

**UNITED INDUSTRIES GROUP, INC.**

**SPECIFICATION SECTION 13210**

**GLASS-FUSED-TO STEEL BOLTED STORAGE TANKS & BIOGAS DIGESTERS**

**PART 1 – GENERAL**

* 1. **DESCRIPTION**

1. CONTRACTOR shall furnish all labor, materials, equipment, and incidentals required to design, fabricate, deliver, erect and test tank constructed of factory prefabricated glass‐coated, bolt‐together steel panels. Each tank structure shall include a foundation and other accessory components as shown on the Contract Drawings and described herein.
2. All required tank materials and principal appurtenances shall be supplied by the tank

manufacturer.

1. Installation shall be executed by a qualified and experienced erection crew,

trained and certified by the tank manufacturer.

1. Tank structures and appurtenances shall be new and not previously used.
   1. **QUALITY ASSURANCE**
2. The Supplier shall offer a factory applied Glass-Fused-to-Steel coated bolt together shop pre‐fabricated sectional steel tank.
3. The Supplier will offer a new tank structure as a manufacturer specializing in the design, fabrication and erection of factory applied glass coated, bolted tank systems. Structural design per the latest AWWA D103 Standard for Bolted Steel Water Storage Tanks (AWWA D103-09 & AWWA D103-19).
4. **Design and Fabrication Criteria:**
5. Except as otherwise shown or specified, all materials, joints, workmanship and all other aspects of the tank and fabrication shall conform to ANSI/AWWA D103-19 hereinafter AWWA D103.
6. Tanks with roofs shall be designed for roof live loads and roof dead loads.
7. Roof Live Load shall be min. **20psf** as per ASCE 7-16 Section 4.8.2
8. Structure Risk Category: xx
9. **Snow Loads:**

The ground snow load shall be xx pounds per square foot.

Design to include Balanced and Unbalanced loads for curved roofs as per ASCE 7-16 Section 7.6.4 and Figure 7-3, not less than AWWA D108-19std Sec. 5.3 and as required by local building codes and/or amendments.

**a**. Snow Load Importance Factor: xx (ls) as per ASCE 7-16 Table 1.5-2 for the required Risk Category

**b**. Thermal Factor: x.x (Ct)

**c**. Snow Exposure Factor: x (Ce)

**d.** Slope Factor: x (Cs) ASCE 7-16 Figure 7-2 or greater.

1. **Wind:**

Tank shall be designed for a basic wind speed of xx miles per hour.

a. Importance Factor: xx (Iw)

b. Occupancy Category xx as per ASCE 7-16 Table 1.5-2. Figure 26.5-1 B.

c. Exposure Factor = x

1. **Seismic:**

Tank shall be designed for the following seismic conditions:

**a**. Map Spectral Response:

i. Ss = x.xx

ii. S1 = x.xx

**b.** Seismic Use Group: xxx

**c.** Seismic Design Cat: x

1. **Tank Foundation**

Shall be designed based on the design recommendations as per project’s Geo-technical report.

1. Maximum allowable soils design bearing capacity: xxxx psf.
2. Site Class: x
3. Frost Depth: xx
4. Specific Gravity of stored media: x.x
5. Pressure:

**Water Tanks:**

Internal Design pressure Cg: 0.18

Operating pressure - Atmospheric (ATM)

**Biogas Digesters:**

Internal Design Pressure: up to 12” W.C. (30mbar or 0.43PSI)

Operating Pressure: up to 8” W.C. (20mbar or 0.29PSI)

**1.3 SUBMITTALS**

**A. Action Submittals:**

Construction shall be governed by the Owner's drawings and specifications showing general dimensions and construction details, after written approval by the Engineer of detailed erection drawings prepared by the tank bidder. There shall be no deviation from the Owner’s drawings and specifications, except upon written order from the Engineer.

**Submit for approval the following:**

1. Copies of detailed tank Design Drawings & Structural Calculations.

Submittals shall be sealed/stamped by a Professional Engineer licensed in the State of XX

Drawings shall include all dimensions, sizes, plate thicknesses, anchorage, nozzle details, and details of all required accessories.

