

**ASME B30.30-2023**  
(Revision of ASME B30.30-2019)

# Ropes

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**Safety Standard for Cableways,  
Cranes, Derricks, Hoists, Hooks,  
Jacks, and Slings**

AN AMERICAN NATIONAL STANDARD



**The American Society of  
Mechanical Engineers**

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Two Park Avenue • New York, NY • 10016 USA

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# FOREWORD

This American National Standard, Safety Standard for Cableways, Cranes, Derricks, Hoists, Hooks, Jacks, and Slings, has been developed under the procedures accredited by the American National Standards Institute (ANSI). This Standard had its beginning in December 1916, when an eight-page “Code of Safety Standards for Cranes,” prepared by The American Society of Mechanical Engineers (ASME) Committee on the Protection of Industrial Workers, was presented at the annual meeting of ASME.

Meetings and discussions regarding safety on cranes, derricks, and hoists were held from 1920 to 1925 involving the ASME Safety Code Correlating Committee, the Association of Iron and Steel Electrical Engineers, the American Museum of Safety, the American Engineering Standards Committee (AESC) [later changed to American Standards Association (ASA), then to the United States of America Standards Institute (USASI), and finally to ANSI], Department of Labor — State of New Jersey, Department of Labor and Industry — State of Pennsylvania, and the Locomotive Crane Manufacturers Association. On June 11, 1925, the AESC approved the ASME Safety Code Correlating Committee’s recommendation and authorized the project with the U.S. Department of the Navy, Bureau of Yards and Docks, and ASME as sponsors.

In March 1926, invitations were issued to 50 organizations to appoint representatives to a Sectional Committee. The call for organization of this Sectional Committee was sent out October 2, 1926, and the Committee was organized on November 4, 1926, with 57 members representing 29 national organizations.

Commencing June 1, 1927, and using the eight-page Code published by ASME in 1916 as a basis, the Sectional Committee developed the “Safety Code for Cranes, Derricks, and Hoists.” The early drafts of this safety code included requirements for jacks, but due to inputs and comments on those drafts, the Sectional Committee decided in 1938 to make the requirements for jacks a separate code. In January 1943, ASA B30.2-1943 was published addressing a multitude of equipment types, and in August 1943, ASA B30.1-1943 was published addressing only jacks. Both documents were reaffirmed in 1952 and widely accepted as safety standards.

Due to changes in design, advancement in techniques, and general interest of labor and industry in safety, the Sectional Committee, under the joint sponsorship of ASME and the Bureau of Yards and Docks (now the Naval Facilities Engineering Command), was reorganized on January 31, 1962, with 39 members representing 27 national organizations. The new Committee changed the format of ASA B30.2-1943 so that the multitude of equipment types it addressed could be published in separate volumes that could completely cover the construction, installation, inspection, testing, maintenance, and operation of each type of equipment that was included in the scope of ASA B30.2. This format change resulted in B30.3, B30.5, B30.6, B30.11, and B30.16 being initially published as “Revisions” of B30.2, with the remainder of the B30 volumes being published as totally new volumes. ASA changed its name to USASI in 1966 and to ANSI in 1969, which resulted in B30 volumes from 1943 to 1968 being designated as ASA B30, USAS B30, or ANSI B30, depending on their date of publication. In 1982, the Committee was reorganized as an Accredited Organization Committee operating under procedures developed by ASME and accredited by ANSI.

This Standard presents a coordinated set of rules that may serve as a guide to government and other regulatory bodies and municipal authorities responsible for the guarding and inspection of the equipment falling within its scope. The suggestions leading to accident prevention are given both as mandatory and advisory provisions; compliance with both types may be required by employers of their employees. In case of practical difficulties, new developments, or unnecessary hardship, the administrative or regulatory authority may grant variances from the literal requirements or permit the use of other devices or methods, but only when it is clearly evident that an equivalent degree of protection is thereby secured. To secure uniform application and interpretation of this Standard, administrative or regulatory authorities are urged to consult the B30 Committee, in accordance with the format described on the Correspondence With the B30 Committee page, before rendering decisions on disputed points.

Safety codes and standards are intended to enhance public safety. Revisions result from committee consideration of factors such as technological advances, new data, and changing environmental and industry needs. Revisions do not imply that previous editions were inadequate.

The first edition of ASME B30.30, which was approved by the B30 Committee and ASME, was approved by ANSI and designated an American National Standard on January 29, 2019.

This edition adds new provisions for a qualified person to reflect current industry practice, adds definitions to support new diameter reduction criteria and clarifies and updates some definitions, revises the rope certificate, revises [Table 30-1.4.7-1](#), and adds a table for reduction in diameter indicating rope removal, as well as other updates.

This Volume of the Standard, which was approved by the B30 Standards Committee and by ASME, was approved by ANSI and designated as an American National Standard on October 18, 2023.

# ASME B30 COMMITTEE

## Safety Standard for Cableways, Cranes, Derricks, Hoists, Hooks, Jacks, and Slings

(The following is the roster of the committee at the time of approval of this Standard.)

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**T. W. Klein**, *Contributing Member*, WireCo WorldGroup

### **B30 INTEREST REVIEW GROUP**

**O. Akinboboye**, Ropetech Engineering Services, Ltd.  
**B. Dobbs**, LEEA  
**J. Edmundson**, Konecranes Nuclear Equipment & Services, LLC  
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(23)

**General.** ASME codes and standards are developed and maintained by committees with the intent to represent the consensus of concerned interests. Users of ASME codes and standards may correspond with the committees to propose revisions or cases, report errata, or request interpretations. Correspondence for this Standard should be sent to the staff secretary noted on the committee's web page, accessible at <https://go.asme.org/B30committee>.

**Revisions and Errata.** The committee processes revisions to this Standard on a continuous basis to incorporate changes that appear necessary or desirable as demonstrated by the experience gained from the application of the Standard. Approved revisions will be published in the next edition of the Standard.

In addition, the committee may post errata on the committee web page. Errata become effective on the date posted. Users can register on the committee web page to receive e-mail notifications of posted errata.

This Standard is always open for comment, and the committee welcomes proposals for revisions. Such proposals should be as specific as possible, citing the paragraph number, the proposed wording, and a detailed description of the reasons for the proposal, including any pertinent background information and supporting documentation.

**Cases.** The committee does not issue cases for this Standard.

**Interpretations.** Upon request, the committee will issue an interpretation of any requirement of this Standard. An interpretation can be issued only in response to a request submitted through the online Interpretation Submittal Form at <https://go.asme.org/InterpretationRequest>. Upon submitting the form, the inquirer will receive an automatic e-mail confirming receipt.

ASME does not act as a consultant for specific engineering problems or for the general application or understanding of the Standard requirements. If, based on the information submitted, it is the opinion of the committee that the inquirer should seek assistance, the request will be returned with the recommendation that such assistance be obtained. Inquirers can track the status of their requests at <https://go.asme.org/Interpretations>.

ASME procedures provide for reconsideration of any interpretation when or if additional information that might affect an interpretation is available. Further, persons aggrieved by an interpretation may appeal to the cognizant ASME committee or subcommittee. ASME does not "approve," "certify," "rate," or "endorse" any item, construction, proprietary device, or activity.

Interpretations are published in the ASME Interpretations Database at <https://go.asme.org/Interpretations> as they are issued.

**Committee Meetings.** The B30 Standards Committee regularly holds meetings that are open to the public. Persons wishing to attend any meeting should contact the secretary of the committee. Information on future committee meetings can be found on the committee web page at <https://go.asme.org/B30committee>.

## B30 STANDARD INTRODUCTION

### SECTION I: SCOPE

The ASME B30 Standard contains provisions that apply to the construction, installation, operation, inspection, testing, maintenance, and use of cranes and other lifting and material-movement-related equipment. For the convenience of the reader, the Standard has been divided into separate volumes. Each volume has been written under the direction of the ASME B30 Standards Committee and has successfully completed a consensus approval process under the general auspices of the American National Standards Institute (ANSI).

As of the date of issuance of this Volume, the B30 Standard comprises the following volumes:

- B30.1 Jacks, Industrial Rollers, Air Casters, and Hydraulic Gantries
- B30.2 Overhead and Gantry Cranes (Top Running Bridge, Single or Multiple Girder, Top Running Trolley Hoist)
- B30.3 Tower Cranes
- B30.4 Portal and Pedestal Cranes
- B30.5 Mobile and Locomotive Cranes
- B30.6 Derricks
- B30.7 Winches
- B30.8 Floating Cranes and Floating Derricks
- B30.9 Slings
- B30.10 Hooks
- B30.11 Monorails and Underhung Cranes (withdrawn 2018 — requirements found in latest revision of B30.17)
- B30.12 Handling Loads Suspended From Rotorcraft
- B30.13 Storage/Retrieval (S/R) Machines and Associated Equipment
- B30.14 Side Boom Tractors
- B30.15 Mobile Hydraulic Cranes (withdrawn 1982 — requirements found in latest revision of B30.5)
- B30.16 Overhead Underhung and Stationary Hoists
- B30.17 Cranes and Monorails (With Underhung Trolley or Bridge)
- B30.18 Stacker Cranes (Top or Under Running Bridge, Multiple Girder With Top or Under Running Trolley Hoist)
- B30.19 Cableways
- B30.20 Below-the-Hook Lifting Devices
- B30.21 Lever Hoists
- B30.22 Articulating Boom Cranes
- B30.23 Personnel Lifting Systems
- B30.24 Container Cranes
- B30.25 Scrap and Material Handlers
- B30.26 Rigging Hardware
- B30.27 Material Placement Systems
- B30.28 Balance Lifting Units
- B30.29 Self-Erecting Tower Cranes
- B30.30 Ropes
- B30.31 Self-Propelled, Towed, or Remote-Controlled Hydraulic Platform Transporters<sup>1</sup>
- B30.32 Unmanned Aircraft Systems (UAS) Used in Inspection, Testing, Maintenance, and Load-Handling Operations

### SECTION II: SCOPE EXCLUSIONS

Any exclusion of, or limitations applicable to, the equipment, requirements, recommendations, or operations contained in this Standard are established in the affected volume's scope.

### SECTION III: PURPOSE

The B30 Standard is intended to

(a) prevent or minimize injury to workers, and otherwise provide for the protection of life, limb, and property by prescribing safety requirements

(b) provide direction to manufacturers, owners, employers, users, and others concerned with, or responsible for, its application

(c) guide governments and other regulatory bodies in the development, promulgation, and enforcement of appropriate safety directives

### SECTION IV: USE BY REGULATORY AGENCIES

These volumes may be adopted in whole or in part for governmental or regulatory use. If adopted for governmental use, the references to other national codes and standards in the specific volumes may be changed to refer to the corresponding regulations of the governmental authorities.

<sup>1</sup>This volume is currently in the development process.

## SECTION V: EFFECTIVE DATE

(a) *Effective Date.* The effective date of this Volume of the B30 Standard shall be 1 yr after its date of issuance. The effective date of any Volume of the B30 Standard that adopts and references this Volume shall be in accordance with the effective-date provisions of that Volume.

(b) *Existing Installations.* Equipment manufactured and facilities constructed prior to the effective date of this Volume of the B30 Standard shall be subject to the inspection, testing, maintenance, and operation requirements of this Standard after the effective date.

It is not the intent of this Volume of the B30 Standard to require retrofitting of existing equipment. However, when an item is being modified, its performance requirements shall be reviewed relative to the requirements within the current volume. The need to meet the current requirements shall be evaluated by a qualified person selected by the owner (user). Recommended changes shall be made by the owner (user) within 1 yr.

## SECTION VI: REQUIREMENTS AND RECOMMENDATIONS

Requirements of this Standard are characterized by use of the word *shall*. Recommendations of this Standard are characterized by the word *should*.

## SECTION VII: USE OF MEASUREMENT UNITS

This Standard contains SI (metric) units as well as U.S. Customary units. The values stated in U.S. Customary units are to be regarded as the standard. The SI units are a direct (soft) conversion from the U.S. Customary units.

## SECTION VIII: ADDITIONAL GUIDANCE

The equipment covered by the B30 Standard is subject to hazards that cannot be abated by mechanical means, but only by the exercise of intelligence, care, and common

sense. It is therefore essential to have personnel involved in the use and operation of equipment who are competent, careful, physically and mentally qualified, and trained in the proper operation of the equipment and the handling of loads. Serious hazards include, but are not limited to, improper or inadequate maintenance, overloading, dropping or slipping of the load, obstructing the free passage of the load, and using equipment for a purpose for which it was not intended or designed.

The B30 Standards Committee fully realizes the importance of proper design factors, minimum or maximum dimensions, and other limiting criteria of wire rope or chain and their fastenings, sheaves, sprockets, drums, and similar equipment covered by the Standard, all of which are closely connected with safety. Sizes, strengths, and similar criteria are dependent on many different factors, often varying with the installation and uses. These factors depend on

- (a) the condition of the equipment or material
- (b) the loads
- (c) the acceleration or speed of the ropes, chains, sheaves, sprockets, or drums
- (d) the type of attachments
- (e) the number, size, and arrangement of sheaves or other parts
- (f) environmental conditions causing corrosion or wear
- (g) many variables that must be considered in each individual case

The requirements and recommendations provided in the volumes must be interpreted accordingly, and judgment used in determining their application.

# ASME B30.30-2023

## SUMMARY OF CHANGES

Following approval by the ASME B30 Committee and ASME, and after public review, ASME B30.30-2023 was approved by the American National Standards Institute on October 18, 2023.

ASME B30.30-2023 includes the following changes identified by a margin note, **(23)**.

