



Ohio Administrative Code Rule 901:5-3-07 Piping, tubing and fittings.

Effective: November 18, 1978

- (A) All piping, tubing and fittings shall be made of material suitable for anhydrous ammonia service;
- (B) All piping, tubing and fittings shall be designed for a pressure not less than the maximum pressure to which they may be subjected in service;
- (C) All piping shall be well supported and provision shall be made for expansion and contraction;
- (D) Piping used in systems shall be at least ASTM "A-53 Grade B" seamless electric resistance welded. Such pipe shall be at least "Schedule 40" when joints are welded, or welded and flanged. Such pipe shall be at least "Schedule 80" when joints are threaded. Brass, copper, or galvanized steel pipe or tubing shall not be used;
- (E) All metal flexible connections for permanent installations shall have a minimum working pressure of two hundred fifty psig (safety factor of four). For temporary installations, hose meeting the requirements of rule 901:5-3-08 of the Administrative Code shall be used;
- (F) Cast iron fittings shall not be used but this shall not prohibit the use of fittings made specifically for ammonia service of ductile iron such as "Specification ASTM A47" or "ASTM A395";
- (G) Provisions shall be made for expansion, contraction, jarring, vibration, and for settling;
- (H) Adequate provisions shall be made to protect all exposed piping from physical damage that might result from moving machinery, the presence of automobiles or trucks, chemical corrosion or any other undue strain that may be placed upon the piping;
- (I) Joint compounds shall be resistant to ammonia. Teflon ammonia resistant tape can be used;
- (J) After assembly, all piping and tubing shall be tested and proved to be free from leaks at a



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pressure not less than the normal operating pressure of the system.