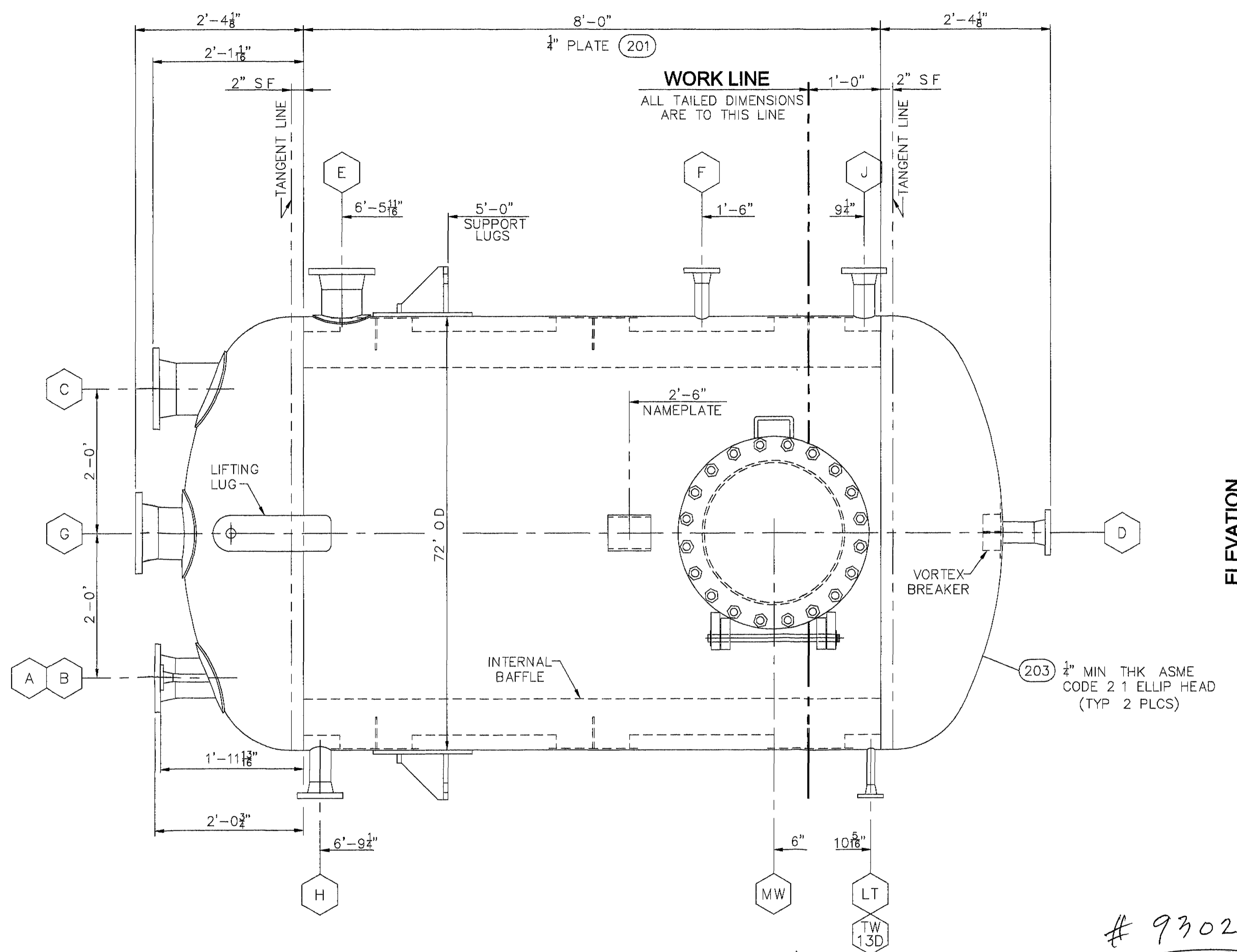


PLAN VIEW



ELEVATION  
SEE PLAN FOR TRUE ORIENTATION

# 93029

CERTIFIED FOR FABRICATION  
BY DF DATE 4-12-00

<b>OFFENHAUSER COMPANY</b>			
HOUSTON TEXAS			
CUSTOMER CELANESE			
P O NO 4500069617			
S/O# 1739	NO REQ'D	ONE	
DWG# 00-1739A	SHEET 2 OF 4	REV	0

