



TECHNICAL BULLETIN

Category M Valve Service

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February 20, 2001

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This bulletin outlines the general guidelines Milwaukee Valve Co. engineering follows for all category M service.

ASME/ANSI B31.3 points out requirements and rules for Category M, typically referred to in the industry as 'lethal' service. The specification relates to listed valves, made to industry specifications, for example ASME/ANSI B16.34, and also non-listed valves, and identifies design requirements for same.

Over and above the requirements of ASME/ANSI B31.3, Milwaukee Valve follows guidelines as listed below. This list is not exhaustive; it serves only as the foundation for evaluation of Category M quotes and orders at the initial stage. Each application is handled individually to ensure the highest level of product safety and performance.

1. Written specifications are required, detailing all valve requirements for configuration(s), material(s), compliance with industry specifications and standards, and performance. Valves will not be quoted to 'zero' leakage requirements; leakage requirements shall be specified, even at very low allowable levels, e.g. 2×10^{-7} std cc/sec GHe at pressure.
2. Where applicable, Milwaukee valve will offer only upgraded FE stem seal packages.
3. Any welded joints will be full penetration, made only by ASME Section IX qualified welders, and shall be fully inspected and tested. All joints will be fully post weld heat treated, consistent with the material specifications.
4. For cast valves, Milwaukee will quote and supply upgraded material only, meeting the following minimum requirements, over and above the baseline material specifications. Radiography of critical sections, and dye pen/magnetic particle as applicable to all accessible machined surfaces of castings.
5. All material used in wetted areas of the valve shall be traceable to chemical and physical data.
6. All bolting shall be domestic and shall carry markings for material and manufacturer, and shall be traceable to chemical and physical data.
7. All valves, in addition to standard shell and seat testing to industry specifications, e.g. API 598, will be subjected to shell testing with GHe to ensure pressure boundary integrity. Any sign of

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visible leakage across the structure shall be cause for rejection. Leakage at the seats, and static and dynamic seals shall be negotiated at the time of the quotation and/or order.

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