1. Fabrication shall not be started until submitted drawings are approved.

When approved, an electronic copy of the submittal information will be returned to the tank manufacturer marked "APPROVED FOR CONSTRUCTION" and these drawings will then govern the work detailed thereon. The approval by the Engineer of the tank supplier's drawings shall be an approval relating only to their general conformity with the bidding drawings and specifications and shall not guarantee detail dimensions and quantities, which remains the tank suppliers’ responsibility

**B. Warranty:**

If within a period of Five (5) years from date of completion the tank structure or any part thereof shall prove to be defective in material or workmanship upon examination by the manufacturer, the manufacturer will supply a replacement part, will repair, or allow a credit for same.

The tank manufacturer shall provide a standard Maintenance Manual upon

approval of the drawings and completion of the tank installation.

**PART 2 – PRODUCTS**

**2.1 GENERAL**

1. Tanks shall be manufactured by the following manufacturer:

1. United Industries Group, Inc.

2. Pre‐approved equal

**2.2 TANK**

1. **Tank Size:**

1. Nominal Diameter: \_\_\_\_\_feet.
2. Max. Nominal Tank Sidewall Height: \_\_\_\_\_feet.
3. Design Freeboard: \_\_\_\_\_\_\_\_inches.
4. Min. Nominal Tank Capacity: \_\_\_\_\_\_\_\_\_\_\_\_gallons.

5. Number of Tanks: \_\_\_\_.

1. **Plates and Sheets:**
2. Plates and sheets used in the construction of the tank shell, tank floor

and tank roof shall meet or exceed structural requirements of AWWA D103-09std & AWWA D103-19std latest edition.

1. Design requirements for High Strength Hot Rolled Carbon Steel shall be ASTM A1011 Grade 50, 55, 60, 65, 70; ASTM A572 Grade 42, 50, 60, 65; or special Enamelable Titanium Rich Hot Rolled Carbon Steel ART 310 or SRT480 that is specifically manufactured for Enameling application from a Continuously Cast Steel Slabs.

Titanium Rich Steel Mechanical properties:

ART 310: Titanium (Ti) Rich Hot Rolled Carbon Steel with Min. Ultimate Tensile Strength of 52KSI before firing and Min. Yield Strength of 36KSI after firing utilizing min. 30% reduction in steel strength as per AWWA D103-19 Section 5.3.2.1 & 5.3.2.2

SRT480: Titanium (Ti) Rich Hot Rolled Carbon Steel with Min. Ultimate Tensile Strength of 60KSI before firing and Min. Yield Strength of 42KSI after firing utilizing min. 30% reduction in steel strength as per AWWA D103-19 Section 5.3.2.1 & 5.3.2.2.

1. Steel plates shall be mechanically rolled in factory to the required tank radius utilizing rolling machines.
2. When Rolled Structural Shapes are used, the design and engineering shall conform to minimum standards of the latest AWWA D‐103std.

A. Material shall conform to minimum standards of ASTM A36 or ASTM A992.

1. **Horizontal Wind Girders/Stiffeners:** A36 or equal.

A. Design requirements for intermediate horizontal wind stiffeners shall be of the Web-truss design type with an extended tail creating multiple layers of stiffener, permitting wind loads to be distributed around the tank.

B. Web truss stiffeners shall be of steel with hot dipped galvanized coating.

C. Rolled steel angle stiffeners are not permitted for use as intermediate horizontal wind stiffeners.

D. The number and size of wind girders shall be determined by the design calculations. Multiple wind girders shall be utilized as determined by the calculations permitting wind loads to distribute uniformly around the tank.

E. Wind girder shall be fabricated of steel with hot dipped galvanized coating.

1. **Bolt Fasteners: Finless Type**

A. Bolts used in tank lap joints shall be ½" - 13 UNC- 2A rolled thread, and shall meet the minimum requirements of AWWA D103, Section 4.2.

B. Bolt Material SAE J429 Grade 8/ASTM A490/ASTM A354

SAE J429 Grade 8

a) Tensile Strength - 150,000 psi Min.

b) Proof Load - 120,000 psi Min.

c) Allowable shear stress with threads excluded from the shear plane: 36,818psi Min.

