INTERPRETATIONS TO ASME B16.34 (a)

(These interpretations are not part of ASME B16.34-1996 and are included for information only. These interpretations apply to the 1988 and earlier editions and the requirements cited may be different in this Edition. Therefore, some replies may not be valid in regards to this Edition.)

INTRODUCTION

As a service to persons who use the B16 standards, B16 Committee renders interpretations of the requirements upon request. The procedure for requesting an interpretation is described in the following paragraphs.

The interpretations include all replies which have been approved by the B16 Main Committee in response to inquiries concerning interpretation of this Standard.

An interpretation applies either to the Edition and Addenda in effect on the date of issuance of the interpretation or the Edition and Addenda stated in the interpretation. Subsequent revisions to this Standard may supersede the interpretation.

PROCEDURE FOR REQUESTING INTERPRETATIONS

Upon request, the B16 Committee will render an interpretation of any requirement of this Standard. Interpretations can only be rendered in response to a written request, which should be addressed to:

Secretary, B16 Main Committee
The American Society of Mechanical Engineers
Three Park Avenue
New York, NY 10016-5990

The request for interpretation should be clear and unambiguous. It is further recommended that the inquirer submit his request using the following format:

(a) Subject. Cite the applicable paragraph number(s) and/or give a concise description of the subject.

(b) Question. Phrase the question as a request for an interpretation of a specific requirement suitable for general understanding and use, not as a request for an approval of a proprietary design or situation. The inquirer may also include any plans or drawings which are necessary to explain the question; however, they should not contain proprietary names or information.

Requests which are not in this format may be rewritten in this format prior to being answered, which may inadvertently change the original intent of the request.

ASME procedures provide for reconsideration of an interpretation when or if additional information is available which the inquirer believes might affect the interpretation. Further, persons aggrieved by an interpretation may appeal to the cognizant ASME committee or subcommittee. ASME does not "approve," "certify," "rate" or "endorse" any item, construction, proprietary device, or activity.

Copyright ASME International
Provided by IHS under license with ASME
No reproduction or networking permitted without license from IHS
Not for Resale

INTERPRETATIONS NO. 2

Replies to Technical Inquiries Issued from January 1, 1997 Through July 1, 1998

Interpretation: 2-45

Subject: Para. 6.7

Date Issued: August 11, 1997

File: B16-97-002

Question (1): Are multiple radial holes that penetrate the required minimum wall thickness of a valve body, e.g., holes for the purpose of securing an identification plate, permitted under the requirements of para. 6.7(g) of ASME B16.34-1988?

Reply (1): No. This clause only identifies requirements related to a single radial hole.

Question (2): Is it permissible to apply the requirements of para. 6.7 of ASME B16.34-1988 to butterfly-type valves that have integral or welded flanges on one or both body ends?

Reply (2): No.

Interpretation: 2-46

Subject: Multiple Material Marking/Identification Plate

Date Issued: April 6, 1998

File: B16-98-005

Question (1): When a valve body material meets all the requirements of two separate material specification grades listed in Table 1 of ASME B16.34-1996, may the valve body be marked with both material grade symbols in accordance with para. 4.2.8?

Reply (1): Yes.

Question (2): Is the selection of which of the two maximum or limiting temperatures to be shown on the identification plate required by para. 4.3 of ASME B16.34-1996 for a valve body that is marked with two material grade symbols designating material grades that have differing cautionary or specified temperature limits listed in the respective Table 2 Notes the option of the manufacturer?

Reply (2): Yes.

Copyright ASME International
Provided by IHS under license with ASME
No reproduction or networking permitted without license from IHS Not for Resale

Interpretation: 2-47

Subject: Minimum Wall Thickness

Date Issued: April 6, 1998

File: B16-98-006

Question (1): Do the rules of para. 6.1.6 in ASME B16.34-1996 apply to local areas having less than the required minimum wall thickness resulting from manufacturing operations such as casting, forging, and machining, including grinding, milling, and drilling?

Reply (1): Yes.

Question (2): Under the rules of ASME B16.34-1988, is it permissible to use Table 3 to extrapolate minimum wall thickness for valves having pressure–temperature ratings less than Class 150?

Reply (2): No.