<i>Page</i>	<i>Location</i>	<i>Change</i>
ix	Correspondence With the B30 Committee	Added
x	B30 Standard Introduction	Updated
1	Section 30-0.1	Revised
1	Section 30-0.2	(1) Definitions of <i>birdcage</i> , <i>denier</i> , <i>fleet angle</i> , <i>guy</i> , <i>high modulus polyethylene (HMPE)</i> , <i>low-torque (reduced-torque) wire rope</i> , <i>tenacity</i> , <i>tex</i> , and <i>yarn</i> revised (2) Definitions of <i>break-in</i> ; <i>crossover point</i> ; <i>diameter, measured, <math>d_m</math></i> ; <i>diameter, nominal, <math>d</math></i> ; <i>diameter, reference, <math>d_{ref}</math></i> ; <i>flange point</i> ; <i>intermediary</i> ; <i>nominal rope length</i> ; and <i>repetitive pickup point</i> added
2	Figure 30-0.2-1	Second image deleted
3	Figure 30-0.2-3	Locations of <i>d</i> and <i>D</i> added
5	Section 30-0.5	Updated
8	30-1.4.2	Subparagraph (b) added and subsequent subparagraphs redesignated
9	30-1.4.6	Subparagraph (c) deleted and subsequent subparagraphs redesignated
9	30-1.5.1	Subparagraph (i) added
10	Table 30-1.4.4-1	Rows B30.2 and B30.19 and General Note (c) revised
12	Table 30-1.4.7-1	Revised
13	30-1.5.5	(1) First paragraph and subpara. (d) revised (2) Subparagraphs (e) and (i) added and subsequent subparagraphs redesignated (3) Note deleted and Notes (1) and (2) added
14	30-1.7.4	(1) Subparagraphs (b)(1), (g), and (k) revised (2) Subparagraph (b)(8) revised and redesignated as (b)(2) and subsequent subparagraphs redesignated (3) Subparagraphs (k)(1) and (k)(2) added
16	30-1.8.2	Subparagraph (a) and Note following subpara. (a) revised
17	Table 30-1.8.2-1	Added and former Table 30-1.8.2-1 redesignated as Table 30-1.8.2-2
18	Figure 30-1.8.2-1	Added and former Figures 30-1.8.2-1 through 30-1.8.2-9 redesignated as Figures 30-1.8.2-2 through 30-1.8.2.10, respectively
19	Figure 30-1.8.2-4	In former Figure 30-1.8.2-3, second image deleted

<i>Page</i>	<i>Location</i>	<i>Change</i>
17	30-1.8.4	(1) Subparagraph (b) revised (2) Subparagraph (d) added
28	30-2.4.3	Revised
28	30-2.4.4	Former in-text table designated as Table 30-2.4.4-1
28	30-2.4.7	Revised
29	30-2.5.5	(1) First paragraph and subparas. (d) and (h) [formerly (g)] revised (2) Subparagraph (e) added and subsequent subparagraphs redesignated (3) Note deleted and Notes (1) and (2) added

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## Chapter 30-0

# Scope, Definitions, Personnel Competence, Translations, and References

### (23) SECTION 30-0.1: SCOPE OF ASME B30.30

Volume B30.30 includes provisions that apply to the construction, selection, installation, attachment, testing, inspection, maintenance, repair, use, and replacement of wire rope, hybrid rope, synthetic fiber rope, and rope-lifting components used in conjunction with equipment addressed in the volumes of the ASME B30 Standard. These provisions apply to a particular volume when ASME B30.30 is referenced and as specified in that volume.

### (23) SECTION 30-0.2: DEFINITIONS

*aramid fiber*: a manufactured, high modulus fiber made from a long-chain synthetic aromatic polyamide in which at least 85% of the amide linkages join two aromatic rings.

*birdcage*: a rope condition that results in deformation when the outer strands are displaced away from the rope axis. It is usually the result of shock loading or localized twisting in a rope (see [Figure 30-0.2-1](#)).

*braid*: a rope or textile structure formed by intertwining strands.

*double braid*: a rope constructed from an inner hollow braided rope (core) surrounded by another hollow braided rope (cover) (also known as braid-on-braid or two-in-one braid).

*single braid*: rope structure consisting of multiple strands that may be intertwined in a plain or twill pattern.

*break-in*: initial pull-down phase in a rope's service life just after installation when initial loading is applied and where individual components adjust and set in among one another at operating conditions.

*crossover point*: in multiple-layer spooling of rope on a drum, those points of rope contact where the rope crosses the preceding rope layer.

*crown break*: a wire break located on the outside of the rope that occurs above the strand-to-strand contact points with both ends visible (see [Figure 30-0.2-2](#)).

*D/d ratio*: the ratio of the pitch diameter of the sheave or drum,  $D$ , to the nominal rope diameter,  $d$  (see [Figure 30-0.2-3](#)).

*denier*: a mass-per-unit-length measure equal to the weight in grams of 9000 m of the material. Denier is a value in which the lower numbers represent the finer sizes and the higher numbers the coarser sizes.

*design factor*: the minimum breaking force of the rope in a rope system divided by the maximum static tension in the rope.

*diameter, measured,  $d_m$* : actual diameter derived from direct measurement.

*diameter, nominal,  $d$* : conventional diameter value by which a rope is named, designated, or ordered.

*diameter, reference,  $d_{ref}$* : measured diameter from a section of rope that has not been subjected to significant bending, wear, or other sources of cross-sectional deformation or degradation, taken after break-in.

*dogleg, minor*: a bend or deformation exhibiting no associated strand distortion and that cannot be observed while the rope is under tension.

*dogleg, severe*: a permanent, localized, irreparable bend or deformation in a wire rope that restricts the natural adjustment of the rope's components during operation due to strand distortion. It is caused by improper use or handling and results in an indeterminate loss of strength in the rope (see [Figure 30-0.2-4](#)).

*fiber core*: a wire rope center component consisting of man-made or natural (vegetable) materials whose purpose is to support the outer strands of the wire rope and is not included as one of the load-bearing components of the wire rope when calculating the minimum breaking force.

*flange point*: the point of contact between the rope and the drum flange where the rope changes layers.

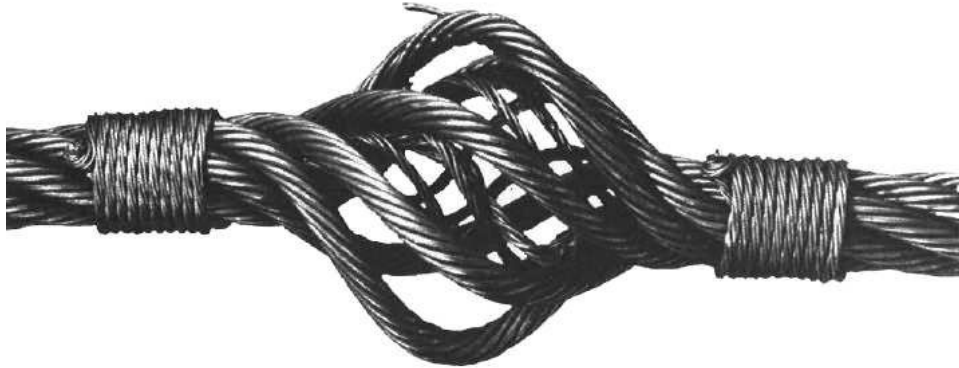
*fleet angle*: the angle between a rope's position on a drum or sheave and a line perpendicular to the axis of the drum or sheave through the center of the nearest fixed sheave (see [Figure 30-0.2-5](#)).

*groove corrugation*: a repetitive pattern in the groove of a sheave or drum caused by wear at the contact point with each rope strand that may cause rope wear and distortion.

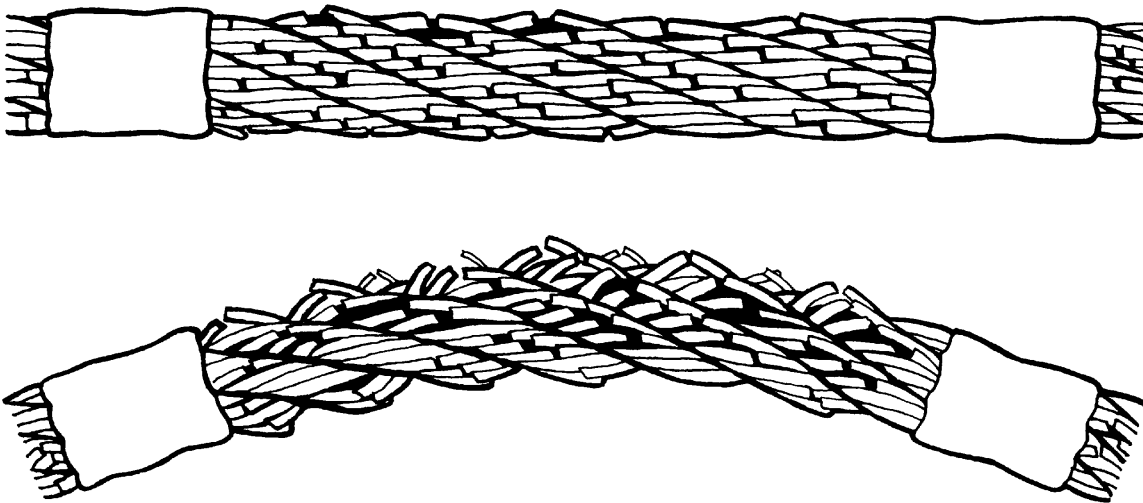


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**Figure 30-0.2-1  
Birdcage Example**

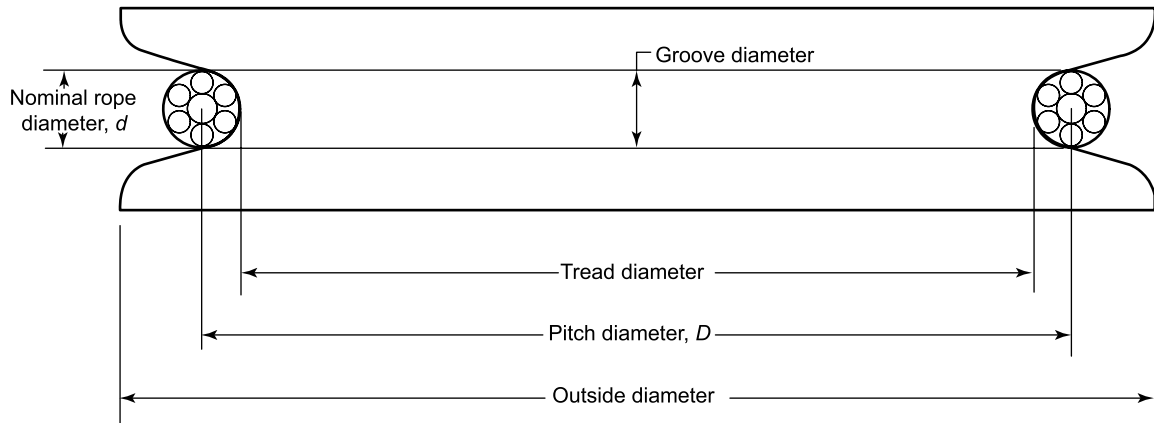


**Figure 30-0.2-2  
Crown Breaks**

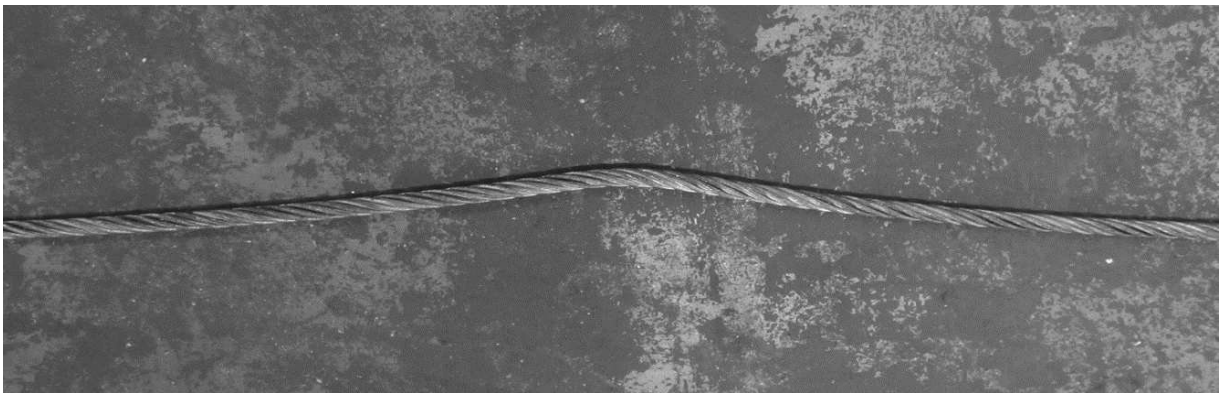


**Figure 30-0.2-3**  
***D/d* Ratio**

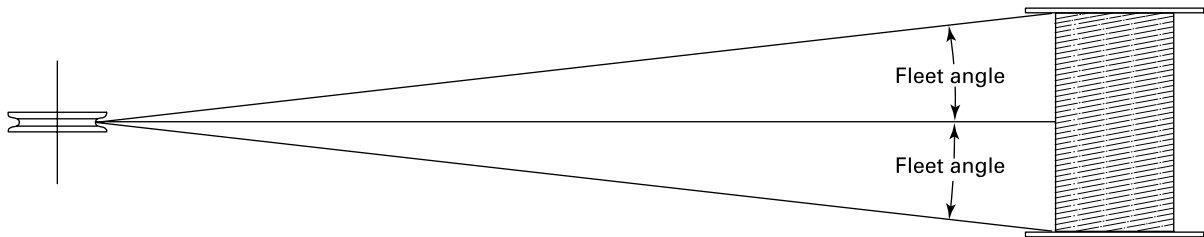
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**Figure 30-0.2-4**  
**Dogleg**



**Figure 30-0.2-5**  
**Fleet Angle**



*guy*: a fixed length of strand or rope for stabilizing or maintaining a structure in a fixed position, or for maintaining a constant distance between the two components connected by the rope.

*heavy rope service*: service that involves operating at 85% to 100% of rope rated load or in excess of ten lift cycles per hour as a regular specified procedure.

*high modulus polyethylene (HMPE)*: a polyolefin fiber produced by gel spinning or solid-state extrusion of an ultra-high-molecular-weight polyethylene (UHMWPE) feedstock to produce high tenacity. Also called *extended-chain polyethylene (ECPE)* or *high-performance polyethylene (HPPE)*.

*hours of rope operation*: the actual or estimated operating time of the rope.

*hybrid rope*: a wire rope consisting of both synthetic and steel components. The synthetic components are included as load-bearing components of the rope when calculating its minimum breaking force.

*independent wire rope core (IWRC)*: a wire rope used as the axial member of a larger wire rope.

*intermediary*: individual, organization, or company that is supplied with product by the original manufacturer which in turn supplies that product without further processing or alterations that would result in changes to the properties of that product as specified in the purchase order and the product's referenced standard under which it was manufactured.

*kink*: a deformation in a wire rope caused by a loop of rope being pulled tight. It represents irreparable damage and an indeterminate loss of strength in the rope.

