

GP 05-03-01	Pressure Testing of Unfired Pressure Vessels	March 2005
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Pressure Testing of Unfired Pressure Vessels

GP 05-03-01

Scope

- 1) [I] This Global Practice (GP) covers the pressure testing of pressure vessels, including TEMA type, double pipe, and air-cooled heat exchangers.
 - 2) [I] An asterisk (*) indicates that a decision by the purchaser is required or that additional information is furnished by the purchaser.
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1. Required References

[I] This Section lists the Practice and Standards that shall be used with this Practice. Unless otherwise specified herein, use the latest edition.

1.1. Global Practices-ExxonMobil Engineering Practices

GP 18-10-01	Additional Requirements for Materials
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1.2. ASME-American Society of Mechanical Engineers

ASME SEC VIII D1	BPVC Section VIII - Rules for Construction of Pressure Vessels - Division 1
ASME SEC VIII D2	BPVC Section VIII - Rules for Construction of Pressure Vessels - Division 2 Alternative Rules

2. Definitions

Term	[I] Definition
MAWP	Maximum Allowable Working Pressure (MAWP) is the maximum allowable pressure at the design temperature in the corroded condition. MAWP is determined by calculation using the actual thickness less the corrosion allowance in accordance with ASME SEC VIII D1, Paragraph UG-98.

3. Test Procedures

- 1) * [S] Pneumatic testing with vessels partly or completely filled with air is not permitted unless approved by Owner. When such testing is approved, the test pressure shall meet the minimum requirements specified by ASME (ASME SEC VIII D1 and ASME SEC VIII D2), and the testing procedure shall be submitted to the Owner's Engineer. The test temperature shall be per [GP 18-10-01](#).
- 2) [R] Vessels with internal non-metallic linings or protective coatings shall be pressure tested before the application of such linings or coatings.
- 3) [R] Vessels shall be pressure tested before external painting of pressure containing welds.
- 4) [R] All vessels with austenitic stainless steel or high alloy materials exposed to test water shall be drained immediately after hydrostatic testing, and dried by blowing with air.

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