Contents

1	Scope	••••••
	1.1 What is included?	1
	1.2 Standards for thermopastic tanks	1
	1.3 Standards for Glass Reinforced Plastic (GRP) tanks	3
	1.4 What is not included?	5
2	Materials	7
	2.1 Group 1, Thermoplastics	7
	2.2 Group 2, Glass Reinforced Plastic (GRP)	7
3	Design issues	
	3.1 Information to be provided to the manufacturer	9
	3.2 Tank procurement: selecting a manufacturer	10
	3.3 Requirements for discussion/information to be exchanged between the end user and manufacturer	10
	3.4 Information to be provided to the end user by the manufacturer	
	3.4.1 Information to be provided for thermoplastic tanks	
	3.4.2 Information to be provided for GRP tanks	
	3.5 Tanks with secondary containment	
	3.5.1 Bunded tanks	23
	3.5.2 Close bunded tanks	23
	3.5.3 Tanks with low-level nozzles	24
	3.5.4 Tanks with "over the top" discharge systems	24
	3.5.5 Integrally bunded tank	
	3.5.6 Thermal insulation	
	3.6 Vents	25
4	Nameplates, data book, and management of change	27
	4.1 Tank nameplates	27
	4.2 Tank data book	27
	4.3 Management of change	28
5	Installation, commissioning, and operation within the design window	29
	5.1 Pre-delivery/Factory acceptance testing (FAT)	29
	5.2 Transport and delivery	30

	5.3 Offloading and installation	31
	5.3.1 Vertical tanks	31
	5.3.2 Horizontal tanks	34
	5.4 Commissioning	36
	5.5 Operation	37
	5.6 Modification	37
	5.7 Reuse, re-siting	38
6	Degradation mechanisms and failure modes	39
	6.1 Degradation and failure modes of thermoplastics and thermoplastic-lined GRP	39
	6.1.1 General	39
	6.1.2 Chemical degradation	39
	6.1.3 Thermal degradation	41
	6.1.4 Weathering	41
	6.1.5 Mechanical degradation	42
	6.1.6 Failure modes	43
	6.2 Degradation and failure modes of glass fibre reinforced plastic (GRP) tanks	44
	6.2.1 General	44
	6.2.2 Chemical degradation	45
	6.2.3 Thermal degradation	48
	6.2.4 Weathering	48
	6.2.5 Mechanical degradation	49
	6.2.6 Failure modes	49
7	Inspection methods and NDT techniques	53
	7.1 The purpose of inspections	53
	7.2 Safety and preliminary considerations for inspections	
	7.3 Type and frequency of inspection	
	7.4 What to inspect	54
	7.4.1 Tank bases and supports	54
	7.4.2 Tank shell/body	54
	7.4.3 Tank bottom	55
	7.4.4 Tank roofs	55
	7.4.5 Paintwork	55
	7.4.6 In-tank measurement and sampling devices	55
	7.4.7 Connections and nozzles	55
	7.4.8 Stairway, ladder, handrail system, walkways or platforms	56
	7.4.9 Associated equipment/items	56
	7.5 Inspection techniques	56
	7.5.1 Visual inspection	56
	7.5.2 Remote visual inspection	57

	7.5.3 Techniques for shell thickness measurement	58	
	7.5.4 Techniques to assess structural flaws	58	
	7.6 Reportong on inspections	60	
8	Deciding end-of-life, repairs, modification and recommissioning	61	
	8.1 General considerations	61	
	8.2 Deciding end-of-life	61	
	8.3 Assessing whether to repair a tank	62	
	8.4 Modifying and repairing thermoplastic tanks	63	
	8.4.1 Types of damage	63	
	8.4.2 Planning for thermoplastic repairs		
	8.5 Modifying and repairing GRP and dual laminate tanks		
	8.5.1 Types of damage		
	8.5.2 Planning for GRP or dual laminate repairs		
	8.5.3 Steps in the repair process for GRP tanks		
	8.6 Recommissioning and returning tanks to service following repair	66	
9	Decommissioning, mothballing, reuse and disposal	67	
	9.1 Introduction	67	
	9.2 Decommissioning	67	
	9.3 Re-siting and reuse	68	
	9.4 Disposal	68	
Αį	ppendix 1: Example nameplates	69	
Αį	ppendix 2: Example management of change form and checklist	71	
Αį	ppendix 3: Recommended bolt tightening torques for flanges	79	
Αį	ppendix 4: Example commissioning check list	81	
Αį	ppendix 5: Risk-based inspection frequencies for tanks containing potentially aggressive contents	85	
Αį	ppendix 6: Example Inspection Record Form	89	
Αį	ppendix 7: Detectable defects, applicable inspection techniques, and possible action	ıs103	
Bi	Bibliography107		

List of Figures

Figure 1:	Installed polypropylene and high-density polyethylene tanks	2
Figure 2:	Installed GRP tanks	∠
Figure 3:	GRP tank showing outlets	11
Figure 4:	A tank being filled by discharge from a road tanker	13
Figure 5:	Bunded tanks	14
Figure 6:	Tank manway	15
Figure 7:	Tank showing access ladders, platforms and circular hand railing	16
Figure 8:	Illustration of spiral wound thermoplastic tank	18
Figure 9:	Illustration of sheet constructed thermoplastic tank	18
Figure 10:	GRP and lined-GRP flange sections	20
Figure 11:	GRP pipe section	21
Figure 12:	Lined GRP pipe section	21
Figure 13:	A thermoplastic tank insulated to 150mm above base level	24
Figure 14:	Example of damage to tank as a result of incorrect transport	30
Figure 15:	Tanks being offloaded	31
Figure 16:	Typical vertical tank transport arrangement	33
Figure 17:	Vertical tank offloading and installation	33
Figure 18:	Vertical tank installation arrangement	34
Figure 19:	Typical horizontal tank transport arrangement	35
Figure 20:	Horizontal tank offloading and installation	
Figure 21:	Tank weathering	42
Figure 22:	Mechanical damage to a thermoplastic tank caused by misaligned agitator	42
Figure 23:	Cracking of internal welds on a thermoplastic tank	43
Figure 24:	Cracking on a thermoplastic tank due to chemical degradation	44
Figure 25:	Failure of an incorrectly specified GRP flange fitting due to attack by	
	sodium hypochlorite	46
Figure 26:	Blistering on a GRP tank	47
Figure 27:	Weathering on a GRP tank	48
Figure 28:	Corrosion on a GRP tank caused by chemical attack	49
Figure 29:	Cracks on a GRP tank flange	50
Figure 30:	A pin-hole leak detected visually in the base of a tank using residual water in the tank base	57
Figure 31:	Flowchart to aid tank repair assessment	62

List of Tables

Table 1:	EN13121 Group 2(a) resin types and characteristics	.7
Table 2:	EN13121 Group 2(b) thermoplastic lining (TPL) polymer types and characteristics	8.
Table 3:	Design information to be provided to manufacturer	9