Contents

Lis	t of Figures, vii
Lis	t of Tables, ix
For	reword, xi
Ack	knowledgments, xiii
Int	roduction, xv
	Definitions, xvi AWWA Standards, xvi Welded Tanks, xvii Bolted Tanks, xvii
Par	rt I Elements of Steel Water Tanks
Cha	apter 1 Typical Capacities and Configurations
	Reservoirs, 3 Standpipes, 3 Roof Designs for Reservoirs and Standpipes, 10 Elevated Tanks, 13 Multiple-Column Elevated Tanks, 13 Pedestal Elevated Tanks, 18
Cha	apter 2 Appurtenances
	Shell Manholes, 25 Pipe Connections, 26 Overflow, 28 Ladders and Safety Devices, 29 Roof Openings, 32 Vents, 33 Devices for Indicating Water Level, 35 Emergency Fill/Withdraw Connections, 36
Cha	apter 3 Cathodic Protection
	Nature of Corrosion, 37 Principles of Cathodic Protection, 39 Cathodic Protection Design, 40 Maintenance, 41
Cha	apter 4 Coating Systems
	Interior Coatings, 45 Exterior Coatings, 47 Inspection and Quality Control, 48 Removing Coating by Abrasive Blasting, 49

Part	II The New Tank Project
Cha	pter 5 Selecting and Sizing Water Storage Tanks
	Peak Demand, 53 Fire Flow, 54 Top and Bottom Capacity Levels, 54 Energy Costs, 55 Future Needs, 55 Environmental Impact, 56 Tank Costs, 56
Cha	pter 6 Construction Considerations
	Design Standards, 59 Contract Documents, 60 Constructor Capabilities, 60 Guarantees, 60 Soil Investigations, 60 Reservoir and Standpipe Foundations, 63 Elevated Tank Foundations, 64 Tank Site, 65 Tank Coating—Welded Steel Tanks, 67 Tank Coating—Bolted Steel Tanks, 68 Tank Water Testing and Disinfection, 68 Engineer's Role, 69 Bidding Documents, 70
Chaj	pter 7 Inspecting New Tank Construction
	Responsibility for Quality, 73 The Foundation, 74 Fabrication, 76 Steel Delivery, 76 Tank Erection, 76 Field Cleaning and Coating, 79 Mechanical and Electrical Appurtenances, 81
Part	III Existing Tanks
Cha	pter 8 Routine Operation and Maintenance
	Energy Management, 85 Controls, 86 Periodic Operator Inspection, 86 Tank Washouts, 88
Cha	pter 9 Professional Examination and Renovation 91
	Tank Maintenance Engineer's Functions and Qualifications, 92 Pre-Bid Inspection, 94 Preparing Specifications, 99 Monitoring the Constructor's Progress, 101 Periodic Reinspection, 104

Chapter 10 Cold-Weather Operation		
Causes and Results of Freezing, 105		
Quantitative Data Related to Freezing, 108		
Designing Tanks for Cold Weather, 108		
Cold-Weather Operating Procedures, 113		
Systems to Prevent Freezing, 114		
Dealing With Frozen Tanks, 116		
Appendix A Bibliography		
Appendix B Steel Water Tank Industry Standards Organizations and Information Sources		
Appendix C Inspecting and Repairing Steel Water Tanks, Standpipes, Reservoirs, and Elevated Tanks for Water		
Storage		
Index, 139		
AWWA List of Manuals, 143		