*lang lay*: a lay type where the wires in the strand are laid in the same direction as the lay of the strands.

*lay length*: the length along a rope for a complete revolution of a single strand in laid, twisted, or braided rope.

*lead line*: the fastest moving section of a rope in a multipart reeving system that pays directly on and off of the drum and to the first sheave.

*linear density*: the mass-per-unit length of a fiber, yarn, or rope.

*liquid crystal polyester (LCP)*: a thermotropic liquid crystal aromatic polyester fiber produced by melt spinning. It is a high-performance multifilament yarn with high tenacity and modulus (also known as polyester-arylate).

*load-handling equipment (LHE)*: equipment used to move a load vertically or horizontally.

*low-torque (reduced-torque) wire rope*: single-layer-stranded wire rope designed to reduce load-induced torque without the use of contra-helically laid strand layers.

*minimum breaking force*: the minimum load at which a new and unused rope will break when loaded to destruction in direct tension.

*nominal rope length*: length by which a rope is ordered.

*nonoperating rope*: see *guy*.

*normal rope service*: service that involves operating at less than 85% rated load and not more than ten lift cycles per hour, except for isolated instances.

*nylon*: a manufactured fiber in which the fiber-forming substance (polyamide) is characterized by recurring amide groups (–NH–CO–) as an integral part of the polymer chain.

*para-aramid*: see *aramid fiber*.

*pendant*: see *guy*.

*polyester (PET)*: a manufactured fiber in which the fiber-forming substance (polyester) is characterized by a long-chain polymer having 85% by weight of an ester of a substituted aromatic carboxylic acid.

*preformed wire rope*: wire rope in which the strands are permanently formed during fabrication into the helical shape they will assume in the wire rope.

*qualified person*: a person who, by possession of a recognized degree or certificate of professional standing in an applicable field, or who, by extensive knowledge, training, and experience, has successfully demonstrated the ability to solve or resolve problems relating to the subject matter and work.

*rated load*: the maximum allowable force in the rope at the applicable design factor.

*regular lay*: a lay type where the wires in the strand are laid in the opposite direction to the lay of the strands.

*repetitive pickup point*: when operating on a short cycle operation, the rope being used on a single layer and being spooled repetitively over a short portion of the drum.

*rotation-resistant wire rope*: stranded wire rope consisting of at least two layers of strands where the outer layer of strands is laid opposite to the underlying layer. The design results in a reduction in load-induced torque.

*running rope*: a rope that travels around sheaves or drums (e.g., main, auxiliary, and boom hoist rope).

*severe rope service*: service that involves normal or heavy service with abnormal operating conditions (e.g., corrosive environment, extreme temperatures).

*shall*: a word indicating a requirement.

*should*: a word indicating a recommendation.

*special rope service*: service that involves operation, other than normal, heavy, or severe, that is identified by a qualified person.

*splice*: the joining of two ends of yarn, strand, or cordage by intertwining or inserting these ends into the body of the product. An eye splice may be formed by using a similar process to join one end into the body of the product.

*standard wire rope*: stranded wire rope, the design of which is not intended to reduce load-induced torque (also known as non-rotation-resistant wire rope).

*standing rope*: see *guy*.

*stay rope*: see *guy*.

*strand, fiber*: the largest individual element used in the final synthetic rope-making process and obtained by joining and twisting together several yarns or groups of yarns (see [Figure 30-0.2-6](#)).

*strand, wire*: an arrangement of wires laid helically about an axis or another wire or fiber center to produce a symmetrical cross section.

*strength member*: any fiber in a rope construction that supports a portion of the applied load during use.

*structural strand*: a single-strand wire product used in static applications as a structural support member.

*synthetic rope*: a rope made up of synthetic fibers, tapes, or films twisted or braided around an axis (see [Figure 30-0.2-6](#)).

*tenacity*: specific tensile strength of a textile material expressed as force-per-unit linear density (e.g., grams-force per denier or newtons per tex).

*tex*: a unit for expressing linear density, equal to the mass in grams of 1 km of yarn, filament, fiber, or other textile element.

*torque-neutral synthetic rope*: a rope with construction designed such that, without any externally applied twist distorting the structure, it does not exert torque while under tension.

*track cable*: see *guy*.

*valley break*: a wire break that occurs at or below the strand-to-strand contact points (see [Figure 30-0.2-7](#)).

*whipping*: wrapping small-diameter cord or twine around a synthetic fiber rope to prevent the rope from unlaying or unbraiding.

*wire*: a long, slender, pliable, steel component that is typically cylindrical in shape, drawn from rod, and used as smaller load-bearing components of a strand or wire rope.

*wire rope*: a rope made up of steel wire strands helically laid around an axis (see [Figure 30-0.2-8](#)).

*wire strand core (WSC)*: a wire strand used as the axial member of a wire rope.

*working end*: the nondrum end of the wire rope.

*yarn*: a generic term for a continuous collection of textile materials (filaments, fibers, tapes, etc.) suitable to form a structure via any one of a number of textile processes (e.g.,

twisting or braiding). Yarns are used, for example, as smaller load-bearing components of a synthetic strand or rope (see [Figure 30-0.2-6](#)).

### SECTION 30-0.3: PERSONNEL COMPETENCE

Persons performing the functions identified in this Volume shall, through education, training, experience, skill, and physical fitness, as necessary, be competent and capable to perform the functions as determined by the employer or employer's representative.

### SECTION 30-0.4: TRANSLATION OF SAFETY-RELATED INFORMATION

(a) Documentation shall be provided in English.

(1) The wording of written non-English safety information and manuals regarding use, inspection, and maintenance shall be translated into English by professional translation industry standards, which include, but are not limited to, the following:

(-a) translating the complete paragraph message, instead of word by word

(-b) ensuring grammatical accuracy

(-c) preserving the source document content without omitting or expanding the text

(-d) translating the terminology accurately

(-e) reflecting the level of sophistication of the original document

(2) The finished translation shall be verified for compliance with (1)(-a) through (1)(-e) by a qualified person having an understanding of the technical content of the subject matter.

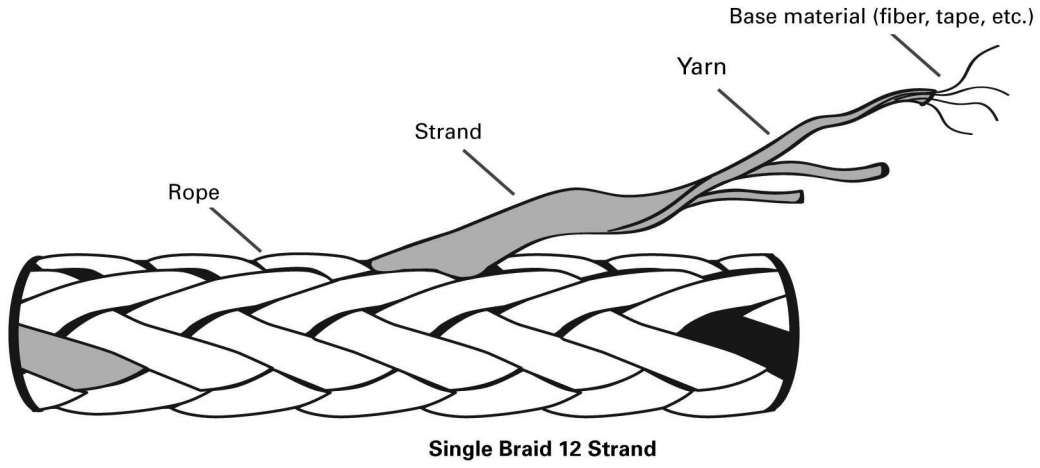
(b) Any non-English documentation provided in addition to the English documentation shall be translated and reviewed in accordance with the requirements listed in (a)(1) and (a)(2).

### SECTION 30-0.5: REFERENCES

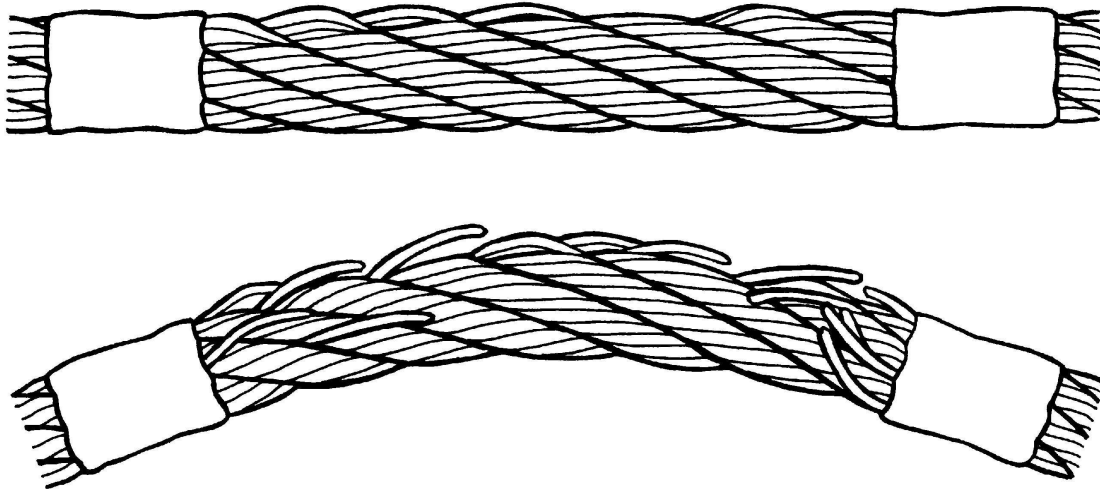
(23)

- ASME B30.26-2015. Rigging Hardware. The American Society of Mechanical Engineers.
- ASTM A931-08(2013). Standard Test Method for Tension Testing of Wire Ropes and Strand. American Society for Testing and Materials.
- ASTM A1023-15. Standard Specification for Stranded Carbon Steel Wire Ropes for General Purposes. American Society for Testing and Materials.
- CI-1500A (2015). Test Methods for Fiber Rope — Physical Properties. The Cordage Institute.
- CI-1500B (2015). Test Methods for Fiber Rope — Performance Properties. The Cordage Institute.
- CI-2001 (2004). Fiber Rope Inspection and Retirement Criteria. The Cordage Institute.
- EN 13411-3:2004+A1:2008. Terminations for steel wire ropes — Safety — Part 3: Ferrules and ferrule-securing. European Committee for Standardization.

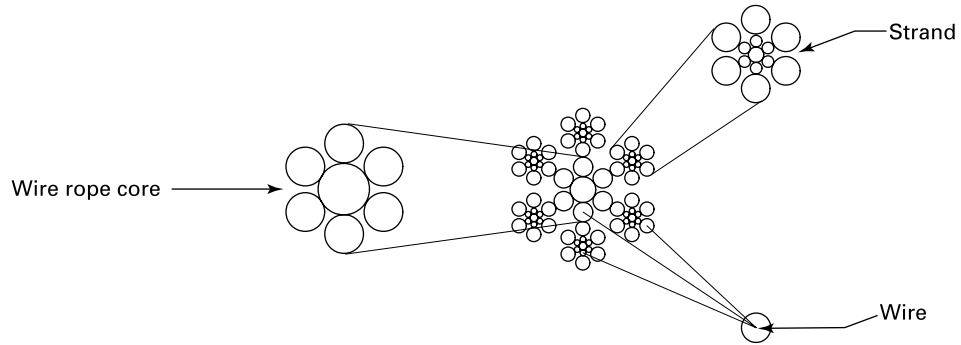
**Figure 30-0.2-6  
Synthetic Rope, Strand, and Yarn**



**Figure 30-0.2-7  
Valley Breaks**



**Figure 30-0.2-8  
Wire Rope**



EN 13411-4:2011. Terminations for steel wire ropes — Safety — Part 4: Metal and resin socketing. European Committee for Standardization.

EN 13411-5:2003+A1:2008. Terminations for steel wire ropes — Safety — Part 5: U-bolt wire rope grips. European Committee for Standardization.

EN 13411-6:2004+A1:2008. Terminations for steel wire ropes — Safety — Part 6: Asymmetric wedge socket. European Committee for Standardization.

EN 13411-8:2011. Terminations for steel wire ropes — Safety — Part 8: Swage terminals and swaging. European Committee for Standardization.

ISO 2307: 2010(E). Fiber Ropes — Determination of certain physical and mechanical properties. International Organization for Standardization.

ISO 2408:2004. Steel wire ropes for general purposes — Minimum requirements. International Organization for Standardization.

Wire Rope User's Manual (4th ed.) (2005). Wire Rope Technical Board.

# Chapter 30-1

## Steel Wire Rope

### SECTION 30-1.1: SCOPE

Chapter 30-1 includes provisions that apply to wire rope.

### SECTION 30-1.2: TRAINING

Users of wire rope shall be trained, as applicable, in the use, selection, inspection, installation, maintenance, attachment, replacement, and effects of environment as covered by this Chapter.

### SECTION 30-1.3: TYPES OF STEEL WIRE ROPE

#### 30-1.3.1 Standard Wire Rope

Standard wire rope is a wire rope that has one of the following:

- (a) a steel core rope, WSC, or IWRC that has the same direction of lay as the wire rope in which it is used
- (b) a non-load-bearing fiber core
- (c) no core
- (d) load-bearing synthetic fibers in the strands, the core, or both (also known as a hybrid rope)

NOTE: Low-torque rope is considered standard wire rope.

#### 30-1.3.2 Rotation-Resistant Wire Rope

Rotation-resistant wire rope is rope designed to generate reduced levels of torque and rotation when loaded and comprising an assembly of two or more layers of strands laid helically around a center, the direction of lay of the outer strands being opposite to that of the underlying layer. There are three categories of rotation-resistant rope. The applicable rotation resistance categories shall be identified by the rope manufacturer on the wire rope certificate as follows (see [para. 30-1.5.5](#)):

- (a) Category 1: a wire rope constructed in such a manner that it displays little or no tendency to rotate and has at least 15 outer strands.
- (b) Category 2: a wire rope constructed in such a manner that it has significant resistance to rotation and has at least ten outer strands.
- (c) Category 3: a wire rope constructed in such a manner that it has limited resistance to rotation and has no more than nine outer strands.

