

## **4.8 Welding Electrodes**

**4.8.1** For the welding of materials with a minimum tensile strength less than 550 MPa (80 ksi), the manual arc-welding electrodes shall conform to the E60 and E70 classification series (suitable for the electric current characteristics, the position of welding, and other conditions of intended use) in AWS A5.1 and shall conform to 7.2.1.10 as applicable.

**4.8.2** For the welding of materials with a minimum tensile strength of 550 MPa to 585 MPa (80 ksi to 85 ksi), the manual arc-welding electrodes shall conform to the E80XX-CX classification series in AWS A5.5.

## **4.9 Gaskets**

### **4.9.1 General**

- **4.9.1.1** Gasket materials shall be specified in Table 3 of the Data Sheet. Unless otherwise specified by the Purchaser, gasket materials shall not contain asbestos.

**4.9.1.2** Sheet gaskets shall be continuous. Metal gaskets made continuous by welding are acceptable if the weld is ground flush and finished the same as the non-welded portion of the gasket. Rope or tape gaskets shall have overlapped ends.

**4.9.1.3** Each gasket shall be made with an integral centering or positioning device.

- **4.9.1.4** No joint sealing compound, gasket adhesive, adhesive positioning tape, or lubricant shall be used on the sealing surfaces of gaskets, or flanges during joint make-up unless specifically allowed by the Purchaser. When these materials are approved by the Purchaser, consideration should be given to chemical compatibility with the gasket and flange materials.
- **4.9.1.5** Spare gaskets are not required unless specified in the Data Sheet, Line 23.

### **4.9.2 Service**

- When service gaskets are designated to be furnished by the Manufacturer, the gaskets provided shall be as specified in the Data Sheet, Table 3.

### **4.9.3 Test**

- **4.9.3.1** Test gaskets must have comparable dimensions and compressibility characteristics as service gaskets. Descriptions of gaskets for temporary use only as test gaskets shall be submitted for Purchaser's approval.

**4.9.3.2** For joints that will not be disassembled after testing, the test gasket must be the specified service gasket.

**4.9.3.3** Except for stainless steel bolting, flange bolts and nuts used for testing are acceptable for use in the completed tank.