1. **Bolt Finish**

* JS1000 Coating/Plating System by Leland Industries or equal.
* Zinc, mechanically deposited. 2.0 mils minimum - under bolt head, on shank and threads.

1. **Bolt Head Encapsulation:**
   1. High impact polypropylene copolymer encapsulation of entire bolt head up to the shank.
   2. Resin shall be stabilized with an ultraviolet light resistant material such that the color shall
   3. appear black.
   4. The bolt head encapsulation shall be certified to meet the ANSI/NSF Standard 61 for indirect additives.
2. Tank sidewall bolts shall be installed such that the head portion is located inside of the tank and washer and nut are located on the exterior.
3. All lap joint bolts shall be properly selected such that threaded portions will not be exposed in the "shear plane" between the sheets.

Also, bolt lengths shall be sized as to achieve a neat and uniform appearance.

1. Excessive threads extending beyond the nut will not be permitted.
2. **Sealants:**
3. The lap joint sealant shall be a one component, moisture cured, polyurethane based elastic sealant. For potable water storage tanks the sealant shall be suitable for contact with potable water and shall be approved by the manufacturer and certified for this use (NSF61), as an indirect additive: such as Manus Bond 75AM or Sikaflex-1a.
4. Sealant shall be used to seal lap joints and bolt connections and edge fillets for sheet notches and starter sheets. The sealant shall cure to a rubber‐like consistency, have excellent adhesion to glass coating, low shrinkage, and be suitable for interior and exterior use. Neoprene gaskets and tape type sealer shall not be used.
5. Sealant curing rate at 73°F and 50% RH.

Tack-free time: 6 to 8 hours.

Final cure time: 5 to 12 days.

NOTE: Neoprene gaskets and tape type sealer shall not be used.

1. **Surface Preparation and Cleaning:**
2. After plate fabrication and prior to application of the glass coating system, all sheets/plates shall be steel grit-blasted to SSPC SP-10/NACE2 (Near White Metal) on both sides.
3. The surface anchor pattern shall be not less than 1.0 mil (0.001 inches).
4. All sheets shall be air blasted to remove any latent grit and then coated immediately with a rust preventative material.
5. **Sheet Edge Preparation**

Prior to glass slurry application all four (4) exposed rectangular continuous sheet edges for each specific sheet radii shall be mechanically rounded in profile resulting in an optimized radius and adhere to The Porcelain Enameling Institute’s Technical Manual PEI-101.

All edges shall receive glass coating system approx. 5mils DFT.

1. **GLASS COATINGS; APPLICATION AND FIRING.**
2. The tank coating system shall conform solely to Section 12.4 of the latest ANSI/AWWA D103std.
3. The manufacturer shall be currently listed on NSF website ([www.nsf.org](http://www.nsf.org)) as approved and in full compliance with NSF61 and NSF372 standards.
4. Glass coatings to be applied by Wet Spraying and must be fused-to-steel by firingin high temperature ovenat 1450°F - 1600°F in strict accordance with the ISO 9001 quality control procedures, including firing time, furnace humidity, and temperature control requirements.
5. The tank manufacturers coating process shall employ equipment that evenly coats the sheet surfaces and all (4) exposed sheet edges.
6. Manufacturer shall maintain and use supplementary directional spray nozzles using an automated machine process to consistently coat the sheet edge profiles per PEI 101 standard.
   * 1. The sheet edges shall be coated with the same vitreous enamel glass coating system as the sheet surface.
     2. A base coat/ground coat of glass frit containing Nickel Oxide (NiO) shall be applied to all 6 sides of the sheet.
     3. A second coat of milled Cobalt Blue or Olive-Green glass shall be applied to both sides of the sheets.
     4. A third coat of Titanium Dioxide (TiO2) reinforced glass mixture shall be applied to all interior sidewall and floor, roof sheet surfaces for NSF61 potable water application.

Note: For NSF61 certified tanks the interior coating color shall be White.

* + 1. The specified coating shall be UIG-Everstore TRS-Vitreous Enamel Glass-Fused-to-Steel Coating System.
    2. An acceptable alternate coating system must be submitted for approval prior to the bid.