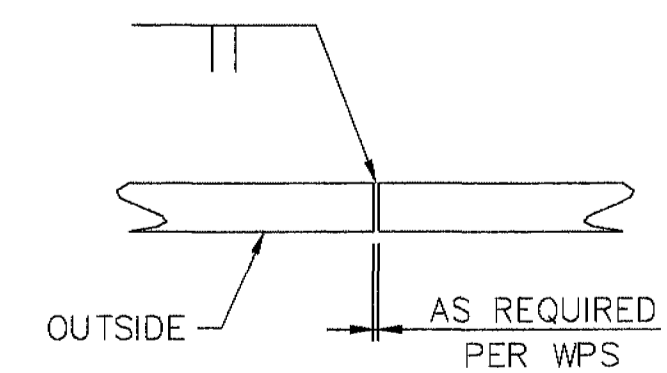
CONFIDENTIAL  
THIS DRAWING IS THE PROPERTY OF AND CONTAINS CONFIDENTIAL AND PROPRIETARY INFORMATION BELONGING TO CELANESE CHEMICALS DIVISION. IT MUST BE RETURNED IMMEDIATELY UPON REQUEST AND MUST NOT BE COPIED IN WHOLE OR IN PART NOR THE INFORMATION SHOWN THEREON DISCLOSED TO THIRD PARTIES OR OTHERWISE USED EXCEPT AS SPECIFICALLY PERMITTED BY CELANESE CHEMICALS DIVISION.

**Celanese**  
Chemicals Division Bishop Plant

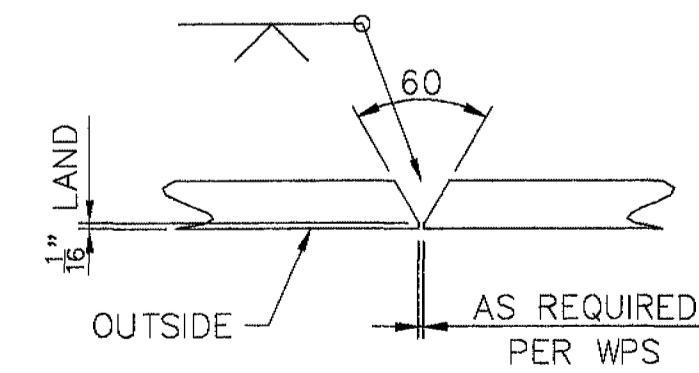
FEED VESSEL / 10043546  
72" O.D x 8'-0" SM/SM  
PLAN AND ELEVATION

BILL OF MATERIALS				
ITEM	QTY	DESCRIPTION	MATERIAL SPEC	REMARKS
200	2	72 OD x 1/4" MIN THK ASME CODE 2.1 ELLIP HEAD w/2" SF	SA-240-316L	HEADS
201	1	1/4" PLATE 97" x 225 7/16" ROLL TO 72" OD INCLUDES 1" EXCESS FOR TRIM	SA-240-316L	SHELL RING #1
202	1	3/16" PLATE 7" x 12 1/2	T-316L SS	NAME PLATE BRACKET

NO	DESCRIPTION	BY	CHK	APP'D	DATE
0	ISSUED FOR FABRICATION	DF	JBC	SG	4-12-00
X	ISSUED FOR APPROVAL	DF	JBC	SG	3-3-00



LONG SEAM DETAIL



CIRCUMFERENTIAL & HEAD SEAM DETAIL

# 93029

NATIONAL BOARD NO. 860



OFFENHAUSER COMPANY  
HOUSTON TEXAS

RT-3

VESSEL

IKT/COIL

MAWP (INT)

66

N/A

MAWP (EXT)

7.5

N/A

S/O NO

DES TEMP

400 °F

°F

1739A

TEMP

-20 - 66

N/A

N/A

00-1739

112

N/A

ITEM NO.

