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| Title:             | Post Hydro API 650 work                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                                                                                                                           | Agenda Item # 650-2086 |
| Date:              | 7/8/2026                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                                                                                                           |                        |
| Contact:           | Name:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | Leacil Kirkes                                                                                                                             |                        |
|                    | Company:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | Smith Tank & Steel, Inc.                                                                                                                  |                        |
|                    | Phone:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | 225-305-6167                                                                                                                              |                        |
|                    | E-mail:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | lkirkes@smith-tank.com                                                                                                                    |                        |
|                    | Task Group Members:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | Edward Kennepohl, Lyle Smith, David Clark, Chris Ingold, Jerry Kolek, Rama Challa, Chuck Kolb, Earl Crochet, Kirk Sheppard, Daniel Simard |                        |
| Purpose:           | To provide guidance and requirements when (By agreement with Purchaser) modifications, repairs, additional welding is done to a new construction tank, such as removing/reinstalling a section of Shell, after hydrostatic testing has been completed.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                                                                                                                                           |                        |
| Source:            | API 650 14 <sup>th</sup> Edition August 2025                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                                                                                                                           |                        |
| Revision:          | 0                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                           |                        |
| Impact:            | In certain circumstances could be substantial                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                                                                                                                           |                        |
| Rationale:         | Currently, no guidance exists for a new tank when doing modifications/repairs to a new tank such as removing a Shell section to gain access inside the tank after Hydrostatic testing, installing a patch plate on a new bottom, or installing a nozzle after hydro-test. Propose utilizing and following API 653 guidelines, which may include Hydro-exemption and performing fitness-for-service.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                                                                                           |                        |
| Current document:  | API 650-----<br>Section 2 Normative References<br>Section 7.3.7 Hydrostatic Testing Requirements                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                           |                        |
| Proposed document: | Add into API 650-----<br>Normative References<br>Sec. 2<br>API 650 <ul style="list-style-type: none"><li>API standard 653, Tank Inspection, Repair, Alteration, and Reconstruction</li></ul><br>7.3.7 Hydrostatic Testing Requirements<br><br>7.3.7.1 The tank hydrostatic test shall be conducted before permanent external piping is connected to the tank except for piping that is necessary to fill and empty the tank, which should have a flexible component to allow for settlement.<br><br>7.3.7.2 Attachments to the shell defined in 5.8.1.1, located at least 1 m (3 ft) above the water level, and roof appurtenances may be welded during the filling of the tank with water.<br><br>7.3.7.3 After completion of the hydrotest hydrostatic test, only nonstructural small attachments may be welded to the tank in accordance with 7.2.1.11. Additional welding, repairs or modification after completion of the hydrostatic test, but prior to tank being commissioned, or placed in service, may be performed as specified in API 653 if agreed to by the Purchaser.<br><br>7.3.7.24 Unless otherwise specified by the Purchaser, all internal and external coating systems that will cover tank shell joints shall be applied after the hydrostatic test. If specified by the Purchaser that a coating system is to be applied to the shell joints before the hydrostatic test, all shell joints to be coated shall be tested in accordance with 7.3.6.2.1 prior to the application of coating.<br><br>7.3.7.35<br><br>(Change numbering on remainder of section) |                                                                                                                                           |                        |