Question (3): Are flanged valves that conform to the flange thickness requirements for PN 10 steel valves within the scope of either ASME B16.34-1988 or -1996?

Reply (3): No.

Copyright ASME International
Provided by IHS under license with ASME
No reproduction or networking permitted without license from IHS Not for Resale

INTERPRETATIONS TO ASME B16.34

(These interpretations are not part of ASME B16.34-1996 and are included for information only. These interpretations apply to the 1988 and earlier editions and the requirements cited may be different in the current edition. Therefore, some replies may not be valid in regards to this Edition. The effective date of this Edition is as noted in the forward.)

INTRODUCTION

As a service to persons who use the B16 standards, B16 Committee renders interpretations of the requirements upon request. The procedure for requesting an interpretation is described in the following paragraphs.

The interpretations include all replies which have been approved in response to inquiries concerning interpretation of this Standard since the publication of ASME/ANSI B16.34-1988.

An interpretation applies either to the edition and Addenda in effect on the date of issuance of the interpretation or the edition and Addenda stated in the interpretation. Subsequent revisions to this Standard may supersede the interpretation.

PROCEDURE FOR REQUESTING INTERPRETATIONS

On request, the B16 Committee will render an interpretation of any requirement of this Standard. Interpretations can only be rendered in response to a written request, which should be addressed to:

Secretary, B16 Main Committee
The American Society of Mechanical Engineers
United Engineering Center
345 East 47th Street
New York, NY 10017

The request for interpretation should be clear and unambiguous. It is further recommended that the inquirer submit his request using the following format:

(a) Subject. Cite the applicable paragraph number(s) and/or give a concise description of the subject.

(b) Question. Phrase the question as a request for an interpretation of a specific requirement suitable for general understanding and use, not as a request for an approval of a proprietary design or situation. The inquirer may also include any plans or drawings which are necessary to explain the question; however, they should not contain proprietary names or information.

Requests which are not in this format may be rewritten in this format prior to being answered, which may inadvertently change the original intent of the request.

ASME procedures provide for reconsideration of an interpretation when or if additional information is available which the inquirer believes might affect the interpretation. Further, persons aggrieved by an interpretation may appeal to the cognizant ASME committee or subcommittee. ASME does not "approve," "certify," "rate," or "endorse" any item, construction, proprietary device, or activity.

Copyright ASME International
Provided by IHS under license with ASME
No reproduction or networking permitted without license from IHS
Not for Resale

INTERPRETATIONS NO. 2

Replies to Technical Inquiries Issued from January 1, 1990 Through December 31, 1995

Interpretation: 2-1

Subject: Table 1; Materials

Date Issued: May 17, 1990

File: B16-89-001

Question (1): Is there an error in Table 1 in that ASTM A 351-CG8M is not listed?

Reply (1): No.

Question (2): Does a valve with a valve body made of ASTM A 351-CG8M comply with the requirements of ASME/ANSI B16.34-1988?

Reply (2): No.

Question (3): Can new materials be added to Table 1?

Reply (3): Yes. This can be done at the next revision or when an Addenda is prepared. In order to facilitate the inclusion of new materials, it is recommended that the requester provide the Committee with the data needed to establish pressure–temperature ratings as provided in Annex F.

Interpretation: 2-2

Subject: Paragraph 8.4.2; Weld Repair

Date Issued: May 29, 1989

File: B16-89-002

Question: Does B16.34 set limits on the extent of weld repair that may be performed on castings for Standard Class, Special Class or Limited Class valves?

Reply: No

Copyright ASME International
Provided by IHS under license with ASME
No reproduction or networking permitted without license from IHS Not for Resale

Interpretation: 2-3

Subject: Paragraph 8.3.2.2; Surface Examination

Date Issued: May 30, 1990

File: B16-89-003

Question: Under ASME/ANSI B16.34-1988, para. 8.3.2.2, is it permissible, for Special Class valves, to perform any or all of the required surface examinations either prior to or after machining?

Reply: Yes, provided that the required examinations take place, as required by para. 8.2, after any required heat treatment.

Interpretation: 2-4

Subject: Paragraph 6.1.5, Tables 3 and G3, Annexes A and G

Date Issued: May 21, 1990

File: B16-89-004

Question (1): Minimum wall thickness requirements are defined in ANSI B16.34-1981, para. 6.1.5 for the zone $1.33t_m$ from the weld end and for the zone t_m from the body neck. The intervening transition zone is required to be gradual. Is it required that the transition taper be external?