### SECTION 30-1.4: ROPE SELECTION, MINIMUM BREAKING FORCE, DESIGN FACTORS, AND OTHER REQUIREMENTS

#### 30-1.4.1 Selection

The wire rope shall be selected by the LHE manufacturer, the rope manufacturer, or a qualified person.

#### 30-1.4.2 Selection Limitations

(23)

(a) Wire rope with fiber core shall not be used for boom hoist or luffing attachment reeving.

NOTE: This does not preclude the use of hybrid rope.

(b) Wire rope with fiber core and hybrid rope shall not be used for cranes handling molten metal.

(c) Category 2 and 3 rotation-resistant rope shall not be used on single-layer drums unless approved by the LHE manufacturer or a qualified person.

(d) Rotation-resistant rope and fiber core rope shall not be used for the following:

- (1) boom support, boom hoist, or boom extension system rope, except as noted in (f)
- (2) boom support or boom hoist rope during erection, except as noted in (f)
- (3) standing rope that is used as live rope during erection

(e) Rotation-resistant wire rope shall not be used for hoisting on ASME B30.14 LHE.

(f) Rotation-resistant rope may be used as boom hoist reeving when load hoists are used as boom hoists for attachments, such as luffing attachments or boom and mast attachment systems. Under these conditions, the following requirements shall be met:

(1) The load hoist drum being used as a boom hoist shall have a first-layer rope pitch diameter of not less than 18 times the nominal diameter of the rope used.

(2) All sheaves used in the boom hoist reeving system shall have a rope pitch diameter of not less than 18 times the nominal diameter of the rope used.

(3) The design factor shall be the total minimum breaking force of all parts of rope in the system divided by the load imposed on the rope system when supporting the static weights of the structure and the crane rated load.

(4) The frequency of inspection of the wire rope shall be increased when using rotation-resistant rope in boom hoist or luffing attachment service.

### 30-1.4.3 Minimum Breaking Force

The actual breaking force shall meet or exceed the minimum breaking force values given in ASTM A1023 or ISO 2408 for the rope grade specified. For rope not covered under the above standards, the rope shall meet or exceed the minimum breaking force specified by the rope manufacturer as tested in compliance with ASTM A931. The minimum breaking force shall be shown on the wire rope certificate.

### 30-1.4.4 Wire Rope Design Factors

Wire rope design factors shall be, at a minimum, as shown in [Table 30-1.4.4-1](#).

### 30-1.4.5 Multiple Lead Lines

If a load is hoisted by more than one lead line, the tension in the lines should be equalized.

### (23) 30-1.4.6 Standing Rope (Pendants, Stay Rope, Guys, Nonoperating Rope, Track Cables, and Boom and Jib Support Rope)

(a) Standing rope shall be regular lay wire rope or structural strand.

(b) Only new and unused rope or structural strand shall be used to manufacture standing rope.

(c) Swaged fittings shall not be used on fiber core rope; this does not preclude the use of hybrid rope.

(d) Rotation-resistant rope shall not be used.

(e) Terminations, such as turnbuckles, shall have provisions to prevent loosening during usage.

(f) Standing rope connected in series shall be of the same lay direction.

(g) Structural strand shall not be used as a running rope during erection.

### 30-1.4.7 Minimum $D/d$ Ratios — Sheave and Drum

The minimum pitch diameter shall be determined by using the  $D/d$  ratios specified in [Table 30-1.4.7-1](#). If the  $D/d$  ratio is not specified, the minimum sheave and drum pitch diameter for any rope shall be specified by the LHE manufacturer or a qualified person.

NOTE: The life of wire rope is affected by the pitch diameters. Pitch diameters larger than the minimums determined by the  $D/d$  ratios listed in [Table 30-1.4.7-1](#) should achieve a longer service life.

## SECTION 30-1.5: INSTALLATION, TESTING, MAINTENANCE, REPLACEMENT, AND ROPE CERTIFICATION

### 30-1.5.1 Storage and Installation

(23)

(a) Rope should be stored to prevent damage or deterioration from moisture, chemicals, steam, corrosive agents, and other contaminants.

(b) Before installing wire rope, the documents that accompany the reel or the rope should be checked to ensure the rope being installed on the LHE is correct as specified in [para. 30-1.5.4](#).

(c) Unreeling or uncoiling of rope should be done with care as recommended by the rope manufacturer or qualified person to avoid kinking or inducing a twist.

(d) Prior to cutting a wire rope, seizing should be placed on each side of the point to be cut as recommended by the rope manufacturer. In the absence of manufacturer-specific recommendations, the following minimums should be observed. The length of each seizing should be equal to or exceed the nominal diameter of the wire rope. Seizing material may consist of wire, strand, tape, or other material capable of holding the wires and strands firmly in place during cutting and handling. The recommended number of seizings is as follows:

(1) on preformed wire rope, one seizing on each side of the point to be cut, approximately two rope diameters apart

(2) on rotation-resistant and other nonpreformed rope, three seizings on each side of the point to be cut, with each seizing approximately two rope diameters apart

(e) During installation, avoid dragging the rope in dirt or around objects that will scrape, nick, crush, or induce sharp bends.

(f) The wire rope should be wound onto the top of the drum from the top of the reel or onto the bottom of the drum from the bottom of the reel.

(g) After the rope is installed, but before starting normal operation, the rope should be cycled with increasing loads and speeds as specified by the LHE manufacturer, the rope manufacturer, or a qualified person.

(h) For rope subject to multilayer spooling, the rope should be installed under tension to prevent excessive distortion on the bottom layers and to promote proper spooling. Unless otherwise specified by the LHE manufacturer, the rope manufacturer, or a qualified person, tension should be 2.5% to 5% of the minimum breaking force.

(i) After break-in, the reference diameter shall be recorded in accordance with [para. 30-1.8.4\(d\)](#). For an existing installation, the reference diameter shall be recorded prior to or during the next periodic inspection.



**Table 30-1.4.4-1  
Wire Rope Design Factors**

(23)

ASME B30 Volume	Application	Usage	Rope Type	Minimum Design Factor
B30.2	Load hoist rope	Running	Rotation resistant	5.0
			Standard	5.0
			Standard	3.5
B30.3	Load hoist rope	Running	Rotation resistant	5.0
	Boom support rope	Running	Standard	3.5
	Boom support rope during erection	Running	Standard	3.0
	Standing rope	Standing	Standard	3.0
	Standing rope used as live rope during erection	Standing	Standard	3.0
B30.4	Load hoist rope	Running	Rotation resistant	5.0
			Standard	3.5
	Boom support rope	Running	Standard	3.5
		Standing	Standard	3.0
	Boom support rope during erection	Running	Standard	3.0
		Standing	Standard	3.0
	In/out haul or trolley	Running	Rotation resistant	5.0
			Standard	3.5
B30.5	Load hoist rope	Running	Rotation resistant	5.0
			Standard	3.5
	Boom support (hoist) rope	Running	Standard	3.5
		Standing	Standard	3.0
	Boom support (hoist) rope during erection	Running	Standard	3.0
		Standing	Standard	2.5
	Load hoist rope used as boom hoists for luffing attachments or boom and mast attachment systems	Running	Rotation resistant	5.0
Internal boom extend/retract rope	Running	Standard	3.5	
B30.6	Load hoist rope	Running	Rotation resistant	5.0
			Standard	3.5
	Boom support rope	Running	Standard	3.5
	Guy rope	Standing	Standard	3.0
B30.7	Load movement rope	Running	Rotation resistant	5.0
			Standard	3.5
B30.8	Load hoist rope	Running	Rotation resistant	5.0
			Standard	3.5
	Boom support rope	Running	Standard	3.0
		Standing	Standard	3.0
	Boom support rope during erection	Running	Standard	3.0
Standing		Standard	2.5	
B30.13	Load hoist rope	Running	Rotation resistant	5.0
		Running	Standard	5.0
B30.14	Load hoist rope	Running	Standard	4.0
	Load support rope	Standing	Standard	3.5
B30.16	Load hoist rope	Running	Standard	5.0
		Running	Rotation resistant	5.0
B30.18	Load hoist rope	Running	Standard	5.0

**Table 30-1.4.4-1  
Wire Rope Design Factors (Cont'd)**

ASME B30 Volume	Application	Usage	Rope Type	Minimum Design Factor
B30.19	Load hoist rope	Running	Rotation resistant	5.0
			Standard	3.5
	Nonoperating rope	Standing	Standard or strand	3.0
	Track cables	Standing	Standard or strand	3.0
	Nonoperating rope and track cables installed in contact with the earth or in water	Standing	Standard or strand	6.0
B30.20	In accordance with ASME BTH-1			
B30.21	Load hoist rope	Running	Standard	4.0
B30.22	Load hoist rope	Running	Rotation resistant	5.0
			Standard	3.5
	Internal boom extend/retract rope	Running	Standard	3.5
B30.23	One leg lifting system	Standing	Standard	7.0
	Two or more leg lifting system with only two legs considered under stress	Standing	Standard	5.0
B30.24	Load hoist rope	Running	Standard	5.0
	Boom hoist	Running	Standard	7.0
	Trolley hoist rope/catenary trolley rope	Running	Standard	5.0
B30.28	Load hoist rope	Running	Standard	5.0
B30.29	Load hoist rope	Running	Standard	5.0
	Jib suspension or erection rope	Running	Standard	3.5
	Standing rope	Standing	Standard	3.0
	Standing rope used as live rope during erection	Standing	Standard	3.0
	Telescoping rope used during mast erection	Running	Standard	3.5
Any	Load hoist rope handling molten metal	Running	Standard	8.0

## GENERAL NOTES:

- (a) Rope design factors are not applicable for volumes B30.10, B30.25, B30.26, and B30.27.
- (b) When rotation-resistant rope is used for load hoisting with an operating design factor less than 5, but in no case less than 3.5, the following special provisions shall apply:
- (1) For each such lifting assignment
    - (a) a designated person shall direct each lift
    - (b) a qualified person shall ascertain that the rope is in satisfactory condition (see [Sections 30-1.8](#) and [30-2.8](#)) both before and after lifting; more than one broken wire in any one lay shall be sufficient reason to consider not using the rope for such lifts
    - (c) operations shall be conducted in such a manner and at such speeds as to minimize dynamic effects
  - (2) Each lift under these provisions shall be recorded in the LHE inspection record, and such prior uses shall be considered before permitting another such lift.
  - (3) These provisions are not intended to permit duty cycle or repetitive lifts to be made with operating design factors less than 5.
- (c) If ASME B30.14 LHE operating conditions result in design factors for running ropes of less than 4.0, but not less than 2.5, the following requirements shall be met:
- (1) An inspection prior to and following the lift reveals no deficiencies of the rope, per [para. 30-1.8.1\(b\)](#).
  - (2) The maximum load capacity of the side boom tractor pipelayer is not exceeded.
  - (3) The load can be and is handled in such a manner and at such speeds as to minimize dynamic effects.
  - (4) The lift and inspections are made under controlled conditions and under the direction of a qualified person.
- (d) For ASME B30.17, refer to ASME B30.16 for wire rope design factors.

(23)

**Table 30-1.4.7-1**  
**Minimum  $D/d$  Ratios — Sheave and Drum**

ASME B30 Volume	Boom or Luffing Hoist		Load Hoist			In/Out Haul or Trolley or Catenary Trolley		Nonrunning/ Equalizer, Sheave	Extend/ Retract, Sheave
	Sheave	Drum	Sheave	Drum	Load Block, Sheave	Sheave	Drum		
B30.2	...	...	x	x	x	...	...	x	...
B30.3	18	16	18	16	18	16	14	x	...
B30.4	15	15	18	18	16	16	18	15	...
B30.5	15*	15*	18	18	16	...	...	x	x
B30.6	15	15	18	18	x	...	...	Guy rope: 6 Boom pendants: 7	...
B30.7	...	...	...	15	...	...	...	...	...
B30.8	15	15	18	18	16	...	...	x	...
B30.13	...	...	20	x	...	...	...	18	...
B30.14	10	10	10	10	10	...	...	...	...
B30.16	...	...	16 <sup>s</sup>	18 <sup>s</sup>	16 <sup>s</sup>	...	...	12 <sup>s</sup>	...
B30.18	...	...	x	x	x	...	...	x	...
B30.19	16	18	18	18	16	16	18	x	...
B30.20	In accordance with ASME BTH-1								
B30.21	...	...	x	x	x	...	...	...	...
B30.22	...	...	18	18	16	...	...	...	15
B30.24	18	15	18	15	18	18	15	...	...
B30.26	...	...	...	...	6	...	...	...	...
B30.28	...	...	x	x	...	...	...	...	...
B30.29	...	...	18	18	16	15	x	x	...

## GENERAL NOTES:

- (a) An "x" entry in a column indicates  $D/d$  ratios are not specified for the application or component.  
 (b) A "..." entry in a column indicates  $D/d$  ratios are not applicable for the specified application or component.  
 (c) For ASME B30.17, refer to ASME B30.16 for sheave and drum requirements. Drums and sheaves are not addressed in volume B30.10, B30.23, B30.25, or B30.27.  
 (d) An "\*" included with an entry indicates that if rotation-resistant wire rope is used in these applications, a minimum  $D/d$  ratio of 18 shall be used.  
 (e) An "<sup>s</sup>" included with an entry indicates the  $D/d$  ratio is a should recommendation and not a shall requirement.

**30-1.5.2 Testing**

(a) LHE load testing shall be in accordance with the applicable ASME B30 volume.

(b) Load testing of rope end terminations shall be in accordance with [para. 30-1.7.4](#).

**30-1.5.3 Maintenance**

(a) Wire rope should be maintained in a well-lubricated condition in order to reduce internal friction and prevent corrosion. It is important that lubricant applied as part of a maintenance program be compatible with the original rope manufacturer-specified lubricant. The LHE manufacturer, the rope manufacturer, or a qualified person should be consulted before using alternative lubricants. Ensure sections of rope that are normally

hidden (e.g., rope located over equalizer sheaves) are properly lubricated.

(b) When operating conditions will cause localized wear areas on a running rope, and if reducing the rope length is allowable, a section may be cut off the drum end to reposition and distribute these areas throughout the remaining length.

(c) To prevent a crown break from causing additional damage to other components, where both ends are visible, it is acceptable to remove both ends of the broken wire. Removal may be accomplished by grasping the protruding ends and bending them back and forth until they break between the strands. This action and location shall be documented and counted as one crown break (not a valley break) for future inspections. This action is not considered a repair.