1. **Glass-Fused-to-Steel Coating Systems:**

UIG-Everstore TRS-Vitreous Enamel Glass-Fused-to-Steel Coating System.

**System No 1:** Wet Spraying Slurry with 2-Coats & 2-Burns Process at 7-18 MILS DFT

**NOTE:** FOR TANKS WITH THE SAME COLOR ON THE INTERIOR & EXTERIOR

SURFACES (Ex. White TITANIUM DIOXIDE TiO2 INTERIOR FINISH):

* A ground coat of milled Cobalt Blue or Olive-Green Glass Frit mixture with Nickel Oxide (NiO) shall be applied to both sides of the sheets plus to all four edges of the sheets and to the interior edge of the bolt holes and all shop-located and laser cut manways and tank nozzle openings.

**1st Burn: Fire at 1600F**

* A second coat of milled Cobalt Blue, Forest Green, TAN or any other custom

Top layer of glass coating color as required by the Owner or the Project

Engineer to match the required tank colors shall be applied to both sides of

the sheets plus to all four edges of the sheets and to the interior edge of the

bolt holes and shop-located and laser cut manways and tank nozzle

openings.

**2nd Burn: Fire at 1450F**

**System No 2:** Wet Spraying Slurry with 3-Coats & 2-Burns Process at 7-19 MILS DFT

**NOTE:** FOR TANKS WITH TWO DIFFERENT COLORS, SPECIFICALLY TITANIUM

DIOXIDE (TiO2) WHITE INTERIOR FOR NSF61 APPLICATION & ANY

OTHER COLOR ON THE EXTERIOR TANK SURFACE:

* A ground coat of milled Cobalt Blue or Olive-Green Glass Frit mixture with Nickel Oxide (NiO) and it shall be applied to both sides of the sheets plus to all four edges of the sheets and to the interior edge of the bolt holes and all shop-located and laser cut manways and nozzle openings.

**1st Burn: Fire at 1600F**

* A second coat of milled Cobalt Blue, Forest Green, TAN or Titanium Dioxide

White (TiO2) glass as required by the Owner or the Project Engineer to

match the required tank colors shall be applied to both sides of the sheets

plus to all four edges of the sheets and to the interior edge of the bolt holes

and all shop-located and laser cut manways and nozzle openings and then

dried.

* A third coat of milled Titanium Dioxide White (TiO2) glass shall be applied to

the interior surfaces of the sheets plus to all four edges of the sheets and to

the interior edge of the bolt holes and all shop-located and laser cut

manways and nozzle openings.

**2nd Burn: Fire at 1450F**

**System No 3:** Wet Spraying Slurry: 3-Coats & 1-Burn Process at 7-19 MILS DFT

**NOTE:** FOR TANKS WITH TWO DIFFERENT COLORS, SPECIFICALLY TITANIUM

DIOXIDE (TiO2) WHITE INTERIOR FOR NSF61 APPLICATION & ANY

OTHER COLOR ON THE EXTERIOR TANK SURFACE:

* All 6-sides shall receive a catalytic Nickel Oxide (NiO) pre-coat primer

and then air dried.

* A second coat of milled Cobalt Blue, Forest Green, TAN or Titanium Dioxide

White (TiO2) glass as required by the Owner or the Project Engineer to

match the required tank colors shall be applied to both sides of the sheets

plus to all four edges of the sheets and to the interior edge of the bolt holes

and all shop-located and laser cut manways and nozzle openings and then

dried.

* A third coat of milled Titanium Dioxide White (TiO2) glass shall be applied to

the interior surfaces of the sheets plus to all four edges of the sheets and to

the interior edge of the bolt holes and all shop-located and laser cut

manways and nozzle openings.

**One Burn Process:** Cure Glass-Coating-System with a Single Burn at 1500F

**NOTE:**

As per AWWA D103-09 Section 12.4 Glass Coatings - Dry Film Thickness (DFT) of the interior and exterior coating should be minimum 6.0 mils and should not exceed 19.0 mils DFT. In no case dry film thickness (DFT) shall exceed 20mils (500 microns).

All plates with DFT over 20mils shall be rejected.