Reply (1): No, a transition, if used, may be either external or internal or a combination of both.

Question (2): In ANSI B16.34-1981, the minimum wall thickness tabulated for Class 4500 and 15 in. diameter is 11.64 in. and 295.7 mm. Are these tabular numbers correct?

Reply (2): No. This is a misprint that has been corrected in ASME/ANSI B16.34-1988. The correct value is 11.87 in. Metric dimensions are no longer used in B16.34.

Question (3): In ANSI B16.34-1981, is it a requirement that valve seat diameters be equal to (or greater than) the inside diameters of Annex A?

Reply (3): No. There are, however, user specifications that require "full port" valves and reference Annex A as the definition for full port.

Interpretation: 2-5

Subject: Paragraph 8.3.2.1; Ultrasonic or Radiographic Examination

Date Issued: May 29, 1989

File: B16-89-005

Question: Is it intended that the distance of coverage for the Special Class Examination for forgings under para. 8.3.2.1 be the same as for castings?

Reply: No. It is a requirement of paras. 8.3.2.1(a) and (b) that the entire cylindrical and ring sections be examined.

Copyright ASME International
Provided by IHS under license with ASME
No reproduction or networking permitted without license from IHS Not for Resale

Interpretation: 2-6

Subject: Paragraph 2.3.3; Fluid Thermal Expansion

Date Issued: October 5, 1989

File: B16-89-009

Question: If a pressure relief valve is used as the means of overpressure protection under para. 2.3.3 of ASME/ANSI B16.34-1988, is it required that the relief valve be manufactured and tested in accordance with one of the Sections of the ASME Boiler and Pressure Vessel Code, by a manufacturer holding the applicable Code Certificates?

Reply: This would depend upon the requirements of the purchaser of the B16.34 valve. Paragraph 2.3.3 assigns responsibility for providing means to assure that the pressure in the valve will not exceed that allowed to the purchaser. If the purchaser chooses a pressure relief valve as the means then it is also the purchaser's responsibility to designate which codes or regulation, if any, apply to the installed valve and concomitantly to the pressure relief valve, see para. 1.2.2.

Interpretation: 2-7

Subject: Paragraph 2.1.3; Limited Class Valves

Date Issued: April 9, 1990

File: B16-89-011

Question (1): Does the expression "welding end" in ASME/ANSI B16.34-1988, para. 1.1 apply to both socket welding and butt welding end valves?

Reply (1): Yes.

Question (2): May butt welding end valves, size NPS 2-½ and smaller be constructed in accordance with Annex G of ASME/ANSI B16.34-1988?

Reply (2): Yes.

Interpretation: 2-8

Subject: Seal Welding

Date Issued: April 9, 1990

File: B16-90-001

Question: Does ASME/ANSI B16.34-1988 include fabrication requirements for seal welding of seat rings into valve bodies?

Reply: No.

Copyright ASME International
Provided by IHS under license with ASME
No reproduction or networking permitted without license from IHS Not for Resale

Interpretation: 2-9

Subject: Paragraph 6.1.3; Valve Body Necks

Date Issued: May 4, 1990

File: B16-90-07

Question: Does para. 6.1.3 of ASME/ANSI B16.34-1988 prohibit a gate valve design using a rectangular body neck?

Reply: No, however, para. 6.1.7 requires that the manufacturer determine if additional metal is needed for shapes other than circular.

Interpretation: 2-10

Subject: Paragraph 6.1.2; Inside Diameter

Date Issued: June 11, 1990

File: B16-90-015

Question: With reference to ANSI B16.34-1981, para. 6.1.2, for butt welding end valves, may the "basic inside diameter at the valve end" be taken as the inside diameter of the highest pipe Schedule Number applicable to the valve size and pressure class?

Reply: No. The basic inside diameter is a valve specific dimension that may or may not be relevant to a particular set of pipe dimensions.

Interpretation: 2-11

Subject: Paragraph 2.1.5 (c); Valves Fabricated by Welding

Date Issued: October 31, 1990

File: B16-90-020

Question: Does ASME/ANSI B16.34-1988 require nondestructive examination for Standard Class Valves, NPS 6 and smaller, that are fabricated by welding?

