

# NACE MR0103 Requirements

## Background

In April of 2003, NACE released a new material requirement standard called MR0103, entitled *"Materials Resistant to Sulfide Stress Cracking in Corrosive Petroleum Refining Environments"*. This document is now being adopted by the refining industry worldwide, in many cases in lieu of MR0175, which never was intended to be used for refining applications.

MR0103 is very similar to MR0175-2002 in many respects, but there are some differences. The major differences which affect Fisher products fall into these categories:

- Definition of Sour Environment
- Environmental Restrictions
- Welding of carbon steels
- Welding of alloy steels
- Requirements for duplex stainless steel base materials and welding
- Use of S17400 H1150D bolting

These categories are discussed in more detail below.

## Sour Environment Definitions in MR0103

MR0103 utilizes refinery-based definitions for what constitutes a sour environment. Those definitions are used to determine when the document should apply to equipment. The MR0103 definitions are different than those in MR0175. Refer to MR0103 paragraph 1.3.5 for more information.

In any event, the user is responsible for imposing the requirements of MR0103 when they are applicable, per MR0103 paragraph 1.3.6.

## Environmental Limits

Legacy versions of MR0175 (i.e., 2002 and older revisions) included environmental restrictions on some materials (maximum temperature, maximum H<sub>2</sub>S partial pressures, etc). When MR0175-2003 was released, environmental limits were imposed on nearly all corrosion-resistant alloys because of the expansion of the scope to cover chloride stress corrosion cracking. The imposition of environmental limits continued in the latest version of MR0175, which is a joint NACE/ISO document called NACE MR0175/ISO 15156.

MR0103 only deals with sulfide stress cracking, and does not impose environmental limits on any materials. Materials are either acceptable or not.

## Welding of Carbon Steels

Carbon steel base materials which are classified as P-No. 1 group 1 or 2 steels in the ASME Boiler and Pressure Vessel Code are acceptable per MR0103 without base metal hardness requirements. P-No. 1 groups 1 and 2 include WCC and LCC castings, SA105 forgings, SA516 Grade 70 plate, and the other common carbon steel pressure vessel materials.

On the other hand, MR0103 imposes welding controls on carbon steels that are more rigorous than those imposed by MR0175-2002. MR0103 requires that P-No. 1 carbon steels be welded per another NACE document called RP0472 *"Methods and Controls to Prevent In-Service Environmental Cracking of Carbon Steel Weldments in Corrosive Petroleum Refining Environments"*. RP0472 imposes controls that ensure both the weld deposit and heat affected zone (HAZ) in a weldment will be soft enough to resist sulfide stress cracking. The controls on weld deposits involve actual hardness testing of weld deposits in production. This hardness testing is waived if certain welding process/filler material combinations are employed. HAZ hardness may be controlled by either postweld heat treatment (PWHT) or by base material chemistry restrictions such as imposing a maximum carbon equivalent (CE).



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