

THE FOLLOWING PARAGRAPH NUMBERS REFER TO API-675, SECOND EDITION, OCTOBER 1994,
WHICH IS PART OF THIS PRACTICE

SECTION 1 - GENERAL

- I 1.1 SCOPE
- All requirements specified in this practice are additions to those of **API-675** unless specifically noted as exceptions. Paragraph numbers in this practice which do not appear in **API-675** are new paragraphs.
 - An **asterisk (*)** indicates that a decision by the Purchaser is required or that additional information is furnished by the Purchaser.
- I 1.5 REFERENCED PUBLICATIONS
- Table 1** lists the practices and standard which shall be used with this practice.
 - Table 2** lists the practices which shall be used with this practice **as specified** by the Purchaser.
- I 1.5.4 *

TABLE 1

PRACTICES	
IP 16-9-1	Low Voltage A-C Motors up to 200 HP (150 kW)
IP 18-10-1	Additional Requirements for Materials
IP 18-12-1	Positive Material Identification
IP 20-1-1	Inspection of Equipment and Materials
STANDARD	
API Standard	
API 675	Positive Displacement Pumps - Controlled Volume

TABLE 2

PRACTICES	
IP 2-1-1	Plant Noise Design Criteria
IP 18-4-1	Postweld Heat Treatment of Equipment Handling Alkaline Solutions

SECTION 2 - BASIC DESIGN

- E,I 2.1.4 **Noise.** For pumps rated for over 15 hp (11 kW) vendors shall furnish noise emission data with their proposal per **IP 2-1-1**.
- I,R 2.1.12 **Pumps and auxiliaries** shall be suitable for **outdoor installation** in the climatic zone specified.
- I,O 2.1.14 **Pumps shall be capable of capacity-adjustment** from 0 to 100% of pump rated capacity, while the pump is running.
- 2.2 PRESSURE-CONTAINING PARTS
- R 2.2.2 **Joints of "liquid-end pressure casings"** shall have **confined gaskets** such as tongue-and-groove or male-and-female type facings if the specified design pressure exceeds 300 psig (2000 kPa).
- 2.3 CONNECTIONS
- R 2.3.1 **Suction and discharge flanges** shall have equal ratings.
- 2.7 RELIEF VALVE APPLICATION
- O 2.7.1 (Exception) **Relief valves** shall be sized for maximum pump capacity and set to 110% of maximum discharge pressure or maximum discharge pressure plus 25 psi (1.7 bar) whichever is greater.

IP 10-2-3		Positive Displacement Pumps - Controlled Volume (This practice is appropriate for attachment to Inquiry or Purchase Document)	
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2.13 MATERIALS

2.13.1 GENERAL

- I * 2.13.1.1 a. **Materials for “liquid-end pressure casings” and major internal parts in contact with the liquid** will be specified.
- b. **Vendor's proposals to use non metallic materials and coatings** shall be submitted to the Purchaser for approval by the Owner's Engineer.

2.13.4 WELDING

- R 2.13.4.5.5 a. **PWHT** is required for all carbon and ferritic alloy steel pressure-containing components that are welded and/or weld repaired, when the weldment is exposed to a process environment containing wet H₂S. The PWHT procedure outlined in the **ASME Code Section VIII**, par. UW-40, UW-49, UHA-32 and UCS-56 shall be followed, except that notes in Tables UHA-32 and USC-56 do not apply. All welds, regardless of type or size, that are exposed to wet H₂S shall be PWHT at a minimum temperature of 1150°F (620°C). External attachments or seal welded threaded connections on P-1 Group 1 and 2 materials do not require PWHT.
- * b. **Pumps specified as handling alkaline solutions** shall have PWHT per [IP 18-4-1](#).

2.13.5 IMPACT TEST REQUIREMENTS

- I * 2.13.5.1 **Impact test requirements** shall be per [IP 18-10-1](#) for the specified **Critical Exposure Temperature (CET)**.

SECTION 3 - ACCESSORIES

3.3 BASEPLATES

- I 3.3.1 For packed plunger pumps, the **baseplate** shall have a **raised lip** to contain stuffing box leakage. A 1 in. NPS (25 mm) minimum tapped connection shall be provided in the raised lip at the pump end for **complete drainage**. The pan or upper surface of the base plate shall be sloped 1:100 minimum toward the drain end.

SECTION 4 - INSPECTION, TESTING, AND PREPARATION FOR SHIPMENT

4.4 PREPARATION FOR SHIPMENT

- M 4.4.3.1 (Exception) **Painting of unmachined exterior surfaces for corrosive or marine atmospheres** will be specified.

Revision Memo

1/82	Original Issue of Basic Practice
6/94	Revision 0 - Original Issue of International Practice
6/96	Revision 1
3/98	Revision 2
6/00	Revision 3
	Table 1: IP 18-10-1 moved from Table 2

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