of nonfragmenting disks.
23	<i>Disk Located Downstream of Pressure-relief Valve (yes/no):</i> This information is needed by the user to verify installation and sizing requirements for this application.
24	<i>Nonfragmenting Design (yes/no):</i> See 3.1.35 for definition. User shall specify nonfragmenting requirement to the manufacturer.
25	<i>Nominal Pipe Size:</i> This information is used to identify the nominal size of the mating fittings.
26	<i>Applicable Flange Standard and Class:</i> This information is used to identify pressure ratings and dimensions of holders.
27	<i>Flange Facing (inlet/outlet):</i> Used to identify the mating flange facing (e.g. RF, FF).
28	<i>Piping Connection (schedule/bore):</i> This information is used to evaluate flow area and proper selection of holderless disks.
29	<i>Holder Tag No.:</i> Number assigned to rupture disk holder which identifies holder location.
30	<i>Nominal Holder Size:</i> Specify nominal holder size. In some cases nominal holder size may be larger than the relief piping to obtain lower burst pressures.
31	<i>Design Type:</i> Specify holder type, such as insert or full bolting. Holder selection may be based on ease of installation and maintenance or mating connections. Full bolting holders may reduce the heat flow to flange studs in a fire.
32	<i>Model Designator:</i> When known, specify the applicable manufacturer's model number, name, or designator.

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Table A.1—Rupture Disk Device Specification Sheet Instructions (continued)

Line No.	Instructions
33	<i>Quantity Required:</i> Specify quantity of holders required. Consider preventive maintenance and spares.
34	<i>Holder Material and Coatings (inlet):</i> User should select an inlet material compatible with process fluids. See 4.3.4. Coatings and linings are sometimes used to enhance corrosion resistance or reduce product Buildup.
35	<i>Holder Material and Coatings (outlet):</i> See 4.3.4. Outlet holder material may be different from inlet holder material and should be selected based on frequency and duration of exposure to process and downstream fluids.
36	<i>Gauge Tap (yes/no) and Size (NPT) (outlet):</i> Gauge taps in holder outlets are primarily used to vent and/or monitor the cavity between a rupture disk and a downstream pressure-relief valve (PRV). See 4.3.2.2.3.
37	<i>Studs and Nuts (yes/no) and Material:</i> Specify if studs and nuts are to be supplied with the rupture disk holder and if so what materials (e.g. alloy or stainless steel).
38	<i>Jackscrews (yes/no):</i> Indicate if jackscrews are required. Jackscrews are used to separate mating flanges to facilitate installation and maintenance of holders.
39	<i>Telltale Assembly (yes/no) and Material:</i> Telltale assemblies typically consist of a pressure gauge, excess flow valve, and connecting fittings. These assemblies are installed in holder outlets that are located upstream of PRVs. These devices provide venting and monitoring of the cavity between the disk and valve as specified in 4.3.2.2.3. If other monitoring devices are required, indicate here.
40	<i>Other:</i> Space provided for specifying other accessories.
41	<i>Nominal Disk Size:</i> Specify nominal disk size. In some cases, the nominal disk size may be larger than the relief piping to obtain lower burst pressures.
42	<i>Required Discharge Area:</i> Specify the required discharge area. This is only required when the disk is sized using the coefficient of discharge method (see 5.12.1.2). The minimum net flow area of the disk shall be greater than or equal to this value.
43	<i>Disk Type:</i> Identify preference, if any, for forward-acting, reverse-acting, or graphite.
44	<i>Model Designator:</i> When known, specify the applicable manufacturer's model number, name, or designator.
45	<i>Quantity Required:</i> Specify quantity of disks required. Consider start-up, preventive maintenance, and spares.
46	<i>Manufacturing Design Range:</i> User to specify the desired manufacturing design range. The manufacturing design range shall always be evaluated before the specified burst pressure is determined to ensure that the marked burst pressure is within applicable ASME Code pressure limits. Manufacturing design ranges generally depend on a) the specified burst pressure level, b) the rupture disk design type, and c) the rupture disk manufacturer. Manufacturing design ranges are expressed as a) plus or minus a percentage of the specified pressure, b) plus or minus pressure units, or c) zero percent or no manufacturing design range. See 3.1.29 for definition.
47	<i>Specified Burst Temperature:</i> User to specify the temperature at which the disk is to be rated and marked.
48	<i>Specified Burst Pressure:</i> A pressure specified by the user taking into consideration manufacturing design range, burst tolerance, superimposed backpressure, and operating pressure.
49	<i>Maximum Marked Burst Pressure:</i> This pressure is calculated by adding the positive manufacturing design range to the specified burst pressure. The maximum marked burst pressure is then verified to meet the vessel or piping protection requirements for single, multiple, fire, or redundant applications.

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Table A.1—Rupture Disk Device Specification Sheet Instructions (*continued*)

Line No.	Instructions
50	<i>Minimum Marked Burst Pressure:</i> This pressure is calculated by subtracting the negative manufacturing design range from the specified burst pressure. The minimum marked burst pressure is used to calculate the operating ratio.
51	<i>Operating Ratio:</i> See 3.1.40 for definition. The operating ratio is used to evaluate the proper selection of the rupture disk and is calculated as follows: a) for marked pressures above 40 psig the operating ratio is equal to the maximum normal operating pressure divided by the minimum marked burst pressure; b) for marked pressures between 15 psig and 40 psig, the operating ratio is equal to the maximum normal operating pressure divided by the minimum marked burst pressure, less 2 psig. For marked pressures less than 15 psig, consult the manufacturer.
52	<i>Maximum Flow Resistance Factor (K_f):</i> When using the total flow resistance method to size relief piping components, specify the maximum flow resistance factor required for the rupture disk. The maximum flow resistance factor is expressed as a velocity head loss. See 4.3.1.4 for discussion on the appropriate K_f value, i.e. K_{fl} (liquid), K_{fg} (gas), or K_{rg} .
53	<i>Rupture Disk Materials:</i> The user is responsible for selecting and specifying rupture disk materials that are compatible with system fluids. Verify the selected materials are available for the rupture disk type, pressure, and temperature specified above.
54	<i>Manufacturer's Data:</i> When available, specify the manufacturer's name and lot number. If the rupture disk has been previously ordered, the manufacturer will have lot number traceability to the previous order rupture disk specifications.

Users of instructions should not rely exclusively on the information contained in this document. Sound business, scientific, engineering, and safety judgment should be used in employing the information contained herein. Where applicable, authorities having jurisdiction should be consulted. Work sites and equipment operations may differ. Users are solely responsible for assessing their specific equipment and premises in determining the appropriateness of applying the instructions.

RUPTURE DISK DEVICE SPECIFICATION SHEET			Sheet Number _____ Page _____ of _____	
			Requisition Number _____	
			Job Number _____	
			Date _____	
			Revision Number _____	
			By _____	
General				
1.	Item Number _____		3.	Service, Line, or Equip. Number _____
2.	Tag Number _____		4.	Design Code or Standard _____
Service Conditions (include applicable units)				
5.	Vessel or Piping MAWP _____			
6.	Fluid _____			
7.	Fluid State (initiating rupture) _____			
8.	Fluid State (relieving conditions) _____			
9.	Required Relieving Capacity _____			
10.	Molecular Weight or Specific Gravity _____			
11.	Viscosity at Relieving Temperature _____			
12.	Compressibility Factor (Z) _____			
13.	Specific Heat Ratio _____			
14.	Normal Maximum Operating Pressure _____			
15.	Normal Maximum Operating Temperature _____			
16.	Pressure Fluctuations (static, cyclic, pulsating) _____			
17.	Superimposed Backpressure _____			
18.	Built-up Backpressure _____			
19.	Backpressure _____			
20.	Inlet Vacuum Conditions _____			
21.	Outlet Vacuum Conditions _____			
22.	Disk Located Upstream of Valve (yes/no) _____			
23.	Disk Located Downstream of Valve (yes/no) _____			
24.	Nonfragmenting Design (yes/no) _____			
Connections				
25.	Nominal Pipe Size _____		27.	Flange Facing (inlet/outlet) _____
26.	Flange Standard and Class _____		28.	Piping Schedule or Bore _____
Rupture Disk Holder			Rupture Disk	
29.	Holder Tag Number _____		41.	Nominal Disk Size _____
30.	Nominal Holder Size _____		42.	Required Discharge Area _____
31.	Design Type _____		43.	Disk Type _____
32.	Model Designator _____		44.	Model Designator _____
33.	Quantity Required _____		45.	Quantity Required _____
34.	Holder Material (inlet) _____		46.	Manufacturing Design Range _____
35.	Holder Material (outlet) _____		47.	Specified Burst Temperature _____
36.	Gage Tap (yes/no) and Size _____		48.	Specified Burst Pressure _____
Accessories			49.	Max Marked Burst Pressure _____
37.	Studs and Nuts (y/n) and Matl _____		50.	Min Marked Burst Pressure _____
38.	Jackscrews (yes/no) _____		51.	Operating Ratio _____
39.	Telltale Assy (y/n) and Matl _____		52.	Max Flow Resistance, K_f _____
40.	Other _____		53.	Rupture Disk Materials _____
			54.	Manufacturer's Data _____

Figure A.1—Rupture Disk Device Specification Sheet

Annex B (informative)

Review of Flow Equations Used in Sizing Pressure-relief Devices

B.1 Development of Flow Equations

B.1.1 General

B.1.1.1 The objectives of this annex are as follows:

- a) to provide the theoretical foundation that was used in the development of the sizing equations provided in the main body, including background on the use of the ideal gas specific heat ratio as an estimate for the isentropic expansion coefficient in the vapor sizing equations;
- b) to provide sizing techniques that could be used in situations where the assumptions made to develop the sizing equations are not appropriate.

B.1.1.2 The development of the flow equations used in sizing PRVs is based on the following assumptions:

- a) that the flow limiting element in a fully opened PRV is the nozzle in the body of the PRV between the inlet opening and the seating surface;
- b) that the actual flow through a PRV can be adequately estimated by determining the theoretical maximum flow through the nozzle and then adjusting this theoretical flow to account for deviations from ideality;
- c) that the appropriate thermodynamic path for determining the theoretical maximum flow through the nozzle is adiabatic and reversible (i.e. isentropic), a common assumption that has been validated experimentally for well-formed nozzles;
- d) that the flow is one dimensional;
- e) that the fluid is homogeneous, i.e. it is in thermal (no heat transfer between phases) and mechanical (phases traveling at the same velocity) equilibrium, and its density is radially uniform normal to the direction of flow.

B.1.1.3 The one-dimensional isentropic nozzle flow assumption provides a standard theoretical framework for the PRV sizing equations. The general volumetric energy balance for isentropic nozzle flow of a homogeneous fluid forms the basis for the mass flux calculation ^[6, 7, 8, 12] that is shown in Equation (B.1) and Equation (B.2).

In USC units:

$$G^2 = \frac{\left[-2 \times \int_{P_1}^P 32.174 \times 144 \times v \times dP \right]}{\left[\frac{v^2}{\rho} \right]_{\max}} = \left[\left(\frac{\rho^2}{\rho_t} \right) \times \left[-2 \times \int_{P_1}^P \frac{4633 \times dP}{\rho} \right] \right]_{\max} \quad (\text{B.1})$$

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In SI units:

$$G^2 = \frac{\left| -2 \times \int_{P_1}^P v \times dP \right|}{\left| \frac{v_t^2}{\rho^2} \right|_{\max}} = \left| \left(\frac{\rho^2}{\rho_t} \right) \times \left| -2 \times \int_{P_1}^P \frac{dP}{\rho} \right| \right|_{\max} \quad (\text{B.2})$$

where

- max is the maximization of this calculation with respect to pressure;
- G is the theoretical mass flux (mass flow per unit area) through the nozzle, lb/s·ft² (kg/s·m²);
- v is the specific volume of the fluid, ft³/lb (m³/kg);
- ρ is the mass density of the fluid, lb/ft³ (kg/m³);
- P is the stagnation pressure of the fluid, psia (Pa);
- 1 represents conditions at the inlet to the nozzle;
- t represents the conditions at the throat of the nozzle where the cross-sectional area is minimized.

B.1.1.4 It is important to note that this energy balance is valid irrespective of the nonideality or compressibility of the fluid. As a result, this general expression for isentropic nozzle flux can be used for any homogeneous fluid provided the relationship of fluid density to pressure at constant entropy is known.

B.1.1.5 Where the integral cannot be evaluated analytically, it can be evaluated numerically for any fluid by direct summation over small pressure intervals using an appropriate quadrature technique (e.g. Trapezoidal Rule or Simpson's Rule). The error associated with the numerical integration technique is related to the size of the increment, with the smaller increment resulting in less error. The user is cautioned that fluid property data may not always be available, or the thermodynamic property model may not represent the true behavior of the specific fluid at or near the relieving conditions. In this case, additional work, possibly including bench scale testing, may be required to determine a suitable set of fluid properties. Using the Trapezoidal Rule, the isentropic mass flux integration can be estimated as shown in Equation (B.3).

$$\int_{P_1}^{P_n} v \times dP \approx - \times \sum_{j=1}^{n-1} \frac{v_{j+1} + v_j}{2} (P_{j+1} - P_j) \quad (\text{B.3})$$

where

- v is the specific volume of the fluid, ft³/lb (m³/kg);
- P is the pressure of the fluid, psia (Pa);
- 1 represents conditions at the inlet to the nozzle;
- n represents the conditions at the assumed endpoint pressure;
- j is the increment counter used for summation purposes.

B.1.1.6 If the size of the pressure increment is constant for each step, the integration estimated by the Trapezoidal Rule simplifies as shown in Equation (B.4).

$$\int_{P_1}^{P_n} v \times dP \approx \frac{h}{2} \times \left(v_1 + v_n + \sum_{j=2}^{n-1} v_j \right) \quad (\text{B.4})$$

where

- v is the specific volume of the fluid, ft³/lb (m³/kg);
- P is the pressure of the fluid, psia (Pa);
- h is the constant pressure step size chosen for summation purposes, psi (Pa);
- 1 represents conditions at the inlet to the nozzle;
- n represents conditions at the assumed throat pressure (i.e. the assumed endpoint pressure for the integral);
- j is the increment counter used for summation purposes.

B.1.1.7 The isentropic nozzle mass flux expression is evaluated at each pressure interval until a maximum mass flux is obtained or the total backpressure at the nozzle is reached, whichever occurs first. If the throat pressure corresponding to the maximum mass flux is greater than the total backpressure, this indicates that the flow is choked in the nozzle. It is important to note that the specific volume for each pressure increment is the specific volume at the end of that pressure increment for each step in the summation.

B.1.1.8 A convenient basis for defining the constant pressure step size, h , is to subtract the minimum backpressure on the PRV (typically atmospheric pressure) from the inlet relief pressure, and to use a pressure interval that is 1 % of the total pressure range. Note that for compressible fluids, the entire pressure range may not need to be evaluated due to the potential for reaching the maximum mass flux before the backpressure. To ensure that an appropriate step size was chosen, the calculation may be rerun with a smaller step size, and the results compared to determine whether or not the value changes significantly from the previous calculation.

B.1.2 General Applicability

The applicability of the isentropic nozzle mass flux expression [Equation (B.1) and Equation (B.2)] for all homogeneous fluid regimes provides not only a generic calculation technique covering all common sizing equations but also a useful technique for situations not represented by the common sizing equations. Such situations would include compressible supercritical fluids that may enter the two-phase region as the pressure is decreased along an isentropic path.

B.1.3 Numerical Integration Example

B.1.3.1 In this example calculation of the theoretical nozzle mass flux, a supercritical fluid is relieved and enters the two-phase region; the following data are given.

- The relief fluid consists of supercritical ethylene at stagnation conditions.
- The pressure, P_1 , of the relief fluid entering the nozzle is 797.7 psia (5500 kPa).
- The temperature, T_1 , of the relief fluid entering the nozzle is 80 °F (300 K).
- The backpressure on the PRV is atmospheric pressure [14.7 psia (101.325 kPa)].

B.1.3.2 In this example, the following data are derived.

- Total pressure range of $797.7 - 14.7 = 783$ psi ($5500 - 101.3 = 5399$ kPa).
- Pressure interval for summation purposes $0.01 \times 783 = 7.83$ psi (54 kPa).
- The table of pressure (P), temperature (T), and specific volume (v) data at constant entropy shown in Table B.1.

NOTE Fluid property packages are commercially available to perform constant entropy flashes to get the necessary properties to perform this analysis.

B.1.3.3 Results of the integration of Equation (B.1) or Equation (B.2) using Equation (B.4) are shown in Table B.1.

B.1.3.4 The maximum theoretical mass flux of 3201 lb/s·ft² ($15,630$ kg/s·m²) was encountered at a pressure of 468.8 psia (3232 kPa), well before the minimum expected backpressure of 14.7 psia (101.325 kPa) was reached.

B.1.4 Capacity Corrections

B.1.4.1 Once the theoretical mass flux through the nozzle has been determined, various correction factors are employed to derive an expression for the PRV rated capacity corrected for the actual overpressure. These correction factors may include coefficients of discharge (K_d), backpressure correction factors (K_b and K_w), viscosity correction factors (K_v), and combination capacity correction factors (K_c) depending on the applicability of those correction factors. A general expression for the PRV sizing equation is shown in Equation (B.5).

$$W = GAI\pi[K] \quad (\text{B.5})$$

where

- G is the theoretical mass flux through the nozzle, lb/s·ft² (kg/s·m²);
- W is the mass flow through the PRV, lb/s (kg/s);
- A is the discharge area of the PRV, ft² (m²);
- $I\pi[K]$ is the product of all applicable correction factors (no units).

B.1.4.2 Note that when using the direct numerical integration technique, the choice of the applicable correction factors should be made based on the nature of the relieving fluid. For fluids that behave as incompressible fluids or those that do not choke within the PRV itself, correction factors pertaining to liquid and/or subcooled flashing liquid service have been used. For fluids that behave as compressible fluids or those that do choke within the PRV itself, correction factors pertaining to vapor and/or two-phase service have been used [8, 9, 10].

B.2 Flow Equations for Subcooled Liquids

B.2.1 General

B.2.1.1 For highly subcooled liquids that have a vapor pressure lower than the lowest pressure on the outlet of the PRV and are incompressible, the isentropic nozzle flux expression [Equation (B.1) and Equation (B.2)] is readily simplified. The incompressible constraint indicates that the density is constant regardless of the pressure of the liquid. In addition, the highly subcooled liquid with a vapor pressure below the lowest pressure on the outlet of the PRV indicates that the liquid will not flash as it flows through the valve and thus will not choke. As a result, the pressure at the throat of the nozzle is the same as the total backpressure on the PRV, and the theoretical mass flux equation simplifies to Equation (B.6) and Equation (B.7).