(d) No attempt shall be made to lengthen or repair a wire rope.

### 30-1.5.4 Replacement Rope

(a) Any deviation from the original size, grade, type, or construction shall be specified by the LHE manufacturer, the rope manufacturer, or a qualified person and shall comply with [Section 30-1.4](#).

(b) Metric-size wire rope shall not be substituted for inch-size wire rope and vice versa without the approval of the LHE manufacturer, the wire rope manufacturer, or a qualified person.

### (23) 30-1.5.5 Wire Rope Certificate

A wire rope certificate containing the information listed below shall be provided by the manufacturer of the rope to the original purchaser. Intermediaries shall provide an unaltered copy of the manufacturer's certificate with all ropes distributed by that intermediary. All rope certificates should be made available to the LHE operator.

- (a) certificate number
- (b) name and address of original purchaser of wire rope
- (c) date supplied from rope manufacturer
- (d) name of the rope manufacturer
- (e) address of manufacturing facility [see [Note \(1\)](#)]
- (f) number traceable to rope manufacturer's production run
- (g) standard under which wire rope was manufactured (e.g., ASTM, ISO, EN)
- (h) nominal rope diameter
- (i) nominal rope length [see [Note \(2\)](#)]
- (j) rope classification (e.g., 6X19, 6X37, 19X19, 35X7)
- (k) ASTM A1023 rotation resistance Category 1, 2, or 3 (if applicable)
- (l) swivel prohibited or allowed (see [para. 30-1.7.1](#))
- (m) wire finish (e.g., bright, galvanized)
- (n) rope grade (e.g., IPS, EEIP, 1770, 2160)
- (o) rope core (e.g., IWRC, fiber core)
- (p) lay direction and lay type (e.g., RRL, RLL, LAL, sZ, zZ)
- (q) minimum breaking force (e.g., short tons, pounds, kilonewtons)
- (r) approximate weight per foot or meter

#### NOTES:

- (1) Complete address including country.
- (2) If the nominal rope length being delivered to the LHE owner through an intermediary differs from that shown on the original manufacturer's certificate, or additional information is negotiated between the purchaser and the intermediary, the intermediary shall provide a secondary certificate of conformance traceable to the original manufacturer's certificate, stating that information.

## SECTION 30-1.6: ENVIRONMENTAL CONDITIONS

### 30-1.6.1 Temperature

(a) Wire rope exposed to ambient temperatures in excess of 180°F (82°C) shall have an IWRC, WSC, or other temperature-resistant core.

(b) Wire rope shall not be used in environmental conditions where temperature and prolonged exposure cause the rope temperature to exceed 400°F (204°C) or be less than -40°F (-40°C), unless approved by the LHE manufacturer, the wire rope manufacturer, or a qualified person.

(c) Common types of wire rope lubricants may be adversely affected by temperature extremes. For temperatures greater than 160°F (71°C) or less than -20°F (-29°C), the LHE manufacturer, the rope manufacturer, or a qualified person should be consulted for recommended lubricants for these conditions.

### 30-1.6.2 Chemically Active Environments

The strength of wire rope and wire rope fittings may be degraded by chemically active environments. This includes exposure to chemicals in the form of solids, liquids, gases, vapors, or fumes. The LHE, wire rope, or fitting manufacturer or a qualified person should be consulted before operating in chemically active environments.

## SECTION 30-1.7: ROPE-LIFTING COMPONENTS

### 30-1.7.1 Swivels

Active in-line swivels may be used on Category 1 rotation-resistant rope. Swivels shall not be used with Category 2 or Category 3 rotation-resistant rope or standard rope without the approval of the LHE manufacturer, the rope manufacturer, or a qualified person.

### 30-1.7.2 Sheaves

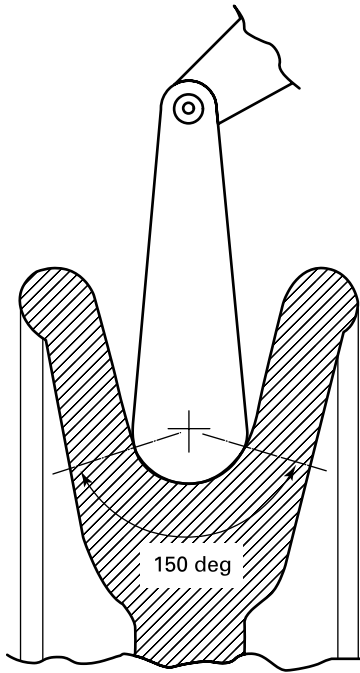
(a) Sheave grooves shall be smooth and free from surface defects that could cause rope damage. The cross-sectional radius at the bottom of the groove should be such as to form a close-fitting saddle for the size of rope used.

(b) The sides of the groove shall be tapered outward and rounded at the rim to facilitate entrance of the rope into the groove. Flange rims shall run true about the axis of rotation.

(c) Groove diameters of new sheaves should be 6% to 10% larger than the nominal rope diameter.

(d) Groove diameters of worn sheaves should not be less than the nominal rope diameter plus 2.5%. Sheaves with grooves worn smaller than the minimum should be replaced or reconditioned.

**Figure 30-1.7.2-1**  
**Arc of Contact**



(e) The arc of contact of a sheave groove should support the rope between 120 deg and 150 deg (see Figure 30-1.7.2-1).

(f) Sheaves carrying rope that can be momentarily unloaded shall be provided with close-fitting guards, or other devices, to guide the rope back into the groove when the load is reapplied.

(g) Sheaves in the lower load blocks of machines shall be equipped with close-fitting guards, or other devices, that will minimize the possibility of rope becoming fouled.

(h) Recommended maximum fleet angle is 2.5 deg.

### 30-1.7.3 Drums

(a) The drum surface shall be free from surface defects that could cause rope damage. When rope drums are grooved, the radius at the bottom of the groove should be such as to form a close-fitting saddle for the size of rope used.

(b) Grooves of new drums should be 6% to 10% larger than the nominal rope diameter.

(c) Drum flanges shall extend a minimum of one-half rope diameter but not less than 0.5 in. (13 mm) above the top layer of rope during operation.

(d) Utilizing a full base layer on a smooth drum may solve multilayer spooling problems because the base layer guides the upper layers of rope.

(e) The pitch of the drum grooves (center-to-center distance between grooves) shall allow adequate room for maximum rope diameter, plus rope ovalization, and maximum fleet angle.

(f) When the LHE is provided by the manufacturer with a smooth drum or a single-layer grooved drum, recommended rope lays are as follows (also, see Figure 30-1.7.3-1):

(1) left-handed drum: right lay rope

(2) right-handed drum: left lay rope

(g) The minimum number of dead wraps of wire rope during normal operation shall be two at each drum termination, unless otherwise specified by the applicable volume or by the LHE manufacturer, the rope manufacturer, or a qualified person.

(h) The recommended fleet angle is as follows:

(1) smooth drum: 0.5 deg minimum, 1.5 deg maximum

(2) grooved drum: 0.5 deg minimum, 2.0 deg maximum

### 30-1.7.4 Rope End Terminations

(23)

(a) The connection method and rating efficiency of the drum end termination of the wire rope shall be as specified by the LHE manufacturer, the rope manufacturer, or a qualified person.

(b) When selecting or changing to a new termination, consideration should be given to the effects of the environment, shock loads, load cycle fatigue, physical abuse and wear, and improper alignment. For guidance concerning end terminations, refer to EN 13411-3 through EN 13411-6 and EN 13411-8, or ASME B30.26. The rating efficiency and integrity of the end termination can be affected by the rope diameter, rope construction, the rope's minimum breaking force, the rope core type, and the type and efficiency of the termination. The end termination at the working end of the wire rope shall be applied as specified and according to the procedures of the LHE manufacturer, the fitting manufacturer, or a qualified person. Wire rope end terminations for use on the working end include, but are not limited to, the following:

(1) forged-base wire rope clips (selection, use, and maintenance shall comply with ASME B30.26)

(2) wedge socket (selection, use, and maintenance shall comply with ASME B30.26)

(3) mechanical splice Flemish eye or loop-back swaged eye

(4) poured socket

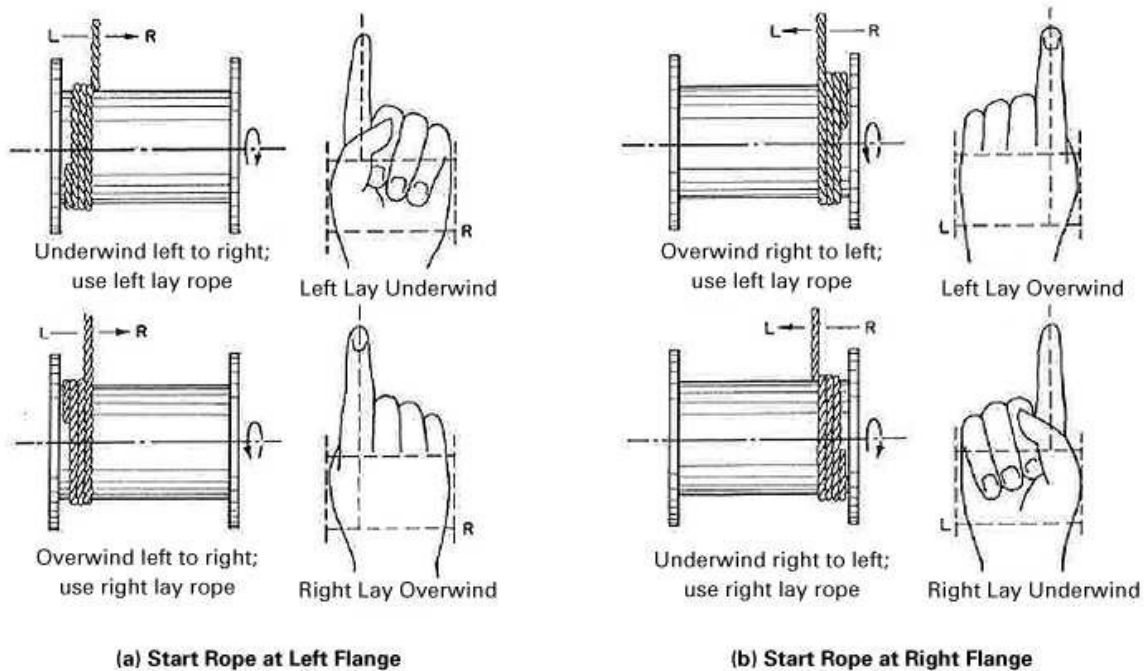
(5) poured button

(6) swaged socket

(7) swaged button

(8) threaded compression fitting

**Figure 30-1.7.3-1**  
**Recommended Rope Lays for a Smooth Drum or a Single-Layer Grooved Drum**



(c) Selection of end terminations should be made after consideration for the mating attachment dimensions, required termination efficiency, and environmental conditions.

(d) A hand-tucked eye shall not serve as the end termination for the working end of a wire rope.

(e) If a poured socket is used, the external and/or internal plastic covering of a plastic-coated core and/or a plastic-filled valley wire rope shall be removed in the end termination contact area to ensure positive adhesion of the socketing material to all wires of the rope.

(f) Lubrication removed during the process of adding an end termination shall be replaced in the affected areas of rope.

(g) Swaged sockets shall not be applied to fiber core rope, lang lay rope, or Category 3 rotation-resistant rope, unless approved by a qualified person.

(h) When an end fitting is to be applied to a used rope, a periodic inspection shall be performed on a length of 60 rope diameters from the rope end to be terminated. This length of rope shall have a diameter equal to or greater than the rope's specified nominal diameter.

(i) When selecting terminations for corrosion-resistant wire rope, consideration should be made for accelerated corrosion rates in some combinations of dissimilar metals.

(j) End terminations shall not be modified without the approval of the fitting manufacturer or LHE manufacturer.

(k) Proof test requirements for new and replacement swaged or poured terminations are as follows:

(1) Swaged or poured terminations installed on standing and running ropes in a wire rope assembly fabrication facility shall be proof loaded to at least 40%, but not greater than 50%, of the minimum breaking force of the wire rope or structural strand.

(2) Swaged or poured terminations installed on running ropes in the field shall be proof loaded to a minimum of 95% of the LHE's maximum rated line pull.

(l) The inspection of end terminations shall be performed in accordance with Section 30-1.8. For wedge socket inspection, refer to ASME B30.26 for removal criteria.

## SECTION 30-1.8: ROPE INSPECTION AND REMOVAL CRITERIA, AND RECORDS

### 30-1.8.1 Inspection

(a) *General.* All inspections shall be performed by a designated person. Any deficiencies identified shall be examined and a determination made by a qualified person as to whether they constitute a hazard and, if so, what steps need to be taken to address the hazard.



*(b) Frequent*

(1) Running rope in service shall be visually inspected daily, unless a qualified person determines it should be performed more frequently. The visual inspection shall consist of observation of all rope that can reasonably be expected to be in use during the day's operations. The inspector should focus on discovering gross damage that may be an immediate hazard.

(2) Specific types of damage include the following:

- (-a) distortion to the uniform structure of the rope
- (-b) broken wires
- (-c) corrosion
- (-d) gross damage or deterioration of the end connection(s)

(-e) evidence of heat, electrical, or lightning damage

(-f) localized change in lubrication condition

(3) When damage is discovered, a qualified person shall inspect the affected section(s) to determine if the rope needs to be removed from service using criteria defined in [para. 30-1.8.2](#).

*(c) Periodic*

(1) The inspection frequency shall be based on such factors as rope life on the particular installation or similar installations, severity of environment, percentage of capacity lifts, frequency rates of operation, and exposure to shock loads. Inspections need not be at equal calendar intervals and should be more frequent as the rope approaches the end of its useful life. Close visual inspection of the entire rope length shall be made to evaluate inspection and removal criteria.

NOTE: Use of nondestructive rope testing should be considered as an additional inspection method.

Periodic inspections shall cover the surface of the entire rope length and focus on uncovering the types of damage listed in [\(b\)](#). No attempt should be made to open the rope. Additionally, sections prone to rapid deterioration, such as the following, require special attention:

(-a) repetitive wear sections, such as the following:

- (-1) flange step-up, crossover, and repetitive pickup points on the drum
- (-2) reverse bends in the reeving system
- (-3) equalizer sheaves
- (-4) end connections
- (-5) sheave/drum groove wear or corrugation

NOTE: If the corrugation pattern is minor and rope performance is acceptable, the wire rope, sheave, or drum may not have to be replaced. However, if the wire rope is developing broken wires or showing signs of distortion, such as waviness, in areas that contact corrugated grooves, then the affected parts should be replaced or remachined.