1. **Glass Coating Characteristics:**

* Acid and alkali resistant pH: 1-14
* Hardness: 6.0 (Mohs)
* Adhesion: 3,450 N/cm

1. **Available Standard Tank Colors:**

* Titanium Dioxide White
* Forest Green
* Desert TAN.
* Cobalt Blue
* Indigo Blue
* Olive Green

1. **Inspections:**

* **Holiday testing per AWWA D103-19std**

1. The maximum voltage of the meter shall not exceed 67.5 volts for wet testing. The sponge shall be dipped in plain tap water as required to keep it uniformly damp, not soaked or dry.
2. Min. 1500V Dry Volt Holiday test on each panel on both sides of every panel.
   * + - Any sheet registering a discontinuity shall be rejected.
       - All inside sheet surfaces shall be holiday free.
       - Frequency of the test shall be every sheet.

Visible inspection as well as Holiday Detection Test shall be performed on both sides of the glass coated plates. If any unacceptable pinholes are found they shall be repaired i.e. coated second time and Holiday Detection Test shall be performed again on the entire panel.

If upon completion of Holiday repairs still any unacceptable pinholes are found at least on one side of the panel, the entire plate shall be rejected and substituted with the one that has successfully passed Holiday Testing inspection.

* **Measurement of Glass Thickness:**

All coated sheets shall be inspected for mil thickness (Mikrotest or equal).

The thickness gage shall have a valid calibration record.

* + - * Interior and Exterior surfaces.
      * Glass thickness shall be measured using an electronic dry film thickness gauge (magnetic induction type or equal).
      * Frequency of the test shall be every Tenth (10th) sheet.
* **Fishscale Testing:** 
  + - * Glass coating shall be tested for fishscale by placing the full-size sheet in an oven at 400 degrees F for one hour.

Then the sheet will then be examined for signs of fishscale.

* + - * Any sheets exhibiting fishscale shall be rejected and all sheets from that gauge lot will be similarly tested.
      * Frequency of this test shall be one sheet per gauge lot run minimum.
* **Adhesion Testing:**
* Coating adhesion shall be tested in accordance with ISO 28765 Class 2 or better. Sheet face and sheet edge must meet the same glass quality test.
* **Impact Adherence Testing:**
* The adherence of the glass coating to the steel shall be tested in accordance with ISO standards. Any sheet that has poor adherence shall be rejected.

1. **Tank Foundations and Tank Floors:**
2. All steel-bottom tanks shall be supported on a concrete ringwall foundation or full slab concrete foundation.
3. All concrete-bottom tanks shall consist of a base-setting ring embedded in concrete.
4. The top of the foundation shall be a minimum of 6-inches above the finished grade.
5. Tank foundation design shall be based on the maximum allowable soil design bearing capacity as determined by the geotechnical report/soils analysis performed by a licensed geotechnical engineer.

The cost of this investigation and analysis shall not be included in the bid price.

Copies of the soil report shall be provided to the bidder prior to bid date by the Owner or Project Engineer.

1. The total settlement shall not to exceed 1” and the differential settlement between the center and edge of the tank shall not exceed 0.5”.
2. **Tank Foundation Types:**

**a. Type 1. Steel-bottom tanks supported on ringwalls.**

A sand or fine stone cushion at least 3-in. (76-mm) thick shall be provided above the earthen interior under the tank bottom.

The shell to be supported on a minimum 1/ 2 in. (13 mm) thick cane-fiber joint filler meeting the requirements of ASTM D1751.Ringwalls after grouting or before placing the cane-fiber joint filler, shall be leveled within ±1/ 8 in. in any 30-ft circumference under the shell. The levelness on the circumference shall not vary by more than ±1/ 4 in. from an established plane.

**b. Type 2. Steel-bottom tanks supported on concrete slabs**

A sand or fine stone cushion not less than 1-in. thick shall be provided between the

flat bottom and the concrete slab foundation. In lieu of a cushion, the bottom may

be supported on a minimum 1/ 2-in. (13-mm) thick cane-fiber joint filler meeting

the requirements of ASTM D1751. The tank shell shall be supported with fiber joint filler. Slabs after grouting or before placing the cane-fiber joint filler, shall be leveled within ±1/ 8 in. in any 30-ft circumference under the shell. The levelness on the circumference shall not vary by more than ±1/ 4 in. from an established plane.