Table B.1—Results for Supercritical Fluid Example Problem B.1.3

P psia (kPa)	T °F (K)	v ft ³ /lb (m ³ /kg)	Integral Term from Equation (B.1) or (B.2) ft ² /s ² (m ² /s ²)	Mass Flux lb/s-ft ² (kg/s-m ²)
797.7 (5500)	80.33 (300.0000)	0.152 (0.009477)	—	—
789.9 (5446)	79.06 (299.2919)	0.153 (0.009552)	5530 (514)	687 (3356)
782.0 (5392)	77.77 (298.5773)	0.154 (0.009628)	11,105 (1032)	966 (4718)
774.2 (5338)	76.47 (297.8560)	0.155 (0.009706)	16,724 (1554)	1176 (5743)
766.4 (5284)	75.16 (297.1279)	0.157 (0.009785)	22,388 (2080)	1350 (6591)
758.6 (5230)	73.84 (296.3929)	0.158 (0.009866)	28,100 (2611)	1500 (7324)
750.7 (5176)	72.50 (295.6508)	0.159 (0.009949)	33,858 (3146)	1633 (7972)
742.9 (5122)	71.15 (294.9016)	0.161 (0.010033)	39,666 (3685)	1753 (8557)
735.1 (5068)	69.79 (294.1451)	0.162 (0.010119)	45,523 (4229)	1861 (9088)
727.2 (5014)	68.42 (293.3813)	0.164 (0.010207)	51,430 (4778)	1962 (9577)
719.4 (4960)	67.03 (292.6099)	0.165 (0.010297)	57,389 (5332)	2054 (10,028)
711.6 (4906)	65.63 (291.8308)	0.166 (0.010389)	63,401 (5890)	2140 (10,447)
703.7 (4852)	64.21 (291.0440)	0.168 (0.010483)	69,467 (6454)	2220 (10,838)
695.9 (4798)	62.78 (290.2492)	0.169 (0.010579)	75,588 (7022)	2295 (11,203)
688.1 (4744)	61.33 (289.4463)	0.171 (0.010677)	81,765 (7596)	2365 (11,545)
680.2 (4690)	59.87 (288.6352)	0.173 (0.010777)	88,000 (8176)	2430 (11,865)
672.4 (4636)	58.40 (287.8157)	0.174 (0.010879)	94,293 (8760)	2492 (12,167)
664.6 (4582)	56.91 (286.9877)	0.176 (0.010984)	100,647 (9351)	2550 (12,450)
656.7 (4528)	55.40 (286.1509)	0.178 (0.011091)	107,063 (9947)	2605 (12,716)
648.9 (4474)	53.88 (285.3052)	0.179 (0.011201)	113,542 (10,548)	2656 (12,967)
641.1 (4420)	52.34 (284.4505)	0.181 (0.011314)	120,085 (11,156)	2704 (13,203)
633.2 (4366)	50.79 (283.5866)	0.183 (0.011429)	126,695 (11,770)	2750 (13,425)
625.4 (4312)	49.21 (282.7132)	0.185 (0.011547)	13,3372 (12,391)	2792 (13,633)
617.6 (4258)	47.62 (281.8302)	0.187 (0.011668)	140,119 (13,018)	2832 (13,829)
609.7 (4204)	46.02 (280.9373)	0.189 (0.011791)	146,936 (13,651)	2870 (14,013)

Table B.1—Results for Supercritical Fluid Example Problem B.1.3 *(continued)*

P psia (kPa)	T °F (K)	v ft ³ /lb (m ³ /kg)	Integral Term from Equation (B.1) or (B.2) ft ² /s ² (m ² /s ²)	Mass Flux lb/s-ft ² (kg/s-m ²)
601.9 (4150)	44.39 (280.0345)	0.191 (0.011918)	153,827 (14,291)	2905 (14,185)
594.1 (4096)	42.75 (279.1214)	0.193 (0.012049)	160,792 (14,938)	2938 (14,346)
586.2 (4042)	41.09 (278.1978)	0.195 (0.012182)	167,834 (15,592)	2969 (14,496)
578.4 (3988)	39.40 (277.2635)	0.197 (0.012319)	174,955 (16,254)	2998 (14,636)
570.6 (3934)	37.70 (276.3184)	0.200 (0.012460)	182,156 (16,923)	3024 (14,766)
562.7 (3880)	35.98 (275.3620)	0.202 (0.012604)	189,440 (17,600)	3049 (14,885)
554.9 (3826)	34.24 (274.3942)	0.204 (0.012752)	196,809 (18,284)	3071 (14,996)
547.1 (3772)	32.48 (273.4147)	0.207 (0.012905)	204,266 (18,977)	3092 (15,097)
539.3 (3718)	30.69 (272.4233)	0.209 (0.013061)	211,812 (19,678)	3111 (15,189)
531.4 (3664)	28.89 (271.4196)	0.212 (0.013222)	219,450 (20,388)	3128 (15,272)
523.6 (3610)	27.06 (270.4034)	0.214 (0.013388)	227,184 (21,106)	3143 (15,347)
515.8 (3556)	25.20 (269.3744)	0.217 (0.013558)	235,015 (21,834)	3157 (15,413)
507.9 (3502)	23.33 (268.3321)	0.220 (0.013733)	242,946 (22,571)	3169 (15,471)
500.1 (3448)	21.43 (267.2764)	0.223 (0.013914)	250,981 (23,317)	3179 (15,521)
492.3 (3394)	19.50 (266.2069)	0.226 (0.014100)	259,122 (24,073)	3187 (15,562)
484.4 (3340)	17.55 (265.1231)	0.229 (0.014291)	267,373 (24,840)	3194 (15,596)
476.6 (3286)	15.57 (264.0248)	0.232 (0.014489)	275,737 (25,617)	3200 (15,622)
468.8 (3232)	13.73 (262.9991)	0.236 (0.014703)	284,221 (26,405)	3201 (15,630)
460.9 (3178)	12.47 (262.3016)	0.240 (0.014964)	292,843 (27,206)	3193 (15,588)
453.1 (3124)	11.20 (261.5952)	0.244 (0.015234)	301,619 (28,022)	3183 (15,540)
445.3 (3070)	9.91 (260.8797)	0.248 (0.015512)	310,555 (28,852)	3172 (15,485)

In USC units:

$$G = \sqrt{\frac{2 \times 4633 \times (P_1 - P_2)}{v}} = \sqrt{2 \times 4633 \times \rho \times (P_1 - P_2)} \quad (\text{B.6})$$

In SI units:

$$G = \sqrt{\frac{2 \times (P_1 - P_2)}{v}} = \sqrt{2 \times \rho \times (P_1 - P_2)} \quad (\text{B.7})$$

where

G is the theoretical mass flux through the nozzle, lb/s·ft² (kg/s·m²);

v is the specific volume of the fluid, ft³/lb (m³/kg);

ρ is the mass density of the fluid, lb/ft³ (kg/m³);

P is the pressure of the fluid, psia (Pa);

1 represents conditions at the inlet to the nozzle;

2 represents conditions at the outlet of the nozzle.

B.2.1.2 The final expressions for liquid PRV sizing presented in this standard (see 5.8) are obtained by algebraically rearranging these equations, substituting what is believed to be readily available variables (e.g. specific gravity instead of density), and applying the appropriate correction factors (see B.1.4).

B.2.2 Subcooled Liquid Example

B.2.2.1 In this example, the following data are given.

- The relief fluid consists of subcooled liquid water at stagnation conditions.
- The pressure, P_1 , of the relief fluid entering the nozzle is 114.7 psia (791 kPa).
- The temperature, T_1 , of the relief fluid entering the nozzle is 80 °F (300 K).
- The backpressure on the PRV is atmospheric pressure or 14.7 psia (101.325 kPa).

B.2.2.2 In this example, the following data are derived.

- Total pressure range of $114.7 - 14.7 = 100$ psi (689.5 kPa).
- Pressure interval for summation purposes $0.1 \times 100 = 10$ psi (69 kPa).
- The table of pressure (P), temperature (T), and specific volume (v) data at constant entropy shown in Table B.2.

NOTE Fluid property packages are commercially available to perform constant entropy flashes to get the necessary properties to perform this analysis.

B.2.2.3 Results of the integration of Equation (B.1) or Equation (B.2) using Equation (B.4) are shown in Table B.2.

B.2.2.4 The maximum mass flux of 7592 lb/s·ft² (37,068 kg/s·m²) was encountered at a pressure of 14.7 psia (101.325 kPa), which is the minimum backpressure on the PRV.

Table B.2—Results for Subcooled Liquid Example Problem B.2.2

P psia (kPa)	T °F (K)	v ft ³ /lb (m ³ /kg)	Integral Term from Equation (B.1) or (B.2) ft ² /s ² (m ² /s ²)	Mass Flux lb/s-ft ² (kg/s-m ²)
114.7 (790.800)	80.33 (300.0000)	0.016069 (0.0010031)	—	—
104.7 (721.900)	80.33 (299.9986)	0.016069 (0.0010032)	745 (69.2)	2401 (11,724)
94.7 (652.900)	80.33 (299.9973)	0.016070 (0.0010032)	1489 (138.0)	3396 (16,580)
84.7 (584.000)	80.32 (299.9959)	0.016070 (0.0010032)	2234 (208.0)	4159 (20,306)
74.7 (515.000)	80.32 (299.9945)	0.016071 (0.0010033)	2978 (277.0)	4802 (23,447)
64.7 (446.100)	80.32 (299.9932)	0.016071 (0.0010033)	3723 (346.0)	5369 (26,214)
54.7 (377.100)	80.32 (299.9918)	0.016072 (0.0010033)	4467 (415.0)	5881 (28,716)
44.7 (308.200)	80.31 (299.9904)	0.016072 (0.0010034)	5212 (484.0)	6352 (31,016)
34.7 (239.200)	80.31 (299.9891)	0.016073 (0.0010034)	5957 (553.0)	6791 (33,156)
24.7 (170.300)	80.31 (299.9877)	0.016073 (0.0010034)	6701 (623.0)	7203 (35,167)
14.7 (101.325)	80.31 (299.9863)	0.016074 (0.0010035)	7446 (692.0)	7592 (37,068)

B.2.3 Comparison of Results to Liquid Sizing Equations

B.2.3.1 For comparison purposes, the required orifice area of a PRV can be determined using the integration approach of the sample problem in B.2.2 and the liquid sizing formula presented in 5.8 [Equation (32) and Equation (33)]. The following data are given.

— Required flow rate of 528 gal/min (2000 L/min).

B.2.3.2 For this comparison, the following data are derived.

— Specific gravity of the fluid at inlet conditions = 0.9969.

— Effective coefficient of discharge for preliminary sizing, $K_d = 0.65$.

— All other correction factors (K_w , K_c , and K_v) = 1.0.

B.2.3.3 Using the theoretical mass flux obtained from numerical integration above, one may determine the required effective discharge area.

In USC units:

$$A = \frac{W}{G \times K_d} = \frac{Q \times \rho}{60 \frac{\text{sec}}{\text{min}} \times 7.4805 \frac{\text{gal}}{\text{ft}^3}} \times \frac{1}{G \times K_d}$$

$$A = \frac{528 \times 62.2}{60 \times 7.4805} \times \frac{1}{7592.14 \times 0.65} = 0.0148 \text{ ft}^2 = 2.135 \text{ in.}^2 \quad (\text{B.8})$$

In SI units:

$$A = \frac{W}{G \times K_d} = \frac{Q \times \rho}{60 \frac{\text{sec}}{\text{min}} \times 1000 \frac{\text{liter}}{\text{m}^3}} \times \frac{1}{G \times K_d}$$

$$A = \frac{2000 \times 996.9}{60 \times 1000} \times \frac{1}{37,068 \times 0.65} = 1.379 \times 10^{-3} \text{ m}^2 = 1379 \text{ mm}^2 \quad (\text{B.9})$$

where

G is the theoretical mass flux through the nozzle, lb/s-ft² (kg/s-m²);

W is the required relief rate, lb/s (kg/s);

Q is the required relief rate, gal/min (L/min);

$\rho = \frac{1}{V}$ is the fluid density, lb/ft³ (kg/m³);

K_d is the effective coefficient of discharge (no units);

A is the required effective discharge area, ft² (m²).

B.2.3.4 Using the liquid sizing [Equation (32) and Equation (33)], one may also determine the required effective discharge area.

In USC units:

$$A = \frac{Q}{38 \times K_d \times K_w \times K_c \times K_v} \sqrt{\frac{G_1}{P_1 - P_2}}$$

$$A = \frac{528}{38 \times 0.65 \times 1.0 \times 1.0 \times 1.0} \sqrt{\frac{0.997}{114.7 - 14.7}} = 2.134 \text{ in.}^2 \quad (\text{B.10})$$

In SI units:

$$A = \frac{11.78 \times Q}{K_d \times K_w \times K_c \times K_v} \sqrt{\frac{G_1}{P_1 - P_2}}$$

$$A = \frac{11.78 \times 2000}{1.0 \times 1.0 \times 1.0} \sqrt{\frac{0.997}{790.830 - 101.325}} = 1378 \text{ mm}^2 \quad (\text{B.11})$$

where

- Q is the required relief rate, gal/min (L/min);
- G_1 is the specific gravity of the fluid at flowing temperature (no units);
- P_1 is the pressure at the inlet to the PRV, psia (kPa);
- P_2 is the backpressure on the PRV, psia (kPa);
- K_d is the effective coefficient of discharge (no units);
- K_w is the correction factor due to backpressure;
- K_c is the combination correction factor for installations with a rupture disk upstream of the PRV;
- K_v is the correction factor due to viscosity;
- A is the required effective discharge area, in.² (mm²).

B.3 Flow Equations for Gases and Vapors

B.3.1 Real Gases

B.3.1.1 For vapors and gases with a constant isentropic expansion coefficient, the expression for the specific volume to pressure relationship along an isentropic path is shown in Equation (B.12).

$$P \times v_1^n = P_1 \times v_1^n \quad (\text{B.12})$$

where

- v is the specific volume of the fluid, ft³/lb (m³/kg);
- P is the pressure of the fluid, psia (Pa);
- 1 represents conditions at the inlet to the nozzle;
- n is the isentropic expansion coefficient.

B.3.1.2 Determining the isentropic expansion coefficient for a real gas is somewhat complicated because it is a function of both pressure and temperature, and while in most cases it is relatively constant, it may vary throughout the expansion process. The coefficient can generally be obtained from an equation of state that describes the pressure volume relationship along an isentropic expansion path.

In the event the isentropic expansion coefficient is constant, an expression for the isentropic expansion coefficient in terms of thermodynamic state variables can be derived. This expression is shown in Equation (B.13).

$$n = -\frac{v}{P} \times \left(\frac{\partial P}{\partial v} \right)_T \times \frac{C_p}{C_v} \quad (\text{B.13})$$

where

- n is the isentropic expansion coefficient;
- v is the specific volume of the fluid, ft³/lb (m³/kg);
- P is the pressure of the fluid, psia (Pa);
- T represents the partial derivative taken at constant temperature;
- C_p is the specific heat capacity of the fluid at constant pressure, Btu/lb°F (J/kg°C);
- C_v is the specific heat capacity of the fluid at constant volume, Btu/lb°F (J/kg°C).

B.3.1.3 Note that these variables can be evaluated at any point along the isentropic path; however, the inlet conditions are most convenient as the relief temperature is known at this point and the specific heat capacities can be readily obtained.

B.3.1.4 Alternatively, an isentropic expansion coefficient can be used based on an average value between the upstream pressure and the pressure in the throat of the nozzle that, in the case of maximum flow, is the critical flow pressure.

B.3.1.5 For vapors and gases that follow the constant isentropic expansion expression, the isentropic nozzle flux equation [Equation (B.1) and Equation (B.2)] can be solved analytically to give the expression shown in Equation (B.14) and Equation (B.15).

In USC units:

$$G^2 = \left(\frac{2 \times 4633}{v_1 \times P_1^{1/n}} \right) \times \left(\frac{P_1^2}{n} \right) \times \left(\frac{1}{n-1} \right) \times \left(P_1^{n-1} - P^{n-1} \right) \quad (\text{B.14})$$

In SI units:

$$G^2 = \left(\frac{2}{v_1 \times P_1^{1/n}} \right) \times \left(\frac{P_1^2}{n} \right) \times \left(\frac{1}{n-1} \right) \times \left(P_1^{n-1} - P^{n-1} \right) \quad (\text{B.15})$$

where

- G is the mass flux through the nozzle, lb/s·ft² (kg/s·m²);
- n is the isentropic expansion coefficient;
- v is the specific volume of the fluid, ft³/lb (m³/kg);

- P is the pressure of the fluid, psia (Pa);
- 1 represents conditions at the inlet of the nozzle;
- t represents conditions at the throat of the nozzle.

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B.3.1.6 For the special case of an isentropic expansion coefficient equal to 1.0:

In USC units:

$$G^2 = \left(\frac{2 \times 4633}{v_1 \times P_1} \right) \times P^2 \times \ln P - \ln P \quad (\text{B.16})$$

$$\left(\frac{1}{v_1 \times P_1} \right) \left(\frac{1}{t} \right) \left(\frac{1}{1} - \frac{1}{t} \right)$$

In SI units:

$$G^2 = \left(\frac{2}{v_1 \times P_1} \right) \times P^2 \times \ln P - \ln P \quad (\text{B.17})$$

where

G is the mass flux through the nozzle, lb/s·ft² (kg/s·m²);

v is the specific volume of the fluid, ft³/lb (m³/kg);

P is the pressure of the fluid, psia (Pa);

1 represents conditions at the inlet of the nozzle;

t represents conditions at the throat of the nozzle.

B.3.1.7 For vapors and gases that follow the constant isentropic expansion expression, the pressure at which maximum mass flux is obtained in the nozzle (i.e. the choking pressure) can be determined as a function of the inlet pressure and the isentropic expansion coefficient, as shown in Equation (B.18) for values of n not equal to 1.0.

$$P_{\text{choke}} = P_1 \times \left(\frac{2}{n+1} \right)^{\frac{n}{n-1}} \quad (\text{B.18})$$

where

n is the isentropic expansion coefficient;

P is the pressure of the fluid, psia (Pa);

1 represents conditions at the inlet of the nozzle;

choke represents the choking condition.

B.3.1.8 For the special case of an isentropic expansion coefficient equal to 1.0:

$$P_{\text{choke}} = P_1 \times \frac{1}{\sqrt{e}} \quad (\text{B.19})$$

where

e is the base of the natural logarithm ≈ 2.7183 ;

P is the pressure of the fluid, psia (Pa);

1 represents conditions at the inlet of the nozzle; ;

choke represents the choking condition.

