

API Ballot Comments Sheet

1/24/2008

Ballot: API 608 Review 12-07 Version

Start Date: 12/3/07

Closing Date: 1/17/08

AMS Ballot ID: 1,287

Associate: Gordon Robertson

Coordinator: Gordon Robertson

Proposal:

81462 Ray Bojarczuk

ExxonMobil Research and Engineering Company

<u>Specification Section</u>	<u>Type</u>	<u>Comment</u>	<u>Suggested Change</u>
Par 5.5.3	Technical	Manufacturers published torque values are often extrapolated for larger sizes and higher pressures.	Add the following sentence to the second paragraph: Published torque values shall indicate if such values have been derived by extrapolating data from smaller sizes and/or lower rated valves.
Par 5.8.1	Technical	Suggest that oval type handles be permitted for valves NPS 1 and smaller.	Limit 5.8.1 to only cover valves larger than NPS 1.
Par 9.1	Technical	Since this revision now covers hollow ball construction (by virtue of permitting them in Par 5.6) Par 9.1 also needs to address hollow ball drainage.	Include reference to hollow balls in Par 9.1
Par 9.4	Technical	I do not understand why NPS 2 and smaller are exempted from the end protection requirements.	Delete the last sentence of Par 9.4

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100715 Ayman Cheta

Shell Global Solutions (US) Inc.

Specification Section

Type

Comment

Suggested Change

Miscellaneous

Technical

1. Unjustified major re-write of ISO 17292. Most changes are editorial. Technical changes are very minor and reconcilable. The result of this proposed re-write will be to turn back the clock and undo all the hard work that was done by the US delegates to make API 608 acceptable internationally under ISO.
2. Omission of SI units and metric dimensions (although the base document ASME B16.34 uses them) will further inhibit the use of API 608 outside the US.
3. Para. 4.3 does not require the lower P/T rating caused by the non-metallic seat/seal material, to be listed on the identification plate / name plate. This is a safety concern for refineries.
4. The proposed draft does not address the fire testing. It is not even listed as optional in Annex A

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102846 Kasey Crowell

CITGO Petroleum Corporation

<u>Specification Section</u>	<u>Type</u>	<u>Comment</u>	<u>Suggested Change</u>
4.3.2	Editorial	The existing wording could be understood to mean that the valve manufacturer had to design the seat to a lower pressure/temperature than the shell.	replace "however in no case shall the seat pressure-temperature exceed the shell rating." with "however, the published seat pressure/temperature rating shall not exceed the published shell rating."
5.3.9	Editorial	The term "ball chamber" could be further explained for clarity.	Replace "ball chamber" with "ball chamber area of the body between seats"
8.3.3	Technical	Ball valves do not have a preferred flow direction, or a preferred inlet or outlet, only a preferred sealing direction. Ball valves are often used in applications where the high pressure side is downstream, when the valve is closed. Isolation valves used to prevent a pressure vessel from emptying its contents will always have the high pressure side to the vessel, despite whether the valve is on an inlet or an outlet. Similarly, pump isolation valves will have the low pressure side of the valve on the pump side, for both the suction and discharge. Arrows are almost always equated with the flow direction, by the field craftsmen and operators (as with a globe or check valve). Therefore arrows on unidirectional block valves should be discouraged.	Delete "flow direction" and replace with "sealing direction". Delete ""inlet" or "outlet"" and replace with "HP". Add "If an arrow is used, it shall point to the low pressure side of the valve, when the valve is closed".

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100644 Jerry D'Avanzo

DuPont

Specification Section

Type

Comment

Suggested Change

Introduction

Editorial

Reference to API 594 is missing.

Add reference to API 594.

4.3.1, 4.3.2, Table 1

Technical

Many manufacturers have standardized on modified PTFE seats (aka copolymer, TFM, super Teflon®). This material should be included in the paragraph.

Suggest the following rewording:

4.3.1 Seat Ratings for PTFE, R-PTFE, and Modified PTFE

Valves employing PTFE (polytetrafluoroethylene), R-PTFE (reinforced polytetrafluoroethylene), or modified PTFE (modified polytetrafluoroethylene) seats ... etc.