Reply: No.

Copyright ASME International
Provided by IHS under license with ASME
No reproduction or networking permitted without license from IHS Not for Resale

Interpretation: 2-12

Subject: Paragraph 8.4; Defect Removal and Repair

Date Issued: January 21, 1991

File: B16-90-030

Question (1): In ASME/ANSI B16.34-1988, is Clause 8.4, covering defect removal and repair, a requirement only for Special Class valves?

Reply (1): Yes.

Question (2): Where are the requirements for defect removal, repair, and post weld heat treatment for other than Special Class valves?

Reply (2): The requirements are those stipulated in the respective ASTM specifications as covered in Table 1.

Question (3): When a valve is used in conjunction with an ASME Code for Pressure Piping and is designated as a Special Class valve and is so marked on the valve identification plate, is it required that the post weld heat treatment provisions of para. 8.4.2(c) be met?

Reply (3): Yes. For limitations imposed by codes and regulations, see para. 1.2.2.

Interpretation: 2-13

Subject: Annex F; Special Class Rating Method

Date Issued: January 21, 1991

File: B16-90-034

Question: Does Annex F, Special Class Rating Method, ANSI B16.34-1981, include requirements for determining hydrostatic shell test pressure?

Reply: No. The purpose of Annex F, see F1.1, is to record the rules that were used to determine the tabulated pressure–temperature ratings. The only pressure–temperature ratings recognized for Special Class valves are those in Table 2. The required hydrostatic shell test pressure, for all valves, is as described in para. 7.1.

Copyright ASME International
Provided by IHS under license with ASME
No reproduction or networking permitted without license from IHS Not for Resale

Interpretation: 2-14

Subject: Requirements for Special Class Valves

Date Issued: January 21, 1991

File: B16-90-038

Question (1): For a Special Class valve in accordance with ASME/ANSI B16.34-1988, is it permissible to construct a composite area for radiographic coverage, based on Fig. 6 through 15, that meets the intent of para. 8.3.1.1 for a valve body shape not illustrated?

Reply (1): Yes.

Question (2): Do any of the Figs. 6 through 15 illustrate the seat–body shell radiographic coverage that would be required for a valve body in the form of two intersecting mutually perpendicular cylinders, where one of the cylinders corresponds to the valve nozzles and the other to an upper and lower bonnet cavity?

Reply (2): Yes, Fig. 13, Sections X-X and Y-Y.

Interpretation: 2-15

Subject: 6.1.1; Minimum Wall Requirements

Date Issued: March 19, 1991

File: B16-90-041

Question: Under ASME/ANSI B16.34-1988, for a valve body of sectional construction (see para. 6.4.2) where the body joint includes an internal gasket whose placement isolates an internal end section of the body wall from the contained fluid, is it necessary that the entire body meet the minimum wall requirements of para. 6.1.1?

Reply: Yes, taking due account that it is an obligation on the part of the manufacturer to identify the wetted surfaces that apply under para. 6.1.1 and to ensure that the applicable metal thickness requirements of para. 6.1.7 and the bolting requirements of para. 6.4.3 are accommodated.

Interpretation: 2-16

Subject: Minimum Wall Thickness

Date Issued: April 10, 1991

File: B16-91-003

Question: Under ASME/ANSI B16.34-1988, are the rules for minimum valve body wall thicknesses also requirements for valve parts other than the valve body?

Reply: No.

Copyright ASME International
Provided by IHS under license with ASME
No reproduction or networking permitted without license from IHS Not for Resale

STD.ASME B16.34 INT-ENGL ■ 0759670 0579690 731 ■

Interpretation: 2-17

Subject: Materials

Date Issued: April 19, 1991

File: B16-91-004

Question: Is a valve that uses ASTM A269-TP304 pipe instead of ASTM A312-TP304 in the fabrication of the valve bonnet in conformance with ASME/ANSI B16.34-1988?

Reply: No, see paras. 1.1 and 5.1.

