



SLOVENSKI STANDARD
oSIST prEN ISO 28765:2022

01-marec-2022

Steklasti in porcelanski emajli - Projektiranje s steklastim emajlom zaščitenih jeklenih rezervoarjev za skladiščenje ali pripravo vode ali komunalnih ali industrijskih odplak (ISO/DIS 28765:2022)

Vitreous and porcelain enamels - Design of bolted steel tanks for the storage or treatment of water or municipal or industrial effluents and sludges (ISO/DIS 28765:2022)

Emails und Emailierungen – Gestaltung von verschraubten Stahlbehältern für die Speicherung oder Behandlung von Wasser oder kommunalen und industriellen Abwässern und Abwasserschläm (ISO/DIS 28765:2022)

Émaux vitrifiés - Conception de réservoirs en acier boulonnés pour le stockage ou le traitement des eaux ou des effluents d'eaux usées urbains ou industriels (ISO/DIS 28765:2022)

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Ta slovenski standard je istoveten z: ²⁰²² prEN ISO 28765

ICS:

23.020.10	Nepremične posode in rezervoarji	Stationary containers and tanks
25.220.50	Emajlne prevleke	Enamels

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DRAFT INTERNATIONAL STANDARD

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Vitreous and porcelain enamels — Design of bolted steel tanks for the storage or treatment of water or municipal or industrial effluents and sludges

Émaux vitrifiés — Conception de réservoirs en acier boulonnés pour le stockage ou le traitement des eaux ou des effluents d'eaux usées urbains ou industriels

ICS: 25.220.50

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Contents

	Page
Foreword.....	v
1 Scope.....	1
2 Normative references.....	2
3 Terms and definitions.....	3
4 Symbols and abbreviated terms.....	4
5 Units.....	5
6 Information and requirements to be agreed and documented.....	5
6.1 General.....	5
6.2 Information to be provided by the purchaser.....	6
6.3 Information to be provided by the designer.....	6
7 Applicable standards.....	7
8 Loads.....	7
8.1 General.....	7
8.2 Contents.....	7
8.2.1 General.....	7
8.2.2 Freeboard.....	8
8.2.3 Hydrostatic pressure.....	8
8.2.4 Axial wall forces.....	8
8.2.5 Filling and discharging.....	8
8.3 Tank structure.....	8
8.4 Roof.....	9
8.5 Equipment loads.....	9
8.5.1 General.....	9
8.5.2 Static load.....	9
8.5.3 Dynamic load.....	9
8.6 Access.....	9
8.7 Environmental.....	9
8.7.1 General.....	9
8.7.2 Seismic action.....	10
8.7.3 Wind.....	10
8.7.4 Snow.....	10
8.7.5 Ice.....	10
8.8 Ancillary items.....	10
9 Design.....	10
9.1 General.....	10
9.2 Steel.....	10
9.2.1 Specification.....	10
9.2.2 Effects of the enamelling process.....	11
9.3 Tank.....	11
9.3.1 Load factors.....	11
9.3.2 Tank walls.....	11
9.3.3 Tank roof.....	14
9.3.4 Attachment of walls to floor.....	15
9.3.5 Tank floor.....	15
9.3.6 Ancillary items.....	16
9.3.7 Cathodic protection.....	16
9.4 Openings.....	16
9.4.1 Access manway.....	16
9.4.2 Pipe connections.....	16
9.4.3 Overflows.....	16
9.4.4 Reinforcement of manways and pipe connections in the tank shell.....	16

ISO/DIS 28765:2022(E)

9.4.5	Connections in the roof	17
9.5	Effects of accidents	17
9.5.1	Risk assessment	17
9.5.2	Explosions	17
9.5.3	Uncontrolled fluctuation in input stream characteristics	18
10	Vitreous enamel coating	18
10.1	Vitreous enamel	18
10.2	Coating	18
10.3	Vitreous enamel quality	18
10.3.1	Preparation and test frequency	18
10.3.2	Inspection	18
10.3.3	On-site rectification	19
10.4	Protection during shipping	23
10.5	Maintenance	23
11	Installation	23
11.1	General guidance	23
11.2	Foundations	23
11.3	Inspection of the vitreous enamel coating at the construction site	23
12	Disinfection	24
	Bibliography	25

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the WTO principles in the Technical Barriers to Trade (TBT) see the following URL: [Foreword - Supplementary information](#)

The committee responsible for this document is ISO/TC 107, *Metallic and other inorganic coatings*.