Same for 4.3.2.

5.3.8

Technical

Add criteria for welded flanges.

Add ratings for modified PTFE to Table 1.
Add the following to Para. 5.3.8:

Valves having flanges attached by welding shall meet the requirements of Paragraph 2.1.6 of ASME B16.34.

143882 Engin Gulgun

ZY-Tech Global Industries

Specification Section

Type

Comment

Suggested Change

5.10 Valve Shell Joints

Technical

Joint stress calculation method for both Bolted and threaded type connections are not addressed

Each bolted or threaded shell joint calculation shall be in accordance with the requirements of ASME B16.34 Section 6.4.

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149020 James Hengehold

Wm. Powell Company

<u>Specification Section</u>	<u>Type</u>	<u>Comment</u>	<u>Suggested Change</u>
1.3	Editorial	Format of "Single Reduced Bore" and "Double-reduced bore" should be the same.	Change "Double-reduced bore" to "Double Reduced Bore".
6.2	Technical	In 6.2, the trim is specified to be "the same nominal composition as the shell". For example, a carbon steel valve would have to have carbon steel trim as this is currently worded. Materials that are superior in corrosion resistance and strength should be allowed.	Change wording back to previous draft which stated that trim materials are to have corrosion resistant properties equivalent to or better than the shell.
8.1	Editorial	The marking to indicate API 608 compliance is stated as "API Std 608". However, other API standards such as API 600 and API 603 state nameplates are to be marked "API 600" or "API 603", as applicable. The lettering "Std" should be eliminated to be in the same format as the other standards.	Change "API Std 608" to "API 608".
Section 10	Editorial	The "Spare Parts" section does not add value. The customer always has to option to request this information if needed and this does not need to be added to the standard.	Delete "Spare Parts" paragraph (Section 10) and remove reference from Annex A.

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161398 Mirek Hubacek

Velan Valve Corp.

<u>Specification Section</u>	<u>Type</u>	<u>Comment</u>	<u>Suggested Change</u>
1.3	Editorial	Since the present draft is no longer taking into consideration the ISO 17292 "Metal ball valves for petroleum, petrochemical and allied industries.", I believe there is no reason to change Full Port to Full Bore, Regular Port to Single Reduced Bore and Reduced Port to Double-reduced bore as is suggested in this draft. We can now go back to the terminology of the previous API 608 revisions which will eliminate confusion in the market place.	Change Full Bore to Full Port, Single Reduced Bore to Regular Port and Double-reduced bore to Reduced Port.
2	Editorial	The present draft does not make references to API 607, ASME B31.3 or MSS SP-45. Those references should be deleted.	Delete API 607, ASME B31.3 and MSS SP-45
Table 2	Editorial	The Port titles in this table are in contradiction to Section 1.3.	Change Single Reduced Port to Regular Port and Double Reduced Port to Reduced Port.
5.3.9	Editorial	In the first sentence of the above paragraph the term of "Ball chamber" is introduced. To prevent confusion we may be better served using existing API terminology. In API 598, Section 4.4.4 the "Ball chamber" is identified as the "Body cavity between the seats".	In the first sentence replace "Ball chamber" with "Body cavity between the seats".
5.8.11	Technical	In this paragraph the lock shank length requirement is for not more than 4.00". Though the locking ability of the valve is only optional we have seen over the years the requirement for valve locking increase to such a degree that we are now making all our ball valves with the provision for locking but some of our customers are expecting that the valve must be suitable for up to 4.0" long lock shank. It is difficult to make all valve sizes compliant with the requirement for the 4.0" long lock shank. We would like to have this requirement removed from this standard.	Remove .."not more than 4.0" (102MM) long" from the second sentence. Change also (8MM) to (8mm).
7.2.3	Technical	The end of the sentence in this paragraph may suggest to some, that it is OK to pack the inside of the valve with grease or sealant after testing.	Remove the "prior the testing".
9.1	Editorial	See my comment in 5.3.9	Replace "ball chamber area" with "body cavity".

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161398 Mirek Hubacek

Velan Valve Corp.