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B.3.1.9 The backpressure on the PRV outlet can then be compared to the choking pressure of the fluid in order to determine whether or not the flow is choked through the nozzle. If the flow is choked (i.e. the backpressure is less than the choking pressure), then the pressure at the throat of the nozzle is the choking pressure; otherwise, the flow is not choked (i.e. the backpressure is greater than the choking pressure), and the pressure at the throat of the nozzle is the backpressure. This effective throat pressure can then be used in the expression shown in Equation (B.14) or Equation (B.15). In the event the flow is choked, the analytical expressions can be simplified even further by substituting Equation (B.18) into Equation (B.14) or Equation (B.15), as shown in Equation (B.20) and Equation (B.21).

In USC units:

$$G^2 = 4633 \times \left(\frac{P_1}{v_1} \right)^{\frac{n+1}{n}} \times \left(\frac{1}{n+1} \right)^{\frac{n+1}{n-1}} \quad (\text{B.20})$$

In SI units:

$$G^2 = \left(\frac{P_1}{v_1} \right)^{\frac{n+1}{n}} \times \left(\frac{1}{n+1} \right)^{\frac{n+1}{n-1}} \quad (\text{B.21})$$

where

- G is the mass flux through the nozzle, lb/s·ft² (kg/s·m²);
- n is the isentropic expansion coefficient;
- v is the specific volume of the fluid, ft³/lb (m³/kg);
- P is the pressure of the fluid, psia (Pa);
- 1 represents conditions at the inlet of the nozzle.

B.3.1.10 For the special case of an isentropic expansion coefficient equal to 1.0:

In USC units:

$$G^2 = 4633 \times \left(\frac{P_1}{v_1} \right)^{\frac{1}{e}} \times \frac{1}{e} \quad (\text{B.22})$$

In SI units:

$$G^2 = \left(\frac{P_1}{v_1} \right)^{\frac{1}{e}} \times \frac{1}{e} \quad (\text{B.23})$$

where

- G is the mass flux through the nozzle, lb/s·ft² (kg/s·m²);
- v is the specific volume of the fluid, ft³/lb (m³/kg);
- P is the pressure of the fluid, psia (Pa);
- e is the base of the natural logarithm ◆ 2.7183;

1 represents conditions at the inlet of the nozzle.

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B.3.1.11 As the temperature and compressibility factor for vapors and gases may be more readily available than the specific volume, the real gas law as shown in Equation (B.24) may be used to substitute these variables for the specific volume, as shown in Equation (B.25) and Equation (B.26).

$$P \times v = Z \times \frac{R_u}{M} \times T \quad (\text{B.24})$$

where

- P is the pressure of the fluid, psia (Pa);
- v is the specific volume of the fluid, ft³/lb (m³/kg);
- Z is the compressibility factor of the fluid (no units);
- R_u is the universal gas constant = 10.73 psia·ft³/lb-mole·°R (8.314 Pa·m³/kg-mole·K);
- M is the molecular weight, lb/lb-mole (kg/kg-mole);
- T is the temperature of the fluid, °R (K).

In USC units:

$$G^2 = 4633 \left(\frac{P_1 M}{Z_1 \times R_u \times T_1} \right)^{\frac{n+1}{n-1}} \left(\frac{2}{n+1} \right)^{\frac{n+1}{n-1}} \quad (\text{B.25})$$

In SI units:

$$G^2 = \left(\frac{P_1^2 M}{Z_1 \times R_u \times T_1} \right)^{\frac{n+1}{n-1}} \left(\frac{2}{n+1} \right)^{\frac{n+1}{n-1}} \quad (\text{B.26})$$

where

- G is the mass flux through the nozzle, lb/s·ft² (kg/s·m²);
- n is the isentropic expansion coefficient (no units);
- P is the pressure of the fluid, psia (Pa);
- Z is the compressibility factor of the fluid, no units;
- R_u is the universal gas constant = 10.73 psia·ft³/lb-mole·°R (8.314 Pa·m³/kg-mole·K);
- M is the molecular weight, lb/lb-mole (kg/kg-mole);
- T is the temperature of the fluid, °R (K);
- 1 represents conditions at the inlet of the nozzle.

B.3.2 Ideal Gas Assumption

B.3.2.1 For vapors and gases that can be considered ideal gases, which follow the ideal gas law as shown in Equation (B.27), the expression for the constant isentropic expansion coefficient [Equation (B.13)] can be further reduced by deriving the expression for the partial derivative of pressure with respect to specific volume at constant temperature for the ideal gas. The isentropic expansion coefficient for an ideal gas is constant and is the ratio of the ideal gas specific heat capacity at constant pressure to the ideal gas specific heat capacity at constant volume (i.e. the ideal gas specific heat ratio, k), as shown in Equation (B.28).

$$P \times v = \frac{R_u}{M} \times T \quad (\text{B.27})$$

where

P is the pressure of the fluid, psia (Pa);

v is the specific volume of the fluid, ft³/lb (m³/kg);

R_u is the universal gas constant = 10.73 psia·ft³/lb-mole·°R (8.314 Pa·m³/kg-mole·K);

M is the molecular weight, lb/lb-mole (kg/kg-mole);

T is the temperature of the fluid, °R (K).

B.3.2.2 It is important to note that the derivation of the ideal gas specific heat ratio, k , as an approximation for the isentropic expansion coefficient, n , is based on the ideal gas assumption, where specific heat capacities vary only with temperature and the compressibility factor, Z , is equal to 1.

$$k = -\frac{v}{P} \times \left(-\frac{P}{v} \right) \times \frac{C_p^*}{C_v^*} = \frac{C_p^*}{C_v^*} \quad (\text{B.28})$$

where

k is the isentropic expansion coefficient for an ideal gas;

P is the pressure of the fluid, psia (Pa);

v is the specific volume of the fluid, ft³/lb (m³/kg);

C_p is the specific heat capacity at constant pressure, Btu/lb·°F (J/kg·°C);

C_v is the specific heat capacity at constant volume, Btu/lb·°F (J/kg·°C);

* denotes the value as determined for an ideal gas.

B.3.2.3 This expression can be evaluated at any point along the isentropic path; however, the inlet conditions are most convenient as the relief temperature is known at this point and the specific heat capacities can be readily obtained. It is useful to note that the ideal gas specific heat ratio is typically not significantly dependent on temperature (and is not dependent at all on pressure); hence, the ideal gas specific heat ratio at standard conditions may be a good estimate in the absence of other information.

B.3.2.4 The final expressions for PRV sizing in vapor service presented in 5.6 are obtained by algebraically rearranging these equations, substituting readily available variables (e.g. using the expression for specific volume as a function of temperature, pressure, compressibility factor, and the ideal gas k), and applying the appropriate correction factors. Note that the inclusion of a compressibility factor other than unity constitutes a deviation from ideal gas behavior. It is also important to note that some of the algebraic manipulation involves the introduction of additional variables that represent parts of the equation and/or unit conversions, such as the variable C in the choked flow calculations, and the variable F_2 in the nonchoked flow calculations.

B.3.2.5 Although many vapors encountered in refinery service do not follow the ideal gas law, in most cases, a PRV is adequately sized based on this assumption. A gas or vapor is close to ideal when the compressibility factor is close to one; nonetheless, the use of the ideal gas assumption for relief device sizing has been found not to introduce significant error for low molecular weight hydrocarbons with compressibility factors greater than 0.8 [11]. Note that this assumption can lead to oversized relief devices. See 5.6.1 for additional guidance on determining when the ideal gas assumption may not be appropriate and potential alternatives.

B.3.3 Gas Example

B.3.3.1 In this example, the following data are given.

- The relief fluid consists of superheated air at stagnation conditions.
- The pressure, P_1 , of the relief fluid entering the nozzle is 114.7 psia (790.8 kPa).
- The temperature, T_1 , of the relief fluid entering the nozzle is 80 °F (300 K).
- The backpressure on the PRV is atmospheric pressure of 14.7 psia (101.325 kPa).

B.3.3.2 In this example, the following data are derived.

- Total pressure range of $114.7 - 14.7 = 100$ psi ($790.8 - 101.3 = 689.5$ kPa).
- Pressure interval for summation purposes $0.01 \times 100 = 1$ psi (6.895 kPa).
- The table of pressure (P), temperature (T), and specific volume (v) data at constant entropy shown in Table B.3.

NOTE Fluid property packages are commercially available to perform constant entropy flashes to get the necessary properties to perform this analysis.

B.3.3.3 Results of the integration of Equation (B.1) or Equation (B.2) using Equation (B.4) are shown in Table B.3.

B.3.3.4 The maximum mass flux of 379.1 lb/s-ft² (1851 kg/s-m²) was encountered at a pressure of 60.7 psia (418.5 kPa).

Table B.3—Results for Gas Example Problem B.3.3

P psia (kPa)	T °F (K)	v ft ³ /lb (m ³ /kg)	Integral Term from Equation (B.1) or (B.2) ft ² /s ² (m ² /s ²)	Mass Flux lb/s-ft ² (kg/s-m ²)
114.7 (790.8)	80.33 (300.0000)	1.741 (0.108670)	—	—
113.7 (783.9)	78.97 (299.2462)	1.752 (0.109347)	8090 (752)	72.6 (354.6)
112.7 (777.0)	77.61 (298.4876)	1.763 (0.110034)	16,231 (1508)	102.2 (499.1)
111.7 (770.1)	76.23 (297.7242)	1.774 (0.110731)	24,423 (2269)	124.6 (608.4)
110.7 (763.2)	74.85 (296.9559)	1.785 (0.111440)	32,668 (3035)	143.2 (699.1)
109.7 (756.4)	73.46 (296.1827)	1.797 (0.112159)	40,965 (3806)	159.3 (777.9)
108.7 (749.5)	72.06 (295.4043)	1.808 (0.112890)	49,316 (4582)	173.7 (848.0)
107.7 (742.6)	70.65 (294.6209)	1.820 (0.113632)	57,722 (5363)	186.7 (911.4)
106.7 (735.7)	69.23 (293.8322)	1.832 (0.114386)	66,184 (6149)	198.6 (969.5)
105.7 (728.8)	67.80 (293.0382)	1.845 (0.115153)	74,702 (6940)	209.6 (1023.1)
104.7 (721.9)	66.36 (292.2388)	1.857 (0.115931)	83,277 (7737)	219.8 (1073.0)
103.7 (715.0)	64.91 (291.4340)	1.870 (0.116723)	91,910 (8539)	229.3 (1119.6)
102.7 (708.1)	63.45 (290.6230)	1.883 (0.117528)	100,603 (9346)	238.3 (1163.3)
101.7 (701.2)	61.98 (289.8075)	1.896 (0.118347)	109,356 (10,160)	246.7 (1204.5)
100.7 (694.3)	60.50 (288.9857)	1.909 (0.119179)	118,170 (10,978)	254.7 (1243.3)
99.7 (687.4)	59.01 (288.1580)	1.923 (0.120026)	127,047 (11,803)	262.2 (1280.1)
98.7 (680.5)	57.51 (287.3243)	1.936 (0.120888)	135,987 (12,634)	269.3 (1314.9)
97.7 (673.6)	56.00 (286.4847)	1.950 (0.121764)	144,991 (13,470)	276.1 (1348.0)
96.7 (666.7)	54.48 (285.6388)	1.965 (0.122656)	154,061 (14,313)	282.5 (1379.4)
95.7 (659.8)	52.95 (284.7867)	1.979 (0.123564)	163,198 (15,162)	288.6 (1409.3)
94.7 (652.9)	51.40 (283.9282)	1.994 (0.124489)	172,403 (16,017)	294.5 (1437.7)
93.7 (646.0)	49.84 (283.0632)	2.009 (0.125430)	181,677 (16,879)	300.0 (1464.8)
92.7 (639.1)	48.27 (282.1916)	2.025 (0.126389)	191,022 (17,747)	305.3 (1490.6)
91.7 (632.2)	46.69 (281.3132)	2.040 (0.127365)	200,438 (18,621)	310.3 (1515.2)
90.7 (625.3)	45.10 (280.4280)	2.056 (0.128360)	209,928 (19,503)	315.1 (1538.6)
89.7 (618.5)	43.49 (279.5358)	2.072 (0.129374)	219,492 (20,392)	319.7 (1561.0)
88.7 (611.6)	41.88 (278.6364)	2.089 (0.130408)	229,132 (21,287)	324.1 (1582.2)
87.7 (604.7)	40.24 (277.7298)	2.106 (0.131462)	238,849 (22,190)	328.2 (1602.5)
86.7 (597.8)	38.60 (276.8158)	2.123 (0.132536)	248,646 (23,100)	332.2 (1621.8)
85.7 (590.9)	36.94 (275.8942)	2.141 (0.133632)	258,523 (24,018)	335.9 (1640.1)

Table B.3—Results for Gas Example Problem B.3.3 *(continued)*

P psia (kPa)	T °F (K)	v ft ³ /lb (m ³ /kg)	Integral Term from Equation (B.1) or (B.2) ft ² /s ² (m ² /s ²)	Mass Flux lb/s-ft ² (kg/s-m ²)
84.7 (584.0)	35.27 (274.9649)	2.158 (0.134750)	268,482 (24,943)	339.5 (1657.5)
83.7 (577.1)	33.58 (274.0277)	2.177 (0.135891)	278,525 (25,876)	342.9 (1674.1)
82.7 (570.2)	31.88 (273.0825)	2.195 (0.137056)	288,654 (26,817)	346.1 (1689.8)
81.7 (563.3)	30.16 (272.1292)	2.214 (0.138245)	298,870 (27,766)	349.1 (1704.6)
80.7 (556.4)	28.43 (271.1674)	2.234 (0.139459)	309,175 (28,724)	352.0 (1718.7)
79.7 (549.5)	26.68 (270.1972)	2.254 (0.140700)	319,571 (29,689)	354.7 (1731.9)
78.7 (542.6)	24.92 (269.2182)	2.274 (0.141967)	330,061 (30,664)	357.3 (1744.4)
77.7 (535.7)	23.14 (268.2303)	2.295 (0.143262)	340,645 (31,647)	359.7 (1756.1)
76.7 (528.8)	21.35 (267.2332)	2.316 (0.144586)	351,327 (32,640)	361.9 (1767.1)
75.7 (521.9)	19.54 (266.2260)	2.338 (0.145940)	362,108 (33,641)	364.0 (1777.4)
74.7 (515.0)	17.71 (265.2110)	2.360 (0.147325)	372,990 (34,652)	366.0 (1786.9)
73.7 (508.1)	15.86 (264.1854)	2.383 (0.148743)	383,977 (35,673)	367.8 (1795.8)
72.7 (501.2)	14.00 (263.1498)	2.406 (0.150193)	395,070 (36,704)	369.5 (1803.9)
71.7 (494.3)	12.12 (262.1040)	2.430 (0.151678)	406,272 (37,744)	371.0 (1811.4)
70.7 (487.4)	10.22 (261.0478)	2.454 (0.153200)	417,586 (38,795)	372.4 (1818.2)
69.7 (480.6)	8.30 (259.9808)	2.479 (0.154758)	429,014 (39,857)	373.7 (1824.4)
68.7 (473.7)	6.36 (258.9029)	2.505 (0.156355)	440,558 (40,930)	374.8 (1829.9)
67.7 (466.8)	4.39 (257.8137)	2.531 (0.157993)	452,223 (42,013)	375.8 (1834.7)
66.7 (459.9)	2.41 (256.7130)	2.558 (0.159673)	464,012 (43,109)	376.6 (1838.9)
65.7 (453.0)	0.41 (255.6005)	2.585 (0.161396)	475,926 (44,215)	377.4 (1842.5)
64.7 (446.1)	−1.61 (254.4759)	2.614 (0.163165)	487,970 (45,334)	378.0 (1845.4)
63.7 (439.2)	−3.66 (253.3387)	2.643 (0.164982)	500,147 (46,466)	378.5 (1847.8)
62.7 (432.3)	−5.73 (252.1888)	2.673 (0.166848)	512,461 (47,610)	378.8 (1849.5)
61.7 (425.4)	−7.82 (251.0258)	2.703 (0.168766)	524,915 (48,767)	379.0 (1850.5)
60.7 (418.5)	−9.94 (249.8492)	2.735 (0.170737)	537,513 (49,937)	379.1 (1851.0)
59.7 (411.6)	−12.08 (248.6587)	2.767 (0.172766)	550,260 (51,121)	379.1 (1850.8)
58.7 (404.7)	−14.25 (247.4539)	2.801 (0.174853)	563,160 (52,320)	378.9 (1850.0)
57.7 (397.8)	−16.45 (246.2345)	2.835 (0.177003)	576,217 (53,533)	378.6 (1848.6)
56.7 (390.9)	−18.67 (244.9998)	2.871 (0.179217)	589,435 (54,761)	378.2 (1846.6)
55.7 (384.0)	−20.92 (243.7496)	2.907 (0.181499)	602,821 (56,004)	377.7 (1844.0)

B.3.4 Comparison of Results to Gas/Vapor Sizing Equations

B.3.4.1 For comparison purposes, the required orifice area of a PRV can be determined using the integration approach of the sample problem in B.3.3 and the vapor sizing formula presented in 5.6 [Equation (6) through Equation (11)]. The following data are given.

- Required flow rate of 158,700 lb/h = 44.09 lb/s (72,000 kg/h = 20 kg/s).
- Assume air is an ideal gas for use with the sizing equations.

B.3.4.2 For this comparison, the following data are derived.

- Fluid molecular weight, $M = 28.96$.
- Fluid compressibility factor, $Z = 1.0$.
- Fluid ideal gas specific heat ratio at standard conditions, $k = 1.4$.
- Ratio of specific heats coefficient, $C = 356.06$ (0.027).
- Effective coefficient of discharge for preliminary sizing, $K_d = 0.975$.
- All other correction factors (K_b and K_c) = 1.0.

B.3.4.3 Using the theoretical mass flux obtained from the numerical integration in example problem in B.3.3, one may determine the required effective discharge area.

In USC units:

$$A = \frac{W}{G \times K_d}$$

$$A = \frac{44.09}{379.1 \times 0.975} = 0.1193 \text{ ft}^2 = 17.176 \text{ in.}^2 \quad (\text{B.29})$$

In SI units:

$$A = \frac{W}{G \times K_d}$$

$$A = \frac{20}{1851 \times 0.975} = 11,082 \times 10^{-6} \text{ m}^2 = 11,082 \text{ mm}^2 \quad (\text{B.30})$$

where

- G is the theoretical mass flux through the nozzle, lb/s·ft² (kg/s·m²);
- W is the required relief rate, lb/s (kg/s);
- K_d is the effective coefficient of discharge (no units);
- A is the required effective discharge area, ft² (m²).

B.3.4.4 Using the critical vapor sizing equation [Equation (6) and Equation (9)], one may also determine the required effective discharge area.

