DRAWING No

D/A7/15/13362

PART IDENTIFICATION		WELDING NOTES	GENERAL NOTES		DESIGN DATA		
SOTE ELAKION KIODDEN TOOT NEED ALION	MATERIAL SPECIFICATION	1. C.T. LTD. TO MAINTAIN A RECORD OF ALL WELDERS EMPLOYED ON THIS JOB.	ALL FLANGE BOLT HOLES ARE TO BE POSITIONED OFF CENTRES TO MAIN VESSEL CENTRELINES UNLESS NOTED OTHERWISE.		DESIGN CODE	THE INTENT OF ASME VIII DIV.1 : (NOT 'U' STAMPED)	
RIRTH FLANGE, NOZZLE 'T1' FLANGE T1' ELBOW	ASTM A105N ASTM A815−UNS31803 ★	2. ALL WELDERS TO BE QUALIFIED IN ACCORDANCE WITH ASME IX	2. ALL PLATE MARKINGS TO BE ON THE OUTSIDE	OF THE HEADEN	DESIGN PRESSURE	5.17 BARG	
REMAINDER	ASTM A240-UNS31803 *	3. WELDING & N.D.E. SHALL COMPLY WITH REQUIREMENTS	AND MUST BE TRANSFERRED BEFORE MATERIAL IS CUT. 3. NOZZLE FLANGES SHALL BE DIMENSIONALLY IN ACCORDANCE WITH		DESIGN TEMPERATURE	156.7 °C (314 °F)	
	:	OF THE CODE 4. WELDING SHALL ALL BE G.T.A.W. USING SUPERDUPLEX	ANSI B16.5. SEE DETAILS FOR FLANGE FACE FI	NISHES.	JOINT EFFICIENCY	0.85	
SERVICE BOLTING (BY OTHERS)	ASTM A193-B7/2H	FILLER METALS OF THE 2507 or ZERON 100 TYPE.	4. DIMENSIONAL TOLERANCES SHALL BE IN ACCOR	PDANCE WITH CODE	CORROSION ALLOWANCE	1.6mm (INT'L)	
SERVICE GASKETS (BY OTHERS)	FLEXITALLIC "SPECIAL" STYLE CGI 1/4" THK TITANIUM SPIRAL WOUND c/w 3/16"THK C.ST. OUTER RING & 3/16" THK TITANIUM INNER RING	5. WELD PROCEDURES SHALL BE CORROSION TESTED USING ASTM G48A ie. 6% BY WEIGHT FERRIC CHLORIDE AT 25°C. ACCEPTANCE SHALL BE NO VISUAL SIGNS OF CORROSION & LESS THAN 1.0 mg/cm WEIGHT LOSS.	5. NOZZLE NECKS SHALL BE DRESSED FLUSH WITH & INSIDE CORNERS ROUNDED OFF TO 3mm RA	DIUS.	RADIOGRAPHY	SPOT - PER UW-5	2
			6. ALL BUTT WELDS SHALL BE GROUND FLUSH IN	TERNALLY.	STRESS RELIEF	NONE	
	:		7. NOZZLE 'T1' REINF'G PAD SHALL HAVE A 1/4"AP	TELL-TALE HOLE.			
EST BOLTS	ASTM A193-B7/2H or EQUIV. 3 THK NON-ASBESTOS FIBRE	INSPECTION REQUIREMENTS	8. DU PONT TO SUPPLY THE EXISTING HEADER C	W CLEAN CERTIFICATE			
EST GASKETS EST BLANKS (T1)	ASTM A105 or EQUIV.	1. SUBJECT TO STAGE/FINAL INSPECTION BY:-	(TO MEET HEALTH & SAFETY REGULATIONS) INTO CTL WORKS. EXISTING UNIT TO BE USED AS A DIMENSIONAL REFERENCE WHEN FABRICATING NEW HEADER & FOR BLANKING OFF NEW HEADER DURING HYDROTEST.				
	ASTA ATOS ST EQUITY	H.S.B.I.Q.L. LTD (SEE QUALITY PLAN FOR DETAILS.)					
* DUPLEX MATERIALS SHALL BE SUPPLIED TO SPECIFICATION & SHALL MEET THE FOLLOWING CRITERIA:-		2. 2 (TWO) COPIES OF DATA FOLDER REQUIRED — CTL STANDARD CONTENTS		,			
MOLYBDENUM CONTENT 2.9-3.2%		3. THE FOLLOWING SHALL BE HARD STAMPED ON THE EDGE OF THE GIRTH FLANGE :-					