(-b) known wear areas based on previous experience with the machine being inspected

(-c) locations where rope vibrations are damped, such as the following:

(-1) sections in contact with equalizer sheaves or other sheaves where rope travel is limited

(-2) sections of the rope at or near end connections where corroded or broken wires may protrude

(-3) rope in the bridle reeving in boom hoists

(-4) repetitive pickup points and crossover and change of layer points at flanges on drums

(-5) fleeting or deflector sheaves

(2) Unless otherwise specified by the LHE manufacturer, the rope manufacturer, or a qualified person, the periodic inspection shall be performed at intervals according to the rope service descriptions below.

*(-a) Boom Hoist Rope*

(-1) normal rope service: not to exceed 3 months or 500 hr of rope operation, whichever comes first

(-2) heavy rope service: not to exceed 2 months or 335 hr of rope operation, whichever comes first

(-3) severe rope service: not to exceed 1 month or 165 hr of rope operation, whichever comes first

(-4) special rope service: less than 165 hr of rope operation

*(-b) All Other Rope*

(-1) normal rope service: not to exceed 12 months or 2,000 hr of rope operation, whichever comes first

(-2) heavy rope service: not to exceed 6 months or 1,000 hr of rope operation, whichever comes first

(-3) severe rope service: not to exceed 3 months or 500 hr of rope operation, whichever comes first

(-4) special rope service: less than 500 hr of rope operation

Certain types of rope and applications require special attention and may require reduced time intervals between periodic inspections. Examples include rotation-resistant rope (due to its unique construction and susceptibility to damage and increased deterioration when it is used under difficult conditions, such as duty cycle operations), rope operating in chemically active environments, rope other than Category 1 rotation-resistant rope operating with active in-line swivels, and rope operating over synthetic sheaves with single-layer drums [see General Note in [Table 30-1.8.2-1](#)].

(d) *Inspections After Unusual Occurrences.* After an unusual occurrence, such as a lightning strike, abnormal shock load, or overload on a wire rope, the wire rope shall be inspected in accordance with [\(c\)](#) or as determined by a qualified person.

**30-1.8.2 Inspection and Removal Criteria**

(23)

There are no precise rules to determine the exact time for the removal of the rope, since many factors are involved. Once a rope reaches any one of the removal criteria, it shall be replaced before the LHE is returned to service. Specific inspection attributes and removal criteria are as follows:

(23) **Table 30-1.8.2-1**  
**Reduction in Diameter Indicating Rope Removal**

Rope Classification	% Reduction Below $d_{ref}$ as Percentage of $d$
<b>Standard rope with FC</b>	
All	>6.5 below $d_{ref}$
<b>Standard rope with IWRC</b>	
≤6 strands, 19 class	>5.0 below $d_{ref}$
≤6 strands, 36 class	>4.0 below $d_{ref}$
>6 strands, 19 class	>3.5 below $d_{ref}$
>6 strands, 36 class	>2.5 below $d_{ref}$
<b>Rotation-resistant rope</b>	
All	>3.5 below $d_{ref}$

GENERAL NOTE:  $\frac{d_{ref} - d_m}{d} \times 100 = \% \text{ reduction}$

(a) Measure the rope diameter in numerous locations to assess loss of diameter along the entire length of rope. Removal criteria include a reduction in diameter that is greater than those values given in Table 30-1.8.2-1 at any location. The calculation to determine the reduction in diameter is included with the table.

NOTE: Loss of diameter in rotation-resistant rope could indicate core failure (see Figure 30-1.8.2-1), and a qualified person shall immediately inspect the affected section or sections to determine if the rope needs to be removed from service. This condition will likely be characterized by lengthening of lay and diameter reduction in localized areas.

(b) *Distortion of Rope Structure.* Distortions of rope structure include kinking, severe doglegs, birdcaging, and crushing (see Figures 30-1.8.2-2 through 30-1.8.2-5).

Removal criteria include steel core protrusion between the outer strands, kinking, severe doglegs (minor doglegs should be noted in inspection documents), and changes in original geometry due to crushing where the minimum dimension across the distorted section is less than or equal to  $\frac{5}{6}$  of the nominal diameter.

(c) *Corrosion.* Removal criteria include widespread or localized external corrosion as evidenced by pitting and obvious signs of internal corrosion, such as magnetic debris coming from valleys (see Figure 30-1.8.2-6).

NOTE: In the early stages, corrosion causes a discoloration of the wires, and, though at this time it does not account for the loss of very much metal, it does detract from the rope’s ability to resist abrasion. As corrosion advances, wires become deeply pitted, and their strength is appreciably reduced, abrasion resistance is lowered, and the rope loses much of its flexibility and elasticity.

(d) *Waviness (Corkscrew Effect) of Rope.* Removal criteria include when the overall envelope diameter [see  $d_1$  in Figure 30-1.8.2-7, illustration (c)] has increased to a value greater than 110% of nominal rope diameter,  $d$ .

(e) *Heat Damage.* Removal criteria include any apparent damage from a heat source, such as welding, powerline strikes, or lightning (see Figure 30-1.8.2-8).

(f) *High or Low Strand.* Removal criteria include a high or low strand that is higher or lower than half of the strand diameter above or below the surface of the rope (see Figure 30-1.8.2-9).

(g) *End Terminations.* Removal criteria include severely corroded, cracked, deformed, worn, grossly damaged, or improperly installed end terminations (see Figure 30-1.8.2-10).

(h) *Visible Broken Wires.* For removal criteria, see Table 30-1.8.2-2.

**30-1.8.3 Rope Not in Regular Use**

(a) Wire rope that has been idle for a period of 1 month to 6 months due to shutdown or storage of the machine shall be inspected in accordance with para. 30-1.8.1(b).

(b) Wire rope that has been idle for a period of over 6 months due to shutdown or storage of the machine shall be inspected in accordance with para. 30-1.8.1(c).

**30-1.8.4 Records**

(23)

(a) *Frequent Inspections.* No records are required.

(b) *Periodic Inspections.* To establish a basis for judging the proper time for replacement, a dated report of rope condition at the latest periodic inspection shall be kept on file. This report shall cover points of deterioration listed in para. 30-1.8.2, including the measured diameter of the rope. If the rope is replaced, only the fact that the rope was replaced needs to be recorded.

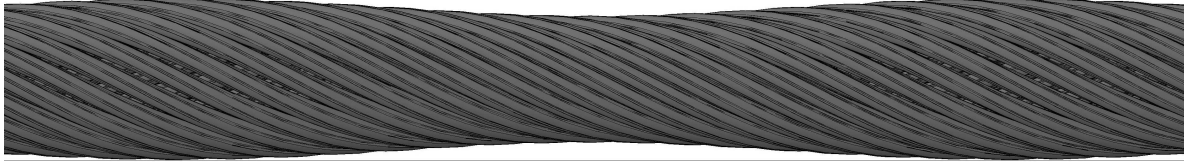
(c) *Long-Term Inspection Program.* A long-term inspection program should be established and should include records on the examination of rope removed from service so that a relationship can be established between visual observation and actual condition of the internal structure.

(d) *Reference Diameter.* The reference diameter for the installed rope shall be retained. The record of reference diameter shall be recorded on the rope certificate, periodic inspection report, or other suitable document available to the inspector.



(23)

**Figure 30-1.8.2-1  
Core Deterioration**



GENERAL NOTE: Category 1 wire rope diameter loss due to core failure.

**Figure 30-1.8.2-2  
Distortion of Rope Structure — Kink**

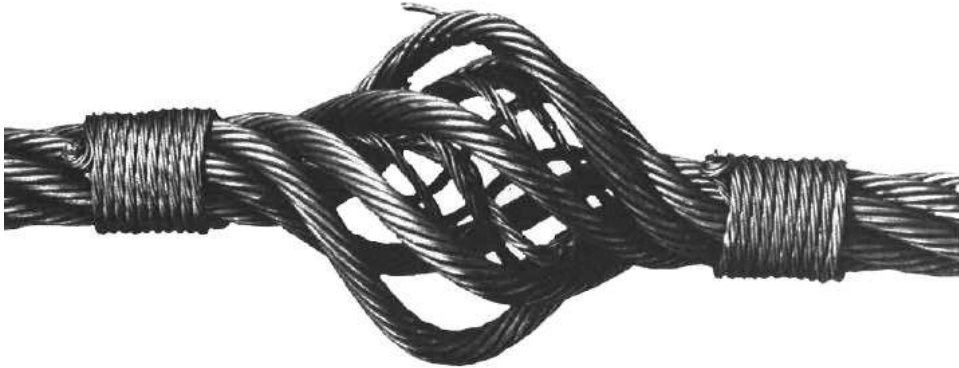


**Figure 30-1.8.2-3  
Distortion of Rope Structure — Dogleg**



(23)

**Figure 30-1.8.2-4  
Distortion of Rope Structure — Birdcaging Example**



**Figure 30-1.8.2-5  
Distortion of Rope Structure — Crushing**



**Figure 30-1.8.2-6**  
**Corrosion**



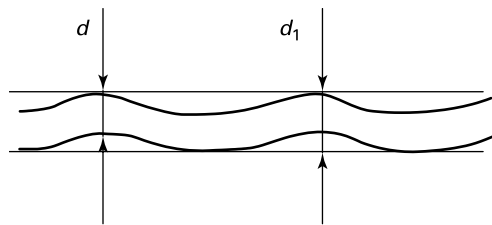
**Figure 30-1.8.2-7**  
**Waviness**



(a)



(b)



(c)

**Figure 30-1.8.2-8  
Heat Damage**



**Figure 30-1.8.2-9  
High or Low Strand**



**Figure 30-1.8.2-10**  
**Damaged End Terminations**



**Table 30-1.8.2-2  
Broken Wire Criteria Indicating Rope Removal**

Rope Type	Number of Visible Broken Wires Requiring Removal of Rope				
	Over Length of 6 × Nominal Rope Diameter		Over Length of 30 × Nominal Rope Diameter		
	Within a Single Strand	Across All Strands	Across All Strands	Of the Valley Break Type [Note (1)]	At End Termination [Note (2)]
<b>Running rope</b>					
≤6 strands, 19 class	3	6	12	2	2
>6 strands, 19 class	4	8	16	2	2
≤6 strands, 36 class	5	10	20	2	2
>6 strands, 36 class	6	12	24	2	2
Rotation-resistant Category 1	N/A	6	12	2	2
Rotation-resistant Category 2	N/A	2	4	2	2
Rotation-resistant Category 3	N/A	2	4	2	2
<b>Standing rope</b>					
All	...	3	...	...	2

GENERAL NOTE: Broken wire rope-removal criteria cited in this Volume apply to wire rope operating on steel and cast iron sheaves and drums and wire rope operating on multilayer drums, regardless of sheave material. When drum spooling is single layer, synthetic sheaves or sheaves with synthetic linings should not be used because there are no broken wire criteria for this configuration, and internal wire breaks may occur in large numbers before any breaks or signs of substantial wear are visible on the outside wires of the rope.

NOTES:

- (1) If one valley break is detected, sections of rope 30 × nominal rope diameter in length on both sides of the detected valley break should be inspected over a bend. For additional information, see [Figure 30-0.2-7](#).
- (2) Broken wires at end terminations may be eliminated by cutting and reattaching the end termination, if reducing the length is allowable.

## Chapter 30-2 Synthetic Rope

### SECTION 30-2.1: SCOPE

Chapter 30-2 includes provisions that apply to synthetic rope.

### SECTION 30-2.2: TRAINING

Users of synthetic rope shall be trained, as applicable, in the use, selection, inspection, installation, maintenance, attachment, replacement, and effects of environment as covered by this Chapter.

### SECTION 30-2.3: TYPES OF AND MATERIALS USED IN SYNTHETIC ROPE

#### 30-2.3.1 Rope Constructions

(a) single braid (e.g., 8 strand, 12 strand) (see Figure 30-2.3.1-1)

(b) cable-laid (e.g., 3 strand, 4 strand) (see Figure 30-2.3.1-2)

(c) jacketed (e.g., double braid, core dependent) (see Figure 30-2.3.1-3)

(d) parallel: a collection of multiple rope of one of the above constructions secured into a single structure through the use of an outer sheath (e.g., braided jacket, extruded sheath) (see Figure 30-2.3.1-4)

#### 30-2.3.2 High-Performance Synthetic Rope

High-performance synthetic rope has a strength member made up of one or a combination of load-bearing materials with a tenacity greater than 15 g/denier. It may have, size-for-size, breaking force and elongation characteristics similar to wire rope. Examples include, but are not limited to, the following:

- (a) high modulus polyethylene (HMPE)
- (b) aromatic polyamide (aramid)
- (c) liquid crystal polyester (LCP)

#### 30-2.3.3 Standard Performance Synthetic Rope

Standard performance synthetic rope has a strength member made up of one or a combination of load-bearing materials with tenacity less than or equal to 15 g/denier. It has, size-for-size, significantly lower breaking force and higher elongation characteristics than high-performance synthetic rope. Examples include, but are not limited to, the following:

- (a) polyester
- (b) nylon

#### 30-2.3.4 Coatings

Finishes and coatings shall be compatible with the other components and shall not impair the performance of the rope. Changes or additions to the coatings shall be approved by the rope manufacturer or a qualified person.

### SECTION 30-2.4: ROPE SELECTION, MINIMUM BREAKING FORCE, DESIGN FACTORS, AND OTHER REQUIREMENTS

#### 30-2.4.1 Selection

The synthetic rope shall be selected by the LHE manufacturer, the rope manufacturer, or a qualified person.