In USC units:

$$A = \frac{W}{C \times K_d \times P_1 \times K_b \times K_c} \times \sqrt{\frac{T \times Z}{M}}$$

$$A = \frac{158,700}{356.06 \times 0.975 \times 114.7 \times 1.0 \times 1.0} \times \sqrt{\frac{540 \times 1.0}{28.96}} = 17.21 \text{ in.}^2 \quad (\text{B.31})$$

In SI units:

$$A = \frac{W}{C \times K_d \times P_1 \times K_b \times K_c} \times \sqrt{\frac{T \times Z}{M}}$$

$$A = \frac{72,000}{0.0270 \times 0.975 \times 790.8 \times 1.0 \times 1.0} \times \sqrt{\frac{300 \times 1.0}{28.96}} = 11,131 \text{ mm}^2 \quad (\text{B.32})$$

where

- W is the required relief rate, lb/h (kg/h);
- C is the specific heat ratio coefficient, a function of the ideal gas specific heat ratio;
- K_d is the effective coefficient of discharge (no units);
- P_1 is the pressure of the fluid entering the nozzle, psia (kPa);
- K_b is the correction factor due to backpressure;
- K_c is the combination correction factor for installations with a rupture disk upstream of the PRV;
- T is the temperature of the fluid entering the nozzle, °R (K);
- Z is the compressibility factor of the fluid entering the nozzle (no units);
- M is the molecular weight of the fluid;
- A is the required effective discharge area, in.² (mm²).

B.3.4.5 As an additional comparison, the theoretical flow for air as provided by UG-131 of the ASME Code is provided.

$$W_T = 356 \times A_T \times P \times \sqrt{\frac{M}{T}}$$

$$G_T = \frac{W_T}{A_T} = 356 \times P \times \sqrt{\frac{M}{T}}$$

$$G_T = 356 \times 114.7 \times \sqrt{\frac{28.96}{540.33}} = 9453.3 \text{ lb/h} \cdot \text{in.}^2 \left(1846.2 \text{ kg/s} \cdot \text{m}^2 \right) \quad (\text{B.33})$$

where

W_T is the theoretical flow rate, lb/h;

A_T is the actual discharge area, in.²;

P is the pressure of the fluid entering the nozzle, psia;

T is the temperature of the fluid entering the nozzle, °R;

M is the molecular weight of the fluid;

G_T is the theoretical mass flux, lb/h·in².

B.4 Flow Equations for Two-phase Flow

The isentropic nozzle flux equation is also used in the development of the two-phase flow sizing equations. Please refer to Annex C for more information.

Annex C (informative)

Sizing for Two-phase Liquid/Vapor Relief

C.1 Sizing for Two-phase Liquid/Vapor Relief

C.1.1 General

The methods for two-phase sizing, presented in this annex, are among several techniques currently in use and newer methods are continuing to evolve as time goes on. It is recommended that the particular method to be used for a two-phase application be fully understood. Note that the methods presented in this annex have not been validated by test, nor is there any recognized procedure for certifying the capacity of PRVs in two-phase flow service.

C.1.2 Application of Equations

C.1.2.1 Many different scenarios are possible under the general category of two-phase liquid/vapor relief. In all of these scenarios either a two-phase mixture enters the PRV or a two-phase mixture is produced as the fluid moves through the valve. As required in 5.4.0.4.11, vapor generation as a result of flashing shall be taken into account, since it may reduce the effective mass flow capacity of the valve. The methods presented in C.2.1 through C.2.3 can be used for sizing PRVs in two-phase liquid/vapor scenarios. In addition, C.2.1 can be used for supercritical fluids in condensing two-phase flow. Use Table C.1 to determine which section to consult for a particular two-phase relief scenario.

Table C.1—Two-phase Liquid/Vapor Relief Scenarios for Pressure-relief Valves

Two-phase Liquid/Vapor Relief Scenario	Example	Section
Two-phase system (liquid vapor mixtures, including saturated liquid) enters PRV and flashes. No noncondensable ^a gas present. Also includes fluids both above and below the thermodynamic critical point in condensing two-phase flow.	Saturated liquid/vapor propane system enters PRV and the liquid propane flashes.	C.2.1 or C.2.2
Two-phase system (highly subcooled ^b liquid and either noncondensable gas, condensable vapor, or both) enters PRV and does not flash.	Highly subcooled propane and nitrogen enters PRV and the propane does not flash.	C.2.1 or C.2.2
Two-phase system (the vapor at the inlet contains some noncondensable gas and the liquid is either saturated or subcooled) enters PRV and flashes. Noncondensable gas enters PRV.	Saturated liquid/vapor propane system and nitrogen enters PRV and the liquid propane flashes.	C.2.1 or C.2.2
Subcooled liquid (including saturated liquid) enters PRV and flashes. No condensable vapor or noncondensable gas enters PRV.	Subcooled propane enters PRV and flashes.	C.2.1 or C.2.2
^a A noncondensable gas is a gas that is not easily condensed under normal process conditions. Common noncondensable gases include air, oxygen, nitrogen, hydrogen, carbon dioxide, carbon monoxide, and hydrogen sulfide. ^b The term "highly subcooled" is used to reinforce that the liquid does not flash passing through the PRV.		

C.1.2.2 The equations presented in C.2.1 are based on the Homogeneous Equilibrium Model (HEM) ^[7], which assumes the fluid mixture behaves as a "pseudo single phase fluid," with a density that is the volume averaged density of the two phases. This method is based on the assumption that thermal and mechanical equilibrium exist as the two-phase fluid passes through the PRV (other specific assumptions or limitations are presented in the appropriate section). For high momentum discharges of two-phase systems in nozzles longer than 4 in. (10 cm), both thermal and mechanical equilibrium can be assumed. These assumptions correspond to the HEM.

C.1.2.3 In applications where the homogeneous equilibrium assumption is not valid, the user is encouraged to apply non-equilibrium methods. The Burnell bubble delay factor, if used, can remove some of the conservatism associated with the homogeneous equilibrium assumption ^[19].

C.1.2.4 The equations presented in C.2.2 through C.2.3 are based on the Leung Omega Method ^[13], which is a version of the HEM. In the procedures presented in C.2.2 through C.2.3, the omega parameter is calculated based on specific volume data obtained from a flash calculation. This is often referred to as a two-point method since fluid properties are determined at the inlet relieving conditions and at flashed conditions at a lower pressure. The omega parameter itself is a correlation between the density of the two-phase fluid and the pressure, using the following relationship:

$$\omega = \frac{\frac{\rho_1 - 1}{\rho_x} = \frac{v_x - 1}{v_1}}{\frac{P_1 - 1}{P_x}} \quad (C.1)$$

where

- P is the pressure from the flash calculation (absolute);
- ρ is the overall two-phase density from the flash calculation;
- v is the overall two-phase specific volume from the flash calculation;
- 1 represents the initial condition (e.g. PRV inlet condition) for the flash;
- x represents the flash result at one lower pressure.

C.1.2.5 In most cases, a flash pressure at 90 % of the initial pressure provides a reasonable correlation parameter; however, lower flash pressures may be more appropriate under some conditions (e.g. near the thermodynamic critical point ^[13]). In some instances, it is possible to estimate the omega parameter using only the fluid properties at the relieving conditions (one-point method) ^[14]. Based on the assumptions used to develop the one-point omega parameter estimation technique, the use of this technique is generally not valid for any of the following situations:

- the nominal boiling range for a multicomponent system is greater than 150 °F (the nominal boiling range is the difference in atmospheric boiling points of the lightest and heaviest components in the system);
- the fluid is close to its thermodynamic critical point ($T_r \geq 0.9$ or $P_r \geq 0.5$);
- the solubility of a noncondensable gas, if present, in the liquid is appreciable;
- the composition of a multicomponent system contains more than 0.1 weight percent hydrogen;
- the gas fraction of a multicomponent system with noncondensable gas is low.

$$\left(\frac{P_{v1}}{P_1} \geq 0.9 \text{ or } \frac{P_{g1}}{P_1} \leq 0.1 \right)$$

where

- T_r is the reduced temperature at the PRV inlet;
- P_r is the reduced pressure at the PRV inlet;
- T_1 is the temperature at the PRV inlet (°R);
- P_1 is the pressure at the PRV inlet (psia); this is the PRV set pressure (psig) plus the allowable overpressure (psi) plus atmospheric pressure;
- P_{v1} is the saturation (vapor) pressure corresponding to the inlet relieving temperature T_1 (psia);

for a multicomponent system, use the bubble point pressure corresponding to T_1 ;

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P_{g1} is the noncondensable gas partial pressure at the PRV inlet (psia).

C.1.2.6 If any of these situations apply, the methods presented in sections C.2.1 through C.2.3 should be used.

C.1.2.7 A more rigorous approach using a fluid property database or vapor/liquid equilibrium thermodynamic models incorporated into analytical or numerical methods based on HEM can be considered. See C.2.1 for more information.

C.1.3 Saturated Water Capacity for ASME Certified Safety Valves

For information about saturated water, see ASME BPVC, Section VIII, Appendix 11.

C.1.4 Effective Coefficient of Discharge

The value for the effective coefficient of discharge for two-phase flow is a subject of current debate [7, 9, 10] and is not likely to be resolved without actual testing of PRV behavior with two-phase fluids. As a result, a conservative recommendation regarding an estimate of the effective coefficient of discharge has been provided within the guidance on sizing methods; see C.2.1, C.2.2, and C.2.3.

C.2 Sizing Methods

C.2.1 Sizing by Direct Integration of the Isentropic Nozzle Flow

C.2.1.1 General

C.2.1.1.1 The inlet nozzle of a relief device is commonly assumed to be the limiting flow element of a fully opened relief device and thus provides the model on which to determine the flow capacity of that relief device. To determine the maximum mass flux through a converging nozzle, the nozzle is assumed to be adiabatic and reversible (both constraints are needed for the isentropic assumption), a common assumption that has been borne through various experimental evidence for well-formed nozzles. The general energy balance for isentropic nozzle flow forms the basis for the mass flux calculation, as shown in Equation (C.2) and Equation (C.3).

In USC units:

$$G^2 = \frac{\left[-2 \times \int_{P_1}^P v \times dP \right]}{v^2} = \left[\left(\frac{\rho^2}{t} \right) \times \left[-2 \times \int_{P_1}^P \frac{4633 \times dP}{\rho} \right] \right]_{\max} \quad (C.2)$$

In SI units:

$$G^2 = \frac{\left[-2 \times \int_{P_1}^P v \times dP \right]}{v^2} = \left[\left(\frac{\rho^2}{t} \right) \times \left[-2 \times \int_{P_1}^P \frac{dP}{\rho} \right] \right]_{\max} \quad (C.3)$$

where

- max represents the maximization of this calculation, which accounts for potential choking of the fluid;
- G is the mass flux, lb/s·ft² (kg/s·m²);
- v is the specific volume of the fluid, ft³/lb (m³/kg);
- ρ is the mass density of the fluid, lb/ft³ (kg/m³);
- P is the stagnation pressure of the fluid, psia (Pa);
- 1 represents conditions at the inlet to the nozzle;
- t represents the conditions at the throat of the nozzle where the cross-sectional area is minimized.

C.2.1.1.2 It is important to note that this energy balance is irrespective of the nonideality or compressibility of the fluid. As a result, this equation forms the basis for the two-phase flow calculations in the HEM employed in PRV calculations.

C.2.1.1.3 With the generic nozzle flow equation, the density of the fluid at various stagnation pressures from the inlet of the nozzle to the throat of the nozzle is needed. Given these values, the numerical integration calculation can be performed to determine the maximum mass flux through the nozzle. Using a suitable physical property database or an appropriate thermodynamic model, one can generate the values for the density at various pressures by starting with the fluid at the inlet stagnation conditions to determine the inlet stagnation entropy, S_1 , and then performing successive isentropic flashes at lower pressures (P, S_1). The path followed for the fluid over this range is normally assumed to be isentropic; however, an isenthalpic path may be acceptable for many conditions (specifically, for low-quality mixtures that are far from the thermodynamic critical point). The pressure and density data points are generated for successively lower pressures until either the mass flux correlation reaches a maximum (representing choked conditions) or the actual backpressure on the nozzle is reached, whichever occurs first. It is at this point that the pressure at the minimal cross-sectional area at the nozzle (the throat pressure) is taken. For a known throat pressure, P_t , the energy balance can be written as shown in Equation (C.4) and Equation (C.5).

In USC units:

$$G = \rho_t \times \left(\frac{2}{\gamma} \right) \left(\frac{P_t}{\rho_t} \right)^{1/\gamma} \int_{P_1}^{P_t} \frac{dP}{\rho} \quad (C.4)$$

In SI units:

$$G = \rho_t \times \left(\frac{2}{\gamma} \right) \left(\frac{P_t}{\rho_t} \right)^{1/\gamma} \int_{P_1}^{P_t} \frac{dP}{\rho} \quad (C.5)$$

C.2.1.1.4 The integral can be readily evaluated numerically for any fluid by direct summation over small pressure intervals.

$$\int_{P_1}^{P_t} \frac{dP}{\rho} \approx \sum_{i=1}^t \left(\frac{P_{i+1} - P_i}{\rho_i} \right) \quad (C.6)$$

where

- G is the mass flux, lb/s·ft² (kg/s·m²);
- v is the specific volume of the fluid, ft³/lb (m³/kg);
- P is the stagnation pressure of the fluid, psia (Pa);
- 1 represents conditions at the inlet to the nozzle;
- t represents the conditions at the throat of the nozzle where the cross-sectional area is minimized;
- ρ is the overall mass density of the fluid, lb/ft³ (kg/m³).

C.2.1.1.5 The overall mass density for a mixture in thermal and mechanical equilibrium can be calculated based on the density of each phase and the volume fraction of the vapor phase in the mixture.

$$\rho = (\alpha \times \rho_v) + (1 - \alpha) \rho_l \quad (C.7)$$

where

- ρ is the density of the two-phase mixture, lb/ft³ (kg/m³);
- ρ_v is the density of the vapor, lb/ft³ (kg/m³);
- ρ_l is the density of the liquid, lb/ft³ (kg/m³);
- α is the volume fraction of vapor phase in the mixture.

C.2.1.1.6 The volume fraction of the vapor phase in the mixture is related to the mass quality of the mixture (mass fraction of the vapor phase) by the following.

$$\frac{\alpha}{1 - \alpha} = \frac{x}{1 - x} \times \frac{\rho_l}{\rho_v} \quad (C.8)$$

C.2.1.1.7 Once the value for the mass flux has been determined, the required orifice area can be calculated using Equation (C.9) or Equation (C.10).

In USC units:

$$A = \frac{0.04W}{K_d K_b K_c K_v G} \quad (C.9)$$

In SI units:

$$A = \frac{277.8 \times W}{K_d K_b K_c K_v G} \quad (C.10)$$

where

A is the required discharge area, in.² (mm²);

W is the required mass flow rate, lb/h (kg/h);

K_d is the coefficient of discharge; for a preliminary sizing estimation, an effective coefficient of discharge of 0.85 can be used for a two-phase mixture or saturated liquid entering the PRV inlet. For the case of a subcooled liquid entering the PRV inlet, a coefficient of discharge equal to 0.65 is consistent with the single-phase method in Equation (32) and Equation (33). Note that a value of 0.65 may result in a conservative valve size for liquids that are only slightly subcooled; the user may select other methods for determining a coefficient of discharge^[8, 9, 10];

K_b is the backpressure correction factor for vapor that should be obtained from the valve manufacturer; for a preliminary sizing estimation, use Figure 31. The backpressure correction factor applies to balanced-bellows valves only;

K_c is the combination correction factor for installations with a rupture disk upstream of the PRV (see 5.12.2);

— the combination correction factor is 1.0, when a rupture disk is not installed;

— the combination correction factor is 0.9, when a rupture disk is installed in combination with a PRV and the combination does not have a certified value;

K_v is the viscosity correction factor; for two-phase flows where the liquid has a viscosity of 100 cP (0.1 Pa-s) or less, the viscosity correction factor can be set to 1.0;

G is the mass flux, lb/s·ft² (kg/s·m²).

C.2.1.2 Example

C.2.1.2.1 In this example, the following data are given.

- Required two-phase flow rate caused by an operational upset of 300,000 lb/h (136,000 kg/h); the relief fluid is from a hydro-desulfurization vessel and contains a significant amount of hydrogen at a high pressure.
- Temperature at the PRV inlet of 80.4 °F (26.9 °C).
- PRV set at 1958 psi (13,500 kPag), the design pressure of the equipment.
- Downstream total backpressure of 29 psig (200 kPag) (superimposed backpressure = 0 psig, built-up backpressure = 29 psig).
- Allowable overpressure (accumulation) of 10 %.
- A viscosity correction factor, K_v , of 1.0 is assumed.

C.2.1.2.2 In this example, the following values are calculated.

- Relieving pressure of $1.10 \times 1958 = 2153.8$ psig (14,850 kPag).
- Percent of gauge backpressure = $(29/1958) \times 100 = 1.5\%$; thus, the backpressure correction factor $K_b = 1.0$ (from Figure 31).

C.2.1.2.3 The following is a step-by-step procedure.

- a) Step 1—Evaluate the stagnation entropy, S_1 . Given the relief fluid composition, relief pressure, and relief temperature, the inlet stagnation entropy was determined by a thermodynamic engine to be -8.178 Btu/lb-mol-°R. Note that the entropy reference state may be different for various thermodynamic engines; therefore, this value may not be the same value obtained from other thermodynamic engines. As long as the same thermodynamic engine and models are used, the reference state is consistent and the flash calculations will be appropriate.
- b) Step 2—Perform successive isentropic flashes to generate fluid properties and numerically evaluate nozzle flow integral. Without a known throat pressure, a number of successive isentropic flashes were performed to generate the fluid properties. A step size of 4 % of the absolute relief pressure was arbitrarily chosen to generate the flash pressures. Note that the smaller the step size, the closer the summation will be to the actual integration. With the fluid properties obtained from the isentropic flashes, Equation (C.6) was used to numerically evaluate the nozzle flow integral. The isentropic flashes were performed until the mass flux reached a maximum value. Results are presented in Table C.2.
- c) Step 3—Find the maximum mass flux. The mass flux is maximized at a throat pressure of 1214.4 psia (8.373 kPa) for a value of 4830.8 lb/s-ft² (23,586 kg/s-m²). This throat pressure is greater than the total backpressure indicated above; therefore, the flow is critical (choked) through the nozzle.
- d) Step 4—Calculate the required orifice area. The required area A of the PRV is calculated from Equation (C.9) as follows:

$$A = \frac{0.04 \times 300,000}{0.85 \times 1.0 \times 1.0 \times 4830.8} = 2.922 \text{ in.}^2 \quad (\text{C.11})$$

- e) Step 5—Select an M orifice PRV (3.600 in.²).