<u>Specification Section</u>	<u>Type</u>	<u>Comment</u>	<u>Suggested Change</u>
9.7	Technical	<p>This paragraph requires the auxiliary tapped connections be fitted with threaded plugs. I believe this paragraph needs to be more specific.</p> <p>What is "fully tightened"? Does it mean tightened to seal or tightened with the same torque as required for sealing or simply tightened enough so the plug does not get lost during transportation? In case of S/S valves there is also the problem of threads galling if installed without sealant. I think this paragraph is not clear.</p> <p>I believe the plug shall be installed and sealed since NPT threads will not seal without sealant during the hydro. This raises another question. Is PTFE tape acceptable for high temperature? Obviously it is not suitable.</p> <p>In this standard we are liberally covering the protective end plugs and covers, but why not to be more specific regarding the auxiliary connections?</p>	<p>Add the following sentence: The thread sealant used to seal the plugs shall be suitable for the full pressure and temperature rating of the valve or as per agreement between the purchaser and valve manufacturer.</p>
5.2	Technical	<p>In this section are again used the terms for single reduced and double reduced bore. See my comment for Section 1.3</p>	<p>Replace full bore with full port, single reduced bore with regular port and double reduced bore with reduced port.</p>
5.5.3/5.8.11/5.9.1/5.9.2/5.10.2	Editorial	<p>All metric units are written incorrectly.</p>	<p>In 5.5.3 change (20 N-M) to (20N-m) 5.8.11 change (8MM) to (8mm) 5.9.2 change (0.25 MM) to (0.25mm) 5.9.1 change (1 MM) to (0.75mm) 5.10.2 change (2.54CM) to (25.4mm)</p>

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94997 Guy Jolly

Vogt Valve Company

Specification Section

Type

Comment

Suggested Change

Various

Technical

Tables are not metrics. Metrics not consistant.
Hydrotesting of shell and seat not consistant with B16.34.
Comments sent as separate item. Guy Jolly

See separate submittal of comments. Guy Jolly

API Ballot Comments Sheet

1/24/2008

94997 Guy Jolly

Vogt Valve Company

Specification Section	Type	Comment	Suggested Change
various	Technical	<p>CLAUSE TYPE MODIFICATION REASON</p> <p>All EditorialAbsents of Metric Units?? Are metrics to be a part of this standard? Starting with Para. 5.8.11 metric attempts are made but Tables do not show metric dimensions nor is metric size (DN) shown.</p> <p>4.2 Technical Add: The valve shell shall be pressure tested to ASME B16.34 requirements. To clarify the requirement of 4.1. A shell test of 1.5 x 100F rating per proposed Table 1 is not acceptable to B16.34.</p> <p>4.3.3 Technical Add: 4.3.3 The valve seats shall be closure tested to ASME B16.34 requirements. To clarify the requirement of 4.1. B16.34 would permit closure test commensurate with the proposed Table 1 values.</p> <p>Table 2 Technical ADD: Note to Table 2 relating to full port dimensions as follows: Except for NPS ½ and smaller the full port dimensions meet or exceed Appendix A, ASME B16.34 for a Class 800 valve. Current API 603 and past API 600 documents have linked "full port" to Appendix A, B16.34 dimensions. Table 1 values do not meet Appendix A, B16.34 for Class 150, 300 or 600 valves. The note would link Appendix A of B16.34 to Class 800 valve full port and retain the "full port" definition of API 603-2007.</p> <p>5.3.1 EditorialEND SENTENCE:ASME B16.34 for the applicable Standard Class. B16.34 wall thickness based on the standard Class of valve and not the P/T ratings of 4.1.</p> <p>5.3.5 Technical END SENTENCE:.....B16.25 with an inside diameter (denoted as B in B16.25) tolerance per ASME B16.34. B16.25 does not specify the tolerance.</p> <p>5.3.9 Technical ADD:solid test plug conforming to ASME B16.11. ASME B16.11 has requirements for threaded plugs.</p> <p>5.5.3 Technical CORRECTION: (20 N-m)</p> <p>5.7.5 Technical Suggested better words: Packing gland bolts shall be designed so that the bolt stress shall</p>	

