**Section 215.25 Basic Rules**

This Section applies to all Sections of this Part unless otherwise noted.

a) These provisions shall not be construed as prohibiting the continued use or reinstallation of containers constructed and maintained in accordance with the 1949, 1950, 1952, 1956, 1959, 1965, 1968, 1971, 1974, 1977, 1980, 1983, 1986, 1989, 1992, 1995 and 1998 editions of the ASME Code or any revisions thereof in effect at the time of fabrication. Reinstalled stationary pressure vessels with a design capacity greater than 3000 gallons shall comply with CGA G-2.1, Section 5.1. If a storage tank is currently being used and does not have a U-1A form or a build sheet or a legible data plate, it must be taken out of service by January 1, 2030.

1) Containers in use or operation on or after July 1, 2016, and any storage vessel that is not in service within the State of Illinois, or any storage vessel greater than 3000 gallons to be reinstalled, shall comply with one or more of the following:

A) The storage vessel has been stress relieved during fabrication in accordance with the Code in effect at the time of fabrication; or

B) The storage vessel has cold-formed heads that have been heat stress relieved; or

C) The storage vessel has been fabricated with hot-formed heads.

2) Welded attachments to pads may be made after post-weld heat treatment. However, implements of husbandry do not require post-weld heat treatment if they are fabricated with hot-formed heads or with cold-formed heads that have been stress relieved.

b) Requirements for new construction and original test, repair, and alterations of containers (including USDOT portable tanks), other than refrigerated storage tanks must comply with the following:

1) Containers used with systems covered in Sections 215.85, 215.110, and 215.115 shall be made of steel or other material compatible with ammonia and tested in accordance with the currently incorporated ASME Code (see Section 215.16). An exception to the ASME Code requirements is that construction under Table UW 12 at a basic joint efficiency of under 80% is not authorized.

2) Containers designed and constructed in accordance with the ASME Code, other than refrigerated storage containers, shall comply with the following additional requirements:

A) The entire container shall be postweld heat treated after completion of all welds to the shells and heads. The method employed shall be as prescribed in the ASME Code, except that the provisions for extended time at a lower temperature for postweld heat treatment shall not be permitted. Welded attachments to pads may be made after postweld heat treatment. Exception: implements of husbandry will not require postweld heat treatment if they are fabricated with hot-formed heads or with cold-formed heads that have been stress relieved.

B) Steels used in fabricating pressure containing parts of a container shall not exceed a specified tensile strength of 70,000 psi. Exception: implements of husbandry may be fabricated from steel having a specified tensile strength of 75,000 psi.

C) Containers shall be inspected by a person who holds a valid National Board Commission. Exception: refrigerated storage tanks with a design pressure of 15 psig or less and containers covered in Section 215.90.

D) Repair or alteration of pressure-containing parts of a container shall be performed in compliance with the applicable provisions of the current edition of the National Board Inspection Code. Where specific procedures are not given, it is intended that, subject to acceptance of the inspector, all repair or alteration shall conform as much as possible to the ASME Code section and edition to which the container was constructed.

c) Except for pneumatic testing, all containers shall only be pressured with ammonia vapor except for dual usage involving the storage of liquid propane. Any device used for the introduction of atmospheric air into any part of anhydrous ammonia storage, transportation or application systems is prohibited. Any introduction of any substance other than anhydrous ammonia into the closed loop anhydrous ammonia system shall be approved by the Department prior to implementation, except when required to comply with the ASME Code or USDOT regulations.

d) Any firm that completes any repair or alteration to a pressure vessel or any piping and associated appurtenances shall be performed by a firm that holds a valid certificate of authorization, commonly referred to as an R stamp holder.

e) A written record of all inspections and maintenance shall be kept at the facility for a period of 5 years or until sold or removed from service.

f) Railroad car tanks permanently mounted and used for storage of anhydrous ammonia shall be removed from a service no later than December 1, 2025.

g) Compliance with the requirements of this Subpart shall be achieved through repairs and modifications on or before December 31, 2020.

h) Any storage vessel that does not have a legible data plate or supporting documentation of the information on the data plate shall be removed from service if it is decommissioned from the current site.

(Source: Amended at 40 Ill. Reg. 8704, effective July 1, 2016)