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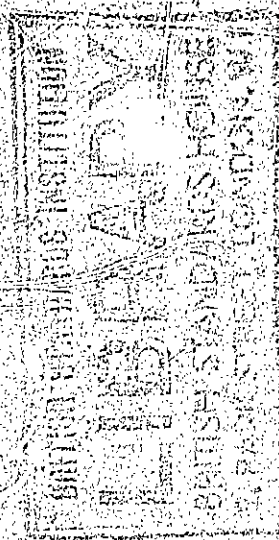
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BRITISH STANDARD 1633:1958

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STEEL FOR
LAND BOILERS
RECEIVERS

AND OTHER PRESSURE VESSELS



BRITISH STANDARDS INSTITUTION

BRITISH STANDARD SPECIFICATION

STEEL FOR
LAND BOILERS, RECEIVERS
AND OTHER PRESSURE VESSELS

B.S. 1633:1958

Price 6/- net

BRITISH STANDARDS INSTITUTION

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THIS BRITISH STANDARD, having been approved by the Iron and Steel Industry Standards Committee and endorsed by the Chairman of the Engineering Divisional Council, was published under the authority of the General Council on 9th September, 1958.

First published, March, 1950.
First revision, September, 1958.

The Institution desires to call attention to the fact that this British Standard does not purport to include all the necessary provisions of a contract.

In order to keep abreast of progress in the industries concerned, British Standards are subject to periodical review. Suggestions for improvements will be recorded and in due course brought to the notice of the committees charged with the revision of the standards to which they refer.

A complete list of British Standards, numbering over 3000, indexed and cross-indexed for reference, together with an abstract of each standard, will be found in the Institution's Yearbook, price 15s.

This standard makes reference to the following British Standards:

- B.S. 18 Tensile testing of metals.
- B.S. 350 Conversion factors and tables.
- B.S. 425 Forms and dimensions of boiler rivets.
- B.S. 1113 Water tube boilers and their integral superheaters.
- B.S. 1121 Methods for the analysis of iron and steel.

British Standards are revised, when necessary, by the issue either of amendment slips or of revised editions. It is important that users of British Standards should ascertain that they are in possession of the latest amendments or editions.

The following B.S.I. references relate to the work on this standard:
Committee reference ISE/51 Draft for comment CX(ISE)7545

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CO-OPERATING ORGANIZATIONS

The Iron and Steel Industry Standards Committee, under whose supervision this British Standard was prepared, consists of representatives from the following Government departments and scientific and industrial organizations:

Admiralty
Alloy Steels Association
British Bolt, Nut, Screw and Rivet Federation
British Cast Iron Research Association
British Constructional Steelwork Association
British Electrical and Allied Manufacturers' Association
British Engineers' Association
*British Iron and Steel Federation
*British Ironfounders Association
*British Railways, The British Transport Commission
British Steel Castings Research Association
British Steel Founders' Association
Council of Ironfoundry Associations
Council of Iron Producers
Crown Agents for Oversea Governments and Administrations
Engineering Equipment Users Association
Federation of Civil Engineering Contractors
Institute of British Foundrymen
Institute of Iron and Steel Wire Manufacturers
Institute of Marine Engineers
Institution of Civil Engineers
Institution of Mechanical Engineers (Automobile Division)
Institution of Structural Engineers
Iron and Steel Board
Iron and Steel Institute
Joint Iron Council
Lloyd's Register of Shipping
Ministry of Labour and National Service (Factory Inspectorate)
Ministry of Supply
National Association of Drop Forgers and Stampers
National Ironfounding Employers' Federation
National Physical Laboratory (D.S.I.R.)
Oil Companies Materials Committee
Royal Institute of British Architects
Shipbuilding Employers' Federation
Society of British Aircraft Constructors
Society of Motor Manufacturers and Traders Ltd.

The Government departments and scientific and industrial organizations marked with an asterisk in the above list, together with the following, were directly represented on the committee entrusted with the preparation of this British Standard:

Associated Offices Technical Committee
Association of Shell Boilermakers
Association of Vertical Boiler Manufacturers
Institute of Welding
Water-Tube Boilermakers' Association

BRITISH STANDARD SPECIFICATION FOR STEEL FOR LAND BOILERS, RECEIVERS AND OTHER PRESSURE VESSELS

FOREWORD

This revision of B.S. 1633 has been authorized by the Iron and Steel Industry Standards Committee, and is intended to unify the requirements for plates, sections, bars, rivet bars and rivets used in the construction of land boilers, receivers and other pressure vessels.

In preparing this revision, the Committee responsible for the drafting have departed radically from the previous arrangement, and, in accordance with modern practice, have divided the standard into two sections: Section One deals with the requirements common to all the materials specified, whereas Section Two covers the requirements peculiar to the individual materials.

NOTE. Where metric equivalents have been given, the figures in British Units are to be regarded as standard. The metric conversions are approximate. More accurate conversions should be based on the tables in B.S. 350, 'Conversion factors and tables'.

SPECIFICATION

SECTION ONE : GENERAL REQUIREMENTS

SCOPE

1. This British Standard covers plates, sections, bars, rivet bars and rivets for land boilers, receivers and other pressure vessels of riveted or welded construction.

PROCESS OF MANUFACTURE

2. The steel shall be made by the open hearth, acid or basic, or electric process, as may be agreed between the purchaser and manufacturer. *rimming steel is not permitted*

FREEDOM FROM DEFECTS

3. The finished material shall be sound, free from harmful segregation or impurities and from cracks, surface flaws and laminations. The material shall have a workmanlike finish and shall not have been hammer dressed, patched or repaired by welding. Minor corrections may, however, be made and slight scale or shell removed by such means as chisel, file, buff or shot blast.