**c. Type 6. Concrete-bottom tanks with embedded steel base setting ring.**

The base-setting ring shall be properly assembled and rigidly supported and attached to a concrete ringwall footing prior to placement of concrete for the curb and tank bottom (2nd pour).

Base-setting rings shall be leveled ±1/16 in. and concentric ± 1/ 4 in.

Base-setting ring shall be embedded in concrete at least 6 inches deep.

A minimum distance of 3-inches between the top of the footing and the bottom of the base-setting ring shall be provided.

The exterior curb shall have a width of minimum 8-inches.

A suitable water-sealing material, shall be installed on the interior surface of the base-setting ring, completely around the entire circumference and prior to placement of concrete for the curb and tank bottom.

The top of the sealing material shall be a minimum distance of 2 in. below the finished top of the concrete bottom.

Concrete shall be reinforced and designed in accordance with ACI 318.

Additional reinforcing steel shall be installed around the base-setting ring, as required, to control shrinkage and resist horizontal loads.

1. **Nozzles & Accessories:**

**Standard Nozzles:** Hot-Dip Galvanized CS

* Optional SS304L
* Optional SS316L
* Optional Glass-Fused-to-Steel on the interior and Epoxy coated on the exterior

1. **Nozzle and Manway Openings:**

To be shop located and cut in factory, mechanically rounded prior to glass application and shall receive glass coating system on the edges approx. 5mils DFT.

1. **Steel Cone Type Tank Roof:**

**Design Standards:** AWWA D108-19std, ASCE7-16, IBC 2018.

1. **General:**
2. Tank roofs shall be furnished by the tank manufacturer.
3. Clear-span self‐supporting aluminum geodesic dome roof type by UIG-EVERDOME or pre-approved equal.
4. ATM Tanks up to 70FT in Diameter can be equipped with 2:12 slope rafter & structure supported Glass Fused-to-Steel CS Cone Decks without columns.

Gastight Biogas Digesters up to 70FT in Diameter can be equipped with 18deg slope external rafter supported cone decks.

1. Roof live loads and dead loads shall be carried by tank sidewalls, without any additional support.
2. **Aluminum Geodesic Dome Roof:**

**Design Standards:** ADM2015, AWWA D108-19std, ASCE7-16, IBC 2018.

1. Aluminum dome roofs shall be constructed of non‐corrugated, triangular aluminum panels, which are sealed and firmly clamped in an interlocking manner within a fully triangulated aluminum space truss system.
2. Dome roof shall be clear span and designed to be self-supporting from the periphery structure with primary horizontal thrust contained by an integral tension ring. Dome roof dead weight shall not exceed 3 pounds per square foot of surface area.
3. Dome roof and tank will be designed to act as an integral unit. The tank will be designed to support an aluminum dome roof including all specified live loads.

Roof Vent ‐ A properly sized atmospheric vent assembly in accordance with AWWA D103‐09 shall be furnished and installed on the roof.

The overflow pipe shall not be considered as a tank vent.

The vent to prevent the entrance of birds and/or animals by including an expanded aluminum screen.

**MATERIAL:**

All aluminum alloys shall be as defined by the Aluminum Association, ADM 2015 and published in the ALUMINUM STANDARDS AND DATA.

1. **Bolts and Fasteners:**

Bolts shall be 300 series stainless steel per ASTM F593, Alloy Group 1, UNE-EN-ISO 3506 AISI 316 (A4).

Screws shall be aluminum or 300 series stainless steel.

1. **Plates and Sheets:**

Roof panels shall be AA3000 or AA5000 series with 0.050” (1.2mm) thickness

Plate and sheet material shall be aluminum alloy, 3003-H16, 5754-H22/H24, 3105-H154, 6061-T6, 5052-H32, 5052-H36; mill finish AA - M10 as fabricated.

Tension ring gussets shall be 0.3125 inch minimum thickness.

Sheet materials shall be 0.050” (1.2mm) minimum thickness.