Table C.2—Results for Direct Integration Example C.2.1.2

Pressure psia (Pa)	Temperature °F (K)	Mass Quality	Density lb/ft ³ (kg/m ³)	Integrand ft ² /s ² (m ² /s ²)	Summation ft ² /s ² (m ² /s ²)	Mass Flux lb/s-ft ² (kg/s-m ²)
2168.5 (14,951,325)	80.3 (300.0)	1.000	5.18 (83.04)	0 (0)	0 (0)	0.0 (0.0)
2081.8 (14,353,272)	75.0 (297.0)	1.000	5.05 (80.88)	-78,546 (-7297.2)	-78,546 (-7297.2)	2001.1 (9770.4)
1995.0 (13,755,219)	69.4 (293.9)	1.000	4.91 (78.67)	-80,696 (-7496.9)	-159,243 (-14,794.1)	2771.6 (13,532.1)
1908.3 (13,157,166)	63.6 (290.7)	1.000	4.77 (76.41)	-83,019 (-7712.7)	-242,261 (-22,506.8)	3320.5 (16,212.3)
1821.5 (12,559,113)	57.6 (287.4)	1.000	4.63 (74.11)	-85,535 (-7946.4)	-327,796 (-30,453.2)	3745.9 (18,289.1)
1734.8 (11,961,060)	52.6 (284.6)	0.995	4.46 (71.46)	-88,443 (-8216.6)	-416,239 (-38,669.9)	4070.5 (19,874.2)
1648.1 (11,363,007)	48.2 (282.1)	0.988	4.28 (68.63)	-91,899 (-8537.7)	-508,138 (-47,207.6)	4319.4 (21,089.0)
1561.3 (10,764,954)	43.5 (279.5)	0.982	4.11 (65.76)	-95,801 (-8900.2)	-603,939 (-56,107.7)	4511.7 (22,027.9)
1474.6 (10,166,901)	38.6 (276.8)	0.975	3.92 (62.84)	-100,120 (-9301.5)	-704,059 (-65,409.2)	4654.8 (22,726.8)
1387.8 (9,568,848)	33.5 (274.0)	0.969	3.74 (59.86)	-104,930 (-9748.3)	-808,989 (-75,157.5)	4753.7 (23,209.5)
1301.1 (8,970,795)	28.1 (271.0)	0.963	3.55 (56.84)	-110,319 (-10,249.0)	-919,307 (-85,406.5)	4811.6 (23,492.3)
1214.4 (8,372,742)	22.5 (267.9)	0.958	3.36 (53.77)	-116,401 (-10,814.0)	-1,035,709 (-96,220.5)	4830.8 (23,585.8)
1127.6 (7,774,689)	16.5 (264.6)	0.952	3.16 (50.63)	-123,323 (-11,457.1)	-1,159,032 (-107,677.6)	4812.6 (23,497.1)
1040.9 (7,176,636)	10.2 (261.1)	0.946	2.96 (47.44)	-131,274 (-12,195.8)	-1,290,306 (-119,873.4)	4757.8 (23,229.5)

C.2.2 Sizing for Two-phase Flashing or Nonflashing Flow Through a Pressure-relief Valve Using the Omega Method

C.2.2.1 General

The method presented in this section can be used for sizing PRVs handling either flashing or nonflashing flow. These methods are also appropriate for fluids both above and below the thermodynamic critical point in condensing two-phase flow. Finally, the methods presented in this section can be used for liquids that are saturated as they enter the relief device.

Note that for saturated liquids, the methods presented in C.2.3 are equivalent to the methods presented in C.2.2.

In all cases, the omega parameter is determined using the specific volume data obtained using fluid property data or flash calculations for a mixture at the stagnation conditions and one additional pressure (two-point method). The following procedure can be used.

- a) Step 1—Calculate the omega parameter, ω . To calculate the omega parameter using two pressure specific volume data points, use Equation (C.12).

$$\omega = 9 \left(\frac{v_g}{v_1} - 1 \right) \quad (C.12)$$

where

ω is the omega parameter;

v_g is the specific volume evaluated at 90 % of the PRV inlet pressure, P_1 in ft³/lb (m³/kg); when determining v_g , the flash calculation should be carried out isentropically, but an isenthalpic (adiabatic) flash is sufficient for low-quality mixtures far from the thermodynamic critical point;

v_1 is the specific volume of the two-phase system at the PRV inlet, ft³/lb (m³/kg).

- b) Step 2—Determine if the flow is critical or subcritical:

$$P_{cf} = \eta_c P_1 \quad (C.13)$$

$$P_{cf} \geq P_2 \Rightarrow \text{critical flow}$$

$$P_{cf} < P_2 \Rightarrow \text{subcritical flow}$$

where

P_{cf} is the critical pressure, psia (Pa);

P_1 is the pressure at the PRV inlet (psia or Pa); this is the PRV set pressure (psig or Pag) plus the allowable overpressure (psi or Pa) plus atmospheric pressure;

P_2 is the downstream backpressure (psia or Pa);

η_c is the critical pressure ratio from Figure C.1.

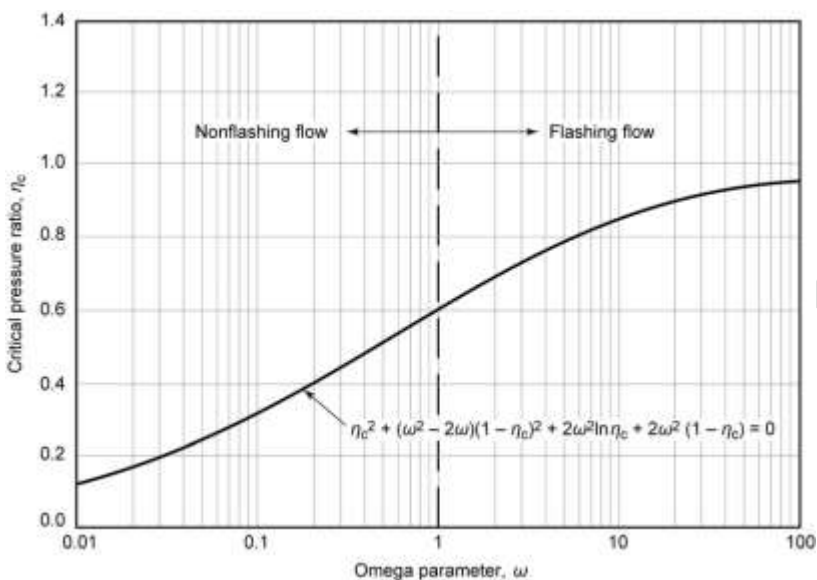


Figure C.1—Correlation for Nozzle Critical Flow of Flashing and Nonflashing Systems

NOTE This ratio can also be obtained from the following expression:

$$\eta_c^2 + (\omega^2 - 2\omega)(1 - \eta_c)^2 + 2\omega^2 \ln \eta_c + 2\omega^2(1 - \eta_c) = 0 \quad (\text{C.14})$$

or from the following approximation:

$$\eta_c = 1 + \left(\frac{1.0446 - 0.0093431 \times \omega}{0.5 - 0.56261 \omega} \right) \times \omega \cdot \left(\frac{-0.70356 + 0.014685 \times \omega}{-0.56261 \omega} \right) \ln \left(\frac{-0.70356 + 0.014685 \times \omega}{-0.56261 \omega} \right) \quad (\text{C.15})$$

- c) Step 3—Calculate the mass flux. For critical flow, use Equation (C.16) or Equation (C.18). For subcritical flow, use Equation (C.17) or Equation (C.19).

In USC units:

$$G = 68.09 \times \eta_c \sqrt{\frac{P_1}{v_1 \omega}} \quad (\text{C.16})$$

$$G = \frac{68.09 \times \left\{ -2 \left[\omega \ln \eta_a + (\omega - 1)(1 - \eta_a) \right] \right\}^{1/2}}{\omega \left(\frac{1}{\eta_a} - 1 \right) + 1} \sqrt{P_1 / v_1} \quad (\text{C.17})$$

In SI units:

$$G = \eta_c \sqrt{\frac{P_1}{v_1 \omega}} \quad (\text{C.18})$$

$$G = \frac{\left\{ -2 \times [\omega \ln \eta_a + (\omega - 1)(1 - \eta_a)] \right\}^{1/2}}{\omega \left(\frac{1}{\eta_a} - 1 \right) + 1} \sqrt{P_1 / v_1} \quad (\text{C.19})$$

where

G is the mass flux, lb/s·ft² (kg/s·m²);

η_c is the critical pressure ratio from Figure C.1;

P_1 is the pressure at the PRV inlet, psia (Pa);

v_1 is the specific volume of the two-phase system at the PRV inlet in ft³/lb (m³/kg);

ω is the omega parameter;

η_a is the actual backpressure ratio, $\eta_a = \frac{P_2}{P_1}$.

d) Step 4—Calculate the required area of the PRV.

In USC units:

$$A = \frac{0.04W}{K_d K_b K_c K_v G} \quad (\text{C.20})$$

In SI units:

$$A = \frac{277.8W}{K_d K_b K_c K_v G} \quad (\text{C.21})$$

where

A is the required discharge area, in.² (mm²);

W is the mass flow rate, lb/h (kg/h);

K_d is the coefficient of discharge; for a preliminary sizing estimation, an effective coefficient of discharge of 0.85 can be used;

K_b is the backpressure correction factor for vapor that should be obtained from the valve manufacturer; for a preliminary sizing estimation, use Figure 31; the backpressure correction factor applies to balanced-bellows valves only;

K_c is the combination correction factor for installations with a rupture disk upstream of the PRV (see 5.12.2);

- the combination correction factor is 1.0, when a rupture disk is not installed;
- the combination correction factor is 0.9, when a rupture disk is installed in combination with a PRV and the combination does not have a certified value;

K_v is the viscosity correction factor; for two-phase flows where the liquid has a viscosity of 100 cP (0.1 Pa-s) or less, the viscosity correction factor can be set to 1.0;

G is the mass flux, lb/s-ft² (kg/s-m²).

C.2.2.2 Example

C.2.2.2.1 In this example, the following relief requirements are given.

- Required crude column overhead two-phase flow rate caused by an operational upset of 477,430 lb/h (216,560 kg/h). This flow is downstream of the condenser.
- Temperature at the PRV inlet of 200 °F (659.7 °R = 366.5 K).
- PRV set at 60 psig (413.7 kPag), the design pressure of the equipment.
- Downstream total backpressure of 15 psig (29.7 psia) (204.7 kPa) (superimposed backpressure = 0 psig, built-up backpressure = 15 psi).
- Two-phase specific volume at the PRV inlet of 0.3116 ft³/lb (0.01945 m³/kg).
- Allowable overpressure (accumulation) of 10 %.
- For this example problem, a viscosity correction factor, K_v , of 1.0 is assumed.

C.2.2.2.2 In this example, the following values are calculated.

- Relieving pressure of $1.10 \times 60 = 66$ psig (80.7 psia) (556.4 kPa).
- Percent of gauge backpressure = $(15/60) \times 100 = 25$ %; thus, the backpressure correction factor, $K_b = 1.0$ (from Figure 31).
- Since the downstream backpressure is greater than 10 % of the set pressure, a balanced-bellows PRV is used.

C.2.2.2.3 The following is a step-by-step procedure.

- a) Step 1—Calculate the omega parameter, ω . Equation (C.12) is used to calculate the omega parameter, ω . The specific volume evaluated at $0.9 \times 80.7 = 72.63$ psia (500.8 kPa) using the results of an isenthalpic (adiabatic) flash calculation from a process simulator is 0.3629 ft³/lb (0.02265 m³/kg). The omega parameter is calculated from Equation (C.12) as follows.

In USC units:

$$\omega = 9 \left(\begin{array}{c} 0.3629 \\ 0.3116 \end{array} - 1 \right) = 1.482 \quad (\text{C.22})$$

In SI units:

$$\omega = 9 \left(\begin{array}{c} 0.02265 \\ 0.01945 \end{array} - 1 \right) = 1.482 \quad (\text{C.23})$$

- b) Step 2—Determine if the flow is critical or subcritical. The critical pressure ratio η_c is 0.66 (from Figure C.1). The critical pressure, P_{cf} , is calculated from Equation (C.13) as follows.

In USC units:

$$P_{cf} = 0.66 \times 80.7 = 53.26 \text{ psia} \quad (\text{C.24})$$

In SI units:

$$P_{cf} = 0.66 \times 556,379 = 367,210 \text{ Pa} \quad (\text{C.25})$$

The flow is determined to be critical since $P_{cf} > P_2$.

$$53.26 > 29.7$$

- c) Step 3—Calculate the mass flux. The mass flux, G , is calculated from Equation (C.16) or Equation (C.18) as follows.

In USC units:

$$G = 68.09 \times 0.66 \times \sqrt{\frac{80.7}{0.3116 \times 1.482}} = 594.1 \text{ lb/s} \cdot \text{ft}^2 \quad (\text{C.26})$$

In SI units:

$$G = 0.66 \times \sqrt{\frac{556,379}{0.01945 \times 1.482}} = 2900 \text{ kg/s} \cdot \text{m}^2 \quad (\text{C.27})$$

- d) Step 4—Calculate the required area of the PRV. The required area of the PRV, A , is calculated from Equation (C.20) or Equation (C.21) as follows.

In USC units:

$$A = \frac{0.04 \times 477,430}{0.85 \times 1.0 \times 1.0 \times 1.0 \times 594.1} = 37.8 \text{ in.}^2 \quad (\text{C.28})$$

In SI units:

$$A = \frac{277.8 \times 216.560}{0.85 \times 1.0 \times 1.0 \times 1.0 \times 2900} = 24,400 \text{ mm}^2 \quad (\text{C.29})$$

- e) Step 5—Select the orifice area. This area requirement may be met by selecting two (2) Q orifice and one (1) R orifice PRVs ($2 \times 11.05 + 1 \times 16.00 = 38.1 \text{ in.}^2$). Since this example resulted in multiple valves, the required area could be recalculated at 16 % overpressure.

C.2.3 Sizing for Subcooled Liquid at the Pressure-relief Valve Inlet Using the Omega Method

C.2.3.1 Pressure-relief Valves Requiring Capacity Certification

The method presented in this section can be used for sizing PRVs handling a subcooled (including saturated) liquid at the inlet. No condensable vapor or noncondensable gas shall be present at the inlet. The subcooled liquid either flashes upstream or downstream of the PRV throat depending on which subcooling region the flow falls into. The equations in this section also apply to all liquid scenarios. The following procedure can be used.

- a) Step 1—Calculate the omega parameter for saturated liquid, ω_s . To calculate the omega parameter for saturated liquid using two pressure density data points, use Equation (C.30).

$$\omega_s = 9 \left(\frac{\rho_{11}}{\rho_9} - 1 \right) \quad (\text{C.30})$$

where

ω_s is the omega parameter for saturated liquid;

ρ_{11} is liquid density at the PRV inlet, lb/ft³ (kg/m³);

ρ_9 is density, lb/ft³ (kg/m³) evaluated at 90 % of the saturation (vapor) pressure, P_s , corresponding to the PRV inlet relieving temperature, T_1 , lb/ft³ (kg/m³).

For a multicomponent system, use the bubble point pressure corresponding to T_1 for P_s . When determining ρ_9 , the flash calculation should be carried out isentropically, but an isenthalpic (adiabatic) flash is sufficient for low-quality mixtures far from the thermodynamic critical point.

- b) Step 2—Determine the subcooling region.

$$P_s \geq \eta_{st} P_1 \Rightarrow \text{low subcooling region (flashing occurs upstream of throat)}$$

$$P_s < \eta_{st} P_1 \Rightarrow \text{high subcooling region (flashing occurs at the throat)} \quad (\text{C.31})$$

$$\eta_{st} = \frac{2\omega_s}{1 + 2\omega_s} \quad (\text{C.32})$$

where

η_{st} is transition saturation pressure ratio;

ω_s is the omega parameter for saturated liquid;

P_s is the saturation (vapor) pressure (psia or Pa);

P_1 is pressure at the PRV inlet, psia (Pa); this is the PRV set pressure, psig (Pag) plus the allowable overpressure (psi or Pa) plus atmospheric pressure.

- c) Step 3—Determine if the flow is critical or subcritical. For the low subcooling region, use the following comparisons:

$$P_{ct} \geq P_2 \Rightarrow \text{critical flow}$$

$$P_{ct} < P_2 \Rightarrow \text{subcritical flow} \quad (C.33)$$

For the high subcooling region, use the following comparisons:

$$P_s \geq P_2 \Rightarrow \text{critical flow}$$

$$P_s < P_2 \Rightarrow \text{subcritical flow (all-liquid flow)} \quad (C.34)$$

where

P_{ct} is the critical pressure in psia (Pa).

$$P_{ct} = \eta_c P_1 \quad (C.35)$$

where

η_c is the critical pressure ratio from Figure C.2 using the value of η_s .

$$\text{For } \eta_s \leq \eta_{st}, \text{ the critical pressure ratio } \eta_c = \eta_s. \quad (C.36)$$

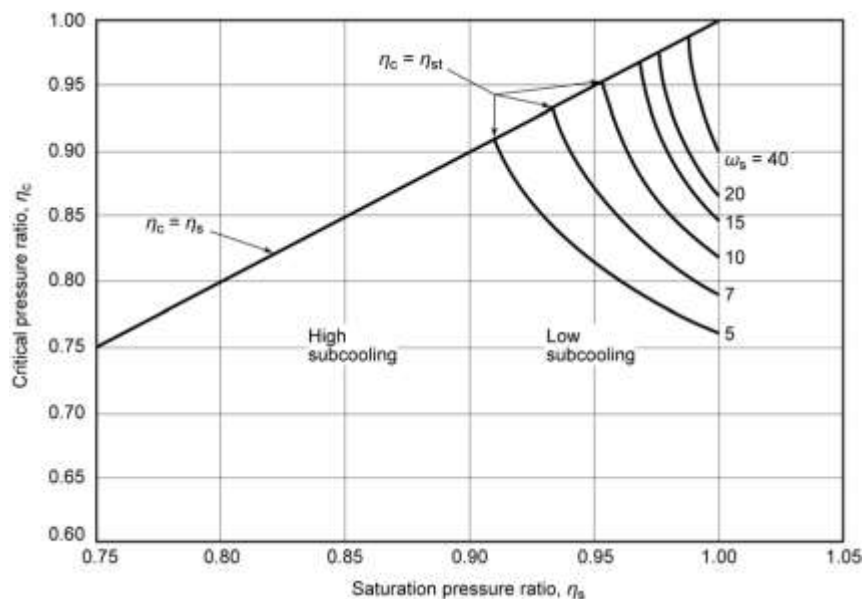


Figure C.2—Correlation for Nozzle Critical Flow of Inlet Subcooled Liquid

For $\eta_s > \eta_{st}$, the critical pressure ratio, η_c , can be calculated implicitly using Equation (C.37) or approximated using Equation (C.38).

$$\left(\omega_s + \frac{1}{\omega_s} - 2 \right) \times \eta_c^2 - 2 \times (\omega_s - 1) \times \eta_c + \omega_s \times \eta_c \times \ln \left(\frac{\eta_c}{\eta_s} \right) + \frac{3}{2} \times \omega_s \times \eta_s - 1 = 0 \quad (C.37)$$

$$\eta_c = \eta_s \times \left(\frac{2 \times \omega_s}{2 \times \omega_s - 1} \right) \times \left[1 - \sqrt{1 - \frac{1}{\eta_s} \times \left(\frac{2 \times \omega_s - 1}{2 \times \omega_s} \right)} \right] \quad (C.38)$$

where

ω_s is the omega parameter for saturated liquid;

η_c is the critical pressure ratio;

η_s is the saturation pressure ratio as calculated in Equation (C.39).

$$\eta = \frac{P_s}{P_1} \quad (\text{C.39})$$

where

P_s is the saturation (vapor) pressure (psia or Pa);

P_1 is pressure at the PRV inlet, psia (Pa); this is the PRV set pressure, psig (Pag) plus the allowable overpressure (psi or Pa) plus atmospheric pressure.