10043546

YEAR BUILT

MFR'S S NO

CAPACITY

2000

00-1739A

2150 GAL.

4,800 LBS.

4500069617

**FORM U-1A MANUFACTURER'S DATA REPORT FOR PRESSURE VESSELS**  
 (Alternative Form for Single Chamber Completely Shop-Fabricated Vessels Only)  
 As Required by the Provisions of the ASME Code Rules Section VIII Division 1

1 Manufactured and certified by OFFENHAUSER COMPANY 2201 Telephone Road Houston TX 77023  
(Name and address of manufacturer)

2 Manufactured for HOECHST CELANESE CHEMICAL, P O Box 428 Bishop TX 78343  
(Name and address of purchaser)

3 Location of installation HOECHST CELANESE CHEMICAL Highway 77 South, Bishop TX 78343  
(Name and address)

4 Type Vertical 00-1739A 00-1739A 860 2000  
(Horiz. or vert. tank) (Mfg's serial No.) (CRN) (Drawing no.) (Nat'l Bd. No.) (Year built)

5 The chemical and physical properties of all parts meet the requirements of material specifications of the ASME BOILER AND PRESSURE VESSEL CODE. The design construction and workmanship conform to ASME Rules Section VIII Division 1  
 Year 1998  
 to 1999 Addenda (Date) N/A Special Service per UG 120(d) N/A  
 Code Case Nos. 250 0312 5-11 5"

6 Shell SA 240-316L 250 0312 5-11 5" 8-0 sm/sm  
Mat'l (Spec. No., Grade) Nom. Thk. (in.) Corr Allow (in.) Diam. I.D. (ft. & in.) Length (overall) (ft. & in.)

7 Seams 1 Spot 85 1 Spot 1  
Long (Welded Dbl., Sngl., Lap, Butt) R.T. (Spot or Full) Eff. (%) H.T. Temp (F) Time (hr) Girth (welded Dbl., Sngl., Lap, Butt) R.T. (Spot, Partial, or Full) No. of Courses

8 Heads (a) Mat'l SA-240-316L (b) Mat'l SA 240-316L  
(Spec No., Grade) (Spec No., Grade)

	Location (Top Bottom Ends)	Minimum Thickness	Corrosion Allowance	Crown Radius	Knuckle Radius	Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure (Convex or Concave)
(a)	Top	250	0312"			2.1			0	Concave
(b)	Bottom	250"	0312"			2.1			0	Concave

If removable bolts used (describe other fastenings) \_\_\_\_\_  
(Mat'l, Spec. No., Gr., Size, No.)

9 MAWP INT 66 EXT 7.5 psi at max temp 400 ° F  
 Min design metal temp 20 ° F at 66 psi Hydro ~~press~~ or ~~vac~~ test pressure 112 psi

10 Nozzles inspection and safety valve openings

Purpose (Inlet, Outlet, Drain)	No	Diam or Size	Type	Mat'l	Nom Thk	Reinforcement Mat'l	How Attached	Location
				See U-4 Attached				

11 Supports Skirt No Lugs 4 Legs Other Attached Shell/Welded  
(Yes or no) (No.) (No.) (Describe) (Where and how)

12. Remarks Manufacturer's Partial Data Reports properly identified and signed by Commissioned Inspectors have been furnished for the following items of this report:

(Name of part, item number Mfg's name and identifying stamp)  
Impact Exempt UHA-51 S/S Safety Relief See UG-125

**CERTIFICATE OF SHOP COMPLIANCE**

We certify that the statements made in this report are correct and that all details of design material, construction, and workmanship of this vessel conform to the ASME Code for Pressure Vessels, Section VIII Division 1 U Certificate of Authorization No. 2088 expires 12/31 2000

Date 5-2-00 Co Name OFFENHAUSER COMPANY Signed [Signature]  
(Manufacturer) (Representative)

