

**Date of Issue:** April 2018

**Affected Publication:** API Specification 11E, *Specification for Pumping Units*, 19th Edition, November 2013

## ADDENDUM 1

*Page 2, the following normative reference shall be added:*

AWS D1.1/D1.1M:2015, *Structural Welding Code – Steel*

*Page 11, Section 5.4, the last two paragraphs shall be replaced with the following:*

Equation (2) shall be used to calculate the design loads for the following structural type walking beams:

- a) I Beam (metric equivalent)
- b) H Beam (metric equivalent)
- c) Wide Flange Beam (metric equivalent)
- d) S Beam (metric equivalent)

Walking beam construction using a single rolled section, the gross section of the rolled beam shall be used to determine the section modulus; however, holes or welds are not permissible on the tension flange in the critical zone (see Figure 1) for either rolled beams or fabricated beams.

Designs for welded walking beam construction and for the addition of built-up sections shall include changes in loading and to check stresses at all critical sections and to include the calculations for stress concentration. However, holes or welds are not permissible on the tension flange in the critical zone (see Figure 1).

The design of welded beams shall conform to AWS D1.1/D1.1M, Section 2.

*Page 12, Section 5.5 shall be replaced with the following:*

The maximum allowable stress,  $f_{cb}$ , for both the conventional rolled walking beam and unconventional construction or built-up sections, shall be determined from Table 1. For standard rolled beams, maximum allowable tensile/compressive stress in line 2 and line 4 shall be  $0.3S_y$ . For the unconventional construction and built-up sections, maximum allowable tensile/compressive stress in line 2 and line 4 shall be  $0.25 S_y$ .

For beams having cross sections symmetrical with the horizontal neutral axis, the critical stress is compression in the lower flange. The maximum value of this stress,  $f_{cb}$ , is the smaller of the values determined from lines 3 and 4 in Table 1.

*Page 12, a new Section 5.6 shall be inserted and the rest of Section 5 shall be renumbered:*

### **5.6 Welded Walking Beam Requirements**

Welding specification and qualifications shall conform to AWS D1.1/D1.1M, Section 4 for welded walking beams. The fabrication of welded walking beams shall conform to AWS D1.1/D1.1M, Section 5. The inspection of the welded walking beams shall conform to AWS D1.1/D1.1M, Section 6.

*Page 12, Table 1, the Values column for Line 2 shall be replaced with the following:*

$(0.25, 0.3) S_y$

*Page 12, Table 1, the Values column for Line 4 shall be replaced with the following:*

$(0.25, 0.3) S_y$

*Page 12, Table 1, the following shall be added to the Where list at the bottom of the table:*

$0.3 S_y$  is for a single rolled section

$0.25 S_y$  is for unconventional construction or built-up sections

It is advised that the equation for lateral torsional buckling only applies to I-shaped beams. If boxed or double webbed beams are used, other detailed analyses may be necessary.

*Page 94, Annex H, From Equation (8): In USC Units, the  $S_{ac}$  equivalent shall be replaced with the following:*

$S_{ac} = 129,100$  psi (see Figure 3)