Interpretation: 2-18

Subject: Special Class Valves

Date Issued: August 2, 1991

File: B16-91-008

Question: In the case of a valve to be qualified for a Special Class designation under ASME/ANSI B16.34-1988 that is not of a type specifically illustrated in Figs. 6 through 15, e.g., a weld end ball valve, may a composite, using for example elements of Figs. 12 and 13, be constructed in order to satisfy the radiographic film coverage requirements detailed in para. 8.3.1.1?

Reply: Yes.

Interpretation: 2-19

Subject: Single Flange (Lug Type) Valve Body

Date Issued: July 31, 1991

File: B16-91-009

Question: Does ASME/ANSI B16.34-1988 prohibit a single flange (lug type) valve body made from a plate material listed in Table 1 when the design is such that the body is loaded in tension from pressure and piping loads?

Reply: No. However, para. 1.2.2 cautions limitations that may be imposed by codes or regulations, para. 5.2 notes that criteria for the selection of materials are not within the scope of the Standard, and para. 6.1.7 places responsibility for adequate metal thickness upon the valve manufacturer.

Interpretation: 2-20

Subject: 6.2.2; Valve Flange Ends

Date Issued: February 27, 1992

File: B16-91-016

Question: Is it a requirement of ASME/ANSI B16.34-1988, that valves with integral flanged ends meet the flange thickness requirements of ASME/ANSI B16.34-1988 for flanged fittings?

Reply: Yes, see para. 6.2.2.

Copyright ASME International
Provided by IHS under license with ASME
No reproduction or networking permitted without license from IHS Not for Resale

Interpretation: 2-21

Subject: Materials

Date Issued: February 14, 1992

File: B16-92-003

Question: In accordance with ASME/ANSI B16.34-1988, is material ASTM A105 suitable for a valve body at a temperature of −25 °C?

Reply: Yes.

Interpretation: 2-22

Subject: Minimum Wall Thickness

Date Issued: April 2, 1992

File: B16-92-004

Question: In accordance with ASME/ANSI B16.34-1988, what basic inside diameter should be used when determining minimum required body wall thickness for a wafer style ball valve?

Reply: The diameter associated with the valve body inside circumference should be used. See para. 6.7(c) and Fig. 16.

Interpretation: 2-23

Subject: Flanged-End Dimensions

Date Issued: May 12, 1992

File: B16-92-004

Question: Under ASME B16.34-1988, what dimensions apply for flanges or flanged-end valves that are of a smaller size than those listed in the reference ASME B16.5?

Reply: Valves having end flanges smaller than those listed in ASME B16.5 are not covered by the scope of ASME B16.34-1988.

Subject: Paragraph 5.1; Bolting Material

Question: For valve bolts, does ASME/ANSI B16.34-1988 have requirements for bolt head configuration?

Reply: No, however, bolting material is required to be in accordance with one of the bolting specifications listed in Table 1 under Group 4. See para. 5.1.

Copyright ASME International
Provided by IHS under license with ASME
No reproduction or networking permitted without license from IHS Not for Resale

Interpretation: 2-24

Subject: Paragraph 2.1.5; Valves Fabricated by Welding

Date Issued: May 12, 1992

File: B16-92-009

Question (1): Under ASME/ANSI B16.34-1988, is there a valve size above which both flanged end valves and Standard Class welding end valves that are fabricated by welding are required to meet the nondestructive examination requirements of ASME Boiler and Pressure Vessel Code, Section VIII, Division 1, for welding?

Reply (1): Yes, see para. 2.1.5(c)(1).

Question (2): For the fabrication welds identified in the first question, are these nondestructive examination requirements applicable to all such welds regardless of size?

Reply (2): Yes.

Interpretation: 2-25

Subject: Paragraph 2.1.5; Valves Fabricated by Welding

Date Issued: May 12, 1992

File: B16-92-010

Question: Are the factors 0.80 and 1.00 cited in paras. 2.1.5(c)(1) and 2.1.5(c)(2) casting quality factors?

Reply: No. These factors represent weld joint efficiency for which the reference ASME Boiler and Pressure Vessel Code, Section VIII, Division 1, specifies, for the type of weld joint used, the degree of nondestructive examination required.

Interpretation: 2-26

Subject: Paragraph 5.1.2; Investment Castings

Date Issued: August 19, 1992

File: B16-92-013

Question (1): Does ASME/ANSI B16.34-1988 place limits on the size or pressure class for investment cast bodies, bonnets or cover plates?

