

**§ 52.01-55**

**46 CFR Ch. I (10-1-13 Edition)**

(e) Double-ended boilers, having individual combustion chambers for each end, in which combustion chambers are common to all the furnaces in one end of the boiler, shall have one plug fitted at or near the center of the crown sheet of each combustion chamber.

(f) Boilers constructed with a separate combustion chamber for each individual furnace shall be fitted with a fusible plug in the center of the crown sheet of each combustion chamber.

(g) Boilers of types not provided for in this section shall be fitted with at least one fusible plug of such dimensions and located in a part of the boiler as will best meet the purposes for which it is intended.

(h) Fusible plugs shall be so fitted that the smaller end of the filling is in direct contact with the radiant heat of the fire, and shall be at least 1 inch higher on the water side than the plate or flue in which they are fitted, and in no case more than 1 inch below the lowest permissible water level.

(i) The lowest permissible water level shall be determined as follows:

(1) Vertical firetube boilers, one-half of the length of the tubes above the lower tube sheets.

(2) Vertical submerged tube boilers 1 inch above the upper tube sheet.

(3) Internally fired firetube boilers with combustion chambers integral with the boiler, 2 inches above the highest part of the combustion chamber.

(4) Horizontal-return tubular and dry back Scotch boilers, 2 inches above the top row of tubes.

(j) [Reserved]

(k)(1) Fusible plugs shall be cleaned and will be examined by the marine inspector at each inspection for certification, periodic inspection, and oftener if necessary. If in the marine inspector's opinion the condition of any plug is satisfactory, it may be continued in use.

(2) When fusible plugs are renewed at other than the inspection for certification and no marine inspector is in attendance, the Chief Engineer shall submit a written report to the Officer in Charge, Marine Inspection, who issued the certificate of inspection informing him of the renewal. This letter report

shall contain the following information:

(i) Name and official number of vessel.

(ii) Date of renewal of fusible plugs.

(iii) Number and location of fusible plugs renewed in each boiler.

(iv) Manufacturer and heat number of each plug.

(v) Reason for renewal.

[CGFR 68-82, 33 FR 18815, Dec. 18, 1968, as amended by CGD 81-79, 50 FR 9432, Mar. 8, 1985; USCG-1999-4976, 65 FR 6500, Feb. 9, 2000; USCG-2003-16630, 73 FR 65160, Oct. 31, 2008]

**§ 52.01-55 Increase in maximum allowable working pressure.**

(a) When the maximum allowable working pressure of a boiler has been established, an increase in the pressure settings of its safety valves shall not be granted unless the boiler design meets the requirements of this subchapter in effect at the time the boiler was contracted for or built; but in no case will a pressure increase be authorized for boilers constructed prior to the effective date of the regulations dated November 19, 1952, if the minimum thickness found by measurement shows that the boiler will have a factor of safety of less than 4½. The piping system, machinery, and appurtenances shall meet the present requirements of this subchapter for the maximum allowable working pressure requested. An increase in pressure shall be granted only by the Commandant upon presentation of data or plans proving that the requested increase in pressure is justified.

(b) When an existing boiler is replaced by a new boiler designed to operate at pressures in excess of the pressure indicated on the certificate of inspection for the previous boiler, an analysis of the complete system shall be made, including machinery and piping, to insure its compatibility with the increased steam pressure. The maximum allowable working pressure on the certificate of inspection shall be based on the results of this analysis.

**§ 52.01-90 Materials (modifies PG-5 through PG-13).**

(a) Material subject to stress due to pressure must conform to specifications as indicated in paragraphs PG-5

through PG-13 of section I of the ASME Boiler and Pressure Vessel Code (incorporated by reference; see 46 CFR 52.01-1) except as noted otherwise in this section.

(b) Material not fully identified with an ASME Boiler and Pressure Vessel Code-approved specification may be accepted as meeting Coast Guard requirements providing it satisfies the conditions indicated in paragraph PG-10 of section I of the ASME Boiler and Pressure Vessel Code.

(c) (*Modifies PG-5.*) When the maximum allowable working pressure (See PG-21) exceeds 15 pounds per square inch, cross pipes connecting the steam and water drums of water tube boilers, headers, cross boxes, and all pressure parts of the boiler proper, shall be made of a wrought or cast steel listed in tables 1A and 1B of section II of the ASME Boiler and Pressure Vessel Code (incorporated by reference; see 46 CFR 52.01-1).

(d) (*Modifies PG-8.2.*) The use of cast iron is prohibited for mountings, fittings, valves, or cocks attached directly to boilers operating at pressures exceeding 15 pounds per square inch.

[USCG-2003-16630, 73 FR 65161, Oct. 31, 2008]

**§ 52.01-95 Design (modifies PG-16 through PG-31 and PG-100).**

(a) *Requirements.* Boilers required to be designed to this part shall meet the requirements of PG-16 through PG-31 of section I of the ASME Boiler and Pressure Vessel Code (incorporated by reference; see 46 CFR 52.01-1) except as noted otherwise in this section.

(b) *Superheater.* (1) The design pressure of a superheater integral with the boiler shall not be less than the lowest setting of the drum safety valve.

(2) Controls shall be provided to insure that the maximum temperature at the superheater outlets does not exceed the allowable temperature limit of the material used in the superheater outlet, in the steam piping, and in the associated machinery under all operating conditions including boiler overload. Controls need not be provided if the operating superheater characteristic is demonstrated to be such that the temperature limits of the material will not be exceeded. Visible and audible alarms indicating excessive superheat shall be

provided in any installation in which the superheater outlet temperature exceeds 454 °C (850 °F). The setting of the excessive superheat alarms must not exceed the maximum allowable temperature of the superheater outlet, which may be limited by the boiler design, the main steam piping design, or the temperature limits of other equipment subjected to the temperature of the steam.

(3) Arrangement shall be made for venting and draining the superheater in order to permit steam circulation through the superheater when starting the boiler.

(c) *Economizer.* The design pressure of an economizer integral with the boiler and connected to the boiler drum without intervening stop valves shall be at least equal to 110 percent of the highest setting of the safety valves on the drum.

(d) *Brazed boiler steam air heaters.* Boiler steam air heaters utilizing brazed construction are permitted at temperature not exceeding 525 °F. Refer to § 56.30-30(b)(1) of this subchapter for applicable requirements.

(e) *Stresses.* (*Modifies PG-22.*) The stresses due to hydrostatic head shall be taken into account in determining the minimum thickness of the shell or head of any boiler pressure part unless noted otherwise. Additional stresses, imposed by effects other than internal pressure or static head, which increase the average stress over substantial sections of the shell or head by more than 10 percent of the allowable stress shall be taken into account. These effects include the weight of the vessel and its contents, method of support, impact loads, superimposed loads, localized stresses due to the reactions of supports, stresses due to temperature gradients and dynamic effects.

(f) *Cylindrical components under internal pressure.* (*Modifies PG-27.*) The minimum required thickness and maximum allowable working pressure of boiler piping, tubes, drums and headers shall be as required by the formula in PG-27 of section I of the ASME Boiler and Pressure Vessel Code except that