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94997 Guy Jolly

Vogt Valve Company

Specification Section	Type	Comment	Suggested Change
		<p>not exceed one third (1/3) of the minimum tensile strength of the bolting material due to average packing compressive stress required to retain the maximum cold working pressure of the valve (CWP rating). Paragraph 4.6.4 of API 599-6th edition words. The 5510 psi packing compressive stress is an "big overkill" for Class 150, 300 and 600 valves, which have a maximum service pressure (CWP) of 290 psig for Class 150, 750 psig for Class 300 and 1500 psig for Class 600 valves under B16.34 P/T tables.</p>	
		<p>5.8.11 EditorialCORRECTION: (8 mm) and (102 mm) Centimeters not used in valve standards.</p>	
		<p>5.9.1 EditorialCORRECTION: (0.75 mm) If 0.030" is minimum than 0.75 mm should be conversion.</p>	
		<p>5.9.2 EditorialCORRECTION: (0.25 mm)</p>	
		<p>5.10.2 EditorialCORRECT: 1" (M24) 2 PLACES. Needs work if inch and/or metric bolts are to be used. SEE API 603-2007, paragraph 4.8 for inch/metric bolting standards and class fit for metric bolting. Metric bolt designation is M24 for 1" bolt equivalent.</p>	
		<p>6.1 Technical Add...cap, trunnion and bolting joining pressure boundary parts, shall be of materials specified in Table 1 of ASME B16.34.</p>	
		<p>Bolting joining body and bonnet is part of shell and bolting is listed in B16.34, Table 1 Group 4 Materials.</p>	
		<p>6.2 EditorialLeave reference to B16.5 for bolting because it identifies intermediate strength bolting and Table 1 of B16.34 does not.</p>	

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160737 Joel Katzman

Foster Wheeler USA Corporation

<u>Specification Section</u>	<u>Type</u>	<u>Comment</u>	<u>Suggested Change</u>
	Technical	Why limit the size range to 20"? Processes now require valving larger than 20".	Increase range of 608 valves to 24".

132463 Yoichi Kono

Kitz Corporation/Nagasaka Facility

<u>Specification Section</u>	<u>Type</u>	<u>Comment</u>	<u>Suggested Change</u>
All	Technical		All numbers shall have two units, American units and metric units.
1.1	Editorial	Valve sizes 1/2 h to 20 h	Valve sizes NPS 1/2 h to 20 h
1.3. and Table 2	Editorial	gSingle Reduce Bore h	gReduced bore h apply to ISO standers.
4.3.1. Table1	Technical	All numbers are American units.	Add centigrade and Bar or Mega Pascal.
Table2	Technical		Single Reduced Port and double reduced port bore sizes shall be 1size and 2 sizes down dimensions between Full port dimensions.
Table2	Technical		e.g. Single reduce port 3/4 h ; 0.47 shall be 0.44. Full port from 14 h to 20 h, Single reduced Port 16 h to 20 h, Double reduced Port 18 h and 20 h, shall meet ISO 17292.
5.4	Technical	~ stem and body of valves <2 h and between ball, stem and body of valves >2 h	Just specify g~electrical continuity between the ball and body".
5.8.11.	Technical	The lockable device shall be ~, not more than 4.0 h long ~.	Manufacturer may be inform the recommended shank length. Because some of small valves hard to utilizing long shank padlock, e.g. 2 h, 3 hand 4 h.
5.10.2	Editorial	2.54CM	25.4mm
Figure	Technical	Example1.	Figure1.

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86320 C. McClinton

Milwaukee Valve Company, Inc.

<u>Specification Section</u>	<u>Type</u>	<u>Comment</u>	<u>Suggested Change</u>
Forward, 3Terms and Definitions	Technical	Several sections not completed, "To be completed by API Staff"	The voting members should not be asked to approve a blank Standard. this should be a partial ballot with final approval after all section are complete.
5.4	Technical	5.4 Anti-static design, should remain optional as in previous edition, "When specified in the purchase order." This would be in agreement with ASME B16-34 5.3 Electrical Continuity.... " When service conditions require elecfrtical continuity to prevent static discharge, the user is responsible for specifying static grounding.	5.4 Anti-static design..... When specified in the purchase order, valves shall incorporate an antistatic feature.....