**CERTIFICATE OF SHOP INSPECTION**

Vessel constructed by OFFENHAUSER COMPANY at Houston TX 77023

I the undersigned holding a valid commission issued by The National Board of Boiler and Pressure Vessel Inspectors and the State or Province of TEXAS and employed by CGU COMMERCIAL UNION INSURANCE COMPANY Boston MA have inspected the component described in this Manufacturer's Data Report on 05-02-00 and state that, to the best of my knowledge and belief the Manufacturer has constructed this pressure vessel in accordance with ASME Code Section VIII Division 1 By signing this certificate neither the Inspector nor his employer makes any warranty expressed or implied concerning the pressure vessel described in this Manufacturer's Data Report. Furthermore neither the Inspector nor his employer shall be liable in any manner for any personal injury or property damage or a loss of any kind arising from or connected with this inspection

Date 05-02-00 Signed [Signature] Commissions NB 8826A TX # 985  
(Authorized Inspector) (Nat'l Board (incl. endorsements) State, Prov and No.)

**FORM U-4 MANUFACTURER'S DATA REPORT SUPPLEMENTARY SHEET**  
**As Required by the Provisions of the ASME Code Rules Section VIII Division 1**

1 Manufactured and certified by OFFENHAUSER COMPANY 2201 Telephone Road Houston TX 77023  
(Name and address of Manufacturer)

Manufactured for HOECHST CELANESE CHEMICAL, P O Box 428 Bishop TX 78343  
(Name and address of Purchaser)

*#93029*

3 Location of Installation HOECHST CELANESE CHEMICAL, Highway 77 South Bishop TX 78343  
(Name and address)

4 Type Vertical Pressure Vessel 00-1739A  
(Horiz., vert., or sphere) (Tank separator heat exch., etc) (Mfg's serial No.)

(CRN) 00-1739A 860 2000  
(Drawing No.) (Nat'l Bd. No.) (Year built)

MK	Data Report Item Number	PURPOSE	Remarks							ATTACHED	LOC
			NO	SIZE	TYPE	MAT L	THK S	REIN F			
A		Product Inlet	1	6"	150#RFWN	SA-312-TP316L	S/40S	SA-240-316L	UW 16 1(d)	Top Head	
B		DMW Inlet	1	1"	150#RFWN	SA-312-TP316L	S/80S	Inherent	UW 16 1(d)	Top Head	
C		Inspection Port	1	8"	150#RFWN	SA-312 TP316L	S/40S	SA-240-316L	UW 16 1(d)	Top Head	
D		Product Outlet	1	3"	150#RFWN	SA-312-TP316L	S/40S	Inherent	UW-16 1(d)	Btm Head	
E		Product Overflow	1	6"	150#RFWN	SA-312 TP316L	S/40S	SA 240-316L	UW-16 1(d)	Shell	
F		Recycle Inlet	1	2"	150#RFWN	SA 312-TP316L	S/40S	Inherent	UW-16 1(d)	Shell	
G		Agitator Nozzle	1	8"	150#RFWN	SA 312-TP316L	S/40S	SA-240 316L	UW-16 1(d)	Top Head	
H		Spare	1	3"	150#RFWN	SA 312-TP316L	S/40S	Inherent	UW-16 1(d)	Shell	
J		Spare	1	3"	150#RFWN	SA-312-TP316L	S/40S	Inherent	UW-16 1(d)	Shell	
LT		Level Transmitter	1	1"	150#RFWN	SA-312-TP316L	S/80S	Inherent	UW 16 1(d)	Shell	
TW 13D		Thermowell	1	1"	N/A	SA-182-F316L		Inherent	UW 16 1(d)	Shell	
MW		Manway	1	24"	150#RFSO	SA 240-316L	1/4 PL	SA-240-316L	UW 16 1(d)	Shell	

Certificate of Authorization. Type U No. 2088 Expires 12/31 2000

Date 5-2-00 Name OFFENHAUSER COMPANY Signed [Signature]  
(Manufacturer) (Representative)

Date 05-02-00 Name [Signature] Commission N B 8826A TX # 985  
(Authorized Inspector) (Nat'l Board incl. endorsement, state, province and no.)