NITROGEN CONTENT 0.145-0.2% MINIMUM PITTING RESISTANCE EQUIVALENT NUMBER (PREN) OF 34.		C.THOMPSON LTD. W/O No. 5554	~.				
EXHIBIT A BALANCED MICROSTRUCTURE (NO SECONDARY PHASES OR GRAIN BOUNDARY PRECIPITATES & FERRITE IN THE RANGE 40-60%)		DESIGN CODE : ASME VIII DIV 1 DESIGN PRESSURE 5.17 BARG @ 156.7 °C					
GRAIN BOUNDARY PRECIPITATES & FEXHIBIT IMPACT TEST RESULTS OF 5	FERRÎTE IN THE RANGE 40-60%) 54J @ -40°C.	TEST PRESSURE (SHOP) : 8.1 BARG					
MATERIAL SHALL BE SUPPLIED IN THE & BOTH PICKLED & PASSIVATED.	HE SOLUTION ANNEALED CONDITION						
PLATE MATERIAL SHALL BE DYE PEN	NETRANT EXAMINED FOR SURFACE						
SLIVERS (AT THE MILL).				, l			
			- Angel				
			≪ .				
PAINTING 15		TEST REQUIREMENTS	ESTIMATED WEIGHTS				···• 6
CARBON STEEL PARTS TO BE PAINTED 1 CT. CTL STANDARD PRIMER		HYDRO-TEST 8.1 BARG	FABRICATED / ERECTED-	– 1251 Kg.			
		PRESSURE (INITIAL & ROUTINE)	FLOODED (S.G. 1.0)	– 3251 Kg.			
		CLEAN TOWNS WATER SHALL BE USED FOR HYDROTEST	•				
	·	MINIMUM TEMPERATURE OF TEST WATER SHALL BE 7°C. HOLD AT TEST PRESSURE UNTIL INSPECTION IS COMPLETE					
		(30 MINS. MIN.) AFTER TEST, HEADER SHALL BE COMPLETELY DRAINED &			СПУБ	LES THOMPSON LI	Minner
PKEPAKATION	N FOR TRANSIT	THOROUGHLY DRIED. NOTE!			CHAK	GLASSHOUSE LANE	RSI
ALL SURFACES TO BE CLEAN & DRY. FLANGE FACES SHALL BE FITTED WITH PLYWOOD BLANKS, WIRED IN POSITION		FOR HYDROTEST, THE NEW HEADER SHALL BE BOLTED TO THE EXISTING HEADER (SEE NOTE 8.)				ROTHERHAM SOUTH YORKSHIRE.	
		CTI TO SUPPLY TEST BLANKS FOR 24" NO77LES				FNCI AND	FM 21344
		TEST BOLTS & TEST GASKETS (SEE 'MATERIALS OF CONSTRUCTION' FOR MATERIAL GRADES). (10) TO (14)				Du Pont (U.K.) Ltd	
					REPLACEME	OTES DRAWING NT BOTTOM CHANNEL FOR	
_					DEHYDRATION EQUIPMENT	ON TOWER REBOILER No. E610	
				DRAWING STATUS NOW "CERT		W.O.No.	5554
					DRN. D.P. D.	ATE 12.01.99 CHKD. P.C. DATE	E 12.01.99
				REV DRN. D.P. DATE	5.2.99 STATUS CODES:- DRAWING A 2 NUMBER A 2	P=PRELIM. C=FOR COMMENT. A=APPRO	OVED. F=FINAL
			→		1313 A URAIA	,	AIUS I KEV.

DRG TITLE: PROJECT No: 10801 PLANT: TA T7 WORKS: DAVIES BUILDING: SECTION: OXIDATION GEOG. AREA: SYSTEM No: P.L.C'S: DO LOC: DEV.GRP
DATE:
DATE: DRAWING/DOCUMENT CHANGE DRG TYPE: DTL THIS DRAWING IS A PRIVATE AND CONFIDENTIAL COMMUNICATION AND THE PROTERTY OF DUPONT SA MUST NOT BE COPIED OR LOANED WITHOUT THE CONSENT OF DUPONT SA AND MUST BE RETURNED.

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Wilton Works

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