The aluminum closure panels shall be attached continuously along their edges to the structural members by means of batten bars which engage the panels in an interlocking joint. This batten bar shall also secure an elastomeric weather-seal gasket that shall form a continuous watertight seal along the panel edges.

1. **Structural Shapes**:

Aluminum structural shapes shall be alloy 6082-T6, AA6005A-T6, 6061-T6.

The aluminum structural members shall be a minimum of 4 ½ inches deep.

1. **Internal Columns** – SS316 series stainless steel (if they are used).
2. **Miscellaneous Shapes:**

Miscellaneous aluminum shapes shall be alloy 6061-T6, 6082-T6/T651, 6063-T5.

1. **Gaskets:**

All gaskets shall be Neoprene, EPDM or Silicone. The gaskets must have a 1/8” - ¼” minimum thickness.

1. **Sealant:**

All sealants shall be silicone and resistant to ozone and ultraviolet light.

**NOTE:**

The entire roof structure shall be designed to sustain the loads specified herein, with the stress limitations of the Aluminum Association SPECIFICATIONS FOR ALUMINUM STRUCTURES and/or ADM2015. For members subjected to axial forces and bending moments due to load eccentricity or lateral loads, the combined member stresses shall be

determined by adding the stress component due to axial load to the stress components due to bending in both the major and minor axis.

In no case shall the roof be designed for any loads less than those specified by the local building code and/or local amendments.

1. **Dead Load** – The dead load shall be defined as the weight of the structure and all permanently attached to and supported by the structure.

2. **Load Combinations** – As required per ASCE 7-10 Section 2.4.1.

3. **Temperature** - The load combinations listed above shall be considered for a temperature change of 100 degrees F below the installation temperature and 100 degrees F above the installation temperature and for a material temperature range of 40 degrees F below 0 to 160 degrees F above zero.

4. **Panel Design Load** - In addition to the above mentioned loads and load combinations, the aluminum panels shall be designed for a 250 pound load distributed over one square foot at any location and a plus or minus 60psf load distributed over the entire area of any given panel. These loads are to be taken as acting separately from one another and not simultaneously with other design loads.

**AVAILABLE LIST OF ACCESSORIES FOR AL. DOME ROOF:**

* Access Hatch composed of AL
* Gravity vent with AL. insect screen composed of AL
* Eyebolt/Safety Pin/Painters Pin composed of SS304
* Non-Slip traction tape to the apex of the dome roof
* AL. single handrail to the apex of the dome roof
* Full or partial perimeter handrails composed of AL
* SS304 Safety Line
* Skylights
* Roof Nozzles composed of AL or SS
* Anode Hand Holes

**2.3 TANK ACCESSORIES**

1. **Level Indicator:**
2. Manufacturer shall supply and install visual liquid level indicator type on the side of the tank (Float Type, Sight Gauge or a Pressure Gauge type).
3. **Pipe Connections:**
4. Where pipe connections are shown to pass through tank panels, they shall be factory located and cut at factory prior to the application of the glass coating system.
5. The manufacturer shall utilize an interior and/or exterior flange assembly and the tank shell reinforcing as required by the project engineer and owner’s requirements.
6. A single component urethane sealer shall be applied on any cut panel penetrations or bolt connections.
7. **Access Door/Manway:**
8. Tank shall be provided with min. One (1) 24‐inch diameter manway in first (bottom) ring as shown on Contract Drawings or as per AWWA D103.
9. **Identification Plate:**
10. A manufacturer’s nameplate shall list the tank serial number, tank diameter and height, maximum design capacity, intended storage use, and date of installation. The nameplate shall be affixed to the tank exterior sidewall at a location approximately 5' from grade elevation in a position of unobstructed view.
11. **Cathodic Protection System:**
12. The manufacturer shall design and supply a passive, cathodic protection system if required.
13. **External Overflow Weir and Pipe:**
14. Overflow pipe shall be determined by the manufacturer or specified by the Engineer and shall be composed of galvanized CS sch 40 pipe, Schedule 80PVC or DI Pipe.
15. **Roof Access Hatch:**
16. Provide min. One (1) 24‐inch x 24‐inch access hatch.
17. **Ladders:**
18. An exterior vertical caged tank ladder shall be furnished and installed as shown on the contract drawings and as per OSHA
19. Ladders shall be fabricated of carbon steel. Finish shall be hot dipped galvanized.
20. Safety cage and step‐off platform shall be constructed of galvanized steel. A locking cage gate shall be attached to the bottom of the safety cage.

