

Notice & Inspection Program for Anhydrous Ammonia Nurse Tanks

December 19, 2011

American Welding & Tank, LLC is working with the U.S. Department of Transportation to address concerns over possible pinhole weld defects in anhydrous ammonia nurse tanks manufactured by American Welding & Tank, LLC (AWT) between June 1, 2009 and September 30, 2010, and is issuing this important inspection program notice to address any and all concerns with respect to the integrity of AWT nurse tanks.

AWT asks that **all customers continue to observe the industry best practice of regular self-inspection of anhydrous ammonia nurse tanks and equipment**. This visual inspection is the only customer action required. Tank inspection guidelines are included for your reference. Because of the corrosive nature of anhydrous ammonia and the general wear on equipment, customers should regularly inspect tanks and related equipment for any sign of damage, wear, or leak, regardless of the tank age or manufacturer. Many local regulations require this type of inspection. Pinhole weld defects should be easily visible during such inspections.

American Welding & Tank is extending the nurse tank structural integrity warranty to 5 years for **all** tanks manufactured in 2009 and 2010. In accordance with the AWT extended warranty policy, AWT will repair weld issues at no cost to the customer. Warranty repairs will be completed at the AWT factory following all requirements of the National Board Inspection Code (NBIC), American National Standards Institute (ANSI) K61.1, and the American Society of Mechanical Engineers (ASME).

If you have any questions regarding this notice or would prefer that your tank inspection be conducted by an AWT representative or a certified cargo tank tester, please contact AWT at 800-445-6709 or email service@AWTank.com.

American Welding & Tank is not aware of any incidents of serious injury or property damage sustained through a pinhole leak of anhydrous ammonia involving one of the company's tanks. Additionally, the company is unaware of any instance in which pinhole leaks led to a rupture or larger release of anhydrous ammonia. Nevertheless, due to the nature of anhydrous ammonia, any leak should be taken seriously. Regular inspection is the best way to identify such issues.

Regular Inspection Guidelines for Anhydrous Ammonia Nurse Tanks

American Welding & Tank, LLC recommends that our customers continue to observe industry best practices by following this protocol to ensure leaks or other maintenance issues with the anhydrous ammonia nurse tanks are immediately detected and treated:

- Make sure tanks are properly secured at all times, including during transport.
- Inspect tanks routinely, before and after use, for signs of a leak or any other damage. Make sure to visually look along all weld seams, including around fittings and attachments and along the circumferential seam (round seam) and the longitudinal seams (long seam).
- If there is a pinhole weld leak, users will notice a bright red rust ring on the weld seam. If you notice a bright red rust ring at a weld seam, please follow the instructions below.
- If there is a leak, users may notice a foggy discharge. If you see a foggy discharge, please follow the instructions below.
- Anhydrous ammonia has a sharp, irritating, pungent odor that acts as a warning of potentially dangerous exposure. Leaks should be easily detected. If you notice this odor, please follow the instructions below.
- Because anhydrous ammonia is stored under pressure, ice often forms at or around the area of the leak. If you notice a small patch of ice on the outside of your tank, please follow the instructions below.
- **If you notice any of these indications of a leak, step away from the tank, follow any safety instructions established by your organization**, and contact your equipment supplier who will contact the manufacturer of the tank or equipment. You may also contact American Welding & Tank at 800-445-6709 if it is an AWT tank.
- Customers should not attempt to repair leaks themselves because weld repairs must be completed by an authorized repair facility. American Welding & Tank will repair weld issues at no cost to the customer for AWT tanks manufactured within the last three years, in accordance with our regular warranty policy, and within 5 years for tanks manufactured in 2009 and 2010.
- Also inspect the tank for signs of corrosion. Any area with corrosion should be thoroughly inspected to determine whether the corrosion is surface-corrosion only or a more severe condition. In the event of surface corrosion, the area should be cleaned and painted to avoid pitting. Corrosion other than surface-only is cause for a more in-depth inspection of the nurse tank that could include measurement of the tank thickness and other tests.
- Tanks should not have gouges or dents. A tank with a gouge or dent should be taken out of service until repairs can be completed by an authorized repair facility.
- Tanks designed and manufactured to store anhydrous ammonia are clearly labeled on the data plate as "Type NH3". Customers should not use tanks designed for other purposes to store anhydrous ammonia. Any customer doing so should immediately contact their equipment dealer to arrange for the appropriate tank.

Please contact American Welding & Tank with any questions at 800-445-6709 or service@AWTank.com.