

ANHYDROUS AMMONIA

Anhydrous Ammonia System Piping Requirements

This factsheet was prepared by the Minnesota Department of Agriculture (MDA) to provide information on some of the State of Minnesota requirements for facilities, which store, handle and use anhydrous ammonia on their premises. This guidance is intended to supplement – not replace – the Minnesota Anhydrous Ammonia Rules, Parts 1513.0010 to 1513.1100 and other applicable standards.

Ammonia-Rated System Piping

Minnesota Rules, Part 1513.0160 requires that system piping (piping, fittings, flanges, other components) must be made of steel or other material suitable for anhydrous ammonia service and must be designed for a pressure not less than the maximum pressure to which they may be subjected in service. System piping components made of, or in part of, brass, copper, zinc, galvanized steel, or cast iron ARE NOT ALLOWED for ammonia service.

Non-Refrigerated System Piping

Non-refrigerated ammonia system piping must conform to the ANSI B31.3 standard. The most common system piping components meeting the minimum standards for non-refrigerated ammonia systems are:

Pipe/Nipples/Flexible Connector Specifications

ASTM/API Specification	Tensile Strength	Schedule Rating (Wall Thickness)	Quality Factor
Piping & Seamless Nipples			
ASTM A53, Grade B, ERW	60,000 psi	40 & 80	85%
ASTM A53, Grade S, Seamless	70,000 psi	40 & 80	100%
ASTM A106, Grade B, Seamless	60,000 psi	40 & 80	100%
ASTM A106, Grade C, Seamless	70,000 psi	40 & 80	100%
API 5L, Grade B, ERW	60,000 psi	40 & 80	85%
Seamless Swage Nipples			
ASTM A234, Grade WPB	60,000 psi	40 & 80	
Stainless Steel, Ammonia-Rated Flexible Connectors			
250 psi/MKB-rated with a safety factor of four			

Notes Related to Pipe/Nipples/Flexible Connectors:

- Welded or welded/flanged joints: At least Schedule 40, Standard (STD) rated piping.
- Threaded joints: At least Schedule 80, Extra Heavy (XH) rated piping.
- Threaded nipples must be seamless, Schedule 80, Extra Heavy (XH) rated.

Fitting/Flange Specifications

ASTM Specification	Pressure Class or Schedule Rating	Fitting Type
Fittings		
A205, (Forged Carbon Steel)	Class 2000 & greater	Threaded & Socket Weld
A234, Grade WPB	Schedule 40 & 80	Butt Weld
A193	Class 300 & greater	Black Malleable Iron (MI)
*1. Malleable iron (MI) fittings are NOT RECOMMENDED for ammonia service because of its marginal applications. *2. MI fittings allowed for ammonia service are Class 300 and greater-rated elbows, tees, crosses, reducing 90°s, street 90°s, reducing couplings. *3. Do not use MI plugs and bushings (only available in Pressure Class 150). *4. Do NOT weld on MI fittings. Use of MI fittings is limited to threaded joints. *5. Do NOT use MI fittings for low temperature, refrigerated ammonia service.		

Flanges

A205, (Forged Carbon Steel)	Class 100 & greater	----
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Other System Piping Component Specifications

ASTM Specification	Component Type
A395 Ductile Iron	Valves
A193, Grade B7	Flange Stud Bolts
A194, Grade 2H	Flange Hex Nuts

Notes Related to Fittings, Flanges, Valves, & Components:

- Unions must be steel to steel seated.
- Components, flanges, and fittings marked with, "FORGED", ASTM/ASME "A/SAXXX", "MI" (malleable iron), and/or Class "xxxx" specification designation(s). Specifications not marked or solely noted must meet the requirements for non-refrigerated ammonia service.

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