127632 William McLean

Newco Valves

<u>Specification Section</u>	<u>Type</u>	<u>Comment</u>	<u>Suggested Change</u>
all	Technical	Agree with the ballot comments registered by Ayman Cheta. The changes made from the last draft will significantly impact and will notably cause API 608 to lose global relevance when compared to ISO 17293. It is obvious from the many discussions about the table removed that spelled out minimum wall values that not all users of the API standard understand the intricacies of B16.34. Its removal also takes away a valuable tool from inspectors causing them to have to calculate minimum wall. WNM	Suggest to go back to using ISO 17292 with an Annex covering API preferred revisions.

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105213 Ron Merrick

Fluor

<u>Specification Section</u>	<u>Type</u>	<u>Comment</u>	<u>Suggested Change</u>
Introduction	Editorial	Add: API Standard 594 to the list of comparable standards.	
1.3	Editorial	Style inconsistency between 'Single Reduced Bore' and 'Double-reduced bore'.	Three separate, capitalized words would be grammatically correct.
2	Editorial	Add: ASME B36.19M for the use of bores to mate with stainless pipe thicknesses.	
5.7.4	Technical	Add words 'or gland follower' to the end of the first sentence.	
5.8.11	Editorial	Metric equivalent of 4.0", referring to length of padlock shank, should be 100 MM.	
5.9.1	Technical	Discrepancy between imperial and metric dimensioning. This constitutes a technical comment since the difference between imperial and metric values as stated is considerable.	Either ' 0.030" (0.75MM) ' or ' 0.040" (1.0MM) '.
5.10.2	Editorial	Bolting nominal size should be expressed as '(25MM)' in two places.	

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1/24/2008

148983 Bill Patrick

Dow Chemical Company

Specification Section	Type	Comment	Suggested Change
General comment throughout document	Editorial	Sizes are listed in inches. Current practice would be to list the sizes as NPS.	Remove inches and state as NPS.
Table 1	Editorial	SI units have not been provided for temperatures. Units for pressure is not listed. Metric units have not been provided for pressure.	Need temperature reported in dg C. Need psi units for pressure listed and add SI pressure units to table.
Table 2	Editorial	NPS listed with " also designated. No units provided for dimensions and need metric sizes listed as well.	List as NPS. Designate mm sizes with inches listed in ().
Section 5.5.3	Editorial	15 Ft-Lbs listed first with 20 N-M listed in () in conflict with API Document Formatting and Style Manual.	list as 20N-m (15 ft-lbs).
General comment throughout document	Technical	Where listed dimension are listed in in wrong order with the USC being listed first and the SI units being listed in (). Units are being specified capitalized when they should be given in lower case.	Correct formatting to match API Document Formatting and Style Manual.
General	Technical	API 607 is not specified in document. Do not feel specifying API 607 should be an exception to this standard.	Provide a reference to API 607 stating "When API 607 is specified by the purchaser The valve shall be supplied to meet manufacturer's API 607 tested design." Reference API 607 in Annex A.
5.5.2	Technical	Torsional strength between stem within pressure boundary and above packing difference has been reduced from 20% to 10%.	None.

93737 Henry Sonderegger

ANVIL International, Inc.

Specification Section	Type	Comment	Suggested Change
Entire document	Technical	The current draft of API 608 (4th ed, Dec 2007) is the result of numerous changes made to ISO 17292 (latest edition) but does not make any substantive changes - format and references have been changed or added. What these changes have created is a draft document that will not be acceptable as an ISO standard in format and with reference to other standards. This will preceive to nationalize the content of API 608 instead of globalize the technical material. This will undo all the work previously done by USTAG and API SCOPV to accommodate international interests.	The clear solution is to return to the starting document of ISO 27292 (latest edition). Correct any technical errors - I have found none - and submit these - if they exist - to ISO TC 153/SC 1 for new work item activity. We have just about come to the end of the iterations required to have a final ISO document in line with API SCOPV interests and it would be a shame and a waste of all the previous work done to abandon this document (ISO 17292) at this time.

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