Reply (1): No.

Question (2): To what extent do the limits on size and pressure class in para. 5.1.2 apply?

Reply (2): These limits restrict the use of the cited alternative material specification requirements when master heats are used for investment castings.

Copyright ASME International
Provided by IHS under license with ASME
No reproduction or networking permitted without license from IHS Not for Resale

Interpretation: 2-27

Subject: Paragraph 7.1; Shell Testing

Date Issued: August 25, 1992

File: B16-92-017

Question (1): Under ASME/ANSI B16.34-1988, when a flanged end valve body that had been shell tested has the end flanged gasket seating surface remachined to provide a different surface finish, is it required that the valve body again be shell tested?

Reply (1): Shell testing requirements apply to assembled valves. There are no provisions for separate pressure testing of valve component parts such as valve bodies.

Question (2): Under ASME/ANSI B16.34-1988, when a flanged end valve that has been shell tested has the body end flange gasket seating surface remachined to provide a different surface finish, is it required that the valve again be shell tested?

Reply (2): No. However, it should be noted that ASME/ANSI B16.34-1988 applies to new valve construction, para. 1.1. Therefore, the valve would not require retest if the remachining was done either by or under the aegis of the valve manufacturer.

Interpretation: 2-28

Subject: Welding End Valves

Date Issued: August 19, 1992

File: B16-92-018

Question: In ASME/ANSI B16.34-1988, when reference is made to welding end valves, e.g., para. 1.1 under Scope, does that include both socket welding end valves and butt welding end valves?

Reply: Yes.

Interpretation: 2-29

Subject: Scope

Date Issued: January 6, 1993

File: B16-92-029

Question (1): Does the scope of ASME/ANSI B16.34-1988 include coverage for valve end configurations other than those related to flanged, butt welding, socket welding or threaded?

Reply (1): No.

Question (2): Are valves with end configurations other than those within the scope of B16.34-1988 permitted under ASME pressure vessel and piping Codes?

Reply (2): Since Code requirements may vary regarding conformance stipulations it is necessary that the applicable code be consulted.

Copyright ASME International
Provided by IHS under license with ASME
No reproduction or networking permitted without license from IHS
Not for Resale

Interpretation: 2-30

Subject: Paragraph 6.4.2; Body Joints

Date Issued: October 19, 1993

File: B16-93-007

Question (1): With reference to ASME/ANSI B16.34-1988, para. 6.4.2, may a valve manufacturer use one of the bolting materials from Table 1 that has an allowable stress in excess of 20,000 psi for a valve body joint?

Reply (1): Yes.

Question (2): When a valve manufacturer selects a bolting material from ASME B16.34-1988, Table 1, for a valve body joint and that material has an allowable stress greater than 20,000 psi, is it permissible to use that higher allowable stress when calculating the bolting area requirement in accordance with Clause 6.4.2(a)?

Reply (2): No.

Interpretation: 2-31

Subject: Special Class Valves

Date Issued: August 11, 1993

File: B16-93-013

Question: Does ASME/ANSI B16.34-1988 include requirements for Special Class Valves having other than threaded or welding ends?

Reply: No.

Copyright ASME International
Provided by IHS under license with ASME
No reproduction or networking permitted without license from IHS Not for Resale

Interpretation: 2-32

Subject: Paragraph 4.1.3; Rating, Identification Plate

Date Issued: November 8, 1993

File: B16-93-014

Question (1): In ASME/ANSI B16.34-1988, para. 4.1.3, is the reference identification plate the identification plate provided by the manufacturer?

Reply (1): Yes.

Question (2): Does ASME/ANSI B16.34-1988 require the applicable "B16.34" designation to be marked other than on the manufacturers identification plate?

Reply (2): No.

Question (3): Is a valve in conformance with ASME/ANSI B16.34-1988 if it does not have the applicable "B16.34" designation on the manufacturers identification plate?

Reply (3): No.

Question (4): The footnote to Clause 4.1.3 in ASME/ANSI B16.34-1988 permits, upon written conformation from the manufacturer, marking socket weld or threaded end valves with "B16.34" or "B16.34 LTD." Does this also permit the marking of flanged end valves as "B16.34" or butt welding end valves as "B16.34 SPL" by other than the valve manufacturer?

