



Kelso Service Bulletin # KTUD1500

September 15, 2015

Service Bulletin

Subject: Corrosion Guidelines of Carbon Steel Flanges

Purpose: To ensure that valves that have been in service are not condemned by visual inspection.

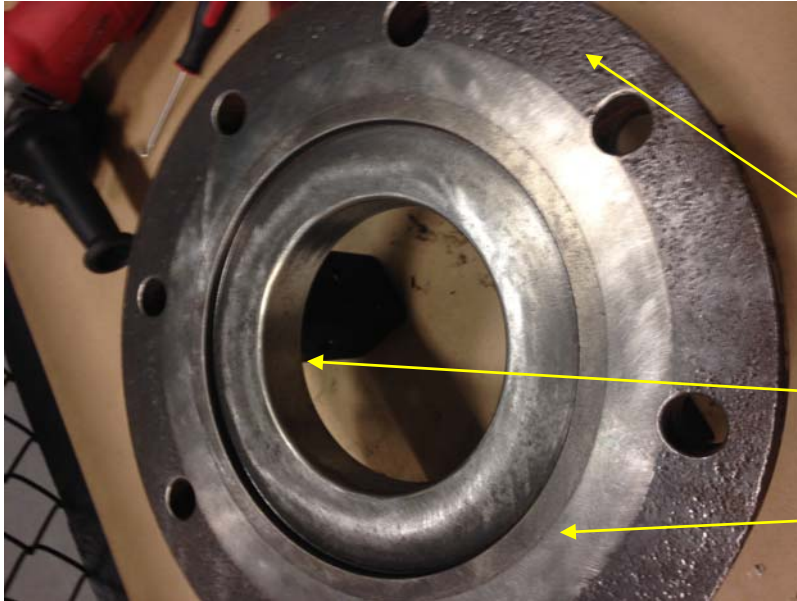
Scope: These guidelines apply to all pressure relieve valve flanges. After being cleaned properly and inspected, these guidelines should help in making a sensible decision about future use of such flanges.

Procedure:

- Disassemble per Kelso's Procedures (Kelso Small PRV Manual JS75L – JS165L and Kelso Large PRV Manual JS75-JS165)
- After disassembling valve, pay close attention to location and degree of rust. Some pitting may also be visible but some blasting and washing of parts will be needed to make a final decision. The blasting media should be iron-free to prevent deposits of iron onto the blasted surface.



Flange after being
in service



Flange after blasting and properly cleaned

Allowed degree of pitting in non-critical areas

Valve Seat Area

Gasket Surface

- After having flange blasted to remove excess rust, the flange can be inspected for excess of pitting, specifically on the valve seat and gasket surface. These areas must be free of scratches, gouges, pitting, dents, etc. Such conditions will make valve leak.
- Some valve flanges are designed for a tongue and grooved and raised faced connections. In such case, the same guidelines apply.
- The use of Emery paper (400 grit) is permitted to clean and buff the seat of the valve and flat face gasket surface for minor dings and scratches.

Note: Repair work on valve involving machining, grinding and/or other alterations/modifications can only be performed by the valve manufacturer, car owner or user with the valve manufacturer's permission. The flat gasket face and gasket tongue maybe machined to remove nicks and burrs. Tolerances on gasket tongue must not be exceeded. (AAR M1002 Appendix A, paragraph 3.11)

- In the event, that excessive pitting or damage is noticed on valve seat and gasket surfaces; flanges may be re-machined/re-conditioned and put back into service. Contact Kelso for assistance.



- Some pitting can be tolerated in non-critical areas. If pitting is more than .030" in non-critical areas, contact Kelso for guidance.
- After blasting and cleaning valve, the entire flange can be wiped down with soybean oil base coat or inert oil base solution. Especial attention should be exercise as some commodities will not tolerate some of these solutions. Contact Kelso for assistance.