This second edition cancels and replaces the first edition (ISO 28765:2008), which has been technically revised.

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Vitreous and porcelain enamels — Design of bolted steel tanks for the storage or treatment of water or municipal or industrial effluents and sludges

1 Scope

This International Standard establishes the requirements for the design and use of vitreous enamel coated bolted cylindrical steel tanks for the storage or treatment of water or municipal or industrial effluents and sludges.

It applies to the design of the tank and any associated roof and gives guidance on the requirements for the design of the foundation.

It applies where

- a) the tank is cylindrical and is mounted on a load-bearing base substantially at or above ground level;
- b) the product of the tank diameter in metres and the wall height in metres lies within the range 5 to 500;
- c) the tank diameter does not exceed 100 m and the total wall height does not exceed 50 m;
- d) the stored material has the characteristics of a liquid, exerting a negligible frictional force on the tank wall; the stored material may be undergoing treatment as part of a municipal or industrial effluent treatment process;
- e) the internal pressure in the headspace above the liquid does not exceed 50 kPa and the internal partial vacuum above the liquid does not exceed 10 kPa;
- f) the walls of the tank are vertical;
- g) the floor of the tank is substantially flat at its intersection with the wall; the floor of the tank may have a rise or fall built in to allow complete emptying of the tank contents, the slope of which does not exceed 1:100;
- h) there is negligible inertial and impact load due to tank filling;
- i) the minimum thickness of the tank shell is 1,5 mm;
- j) the material used for the manufacture of the steel sheets is carbon steel (tanks constructed of sheets made from aluminium or stainless steel are outside the scope of this International Standard);
- k) the temperature of the tank wall during operation is within the range -50 °C to $+100\text{ °C}$ under all operating conditions.

This International Standard also gives details of procedures to be followed during installation on site and for inspection and maintenance of the installed tank.

It does not apply to chemical-reaction vessels.

It does not cover resistance to fire.

ISO/DIS 28765:2022(E)**2 Normative references**

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 2178, *Non-magnetic coatings on magnetic substrates — Measurement of coating thickness — Magnetic method*

ISO 2746:2015, *Vitreous and porcelain enamels — High voltage test*

ISO 2859-1, *Sampling procedures for inspection by attributes — Part 1: Sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection*

ISO 4532, *Vitreous and porcelain enamels — Determination of the resistance of enamelled articles to impact — Pistol test*

ISO 6370-2, *Vitreous and porcelain enamels — Determination of the resistance to abrasion — Part 2: Loss in mass after sub-surface abrasion*

ISO 8289-1:2020, *Vitreous and porcelain enamels — Low-voltage test for detecting and locating defects — Part 1: Swab test for non-profiled surfaces*

ISO 15686-1, *Buildings and constructed assets — Service life planning — Part 1: General principles and framework*

ISO 28706-1:2008, *Vitreous and porcelain enamels — Determination of resistance to chemical corrosion — Part 1: Determination of resistance to chemical corrosion by acids at room temperature*

ISO 28706-2:2017, *Vitreous and porcelain enamels — Determination of resistance to chemical corrosion — Part 2: Determination of resistance to chemical corrosion by boiling acids, boiling neutral liquids, alkaline liquids and/or their vapours*

ISO 28706-3:2017, *Vitreous and porcelain enamels — Determination of resistance to chemical corrosion — Part 3: Determination of resistance to chemical corrosion by alkaline liquids using a hexagonal vessel or a tetragonal glass bottle or a tetragonal glass bottle*