- d) Step 4—Calculate the mass flux. In the low subcooling region, use Equation (C.40) or Equation (C.42). If the flow is critical, use η_c for η , and if the flow is subcritical, use η_a for η . In the high subcooling region, use Equation (C.41) or Equation (C.43). If the flow is critical, use P_s for P , and if the flow is subcritical (all liquid flow), use P_2 for P .

In USC units:

$$G = \frac{68.09 \times \left\{ 2(1-\eta_s) + 2 \left[\omega_s \eta_s \ln \left(\frac{\eta_s}{\eta} \right) - (\omega_s - 1)(\eta_s - \eta) \right] \right\}^{1/2}}{\omega_s \left(\frac{\eta_s}{\eta} - 1 \right) + 1} \sqrt{P_1 \cdot \rho_{l1}} \quad (\text{C.40})$$

$$G = 96.3 \times [\rho_{l1} (P_1 - P)]^{1/2} \quad (\text{C.41})$$

In SI units:

$$G = \frac{\left\{ 2(1-\eta_s) + 2 \left[\omega_s \eta_s \ln \left(\frac{\eta_s}{\eta} \right) - (\omega_s - 1)(\eta_s - \eta) \right] \right\}^{1/2}}{\omega_s \left(\frac{\eta_s}{\eta} - 1 \right) + 1} \sqrt{P_1 \cdot \rho_{l1}} \quad (\text{C.42})$$

$$G = 1.414 [\rho_{l1} (P_1 - P)]^{1/2} \quad (\text{C.43})$$

where

G is the mass flux, lb/s·ft² (kg/s·m²);

ω_s is the omega parameter for saturated liquid;

ρ_{l1} is liquid density at the PRV inlet, lb/ft³ (kg/m³);

η_s is the saturation pressure ratio;

η is the backpressure ratio;

η_c is the critical pressure ratio;

η_a is the subcritical pressure ratio per Equation (C.44):

$$\eta = \frac{P_2}{P_1} \quad (\text{C.44})$$

^a $\overline{P_1}$
 P_1 is pressure at the PRV inlet, psia (Pa);
 P_2 is the downstream backpressure in psia (Pa).

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- e) Step 5—Calculate the required area of the PRV. Equation (C.45) and Equation (C.46) are only applicable to turbulent flow systems. Most two-phase relief scenarios will be within the turbulent flow regime.

In USC units:

$$A = 0.3208 \frac{Q \times \rho_{l1}}{K_d K_b K_c K_v G} \quad (\text{C.45})$$

In SI units:

$$A = 16.67 \frac{Q \times \rho_{l1}}{K_d K_b K_c K_v G} \quad (\text{C.46})$$

where

- A is the required discharge area, in.² (mm²);
- G is the mass flux, lb/s·ft² (kg/s·m²);
- Q is the volumetric flow rate, gal/min (L/min);
- ρ_{l1} is liquid density at the PRV inlet, lb/ft³ (kg/m³);
- K_d is the coefficient of discharge; for a preliminary sizing estimation, an effective coefficient of discharge of 0.65 for subcooled liquids and 0.85 for saturated liquids can be used; a value of 0.65 for slightly subcooled liquids may result in a conservative valve size; the user may select other methods for determining a coefficient of discharge [8, 9, 10];
- K_b is the backpressure correction factor for liquid that should be obtained from the valve manufacturer; for a preliminary sizing estimation, use Figure C.3; the backpressure correction factor applies to balanced-bellows valves only;
- K_c is the combination correction factor for installations with a rupture disk upstream of the PRV (see 5.12.2);
 - the combination correction factor is 1.0, when a rupture disk is not installed;
 - the combination correction factor is 0.9, when a rupture disk is installed in combination with a PRV and the combination does not have a certified value;
- K_v is the viscosity correction factor; for two-phase flows where the liquid has a viscosity of 100 cP (0.1 Pa-s) or less, the viscosity correction factor can be set to 1.0.

- f) Step 6—Select the orifice size.

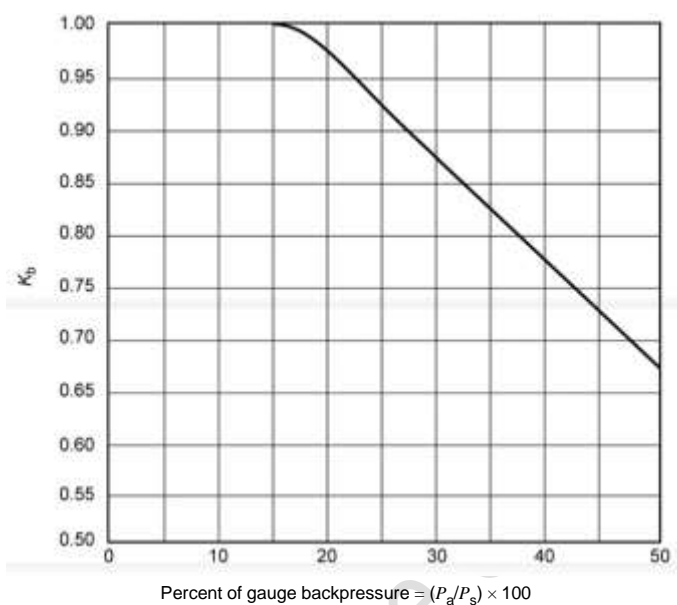


Figure C.3—Backpressure Correction Factor, K_b , for Balanced-bellows Pressure-relief Valves (Liquids)

C.2.3.2 Example

C.2.3.2.1 In this example, the following relief requirements are given.

- Required propane volumetric flow rate caused by blocked in pump of 100 gal/min (378.5 L/min).
- PRV set at 260 psig (1792.6 kPag), the design pressure of the equipment.
- Downstream total backpressure of 10 psig (24.7 psia) (170.3 kPa) (superimposed backpressure = 0 psig, built-up backpressure = 10 psi).
- Temperature at the PRV inlet of 60 °F (519.67 °R) (288.7 K).
- Liquid propane density at the PRV inlet of 31.920 lb/ft³ (511.3 kg/m³).
- Liquid propane specific heat at constant pressure at the PRV inlet of 0.6365 Btu/lb·°R (2.665 kJ/kg·K).
- Saturation pressure of propane corresponding to 60 °F of 107.6 psia (741.9 kPa).
- Specific volume of propane liquid at the saturation pressure of 0.03160 ft³/lb (0.00197 m³/kg).
- Specific volume of propane vapor at the saturation pressure of 1.001 ft³/lb (0.0625 m³/kg).
- Latent heat of vaporization for propane at the saturation pressure of 152.3 Btu/lb (354.2 kJ/kg).
- For this example, a viscosity correction factor, K_v , of 1.0 is assumed.

C.2.3.2.2 In this example, the following values are calculated:

- Overpressure of 10 %.
- Relieving pressure of $1.10 \times 260 = 286$ psig (300.7 psia) (2073.3 kPa).
- Percent of gauge backpressure = $(10/260) \times 100 = 3.8$ %.
- Since the downstream backpressure is less than 10 % of the set pressure, a conventional PRV may be used. Thus, the backpressure correction factor $K_b = 1.0$.
- Since the propane is subcooled, an effective coefficient of discharge, K_d , of 0.65 can be used.

C.2.3.2.3 The following is a step-by-step procedure.

- a) Step 1—Calculate the omega parameter for saturated liquid, ω_s . Since the propane system is a single component system far from its thermodynamic critical point, the omega parameter for saturated liquid, ω_s , could be calculated using the one-point projection technique; however, in this example, Equation (C.30) is chosen to calculate ω_s . The specific volume evaluated at $0.9 \times 107.6 = 96.84$ psia (667.7 kPa) using the results of an isenthalpic (adiabatic) flash calculation from a process simulator is 0.06097 ft³/lb (0.00381 m³/kg). This gives a fluid density of 16.40 lb/ft³ (262.7 kg/m³). The omega parameter is calculated from Equation (C.30) as follows.

In USC units:

$$\omega_s = 9 \times \left(\frac{31.920}{16.402} - 1 \right) = 8.515 \quad (\text{C.47})$$

In SI units:

$$\omega_s = 9 \times \left(\frac{511.3}{262.7} - 1 \right) = 8.515 \quad (\text{C.48})$$

- b) Step 2—Determine the subcooling region. The transition saturation pressure ratio, η_{st} , is calculated from Equation (C.32) as follows:

$$\eta_{st} = \frac{2 \times 8.515}{1 + 2 \times 8.515} = 0.9445 \quad (\text{C.49})$$

The liquid is determined to fall into the high subcooling region since:

$$P_s < \eta_{st} P_1$$

$$107.6 < 0.9445 \times 300.7 = 284.0 \quad (\text{C.50})$$

- c) Step 3—Determine if the flow is critical or subcritical. The flow is determined to be critical since:

$$P_s > P_2$$

$$107.6 > 24.7 \quad (\text{C.51})$$

- d) Step 4—Calculate the mass flux. The mass flux, G , is calculated from Equation (C.41) or Equation (C.43) as follows.

In USC units:

$$G = 96.3 \times \left[31.92(300.7 - 107.6) \right]^{1/2} = 7560 \text{ lb/s} \cdot \text{ft}^2 \quad (\text{C.52})$$

In SI units:

$$G = 1.414 \times \left[511.3 \times (2,073,250 - 741,875) \right]^{1/2} = 36,890 \text{ kg/s} \cdot \text{m}^2 \quad (\text{C.53})$$

- e) Step 5—Calculate the required area of the PRV. The required area, A , of the PRV is calculated from Equation (C.45) or Equation (C.46) as follows.

In USC units:

$$A = 0.3208 \times \frac{100 \times 31.92}{0.65 \times 1.0 \times 1.0 \times 7560} = 0.208 \text{ in.}^2 \quad (\text{C.54})$$

In SI units:

$$A = 16.67 \times \frac{378.5 \times 511.3}{0.65 \times 1.0 \times 1.0 \times 36,890} = 134.5 \text{ mm}^2 \quad (\text{C.55})$$

- f) Step 6—Select an F orifice PRV (0.307 in.²).

C.2.3.3 Pressure-relief Valves Not Requiring Capacity Certification

If the PRV is one that was never certified in liquid service (see 5.9 for a discussion on noncertified PRVs), then the area calculated using Equation (C.45) or Equation (C.46) needs to be adjusted to account for the higher overpressures required to get the valve to go to full lift. Equation (C.45) and Equation (C.46) are modified as shown in Equation (C.56) and Equation (C.57) to handle liquid PRVs that have never been certified:

In USC units:

$$A = 0.3208 \times \frac{Q \rho_{l1}}{K_d K_b K_c K_v G} \times \frac{P_1 - P_2}{K_p \sqrt{1.25 \times P_s - P_2}} \quad (\text{C.56})$$

In SI units:

$$A = 16.67 \times \frac{Q \rho_{l1}}{K_d K_b K_c K_v G} \times \frac{P_1 - P_2}{K_p \sqrt{1.25 \times P_s - P_2}} \quad (\text{C.57})$$

where

- A is the required effective discharge area, in.² (mm²);
- Q is the volumetric flow rate, gal/min (L/min);
- ρ_1 is liquid density at the PRV inlet, lb/ft³ (kg/m³);
- K_d is the effective coefficient of discharge and shall be 0.62;
- K_b is the backpressure correction factor; K_c is the combination correction factor; K_v is the viscosity correction factor;
- K_p is the correction factor due to overpressure; at 25 % overpressure, $K_p = 1.0$. For overpressures other than 25 %, K_p is determined from Figure 39;
- P_s is the set pressure, psig (Pag);
- P_1 is the upstream relieving pressure, psig (Pag); this is the set pressure plus allowable overpressure;
- P_2 is the total backpressure, psig (Pag).

Annex D (informative)

Pressure-relief Valve Specification Sheets

Table D.1—Instructions for Spring-loaded Pressure-relief Valve Specification Sheet

Line No.	Instructions
1	Fill in item number.
2	Fill in user's pressure-relief valve (PRV) identification or tag number.
3	Specify service, line, or equipment to be protected. An equipment tag number and description should be included.
4	Specify number of valves required. A specification sheet for each PRV of a multiple valve installation should be completed.
5	Specify the applicable code(s) and whether Code Symbol nameplate stamping is required.
6	Valve should comply with API 526.
7	Check fire or specify other basis of selection. Consideration should be given to supplying all applicable overpressure scenarios. As a minimum, provide the governing sizing scenario for the vapor sizing case as well as the liquid sizing case if both are applicable.
8	Specify whether a rupture disk is being used under the PRV inlet.
9	Specify whether the PRV is conventional, balanced-bellows, and/or balanced piston.
10	Specify whether the trim type is liquid, vapor, or dual.
11	Specify whether a restricted lift valve design is chosen (nonstandard API orifice area; see 4.2.4). If a restricted lift is selected, the user shall provide provides the manufacturer with a required capacity (Line 37) and the maximum desired rated capacity (specify in the general notes, Line 59).
12	Give description of PRV inlet design (full nozzle, semi-nozzle, or other type). Full nozzles are integral wetted components, which offer the advantage of removal for maintenance and replacement. The biggest advantage of a full nozzle is that the nozzle material can be upgraded without upgrading the metallurgy of the base. Semi-nozzles have the potential for leakage and require threaded connection that may require gaskets or welding. The use of a semi-nozzle also requires that the material of the base be compatible with the process fluid.
13	Specify open or closed bonnet. Open bonnets are limited to services that are nonhazardous, such as steam, air and water, since the process fluid will escape through the open bonnet upon actuation of the PRV. Open bonnets allow the spring to be cooled by ambient conditions in high-temperature applications.
14	Specify metal-to-metal or resilient seat. Metal-to-metal seats are typical. Soft seat designs are available that will minimize leakage. Operating temperature, pressure, and fluid corrosivity may limit the applicability of soft goods.
15	If other than API 527, specify seat test requirements. The ASME Code requires PRVs to be tested in accordance with API 527. Other codes may have alternate requirements.

Users of instructions should not rely exclusively on the information contained in this document. Sound business, scientific, engineering, and safety judgment should be used in employing the information contained herein. Where applicable, authorities having jurisdiction should be consulted. Work sites and equipment operations may differ. Users are solely responsible for assessing their specific equipment and premises in determining the appropriateness of applying the instructions.

Table D.1—Instructions for Spring-loaded Pressure-relief Valve Specification Sheet *(continued)*

Line No.	Instructions
16	Specify pipe size of inlet, flange rating, and type of facing. Inlet flange rating and facing should be chosen to meet the requirements of the upstream protected equipment specification.
17	Specify pipe size of outlet, flange rating, and type of facing. Outlet flange rating and facing should be chosen to meet the requirements of the downstream discharge system. Typically, the discharge system will be designed to ANSI Class 150. However, higher flange class ratings may be required when the PRV discharge is to a closed system.
18	Specify type of connection if other than flanged (e.g. threaded, socket weld, etc.).
19	Specify material of body. API 526 references general construction materials that are appropriate for selection based on pressure and operating temperature only. Where added corrosion resistance is needed to meet the severity of the process fluid, provide material requirements here.
20	Specify material of bonnet (see guidance for Line 19).
21	Specify material of seat or nozzle and disk. These materials are chosen to meet process conditions.
22	If a resilient seat is required, specify material. Resilient, soft seated designs provide tighter sealing and can reduce the amount of leakage through the PRV. Operating temperature, pressure, and fluid corrosivity may limit the applicability of soft goods. Typical resilient seat materials include fluoroelastomers, nitrile, and ethylene propylene. Other materials are available to meet process conditions.
23	Specify material of guide (see guidance for Line 19).
24	Specify material of adjusting ring or rings (see guidance for Line 19).
25	Specify material of spring and spring washer. The spring material should generally be based on the normal operating fluid temperature, since the spring temperature will not change much during a relief scenario, because the spring is separated from the process fluid by the guide and bellows (if used). Factors such as high relief temperature or prolonged auto-refrigeration may be considered in selecting the temperature, depending on the frequency, duration, and temperature of the relieving event. On the other hand, a prolonged fire is generally not considered for spring material selection since the spring will "relax" causing the relief valve to open prematurely as the normal stress in the spring exceeds the tensile strength of the spring material.
26	Specify material of bellows (see guidance for Line 19).
27	Specify material of balanced piston (see guidance for Line 19).
28	Specify the NACE document, if any. (see guidance for Line 19). The NACE requirement is typically needed for processes containing H ₂ S. Special attention is given to spring or bellows materials since they are subject to stress corrosion cracking.
29	Specify material of internal gaskets. Internal gasket material should be compatible with the process fluid on the discharge of the PRV.
30	Specify any other special material requirements (see guidance for Line 19).