#### 30-2.4.2 Selection Considerations

(a) Application considerations such as the following shall be taken into account during rope selection:

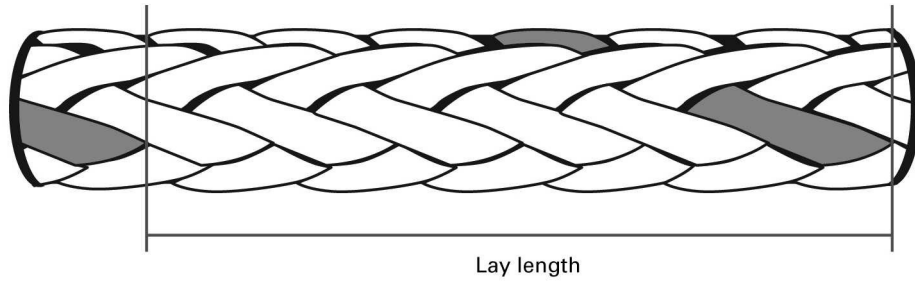
- (1) Loads are not accurately known.
- (2) Dynamic or shock loads are anticipated.
- (3) Heavy or severe rope service is likely to occur.
- (4) Tension is maintained on the rope for extended periods of time.
- (5) Procedures for operation or use are not well defined and/or controlled.
- (6) Severe abrasion is likely to occur from exposure to rough surfaces or cutting edges or by contamination from debris and grit.
- (7) Rope elongation properties are critical to the application as change in rope length under load varies between rope made with different materials.
- (8) LHE is operated in chemically or environmentally hazardous conditions.

(b) The spooling performance of synthetic rope may vary due to the rope type or the configuration of the LHE. For rope stored on drums, the LHE manufacturer or a qualified person should consult with the rope manufacturer to ensure suitable performance in the selected application, with attention paid to the following considerations:

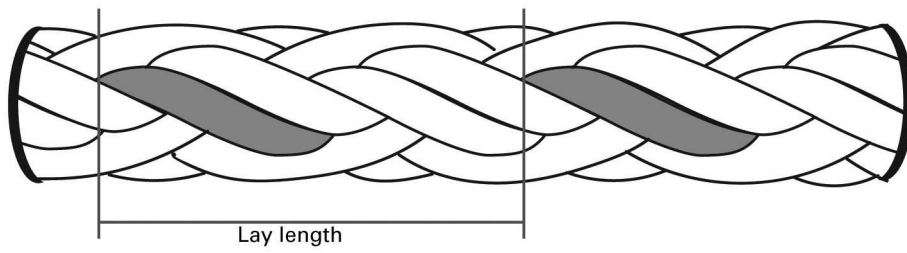
- (1) rope attachment to the drum



**Figure 30-2.3.1-1  
Single Braid**

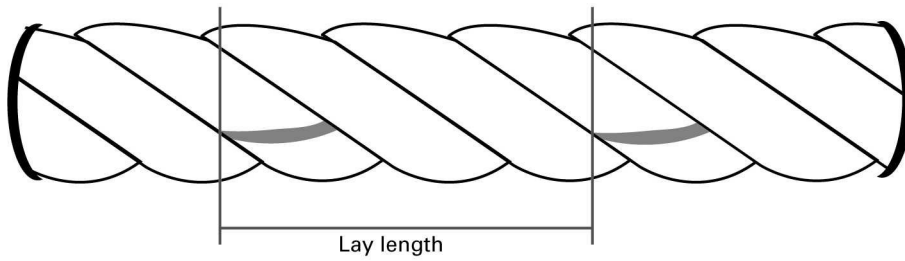


**(a) 12 Strand**

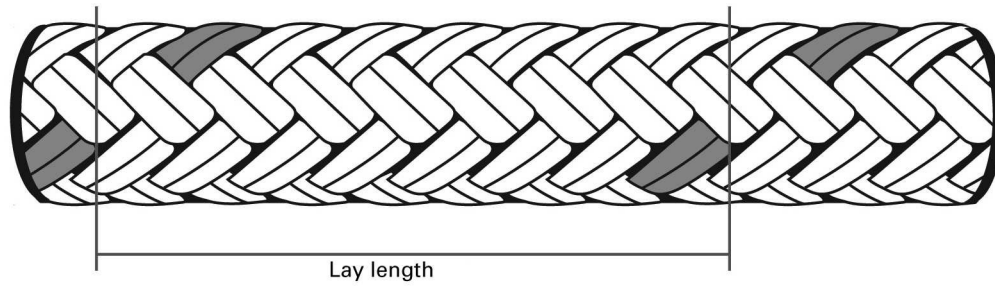


**(b) 8 Strand**

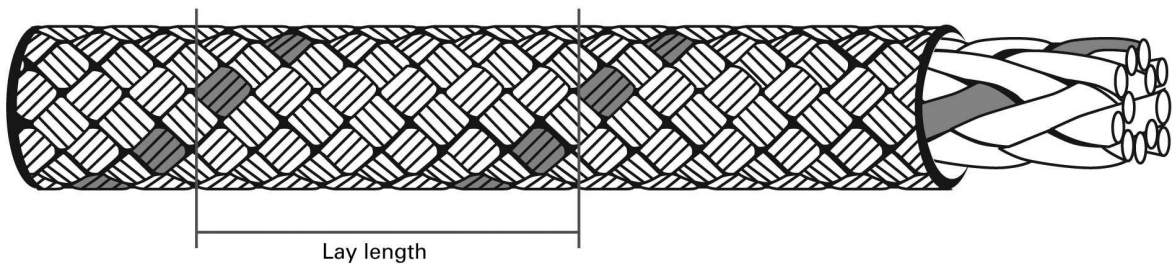
**Figure 30-2.3.1-2  
Three-Strand Cable Laid**



**Figure 30-2.3.1-3  
Jacketed**

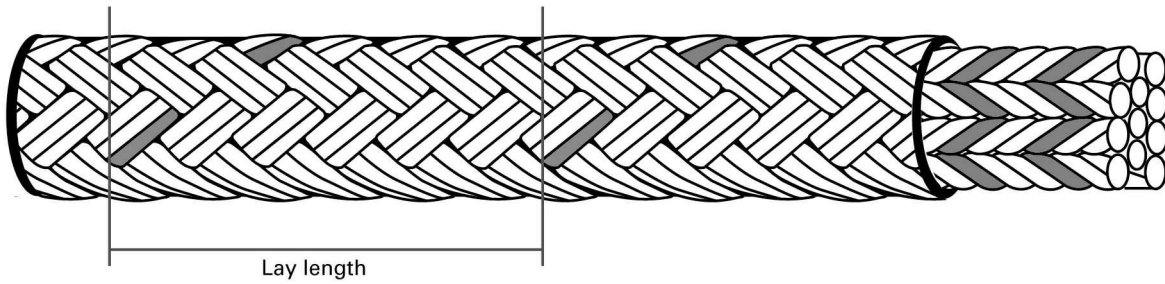


**(a) Double Braid**



**(b) Core Dependent**

**Figure 30-2.3.1-4  
Parallel Core, Braided Jacket: Three-Strand Cores**



**Table 30-2.4.4-1  
Synthetic Rope Design Factors**

Rope Usage	Design Factor
Running	5
Standing	4
Running, under boom erection conditions	4
Standing, under boom erection conditions	3
LHE handling molten metal	Not allowed

(2) drum profile (e.g., smooth, spiral, and parallel groove)

(3) minimum number of wraps required

(4) number of layers required

(5) fleet angle

(6) loading cycles expected

(c) Synthetic rope shall not be used for applications in which there are immediate hazards, such as contact with heat sources in excess of the rope critical temperature limit, welding slag, or edges from surrounding obstructions.

### (23) 30-2.4.3 Minimum Breaking Force

The rope shall meet or exceed the minimum breaking force specified by the rope manufacturer as tested in compliance with ISO 2307 or CI-1500B. The minimum breaking force shall be shown on the synthetic rope certificate and include reference to being unspliced breaking force if specified as such per ISO 2307.

### (23) 30-2.4.4 Synthetic Rope Design Factors

Unless otherwise specified by the LHE manufacturer, the rope manufacturer, or a qualified person, as a minimum, synthetic rope design factors shall be as shown in Table 30-2.4.4-1.

### 30-2.4.5 Multiple Lead Lines

If a load is hoisted by more than one lead line, the tension in the lines should be equalized.

### 30-2.4.6 Standing Rope (Pendants, Stay Rope, Guys, and Boom and Jib Support Rope)

(a) Only new and unused rope shall be used to manufacture standing rope.

(b) New and replacement boom and jib support rope shall be proof tested to the LHE manufacturer's or fitting manufacturer's recommendation, but the proof test shall not exceed 50% of the synthetic rope's minimum breaking force.

(c) Terminations, such as turnbuckles, shall have provisions to prevent loosening during usage.

(d) Standing rope connected in series shall be of the same construction or torsional properties.

### 30-2.4.7 Minimum $D/d$ Ratios — Sheave and Drum (23)

The minimum pitch diameter shall be determined by using the  $D/d$  ratios specified in Table 30-1.4.7-1 unless otherwise specified by the LHE manufacturer. If the  $D/d$  ratio is not specified or less than 16, the minimum sheave and drum pitch diameter for any rope shall be specified by the LHE manufacturer or a qualified person.

NOTE: The life of synthetic wire rope is affected by the pitch diameters. Pitch diameters larger than the minimums determined by the  $D/d$  ratios listed in Table 30-1.4.7-1 should achieve a longer service life.

## SECTION 30-2.5: INSTALLATION, TESTING, MAINTENANCE, REPLACEMENT, AND ROPE CERTIFICATION

### 30-2.5.1 Storage and Installation

(a) Rope should be stored to prevent damage or deterioration from moisture, chemicals, steam, UV, extreme temperatures, dirt, and other contaminants.

(b) Before installing synthetic rope, the documents that accompany the reel or the rope should be checked to ensure the correct rope is being installed on the LHE.

(c) Unreeling or uncoiling of rope should be done with care, as recommended by the rope manufacturer or qualified person to avoid kinking or inducing a twist.

(d) Prior to cutting of synthetic rope, measures such as whipping, shrink tubing, or taping as recommended by the rope manufacturer should be taken to prevent untwisting, unraveling, or unbraiding.

(e) During installation, care should be exercised to avoid dragging the rope in dirt or around objects that will snag, scrape, or cut.

(f) The synthetic rope should be wound onto the top of the drum from the top of the reel or onto the bottom of the drum from the bottom of the reel.

(g) After the rope is installed, but before starting normal operation, the rope should be cycled with increasing loads and speeds as specified by the LHE manufacturer, the rope manufacturer, or a qualified person.

(h) For rope subject to multilayer spooling, the rope should be installed under tension to prevent excessive distortion on the bottom layers and to promote proper spooling. Unless otherwise specified by the LHE manufacturer, the rope manufacturer, or a qualified person, tension should be 2.5% to 5% of the minimum breaking force.

### 30-2.5.2 Testing

(a) LHE load testing shall be in accordance with the applicable ASME B30 volume.

(b) Load testing of rope end terminations shall be performed as required by the rope manufacturer and/or termination manufacturer.

### 30-2.5.3 Maintenance

(a) Synthetic rope should be maintained in a clean condition in order to reduce internal friction and prevent an increased rate of deterioration while in service.

NOTE: Pressure washing/steam cleaning shall not be performed on synthetic rope. In the event that the rope is subject to dirt or particulate ingress, any cleaning methods employed shall be approved by the rope manufacturer or a qualified person.

(b) When operating conditions cause localized wear areas on a running rope, and if reducing the rope length is allowable, a section may be cut off the drum end and reterminated per [para. 30-2.7.4](#) to reposition and distribute these areas throughout the remaining length.

(c) Induced twist in the line should be addressed by removing the twist from the affected section of line and returning the construction to the natural twist level.

(d) Surfaces that contact the rope at any point during operation shall be maintained in a smooth condition not to exceed 300  $\mu\text{in.}$  (7.6  $\mu\text{m}$ ) root mean square value. All protrusions, such as pins, studs, bolts, clips, and edges, that may come in contact with the rope shall be rounded off per the rope manufacturer's recommendation to eliminate the risk of snagging or cutting.

### 30-2.5.4 Replacement Rope

Any deviation from the original size, material, coatings, or construction shall be specified by the LHE manufacturer, the rope manufacturer, or a qualified person and comply with [Section 30-2.3](#).

### (23) 30-2.5.5 Synthetic Rope Certificate

A synthetic rope certificate containing the information listed below shall be provided by the manufacturer of the rope to the original purchaser. Intermediaries shall provide an unaltered copy of the manufacturer's certificate with all ropes distributed by that intermediary. All rope certificates should be made available to the LHE operator.

- (a) certificate number
- (b) name and address of original purchaser of synthetic rope
- (c) date supplied from rope manufacturer
- (d) name of the rope manufacturer
- (e) address of the manufacturing facility [see [Note \(1\)](#)]
- (f) number traceable to rope manufacturer's production run
- (g) nominal rope diameter
- (h) nominal rope length [see [Note \(2\)](#)]
- (i) rope construction (12-strand single braid, 6-strand cable laid, etc.)

- (j) swivel prohibited or allowed (see [para. 30-2.7.1](#))
- (k) material type of load-bearing yarns
- (l) operating temperature range
- (m) minimum breaking force (e.g., short tons, pounds, kilonewtons) and test method (e.g., ISO, CI)
- (n) approximate weight per foot or meter

#### NOTES:

- (1) Complete address including country.
- (2) If the nominal rope length being delivered to the LHE owner through an intermediary differs from that shown on the original manufacturer's certificate, or additional information is negotiated between the purchaser and the intermediary, the intermediary shall provide a secondary certificate of conformance traceable to the original manufacturer's certificate, stating that information.

## SECTION 30-2.6: ENVIRONMENTAL CONDITIONS

### 30-2.6.1 Temperature

Rope physical properties (strength, stiffness) are directly affected by operating temperature. Design factors should be based on rope properties at the anticipated operating temperature. Consult the rope manufacturer for specific effects of exposure outside the following ranges:

(a) Polyester and nylon rope shall not be used in contact with objects or at temperatures in excess of 194°F (90°C) or at temperatures below -40°F (-40°C).

(b) Some synthetic materials do not maintain their published breaking strength during exposure above 140°F (60°C).

(1) The LHE manufacturer or rope manufacturer shall be consulted for the effects of long-term heat exposure if storage above this temperature is anticipated.

(2) The LHE manufacturer or rope manufacturer shall be consulted for the effects on operation if heat exposure above this temperature is anticipated.

### 30-2.6.2 Chemically Active Environments

The strength of synthetic rope and synthetic rope fittings may be degraded by chemically active environments. This includes exposure to chemicals in the form of solids, liquids, gases, vapors, or fumes. The synthetic rope manufacturer, LHE manufacturer, fitting manufacturer, or qualified person should be consulted before operating in chemically active environments.