Figures

F-1	A tank constructed in 1902 is still serving Wabash, Ind., with practically no metal loss, xv
1-1	Welded steel reservoir, 4
1-2	Cross-sectional view of a welded steel reservoir, 4
1-3	Bolted steel reservoir, glass fused to steel, 5
1-4	Cross-sectional view of a bolted steel reservoir, 5
1-5	Welded steel standpipe with decorative pilasters, 8
1-6	Cross-sectional view of a typical welded steel standpipe, 8
1-7	Bolted steel reservoir, 9
1-8	Cross-sectional view of a bolted steel standpipe, 9
1-9	Column- and rafter-supported cone roof tank, 11
1-10	Column- and rafter-supported roof with knuckle, 11
1-11	Self-supporting dome roof or umbrella roof, 12
1-12	Self-supporting ellipsoidal roof, 12
1-13	Double-ellipsoidal tank, 14
1-14	Cross-sectional view of double-ellipsoidal tank, 14
1-15	Medium-capacity welded elevated tank, 15
1-16	Cross-sectional view of medium-capacity, torus-bottom welded elevated tank, 16
1-17	Large-capacity elevated tank, 17
1-18	Cross-sectional view of large-capacity, multi-column elevated tank, 17
1-19	Spherical single-pedestal tanks give pleasant silhouette, 18
1-20	Cross-sectional view of small-capacity spherical single-pedestal tank, 19
1-21	Alternative single-pedestal tank design, 20
1-22	Large-capacity single-pedestal elevated tank, 20
1-23	Cross-sectional view of large-capacity single-pedestal elevated tank, 21
1-24	Folded-plate design of a modified single-pedestal tank support, 22
1-25	Cross-sectional view of modified single-pedestal tank, 22
2-1	Inward-opening shell manhole detail, 26
2-2	Outward-opening shell manhole detail, 27
2-3	Recessed inlet–outlet pipe bottom connection detail, 27
2-4	Nonrecessed inlet–outlet pipe bottom connection details, 28
2-5	Overflow air break with flap valve, 29
2-6	Exterior caged ladder details, 30
2-7	Safe-climbing rail for an outside ladder, 31

2-8	Roof guardrail details, 32
2-9	Roof manhole assembly details, 33
2-10	Double 90° elbow roof vent detail, 34
2-11	Pan deck vent detail, 34
2-12	Typical clog-resistant vent detail, 35
3-1	Schematic diagram of a battery, 38
3-2	Corrosion of steel in water, 39
3-3	Tank corrosion protection—vertically suspended anodes, 42
3-4	Tank corrosion protection—horizontally suspended anodes, 43
5-1	Typical daily flow at constant pumping rate, 54
5-2	Typical daily flow with variable-rate pumping, 55
5-3	Relative cost by type of steel tank for 500,000-gal (1.9-ML) tanks, 56
5-4	Relative cost by type of elevated steel tank, 57
6-1	Soil-testing operations, 62
6-2	Example of tank supported on granular berm foundation, 64
7-1	Tank foundation construction, 75
7-2	Typical welding operation in the field, 77
7-3	Reviewing a weld radiograph, 78
7-4	Newly erected elevated tank, 79
9-1	Experienced riggers evaluate hard-to-reach areas on tower tanks, 93
9-2	Active corrosion penetrated this $\frac{1}{4}$ -in. (6-mm) steel tank bottom in 9 years. Periodic inspections and washouts would have revealed and prevented this problem well in advance of failure, 95
9-3	Measuring shell thickness with ultrasonic equipment, 96
9-4	Washing out tanks allows easier inspection and keeps tanks sanitary, 97
9-5	Inspection of the degree of abrasive blast cleaning, 102
9-6	An abrasive blast-cleaning operation, 102
10-1	A frozen water tank, 106
10-2	Isothermal lines for lowest one-day mean temperatures and normal daily minimum 30°F (-1 °C) temperature line for January, United States and Southern Canada, 110
10-3	Double-seating, internal-closing drain valve, 112
10-4	Tank riser bubbler system, 115
10-5	Pumped circulation system for small riser pipes, 116
10-6	Tank-thawing operation, 118

Tables

1-1	Typical welded steel water-storage reservoir sizes, 6
1-2	Glass-coated, bolted steel reservoirs and standpipes (capacity in thousand gallons), 7
1-3	Typical welded steel water storage standpipe sizes, 10
1-4	Typical double-ellipsoidal steel elevated tank sizes, 15
1-5	Typical medium-capacity welded steel elevated tank sizes, 16
1-6	Typical large-capacity welded steel elevated tank sizes, 18
1-7	Typical small-capacity single-pedestal steel elevated tank sizes, 19
1-8	Typical large-capacity single-pedestal steel elevated tank sizes, 21
1-9	Typical modified single-pedestal steel elevated tank sizes, 23
3-1	Typical soil investigation requirements, 61
3-2	Tank site selection considerations, 65
10-1	Thousands of British thermal units (Btu) lost per hour from elevated steel tanks, 109