**2.4 TANK PACKAGING**

1. All sheets that pass Factory Inspection and Quality Control checks shall be protected from damage prior to packing for shipment.
2. Suitable non‐abrasive packaging sheets shall be placed between each panel to eliminate sheet‐to‐sheet abrasion during shipment.
3. Individual stacks of panels will be wrapped in heavy mil black plastic and steel banded to special wood pallets built to the roll‐radius of the tank panels. This procedure minimizes contact or movement of finished panels during shipment.

**PART 3 – EXECUTION**

**3.1 - ERECTION**

1. Except as otherwise shown or specified, Tank shall be erected in accordance with the requirements of AWWA Standard D103 latest edition and manufacturer’s recommendations and instructions.
2. Supervisory personnel of the erection crew shall identify themselves to responsible personnel of the Engineer or Inspector upon initially entering the job site.
3. **Tank Foundation:**
4. The tank foundation shall be designed by a certified PE to safely sustain the structure and its live loads.
5. Place a Butyl type water‐stop seal on the inside surface of the starter ring below concrete floor line. Sika‐Swell Sealant bead approximately 6” below top of concrete on the internal and/or external surface of the starter ring could be utilized as a water stop. Install materials in accordance with tank manufacturer’s instructions as shown on the foundation plans.
6. Tank footing design shall be based on the soil bearing capacity given by the engineer.
7. **Tank Structure:**
8. Field erection of the glass‐coated, bolted‐steel structures and components shall be in strict accordance with the procedures established by manufacturer and performed by the manufacturer or an authorized dealer of the tank manufacturer regularly engaged in erection of these tanks.
9. Specialized erection jacks, and other building equipment developed and supplied by the tank manufacturer may be used to erect the tanks as well as scaffolding, wooden ladders, crane, scissor lift and/or others depending on the application and location of tank and tank site, and specific tank dimensions that would provide the best value to the tank owner or the purchaser.
10. Particular care shall be taken in handling and bolting of the glass coated steel tank panels, appurtenances and members to avoid abrasion of the coating system. Prior to liquid test, all surface areas shall be visually inspected. Chips or scrapes in the glass coating shall be repaired per the tank manufacturer's recommended procedure.
11. The placement of the sealant on each panel may be inspected prior to placement of adjacent panels. However, the inspection shall not relieve any responsibility for liquid tightness.
12. No backfill is to be placed against the tank sidewall without prior written approval of the tank manufacturer. Any backfill allowed shall be placed strictly in accordance with the instructions of the tank manufacturer.

**3.2 - FIELD TESTING**

1. Following completion of erection and cleaning of the tank, the structure shall be tested for liquid tightness by filling to its overflow elevation.
2. The erector in accordance with the manufacture’s recommendations shall correct any leaks disclosed by this test.
3. The owner shall furnish water required for testing at the time of tank erection completion, and at no charge to the manufacturer or the appointed tank erector. Disposal of test water shall be the responsibility of the owner.
4. Upon request labor, water and equipment necessary for hydrostatic tank testing shall be included in the contract price of the tank as optional.

**3.3 – TANK DISINFECTION**

1. The tank structure shall be disinfected at the time of testing by chlorination in accordance with AWWA Standard C652 “Disinfection of Water Storage Facilities” or as modified by the manufacturer or the appointed erector.
2. Disinfection shall not take place until tank sealant is fully cured.
3. Acceptable forms of chlorine for disinfection shall be:
4. Liquid chlorine as specified in AWWA C652. (Section 4.2.1).
5. Sodium hypochlorite as specified in AWWA C652. (Section 4.2.2).
6. Calcium hypochlorite (HTH) is not acceptable.
7. Acceptable methods of chlorination per AWWA C652:
8. Section 4.3.1.
9. Section 4.3.1.2 – chemical feed pump only (4.3.1.2).
10. Section 4.3.3.
11. Section 4.3.1.3 is not acceptable

**END OF SECTION**