### 30-2.6.3 Sunlight and Ultraviolet Light

The strength of synthetic rope may be degraded by exposure to sunlight or ultraviolet light. Synthetic materials used in rope can have varied UV resistance depending on the construction, coating, and other factors. The rope manufacturer or qualified person should be consulted for additional inspection or removal requirements. For additional degradation information, see CI-2001.

## SECTION 30-2.7: ROPE-LIFTING COMPONENTS

### 30-2.7.1 Swivels

Active in-line swivels may be used with a torque-neutral synthetic rope or as approved by the LHE manufacturer, the rope manufacturer, or a qualified person.

### 30-2.7.2 Sheaves

(a) Sheave grooves shall be smooth and free from surface defects that could cause rope damage.

(b) The sides of the groove shall be tapered outward and rounded at the rim to facilitate entrance of the rope into the groove. Flange rims shall run true about the axis of rotation.

(c) Groove diameters of new sheaves can range from -5% to +15% of nominal rope diameter, depending on specific rope characteristics. Consult the LHE manufacturer, the rope manufacturer, or a qualified person for the acceptable range.

(d) The arc of contact of a sheave groove should support the rope between 120 deg and 150 deg.

(e) Sheaves carrying rope that can be momentarily unloaded shall be provided with close-fitting guards, or other devices, to guide the rope back into the groove when the load is reapplied.

(f) The sheaves in the lower load blocks of machines shall be equipped with close-fitting guards, or other devices, that will minimize the possibility of rope becoming fouled.

(g) Recommended maximum fleet angle is 2.5 deg.

### 30-2.7.3 Drums

(a) Edges on drum surfaces that may contact the rope shall have minimum radii as specified by the rope manufacturer or a qualified person.

(b) The drum surface shall be free from surface defects that could cause rope damage. When rope drums are grooved, the radius at the bottom of the groove should be such as to form a close-fitting saddle for the size of rope used.

(c) Groove diameters of new drums can range from -5% to +15% of nominal rope diameter, depending on specific rope characteristics. Consult the LHE manufacturer, the rope manufacturer, or a qualified person for the acceptable range.

(d) The connection method and rating efficiency of the drum end termination of the rope shall be as specified by the LHE manufacturer or the rope manufacturer. If not specified, they shall be as approved by a qualified person.

(e) Drum flanges shall extend a minimum of one-half rope diameter but not less than 0.5 in. (13 mm) above the top layer of rope during operation.

(f) The pitch of the drum grooves shall allow adequate room for maximum rope diameter, plus rope ovalization, and maximum fleet angle.

(g) Synthetic rope should have a minimum of five full dead wraps on the drum at all times, unless otherwise specified by the LHE manufacturer, the rope manufacturer, or a qualified person.

(h) Recommended fleet angle is as follows:

(1) smooth drum: 0.5 deg minimum, 1.5 deg maximum

(2) grooved drum: 0.5 deg minimum, 2.0 deg maximum

### 30-2.7.4 Rope End Terminations

(a) The connection method and rating efficiency of the drum end termination of the synthetic rope shall be as specified by the LHE manufacturer or a qualified person.

(b) When selecting or changing to a new termination, consideration should be given to the effects of the environment, shock loads, load cycle fatigue, physical abuse and wear, and improper alignment. The rating efficiency and integrity of the end termination can be affected by the rope diameter, rope construction, the rope's minimum breaking force, the rope material type, the rope coating, and the efficiency of the termination. The end termination at the working end of the synthetic rope shall be applied as specified and according to the procedures of the LHE manufacturer, the fitting manufacturer, or a qualified person. Synthetic rope end terminations for use on the working end include, but are not limited to, the following:

(1) hand splicing

(2) mechanical terminations

(3) resin potting

(4) sewn terminations

(c) Mechanical components used in conjunction with a synthetic rope should be selected to meet the following requirements:

(1) Material used shall be compatible with the mechanical and environmental requirements imposed on the rope.

(2) Components shall have sufficient strength to sustain twice the rated load of the rope without visible permanent deformation.

(3) All surfaces shall be cleanly finished and sharp edges removed so as not to cause damage to the rope.

(4) Rope incorporating aluminum fittings shall not be used where fumes, vapors, sprays, mists, or liquids of alkalis or acids are present.

(5) Thimbles shall have a minimum diameter at the bearing surface of at least two times the rope diameter.

(6) Terminations or end attachments being used in LHE applications shall have been type tested to qualify efficiency.

(7) Wire rope wedge sockets, wire rope clips, or knots shall not be used to terminate synthetic rope for attachment to a load unless specified by the rope manufacturer or a qualified person.

(d) Replacement of field-installed, poured running rope terminations shall be proof tested to a minimum of 95% of the LHE's maximum rated line pull when the termination is installed by a documented procedure. Otherwise, the poured termination shall be proof tested to 40% of minimum breaking force.

(e) The inspection of end terminations shall be performed as specified by the termination manufacturer, the LHE manufacturer, or a qualified person [see [para. 30-2.8.2\(k\)](#)].

## SECTION 30-2.8: ROPE INSPECTION AND REMOVAL, RECORDS, AND REPAIR

### 30-2.8.1 Inspection

(a) *General.* All inspections shall be performed by a designated person. Any deficiencies identified shall be examined and a determination made by a qualified person as to whether they constitute a hazard and, if so, what steps need to be taken to address the hazard.

(b) *Frequent*

(1) Running rope in service shall be visually inspected daily, unless a qualified person determines it should be performed more frequently. The visual inspection shall consist of observation of all rope that can reasonably be expected to be in use during the day's operations. The inspector should focus on discovering gross damage that may be an immediate hazard.

(2) Specific types of damage include the following:

- (-a) distortion to the uniform structure of the rope
- (-b) abrasion
- (-c) cut strands
- (-d) gross damage to or deterioration of the end connection(s)
- (-e) evidence of heat/electrical/lightning damage
- (-f) evidence of chemical or UV degradation
- (-g) local changes of diameter
- (-h) local changes of lay length
- (-i) local twisting of rope

When damage is discovered, a qualified person shall inspect the affected section(s) to determine if the rope needs to be removed from service using criteria defined in [para. 30-2.8.2](#).

(c) *Periodic.* The inspection frequency shall be based on such factors as rope life on the particular installation or similar installations, severity of environment, percentage of capacity lifts, frequency rates of operation, drum and sheave diameters, and exposure to shock loads. Inspections need not be at equal calendar intervals and should be more frequent as the rope approaches the end of its useful life. Close visual inspection of the

entire rope length shall be made to evaluate inspection and removal criteria.

NOTE: Use of nondestructive testing should be considered as an additional inspection method.

Periodic inspections shall cover the surface of the entire rope length and focus on uncovering the types of damage listed in (b). Additionally, sections prone to rapid deterioration, such as the following, require special attention:

- (1) Repetitive wear sections, such as the following:
  - (-a) flange step-up, crossover, and repetitive pickup points on the drum
  - (-b) reverse bends in the reeving system
  - (-c) sections facing most bending cycles during standard lifting operation (especially in multifall reeving)
  - (-d) end connections
  - (-e) known wear areas based on previous experience with the LHE being inspected
- (2) Locations where rope vibrations are damped, such as the following:
  - (-a) sections in contact with equalizer sheaves or other sheaves where rope travel is limited
  - (-b) sections of the rope at or near end connections where damage may occur during handling/reeving
  - (-c) rope in the bridle reeving in the boom hoist rope
  - (-d) repetitive pickup points and crossover and change of layer points at flanges on drums
  - (-e) fleeting or deflector sheaves
- (3) Unless otherwise specified by the LHE manufacturer, the rope manufacturer, or a qualified person, the periodic inspection shall be performed at intervals according to the service descriptions below.
  - (-a) *Boom Hoist Rope*
    - (-1) normal rope service: not to exceed 3 months or 500 hr of rope operation, whichever comes first
    - (-2) heavy rope service: not to exceed 2 months or 335 hr of rope operation, whichever comes first
    - (-3) severe rope service: not to exceed 1 month or 165 hr of rope operation, whichever comes first
    - (-4) special rope service: less than 165 hr of rope operation
  - (-b) *All Other Rope*
    - (-1) normal rope service: not to exceed 12 months or 2,000 hr of rope operation, whichever comes first
    - (-2) heavy rope service: not to exceed 6 months or 1,000 hr of rope operation, whichever comes first
    - (-3) severe rope service: not to exceed 3 months or 500 hr of rope operation, whichever comes first
    - (-4) special rope service: less than 500 hr of rope operation

Certain types of rope and applications require special attention and may require reduced time intervals between periodic inspections. Examples include rope operating in chemically active or extreme-temperature environments and synthetic rope constructions that



are specifically susceptible to damage or increased deterioration when used under difficult conditions, such as heavy or severe rope service operations.

(d) *Inspections After Unusual Occurrences.* After an unusual occurrence, such as a lightning strike, shock load, or overload on a synthetic rope, the rope shall be inspected in accordance with (c) or as determined by a qualified person.

### 30-2.8.2 Inspection and Removal Criteria

There are no precise rules to determine the exact time for the removal of the rope since many variable factors are involved. Inspection methods and retirement criteria specific to a given rope design shall be provided by the rope manufacturer. Once a rope reaches any one of the removal criteria, it shall be replaced before the LHE is returned to service. Specific inspection attributes and removal criteria include the following:

(a) Damage that is estimated to have reduced the effective diameter of the rope by more than 10%, as compared to an unaffected section of the rope.

(b) Cuts, gouges, areas of extensive yarn material breakage along the length, and abraded areas on the rope (see [Figure 30-2.8.2-1](#)).

(c) Uniform yarn material breakage along the major part of the length of the rope such that the entire rope appears covered with fuzz or whiskers (see [Figure 30-2.8.2-2](#)).

(d) Inside the rope, yarn material breakage, fused or melted yarn material involving damage estimated at more than 10% of the diameter of the rope or affecting more than 10% of strand diameters in half of the strands in a lay length (see [Figure 30-2.8.2-3](#)). This may be observable by prying or twisting to open the strands in some rope constructions, as recommended by the rope manufacturer.

(e) Discoloration, brittle yarns, and hard or stiff areas that may indicate chemical damage, ultraviolet damage, or heat damage.

(f) Dirt and grit in the interior of the rope structure that is causing damage to rope yarns.

(g) Kinks or distortion in the rope structure, particularly if caused by forcibly pulling on the loops (known as hockles) (see [Figure 30-2.8.2-4](#)).

(h) Melted, hard, or charred areas that affect more than 10% of the diameter of the rope or affect more than 10% of strand diameters in half of the strands in a lay length (see [Figure 30-2.8.2-5](#)).

(i) Any apparent damage from a heat source including, but not limited to, welding, power line strikes, or lightning.

(j) Poor condition of thimbles or other components manifested by corrosion, cracks, distortion, sharp edges, or localized wear (see [Figure 30-2.8.2-6](#)).

(k) End terminations removal criteria include severely corroded, cracked, bent, worn, grossly damaged, or improperly installed end terminations.

(l) For jacketed rope, completely broken jackets that no longer protect the load-bearing fiber (only jacketed rope) (see [Figure 30-2.8.2-7](#)).

(m) Other conditions, including visible damage, that cause doubt as to the continued use of the rope.

### 30-2.8.3 Rope Not in Regular Use

(a) Synthetic rope that has been idle for a period of 1 month to 6 months due to shutdown or storage of the LHE shall be inspected in accordance with [para. 30-2.8.1\(b\)](#).

(b) Synthetic rope that has been idle for a period of over 6 months due to shutdown or storage of the LHE shall be inspected in accordance with [para. 30-2.8.1\(c\)](#).

### 30-2.8.4 Records

(a) *Frequent Inspections.* No records are required.

(b) *Periodic Inspections.* To establish a basis for judging the proper time for replacement, a dated report of rope condition at the latest periodic inspection shall be kept on file. This report shall cover points of deterioration listed in [para. 30-2.8.2](#). If the rope is replaced, only the fact that the rope was replaced need be recorded.

(c) *Long-Term Inspection Program.* A long-term inspection program should be established and should include records on the examination of rope removed from service so that a relationship can be established between visual observation and actual condition of the internal structure.

### 30-2.8.5 Repairs

(a) Synthetic rope shall be repaired only by the rope manufacturer or a qualified person. Load-bearing fibers shall not be repaired.

(b) A repaired rope shall be indicated on the certification and/or marked to identify the repairing entity.

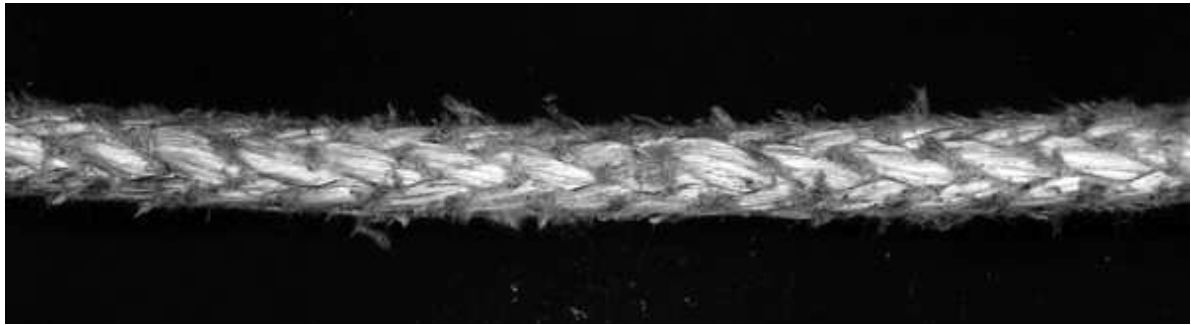
(c) Components used for rope repair shall comply with the provisions of this Chapter.

(d) Modifications, alterations, or repairs to end attachments or fittings shall be approved by the rope, fitting, or component manufacturer or a qualified person and shall conform to all other provisions of this Chapter.

**Figure 30-2.8.2-1  
Cuts, Gouges, and Yarn Material Breakage**



**Figure 30-2.8.2-2  
Appearance of Fuzz or Whiskers**





**Figure 30-2.8.2-3  
Damage Inside the Rope**



**Figure 30-2.8.2-4  
Loops (Hockles)**



**Figure 30-2.8.2-5  
Melt Damage Due to Heat**



**Figure 30-2.8.2-6  
Damaged Components**



**Figure 30-2.8.2-7  
Broken Jackets**



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