ISO 28706-4:2016, *Vitreous and porcelain enamels — Determination of resistance to chemical corrosion — Part 4: Determination of resistance to chemical corrosion by alkaline liquids using a cylindrical vessel*

ISO 28763:2019, *Vitreous and porcelain enamels — Regenerative, enamelled and packed panels for air-gas and gas-gas heat exchangers — Specifications*

ISO 19496-1, *Vitreous and porcelain enamels — Terminology — Part 1: Terms and definitions*

EN 15771, *Vitreous and porcelain enamels — Determination of surface scratch hardness according to the Mohs scale*

EN 1993-1-6, *Eurocode 3 — Design of steel structures — Part 1-6: Strength and Stability of Shell Structures*

EN 1993-4-1, *Eurocode 3 — Design of steel structures — Part 4-1: Silos*

EN 1993-4-2, *Eurocode 3 — Design of steel structures — Part 4-2: Tanks*

EN 1998-4, *Eurocode 8 — Design of structures for earthquake resistance — Part 4: Silos, tanks and pipelines*

EN 10209:2013, *Cold rolled low carbon steel flat products for vitreous enamelling — Technical delivery conditions*

ANSI/AWWA D 103, *Factory-Coated Bolted Steel Tanks for Water Storage*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 19496-1 and the following terms and definitions apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <https://www.electropedia.org/>

3.1

brief

working document which specifies at any point in time the relevant needs and aims of the project, the resources to be provided by the client, the details of the project and any applicable design requirements within which all subsequent briefing (when needed) and designing can take place

3.2

client

person or organization that requires a tank to be provided, altered or extended and is responsible for initiating and approving the brief

3.3

defect

any void, break, crack, discontinuity, blister, foreign inclusion, or contamination of the vitreous enamel coating

3.4

designer

person or organization responsible for stating the shape and specification of the component to be designed

3.5

design life

service life intended by the designer

3.6

Discontinuity free

any vitreous enamel coating which does not allow an electric current to pass through to the steel substrate

3.7

enamel supplier

person or organization supplying materials for use by the vitreous enameller in the enamelling process

3.8

freeboard

distance between the top of the cylindrical-tank vertical shell wall and the surface of the contained liquid at the specified operating level

3.9

headspace pressure

pressure within a roofed tank above the stored liquid

3.10

inspection area

area inside a boundary 25 mm from any panel edge or hole and outside a boundary 25 mm from any opening or hole within the body of a panel

ISO/DIS 28765:2022(E)

**3.11
liquid**

bulk substance that exerts substantially the same vertical and horizontal pressures and has no fixed shape

**3.12
maintenance**

combination of all technical and associated administrative actions during the service life to retain a tank or its parts in a state in which it can perform its required function

**3.13
manufacturer**

person or organization that manufactures the tank or parts of the tank

**3.14
purchaser**

person or organization purchasing the tank from the supplier

Note 1 to entry: The purchaser can also be the client.

**3.15
rectification**

return of a tank or its parts to an acceptable condition by the renewal, replacement or repair of worn, damaged or degraded parts

**3.16
supplier**

person or organization that supplies the tank or parts of the tank

**3.17
service life**

period of time after installation during which the tank or its parts meets or exceeds the performance requirements

**3.18
tank**

cylindrical, vertical shell for containing liquid, with or without a roof, which is constructed from curved vitreous enamelled single or laminated steel panels bolted together on the construction site and mounted on a base which may also form the floor of the container

**3.19
vitreous enameller**

person undertaking and controlling the process of preparing the steel sheets and applying the vitreous enamel coating to the surfaces of the steel sheets

Note 1 to entry: The vitreous enameller will normally be the manufacturer.

4 Symbols and abbreviated terms

For the purposes of this document, the following symbols and abbreviated terms apply.

D	tank diameter
E	Young's modulus of elasticity
F_H	static hoop force
g	acceleration due to gravity
H	depth of liquid at point under consideration, measured from the liquid surface at the maximum possible filling level
H_0	total vertical wall height