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Table D.1—Instructions for Spring-loaded Pressure-relief Valve Specification Sheet *(continued)*

Line No.	Instructions
31	Specify screwed or bolted cap. Screwed caps are more economical. Bolted caps offer higher protection against leakage.
32	Specify if the valve is to have a plain or packed lifting lever, or none, see 4.2.1.4 . Lifting levers are required by the ASME Code in air, steam, and hot water services. Note that ASME Code Case 2203-1 should be specified on this specification sheet if the purchaser wants to waive this requirement. A packed lifting lever is used when there is backpressure due to closed discharge systems or when there is an overpressure scenario that might relieve hot liquid.
33	Specify whether a test gag is required, see 4.2.1.4 . A test gag shall only be used during hydrostatic testing of the protected equipment and shall be removed and replaced with a plug during operation.
34	Specify whether a bug screen in the bonnet vent of a bellows, or balanced piston valve is required.
35	Specify other accessories that are required (e.g. limit switch).
36	Indicate flowing fluid and state (liquid, gas, vapor, or two-phase). Note that in two-phase applications, the purchaser is required to provide the manufacturer with the relieving mass flux (see Line 38).
37	Specify quantity of fluid that the valve is required to relieve at relieving conditions and unit of measure (such as lb/h, gal/min, or ft ³ /min).
38	Specify the mass flux and the basis for the calculations. This is required for two-phase applications only. The basis for the calculations could be the HEM Omega Method or the Direct Integration Method (HDI) as discussed in Annex C. Other calculation methods are acceptable.
39	Specify the molecular weight or specific gravity of the fluid at the flowing temperature. Molecular weight is required for vapor sizing only, specific gravity is required for liquid sizing only. Nothing is required here for two-phase applications provided the mass flux is provided in Line 38.
40	Specify viscosity and unit of measure at the flowing temperature. Viscosity is required for the liquid sizing case only.
41	Specify maximum operating pressure and unit of measure. Note that this is typically the same as the maximum operating pressure of the protected equipment.
42	Specify set pressure and unit of measure.
43	Specify maximum blowdown as a percent of set pressure if different than manufacturer's standard.
44	Specify the latent heat of vaporization. This is only required for vapor sizing for the Fire Case only.
45	Specify the operating temperature and unit of measure. Note that this may not be the same as the operating temperature of the protected equipment due to heat loss from the inlet line. Insulated (or insulated and traced) inlet piping and PRVs may have operating temperatures close to the operating temperature of the protected equipment.
46	Specify the actual temperature at relieving conditions and unit of measure.
47	Specify the increase in pressure in the discharge header as a result of flow. Conventional PRVs are limited in the amount of built-up backpressure they can tolerate. In some cases, a balanced type of valve may be required.
48	Specify the amount of superimposed backpressure that normally exists on the valve outlet and unit of measure. If backpressure is variable, specify the minimum and maximum.

Users of instructions should not rely exclusively on the information contained in this document. Sound business, scientific, engineering, and safety judgment should be used in employing the information contained herein. Where applicable, authorities having jurisdiction should be consulted. Work sites and equipment operations may differ. Users are solely responsible for assessing their specific equipment and premises in determining the appropriateness of applying the instructions.

Table D.1—Instructions for Spring-loaded Pressure-relief Valve Specification Sheet *(continued)*

Line No.	Instructions
49	Manufacturer to specify the set pressure at which the valve is adjusted to open on the test stand. This value is the cold differential test pressure (CDTP). The CDTP includes backpressure and/or temperature corrections to the set pressure for the service conditions.
50	Specify the overpressure allowed, as a percent of set pressure or as a unit of measure.
51	Specify the compressibility factor, if used. The compressibility factor is required for vapor sizing cases only.
52	Specify the ideal gas specific heat ratio as $k = C_p/C_v$. The specific heat ratio is required for vapor sizing cases only.
53	Specify the calculated orifice area, in. ² (mm ²). Note that the purchaser should supply this value and it should be validated by the manufacturer (see Line 57).
54	Specify the selected effective discharge area, in. ² (mm ²). The effective discharge areas are provided in API 526. Special discharge areas exist that exceed the API 526 effective areas. Consult the manufacturer for additional information. If a restricted lift valve design is chosen, this value should be provided by the manufacturer.
55	Specify the letter designation of the selected orifice. The effective orifice letter designations are provided in API 526. If a restricted lift valve design is chosen, the manufacturer should be consulted. For restricted lift applications, the orifice letter designation shall include the suffix "-RL."
56	Fill in the name of the manufacturer, if desired.
57	Fill in the manufacturer's model or type numbers, if desired.
58	Confirmation of orifice sizing calculations required from vendor. It is recommended to always have the manufacturer verify the sizing using actual orifice areas and certified coefficients of discharge.
59	General Notes pertaining to the valve sizing or selection. For example, if a restricted lift valve design is chosen, the user <u>should-shall</u> specify the required capacity on Line 37 and the maximum desired rated capacity here.

Users of instructions should not rely exclusively on the information contained in this document. Sound business, scientific, engineering, and safety judgment should be used in employing the information contained herein. Where applicable, authorities having jurisdiction should be consulted. Work sites and equipment operations may differ. Users are solely responsible for assessing their specific equipment and premises in determining the appropriateness of applying the instructions.

SPRING-LOADED PRESSURE-RELIEF VALVE SPECIFICATION SHEET		Sheet Number _____ Page _____ of _____
		Requisition Number _____
		Job Number _____
		Date _____
		Revision Number _____
By _____		
GENERAL		
1. Item Number: _____	3. Service, Line, or Equip. Number: _____	
2. Tag Number: _____	4. Number of Valves Required: _____	
BASIS OF SELECTION		
5. Code: ASME VIII <input type="checkbox"/> Stamp Required: Yes <input type="checkbox"/> No <input type="checkbox"/>	7. Fire <input type="checkbox"/> Other <input type="checkbox"/> Specify: _____	
Other <input type="checkbox"/> Specify: _____	8. Rupture Disk: Yes <input type="checkbox"/> No <input type="checkbox"/>	
6. Comply with API 526: Yes <input type="checkbox"/> No <input type="checkbox"/>		
VALVE DESIGN		
9. Design Type: _____	13. Bonnet Type: Open <input type="checkbox"/> Closed <input type="checkbox"/>	
Conventional <input type="checkbox"/> Bellows <input type="checkbox"/> Balanced Piston <input type="checkbox"/>	14. Seat Type: Metal-to-Metal <input type="checkbox"/> Resilient <input type="checkbox"/>	
10. Trim Type: Liquid <input type="checkbox"/> Vapor <input type="checkbox"/> Dual <input type="checkbox"/>	15. Seat Tightness: API 527 <input type="checkbox"/>	
11. Restricted Lift: Yes <input type="checkbox"/> No <input type="checkbox"/>	Other <input type="checkbox"/> Specify: _____	
12. Nozzle Type: Full <input type="checkbox"/> Semi <input type="checkbox"/>		
Other <input type="checkbox"/> Specify: _____		
CONNECTIONS		
16. Inlet Size: _____ Rating: _____ Facing: _____	18. Other <input type="checkbox"/> Specify: _____	
17. Outlet Size: _____ Rating: _____ Facing: _____		
MATERIALS		
19. Body: _____	25. Spring: _____ Washer: _____	
20. Bonnet: _____	26. Bellows: _____	
21. Seat (Nozzle): _____ Disk: _____	27. Balanced Piston: _____	
22. Resilient Seal: _____	28. Comply with NACE: Yes <input type="checkbox"/> No <input type="checkbox"/>	
23. Guide: _____	29. Internal Gasket Materials: _____	
24. Adjusting Ring(s): _____	30. Other <input type="checkbox"/> Specify: _____	
ACCESSORIES		
31. Cap: Screwed <input type="checkbox"/> Bolted <input type="checkbox"/>	34. Bug Screen: Yes <input type="checkbox"/> No <input type="checkbox"/>	
32. Lifting Lever: Plain <input type="checkbox"/> Packed <input type="checkbox"/> None <input type="checkbox"/>	35. Other <input type="checkbox"/> Specify: _____	
33. Test Gag: Yes <input type="checkbox"/> No <input type="checkbox"/>		
SERVICE CONDITIONS		
36. Fluid and State: _____	45. Operating Temperature and Units: _____	
37. Required Capacity per Valve and Units: _____	46. Relieving Temperature and Units: _____	
38. Mass Flux and Basis: _____	47. Built-up Backpressure and Units: _____	
39. Molecular Weight or Specific Gravity: _____	48. Superimposed Backpressure and Units: _____	
40. Viscosity at Flowing Temperature and Units: _____	49. Cold Differential Test Pressure and Units: _____	
41. Operating Pressure and Units: _____	50. Allowable Overpressure in Percent or Units: _____	
42. Set Pressure and Units: _____	51. Compressibility Factor, Z: _____	
43. Blowdown: Standard <input type="checkbox"/> Other <input type="checkbox"/>	52. Ratio of Specific Heats: _____	
44. Latent Heat of Vaporization and Units: _____		
SIZING AND SELECTION		
53. Calculated Orifice Area (in square inches): _____	56. Manufacturer: _____	
54. Selected Effective Orifice Area (in square inches): _____	57. Model Number: _____	
55. Orifice Designation (letter): _____	58. Vendor Calculations Required: Yes <input type="checkbox"/> No <input type="checkbox"/>	
GENERAL NOTES		
59. _____		

NOTE The user should indicate items to be completed by the manufacturer with an asterisk (*).

Figure D.1—Spring-loaded Pressure-relief Valve Specification Sheet

Table D.2—Instructions for Pilot-operated Pressure-relief Valve Specification Sheet

Line No.	Instructions
1	Fill in item number.
2	Fill in user's pressure-relief valve (PRV) identification number.
3	Specify service, line, or equipment to be protected. An equipment tag number and description should be included.
4	Specify number of valves required. A specification sheet for each PRV of a multiple valve installation should be completed.
5	Specify the applicable code(s) and whether Code Symbol nameplate stamping is required.
6	Check Yes if compliance with API 526 is desired.
7	Check fire or specify other basis of selection. Consideration should be given to supplying all applicable overpressure scenarios. As a minimum, provide the governing sizing scenario for the vapor sizing case as well as the liquid sizing case, if both are applicable.
8	Specify whether a rupture disk is being used under the main valve inlet.
9	Specify type of main valve operation, piston, diaphragm, or bellows.
10	Specify whether the trim type is liquid, vapor, or dual.
11	Specify whether a restricted lift valve design is chosen (nonstandard API orifice area; see Section 4.2.4). If a restricted lift valve design is selected, the user shall provide the manufacturer with a required capacity on Line 46 and the maximum desired rated capacity (specify in the general notes, Line 68).
12	Specify number of pilots per main valve. Multiple pilots are sometimes advantageous in critical applications. The multiple pilots allow switching, inspecting, repairing, and testing of pilots in applications when higher inspection frequencies are warranted.
13	Specify if pilot is flowing or nonflowing type. Typically, a nonflowing pilot is preferred.
14	Specify type of action, pop or modulating. Modulating pilots minimize the amount of fluid discharged during actuation and also have advantages in high inlet pressure drop applications by reducing the amount of flow to the valve.
15	Specify sensing point as integral at main valve inlet or at a remote location. If remote sensing, provide the distance between the pilot and its sense point.
16	Specify metal-to-metal or resilient seat. Resilient seats are typical. Operating temperature, pressure, and fluid corrosivity or compatibility may limit the applicability of soft goods.
17	If other than API 527, specify seat tightness test requirements. The ASME Code requires PRVs to be tested in accordance with API 527. Other codes may have alternate requirements.
18	Specify if pilot venting is to atmosphere, valve outlet, or other closed system. If pilot vent discharges to a closed system that is different from the main valve discharge, the purchaser needs to supply the pilot vent discharge system pressure.
19	Specify pipe size of inlet, flange rating, and type of facing. Inlet flange rating and facing should be chosen to meet the requirements of the upstream protected equipment specification.

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Table D.2—Instructions for Pilot-operated Pressure-relief Valve Specification Sheet *(continued)*

Line No.	Instructions
20	Specify pipe size of outlet, flange rating, and type of facing. Outlet flange rating and facing should be chosen to meet the requirements of the downstream discharge system. Typically, the discharge system will be designed to ANSI Class 150. However, higher flange class ratings may be required when the PRV discharge is to a closed system.
21	Specify type of connection if other than flanges (e.g. threaded, socket weld, etc.).
22	Specify material of body. API 526 provides general construction materials that are appropriate for selection based on pressure and temperature only. Where added corrosion resistance is needed to meet the severity of the process fluid, provide material requirements here .
23	Specify material of seat or nozzle and piston (see guidance for Line 22).
24	Specify material of resilient seat (if required) and seals. Typical resilient seat materials include fluoroelastomers, nitrile, and ethylene propylene. Other materials are available to meet process conditions.
25	Specify material of piston seal. Typical seal materials include fluoroelastomers, nitrile, and ethylene propylene. Other materials are available to meet process conditions.
26	Specify material of piston liner or guide. Typically, this information is completed by the manufacturer.
27	Specify material of main valve diaphragm or bellows. Diaphragm materials are chosen for compatibility with the process fluid. Typical diaphragm materials include fluoroelastomers, nitrile, and ethylene propylene.
28	Specify material of pilot body and bonnet (see guidance for Line 22).
29	Specify material of pilot internals (see guidance for Line 22).
30	Specify material of seat and seals of the pilot. Typically, this information is completed by the manufacturer.
31	Specify material of pilot diaphragm. Diaphragm materials are chosen for compatibility with the process fluid. Typical diaphragm materials include fluoroelastomers, nitrile, and ethylene propylene.
32	Specify material of tubing and fittings. Typically, stainless steel and other materials are available based on compatibility with the process fluid.
33	Specify material of filter body and cartridge. Typically, stainless steel and other materials are available based on compatibility with the process fluid.
34	Specify material of pilot spring. Generic pilot spring materials are not provided in API 526 as a function of pressure and temperature. Since the pilot spring is not exposed to the process fluid atmosphere, material selection is generally based on the ambient temperature and ambient environment. Typically, this information is completed by the manufacturer.
35	Specify the NACE document, if any (see guidance for Line 22). The NACE requirement is typically needed for processes containing H ₂ S. Special attention is given to spring or bellows materials since they are subject to stress corrosion cracking.
36	Specify any other special material requirements.
37	Specify if external filter is required. External filters are used in the pilot sense line when there are contaminants or high concentrations of solids in the process fluid that may cause plugging in the pilot.
38	Specify if the pilot is to have a plain or packed lifting lever, or none. Lifting levers are required by the ASME Code in air, steam, and hot water services, see 4.2.1.4. Note that ASME Code Case 2203-1 should be specified on this specification sheet, if the purchaser wants to waive this requirement.

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Table D.2—Instructions for Pilot-operated Pressure-relief Valve Specification Sheet (continued)

Line No.	Instructions
39	Specify if field test connection is required. Test connections can be used to verify the set pressure of the pilot while in operation without removing the valve from the installation.
40	Specify if field test indicator is required. The field test indicator indicates that the valve has opened. This device indicates any opening during operation as well as opening during field tests (see Line 39).
41	Specify if backflow preventer is required. Backflow preventers cause the main valve to remain closed when the outlet pressure exceeds the inlet pressure. This is of particular importance during shutdowns when the protected equipment is isolated from a live discharge system.
42	Specify if manual blowdown valve is required. Manual blowdown valves allow opening of the main valve without actuation of the pilot.
43	Specify if test gag is required. see 4.2.1.4. A test gag shall only be used during hydrostatic testing of the protected equipment and shall be removed and replaced with a plug during operation.
44	Specify other accessories that are required.
45	Indicate flowing fluid and state (liquid, gas, vapor, or two-phase). Note that in two-phase applications, the purchaser is required to provide the manufacturer with the relieving mass flux (see Line 47).
46	Specify quantity of fluid that the valve is required to relieve at relieving conditions and unit of measure (such as lb/h, gal/min, or ft ³ /min). If the fire case is the governing vapor overpressure scenario, this relieving rate is not required provided the latent heat of the fluid is provided in Line 53.
47	Specify the mass flux and the basis for the calculations. This is required for two-phase applications only. The basis for the calculation could be the HEM Omega Method or the Direct Integration Method (HDI) as discussed in Annex C. Other calculation methods are acceptable.
48	Specify the molecular weight or specific gravity of the fluid at the flowing temperature. Molecular weight is required for vapor sizing only; specific gravity is required for liquid sizing only.
49	Specify viscosity and unit of measure at the flowing temperature. Viscosity is required for liquid sizing cases.
50	Specify maximum operating pressure and unit of measure. Note that this is typically the same as the maximum operating pressure of the protected equipment.
51	Specify set pressure and unit of measure.
52	Specify the maximum blowdown as a percent of set pressure if different than manufacturer's standard.
53	Specify the latent heat of vaporization and unit of measure. This is required for vapor sizing for the fire case only.
54	Specify the operating temperature and unit of measure. Note that this is typically the same as the operating temperature of the protected equipment.
55	Specify the actual temperature at relieving conditions and unit of measure.
56	Specify the increase in pressure in the discharge header as a result of flow.
57	Specify the amount of superimposed backpressure that normally exists on the valve outlet and unit of measure. If backpressure is variable, specify the minimum and maximum.

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Table D.2—Instructions for Pilot-operated Pressure-relief Valve Specification Sheet *(continued)*

Line No.	Instructions
58	Specify the set pressure at which the valve is adjusted to open on the test stand. This value is the cold differential test pressure (CDTP). The CDTP includes corrections to the set pressure for the service conditions of backpressure or temperature or both.
59	Specify the overpressure allowed, as a percent of set pressure or as a unit of measure.
60	Specify the compressibility factor, if used. The compressibility factor is required for vapor sizing cases only.
61	Specify the ideal gas specific heat ratio as $k = C_p/C_v$. The specific heat ratio is required for vapor sizing cases only (see Annex B).
62	Specify the calculated discharge area, in. ² (mm ²). Note that the purchaser should supply this value and it should be validated by the manufacturer (see Line 67).
63	Specify the selected effective discharge area, in. ² (mm ²). The effective discharge areas are provided in API 526. Special discharge areas exist that exceed the API 526 effective areas. Consult the manufacturer for additional information. If a restricted lift valve design is chosen, this value should be provided by the manufacturer.
64	Specify the letter designation of the selected discharge area. The effective discharge area letter designations are provided in API 526. Consult the manufacturer for additional information. If a restricted lift valve design is chosen, the orifice letter designation shall include the suffix "-RL."
65	Fill in the name of the manufacturer, if desired.
66	Fill in the manufacturer's model or type numbers, if desired.
67	Confirmation of orifice sizing calculations required from vendor. It is recommended to always have the vendor verify the sizing using actual discharge areas and certified coefficients of discharge.
68	General Notes pertaining to the valve sizing or selection. For example, if a restricted lift valve design is chosen, the user <u>should-shall</u> specify the required capacity on Line 46 and the maximum desired rated capacity here.

Users of instructions should not rely exclusively on the information contained in this document. Sound business, scientific, engineering, and safety judgment should be used in employing the information contained herein. Where applicable, authorities having jurisdiction should be consulted. Work sites and equipment operations may differ. Users are solely responsible for assessing their specific equipment and premises in determining the appropriateness of applying the instructions.