Reply (4): No.

Interpretation: 2-33

Subject: Table 1

Date Issued: October 4, 1993

File: B16-93-015

Question: May valves be marked as being in compliance with ASME/ANSI B16.34-1988 when constructed of materials specified in ASME Boiler and Pressure Vessel Code Cases but which are not included in Table 1?

Reply: No. See paras. 1.1 and 5.1 which require that materials be selected from those listed in Table 1.

Copyright ASME International
Provided by IHS under license with ASME
No reproduction or networking permitted without license from IHS
Not for Resale

Interpretation: 2-34

Subject: Paragraph 8.3.1.1; Radiographic Examination

Date Issued: October 4, 1993

File: B16-93-019

Question: If a valve casting is subject to radiography in accordance with ASME B16.34-1988, para. 8.3.1.1, and found to have indications in excess of the Annex B2 acceptance criteria, may that casting be repaired by welding in accordance with para. 8.4 and again be radiographed to determine acceptability?

Reply: Yes.

Interpretation: 2-35

Subject: Table 1, Body-Bonnet and Cover Bolting

Date Issued: February 1, 1994

File: B16-93-024

Question (1): According to ASME/ANSI B16.34-1988, if a valve design incorporates an intervening element between the body and the bonnet or cover plate with said element forming part of the pressure shell while being retained by the body-bonnet or cover bolting, is said element required to be of a material listed in Table 1, Group 1, 2, or 3 and be retained by bolting of a material listed in Table 1, Group 4?

Reply (1): Yes.

Question (2): According to ASME/ANSI B16.34-1988, if a valve design incorporates an intervening element between the body and the bonnet or cover plate with said element forming part of the pressure shell while being retained by the body–bonnet or cover bolting, does the bolting have to meet all the requirements for body–bonnet or cover bolting?

Reply (2): Yes.

Interpretation: 2-36

Subject: Paragraph 7.1; Shell Test

Date Issued: April 5, 1994

File: B16-94-001

Question: According to ASME/ANSI B16.34-1988, are the requirements for valve shell pressure testing met when pressure retaining parts are separately tested in accordance with paragraph 7.1 and later the valve assembled from these parts is tested at a test pressure lower than the shell test pressure required by para. 7.1?

Reply: No.

Copyright ASME International
Provided by IHS under license with ASME
No reproduction or networking permitted without license from IHS Not for Resale

Interpretation: 2-37

Subject: Paragraph 8.3.1.1; Radiographic Examination

Date Issued: June 21, 1994

File: B16-94-004

Question: In ASME/ANSI B16.34-1988, Fig. 10 illustrates casting section radiographic examination film coverage requirements for a plate type flanged bonnet for a gate valve. For a hemispheric flanged bonnet, not illustrated in ASME/ANSI B16.34-1988, does the section dimension "A," when applied at the intersection of the stuffing box neck and the hemispherical junction satisfy the requirements of Clause 8.3.1.1(b)?

Reply: Yes.

Interpretation: 2-38

Subject: Standard Class Valve

Date Issued: August 2, 1994

File: B16-94-005

Question (1): According to ASME/ANSI B16.34-1988, is the sold requirement for conformance as a standard class valve the successful completion of a hydraulic test?

Reply (1): No. For conformance all of the requirements of ASME B16.34 must be met including those applicable requirements of reference specifications.

Question (2): When forgings or castings of an ASME/ANSI B16.34-1988 valve are weld repaired does the valve then merit a special class rating?

Reply (2): No. In order to assign a special class rating all of the requirements for special class must be met.

Copyright ASME International
Provided by IHS under license with ASME
No reproduction or networking permitted without license from IHS Not for Resale

Interpretation: 2-39

Subject: Paragraph F1.3; Wall Thickness

Date Issued: September 14, 1994

File: B16-94-007

Question (1): What is the purpose of American National Standard ASME/ANSI B16.34-1988?

Reply (1): See the Foreword and the Scope of this Standard.

Question (2): Is the equation shown in para. F1.3 of ASME/ANSI B16.34-1988 a valve body minimum wall thickness requirement?

Reply (2): No. See para. 6.1.