PILOT-OPERATED PRESSURE-RELIEF VALVE SPECIFICATION SHEET		Sheet Number _____ Page _____ of _____	
		Requisition Number _____	
		Job Number _____	
		Date _____	
		Revision Number _____	
By _____			
GENERAL			
1. Item Number:		3. Service, Line, or Equip. Number:	
2. Tag Number:		4. Number of Valves Required:	
BASIS OF SELECTION			
5. Code: ASME VIII [] Stamp Required: Yes [] No []		7. Fire [] Other [] Specify:	
Other [] Specify:		8. Rupture Disk: Yes [] No []	
6. Comply with API 526: Yes [] No []			
VALVE DESIGN			
9. Design Type: Piston [] Diaphragm [] Bellows []		15. Pilot Sense: Internal [] Remote []	
10. Trim Type: Liquid [] Vapor [] Dual []		16. Seat Type: Metal-to-Metal [] Resilient []	
11. Restricted Lift: Yes [] No []		17. Seat Tightness: API 527 []	
12. Number of Pilots:		Other [] Specify:	
13. Pilot Type: Flowing [] Nonflowing []		18. Pilot Vent: Atmosphere [] Outlet []	
14. Pilot Action: Pop [] Modulating []		Other [] Specify:	
CONNECTIONS			
19. Inlet Size: _____ Rating: _____ Facing: _____		21. Other [] Specify:	
20. Outlet Size: _____ Rating: _____ Facing: _____			
MATERIALS, MAIN VALVE			
22. Body:		25. Piston Seal:	
23. Seat (Nozzle): _____ Piston:		26. Piston Liner / Guide:	
24. Resilient Seat: _____ Seals:		27. Diaphragm / Bellows:	
MATERIALS, PILOT			
28. Body / Bonnet:		33. Filter Body: _____ Cartridge:	
29. Internals:		34. Spring:	
30. Seat: _____ Seals:		35. Comply with NACE: Yes [] No []	
31. Diaphragm:		36. Other [] Specify:	
32. Tubing / Fittings:			
ACCESSORIES			
37. External Filter: Yes [] No []		41. Backflow Preventer: Yes [] No []	
38. Lifting Lever: Plain [] Packed [] None []		42. Manual Blowdown Valve: Yes [] No []	
39. Field Test Connection: Yes [] No []		43. Test Gauge: Yes [] No []	
40. Field Test Indicator: Yes [] No []		44. Other [] Specify:	
SERVICE CONDITIONS			
45. Fluid and State:		54. Operating Temperature and Units:	
46. Required Capacity per Valve and Units:		55. Relieving Temperature and Units:	
47. Mass Flux and Basis:		56. Built-up Backpressure and Units:	
48. Molecular Weight or Specific Gravity:		57. Superimposed Backpressure and Units:	
49. Viscosity at Flowing Temperature and Units:		58. Cold Differential Test Pressure and Units:	
50. Operating Pressure and Units:		59. Allowable Overpressure in Percent or Units:	
51. Set Pressure and Units:		60. Compressibility Factor, Z:	
52. Blowdown: Standard [] Other []		61. Ratio of Specific Heats:	
53. Latent Heat of Vaporization and Units:			
SIZING AND SELECTION			
62. Calculated Orifice Area (in square inches):		65. Manufacturer:	
63. Selected Effective Orifice Area (in square inches):		66. Model Number:	
64. Orifice Designation (letter):		67. Vendor Calculations Required: Yes [] No []	
GENERAL NOTES			
68.			

NOTE The user should indicate items to be completed by the manufacturer with an asterisk (*).

Annex E (informative)

Capacity Evaluation of Rupture Disk and Piping System 100 % Vapor Flow and Constant Pipe Diameter

E.1 General

E.1.1 The following method can be used to estimate the vapor capacity of a rupture disk/piping system of constant diameter. The method is based on compressible pipe flow equations contained in Crane Technical Paper 410 ^[16] and the application of standard resistance factors (K values) from API 521.

E.1.2 The method assumes that C_p/C_v is equal to 1.4. This assumption provides conservative results. The method can be applied to a piping system with varying diameters by treating each section of constant diameter separately.

NOTE The method presented in Crane 410 is based on graphical evaluation of several parameters. Curve fits of the graphical data are also presented below to allow direct solution without the graphical data. The use of the curve fitting equations introduces negligible error relative to the accuracy of the K factors.

E.2 Example Problem

Figure E.1 shows the arrangement of the vessel and rupture disk/piping system for the example problem.

a) Step 1—Determine required information:

- MAWP = 100 psig;
- P_1 = relieving pressure = 110 % = 124.7 psia;
- T_1 = relieving temperature = 200 °F + 460 °F = 660 °R;
- Z_1 = relieving compressibility = 1.0;
- M = molecular weight = 20;
- P_2 = backpressure = 14.7 psia.

b) Step 2—Determine overall piping resistance factor, K , from Table E.1.

c) Step 3—Determine Y_{sonic} and $\frac{dP_{\text{sonic}}}{P_1}$ based on total system K .

The charts on page A-22 of Crane 410 ^[16] can be used to obtain Y_{sonic} and $\frac{dP_{\text{sonic}}}{P_1}$. From the chart

where, k (C_p/C_v) = 1.4, the following values are determined:

$$Y_{\text{sonic}} = 0.653$$

$$\frac{dP_{\text{sonic}}}{P_1} = 0.70$$

Table E.1—Determination of Overall Piping Resistance Factor, K

Description	K Value	Source of K Value Data
Sharp-edged entrance	0.50	Crane ^[16] , Page A29
Rupture disk	1.50	Consult the rupture disk manufacturer
15 ft NPS 3 Schedule 40 pipe	1.04	$K = \frac{fL}{D}$ $f = 0.0178$ $L = 15 \text{ ft}$ $D = \frac{3.068}{12} = 0.2557 \text{ ft}$
Sudden expansion (exit loss)	1.00	API 521, Table 10 (see NOTE)
Total system K	4.04	

NOTE When the pressure drop calculation method used accounts for kinetic energy (e.g. the Isothermal Method in API 521), the exit loss coefficient can be neglected when discharging compressible fluids into a large reservoir such as the atmosphere ~~if the pressure drop equation accounts for kinetic energy changes (e.g. the Isothermal Method in API 521)~~. The user is cautioned that some piping pressure drop calculation methods do not account for kinetic energy in which case the exit loss should be included in the pressure drop equation.

As an alternate to the chart method, curve fit equations for obtaining Y_{sonic} and $\frac{dP_{\text{sonic}}}{P_1}$ have been

provided as Equation (E.1) through Equation (E.4).

For $\frac{dP_{\text{sonic}}}{P_1}$:

$$\text{If } 1.2 < K \leq 10, \text{ then } \frac{dP_{\text{sonic}}}{P_1} = 0.1107 \ln(K) + 0.5352 \quad (\text{E.1})$$

$$\text{If } 10 < K \leq 100, \text{ then } \frac{dP_{\text{sonic}}}{P_1} = 0.0609 \ln(K) + 0.6513 \quad (\text{E.2})$$

For Y_{sonic} :

$$\text{If } 1.2 < K \leq 20, \text{ then } Y_{\text{sonic}} = 0.0434 \ln(K) + 0.5889 \quad (\text{E.3})$$

$$\text{If } 20 < K \leq 100, \text{ then } Y_{\text{sonic}} = 0.710 \quad (\text{E.4})$$

Based on $K = 4.04$:

$$\frac{dP_{\text{sonic}}}{P_1} = 0.69$$

$$Y_{\text{sonic}} = 0.65$$

$\frac{dP_{\text{sonic}}}{P_1}$ d) Step 4—Compare

$$P_1 \quad \text{to} \quad \frac{dP_{\text{actual}}}{P_1}.$$

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$$\frac{dP_{\text{actual}}}{P_1} = \frac{(124.7 - 14.7)}{124.7} = 0.88$$

Since $\frac{dP_{\text{sonic}}}{P_1} < \frac{dP_{\text{actual}}}{P_1}$, the flow will be sonic (critical).

$$\frac{dP_{\text{sonic}}}{P_1}$$

Use Y_{sonic} and $\frac{dP_{\text{sonic}}}{P_1}$ and skip to Step 6 (if subsonic, proceed to Step 5).

e) Step 5—Evaluate Y_{actual} (subsonic cases only).

Using the Crane 410—Chart A-22 Method to obtain Y_{actual} :

1) at $\frac{dP_{\text{actual}}}{P_1}$ and K determine Y_{actual} from Chart A-22;

2) use $\frac{dP_{\text{actual}}}{P_1}$ and Y_{actual} in Step 6.

Using the Curve Fit Method for obtaining Y_{actual} :

1) calculate Y_{actual} from the Equation (E.5):

$$Y_{\text{actual}} = 1 - \frac{(1 - Y_{\text{sonic}}) \left(\frac{dP_{\text{actual}}}{P_1} \right)}{\frac{dP_{\text{sonic}}}{P_1}} \quad (\text{E.5})$$

2) use $\frac{dP_{\text{actual}}}{P_1}$ and Y_{actual} in Step 6 in place of $\frac{dP_{\text{sonic}}}{P_1}$ and Y_{sonic} .

f) Step 6—Calculate capacity based on Crane 410—Equation (3-20):

$$W = 0.9 \left(1891 \times Y \times d^2 \sqrt{\frac{dP}{K \times V_1}} \right) \quad (\text{E.6})$$

g) Step 7—Using the Chart Method values and Equation (E.6):

1) $Y = Y_{\text{sonic}} = 0.65$;

2) $d = \text{pipe ID (in.)} = 3.068 \text{ in.}$;

3) $dP = \left(\frac{dP_{\text{sonic}}}{P_1} \right) (P_1) = 87.3 \text{ psi};$

4) $K = \text{overall resistance} = 4.04;$

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5) V_1 = vapor specific volume = 2.84 ft³/lb (obtained using ideal gas law and compressibility).

$$6) \quad W = 0.9 \left(\frac{1891 \times 0.65 \times 3.068^2}{4.04 \times 2.84} \sqrt{\frac{87.3}{}} \right) = 28,700 \text{ lb/h.}$$

h) Step 8—Using the Curve Fit Method values from Figure E.2 and Equation (E.6):

1) $Y = Y_{\text{sonic}} = 0.65$;

2) d = Pipe ID (in.) = 3.068 in.;

3) $dP = (dP_{\text{sonic}}/P_1)(P_1) = 86.0$ psi;

4) K = Overall resistance = 4.04;

5) V_1 = vapor specific volume = 2.84 ft³/lb (obtained using ideal gas law and compressibility).

$$6) \quad W = 0.9 \left(\frac{1891 \times 0.65 \times 3.068^2}{4.04 \times 2.84} \sqrt{\frac{86.0}{}} \right) = 28,508 \text{ lb/h.}$$

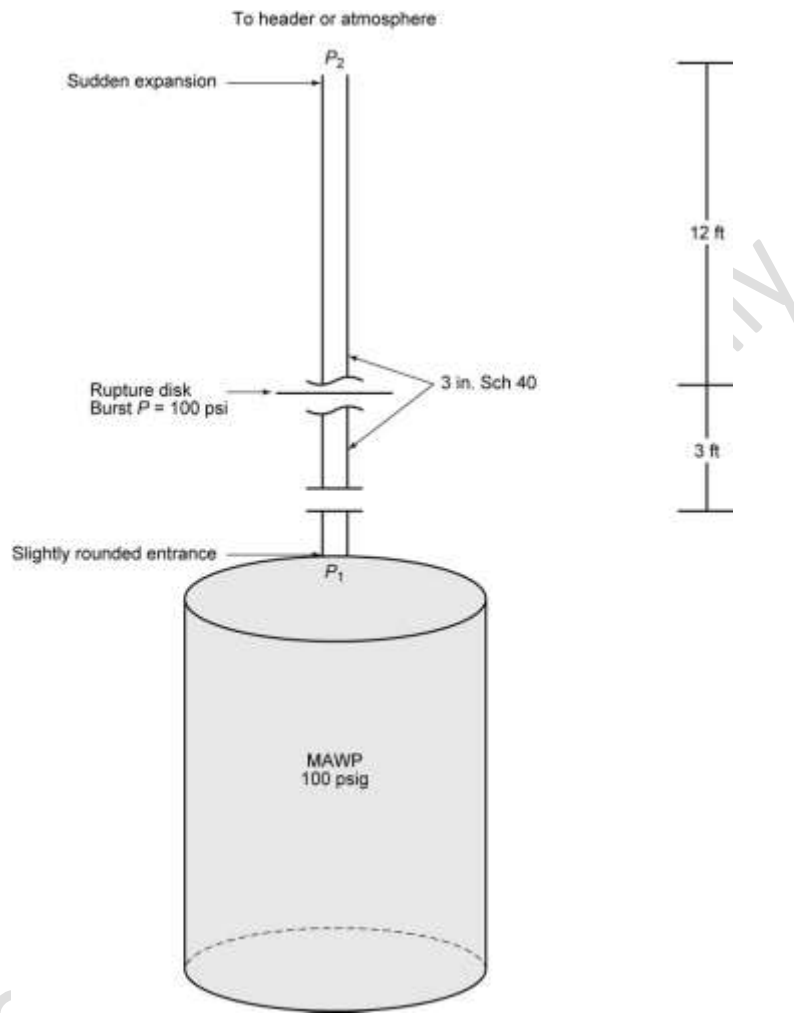


Figure E.1—Pressure-relief System for Example Problem

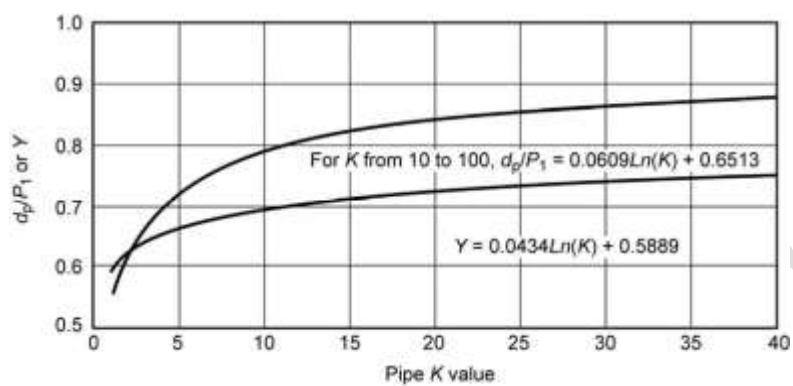


Figure E.2—Curve Fit for $C_p/C_v = 1.4$ (Crane 410, Chart A-22)

Annex F (informative)

Valve Selection Example: Restricted Lift

NOTE This example demonstrates the use of the restricted lift option. The values used in this example may or may not be an example of an actual pressure-relief application.

Data:

Valve Type: Balanced Bellows Spring Operated Valve
Set Pressure: 600 psig
Backpressure: 100 psig
Operating Temperature: 350 °F
Design Temperature: 450 °F
Outlet Temperature: 100 °F
Body/Bonnet Material: Carbon Steel
Orifice: Q
Size: 6 in. inlet x 8 in. outlet
Required Capacity: 200,000 lb/h

In order to reduce the piping pressure losses, it has been determined that the rated capacity needs to be limited to a maximum value of 260,000 lb/h.

Valve Selection:

The following valve details are per API 526:

Q Orifice: Use Table 14 from API 526
Spring: Select Carbon Steel or Chrome Alloy Steel for -75 °F to 450 °F from Table 2 of API 526
Valve Selection: 6Q8 Class 600 Inlet, Class 150 Outlet (inlet rated 600 psi @ 450 °F)
Bellows: Use Annex C of API 526, select any material (all materials are acceptable for 100 psi @ 100 °F)

The following are specified on the purchase specification sheet (see Annex D, Figure D.2):

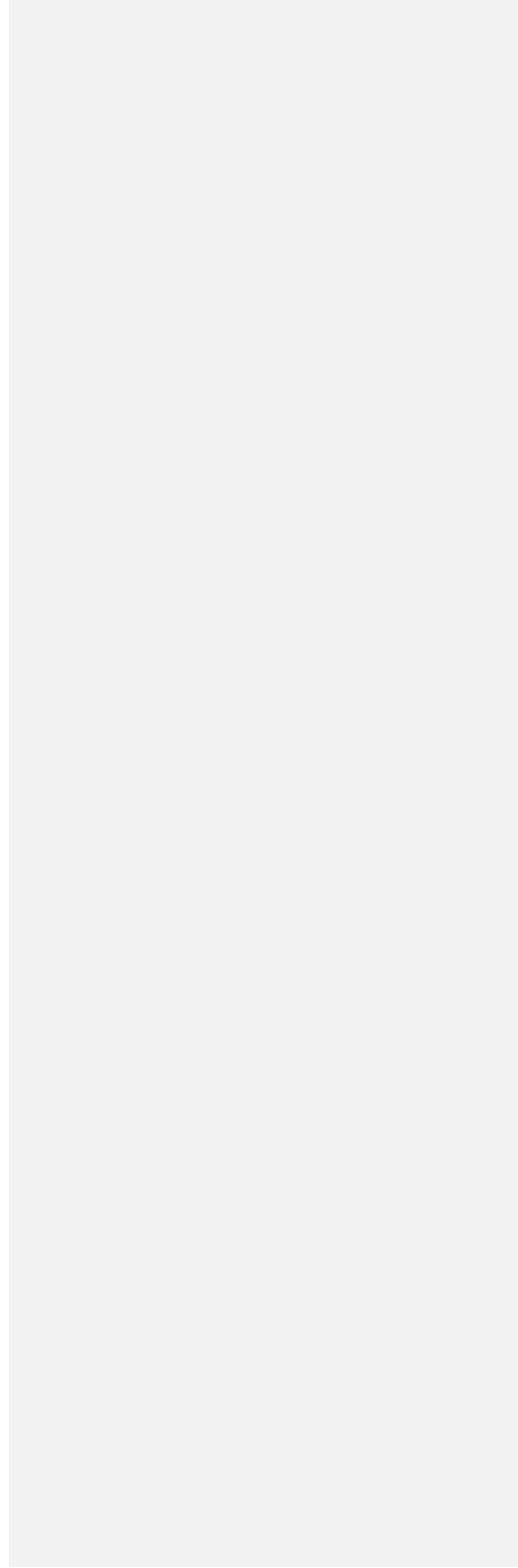
Orifice Designation (Line 55): Q-RL
Required Capacity (Line 37): 200,000 lb/h
Maximum Desired Rated Capacity (specified in the datasheet notes, Line 59): 260,000 lb/h

The manufacturer stamps the nameplate to identify the reduced lift value and the rated capacity based on that reduced lift value. In this example, the nameplate is stamped with a rated capacity that is between 200,000 and 260,000 lb/h per ASME Section VIII-UG-131(e)(1) or ASME Section I-PG- 69.2.3(a).

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