Question (3): Under ASME/ANSI B16.34-1988, is valve design the responsibility of the manufacturer so long as the minimum wall thickness requirement is met?

Reply (3): No, the manufacturer is responsible for meeting all the applicable requirements of the Standard.

Question (4): In ASME/ANSI B16.34-1988, Table 3 values relate to valve body required minimum wall thickness. Since the equation in para. F1.3 is not a wall thickness requirement of the Standard, why was it included?

Reply (4): It is included as background material since it provides, as explained in para. F1.3, a near approximation to the values tabulated in Table 3.

Question (5): May the design rules of the ASME Boiler and Pressure Vessel Code, e.g., Section VIII-Division 1, be used as a supplemental reference for establishing additional metal thickness noted in para. 6.7 of ASME/ANSI B16.34-1988?

Reply (5): In para. 6.7, the responsibility for the determination of appropriate design rules is placed upon the manufacturer.

Question (6): When will ASME/ANSI B16.34-1988 be revised to provide for the use of metric bolting?

Reply (6): Consideration is presently being given to adding metric bolting and other metric references to ASME B16.34. A schedule has not been prepared for the issuance of a metric standard. Until such a revision is completed and approved as an American National Standard, valves using metric bolting cannot be identified as being in conformance with B16.34.

Copyright ASME International
Provided by IHS under license with ASME
No reproduction or networking permitted without license from IHS
Not for Resale

Interpretation: 2-40

Subject: Inservice Material Deterioration

Date Issued: January 16, 1995

File: B16-94-010

Question: Does ASME B16.34-1988 include requirements for inspection for inservice material deterioration and mandatory valve replacement?

Reply: No. Requirements are limited to new valves by the scope.

Interpretation: 2-41

Subject: On-Line Valve Modifications

Date Issued: January 16, 1995

File: B16-94-009

Question: Are on-line valve modifications, for example drilling and tapping into a packing chamber to add an auxiliary fitting, covered by ASME B16.34-1988?

Reply: No. See para. 1.1 where the scope is defined as applying only to new valve construction.

Interpretation: 2-42

Subject: Paragraph 6.7; Wafer or Flangeless Valves

Date Issued: August 11, 1995

File: B16-95-003

Question (1): In B16.34-1988, are the requirements of para. 6.7 applicable to all valves whose body category is wafer or flangeless?

Reply (1): Yes.

Question (2): In B16.34-1988, para. 6.7(e) requires that the sum of an inner and outer ligament shall not be less than t_m, the required minimum wall thickness. In Fig. 16, under "Relationship," it is also noted that the sum of the dimensions "*f*" and "*g*" shall not be less than t_m. Is the dimension "*g*" correctly shown in the drawing?

Reply (2): No. There is a printing error. The dimension "*g*" should have been shown as an outer ligament dimension as described by the text.

Question (3): In B16.34-1988, Fig. 16, may the hole illustrated with dimension "*g*" be repeated around the valve body periphery for the purpose of defining attachment flange bolt holes?

Reply (3): No.

Question (4): In B16.34-1988, may para. 6.7 be used to determine minimum wall thickness requirements for a multipiece valve body having blind holes parallel to the central body run (e.g., holes in a wafer type center piece) for assembly bolting?

Reply (4): Yes.

Copyright ASME International
Provided by IHS under license with ASME
No reproduction or networking permitted without license from IHS Not for Resale

Interpretation: 2-43

Subject: Separation Requirements

Date Issued: August 11, 1995

File: B16-95-004

Question: In B16.34-1988, paras. C2.1(a), C2.2(a), and D2.2(a), does the separation requirement for linear indications apply only to linearly aligned indications?

Reply: No. The separation requirement applies equally to all alignments.

Interpretation: 2-44

Subject: Paragraph 6.1.2; Inside Diameter

Date Issued: December 13, 1995

File: B16-95-008

Question: For socket-welding-end valves, does ASME B16.34-1988, by reference to ASME B16.11 in para. 6.2.3 require that the inside diameter, *d*, defined in para. 6.1.2, be the "bore diameter of fitting" as in ASME B16.11?

Reply: No.

Copyright ASME International
Provided by IHS under license with ASME
No reproduction or networking permitted without license from IHS Not for Resale