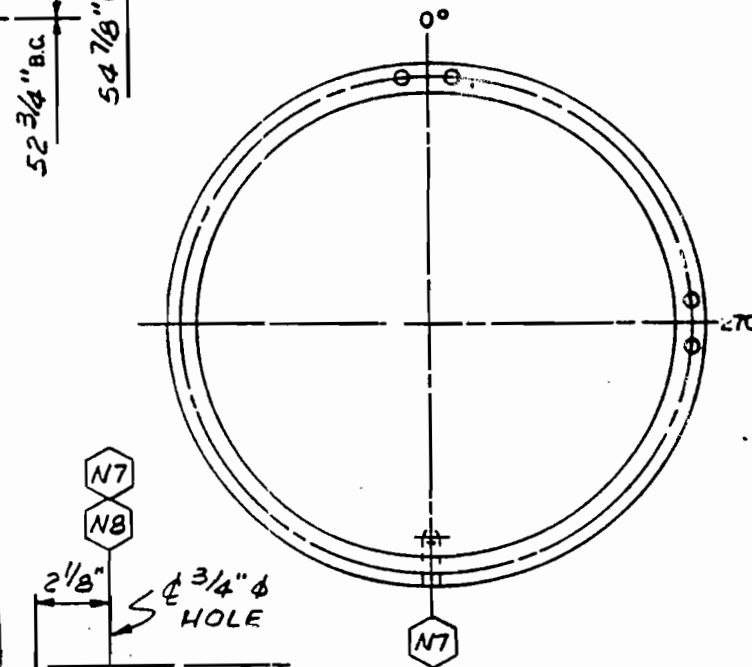
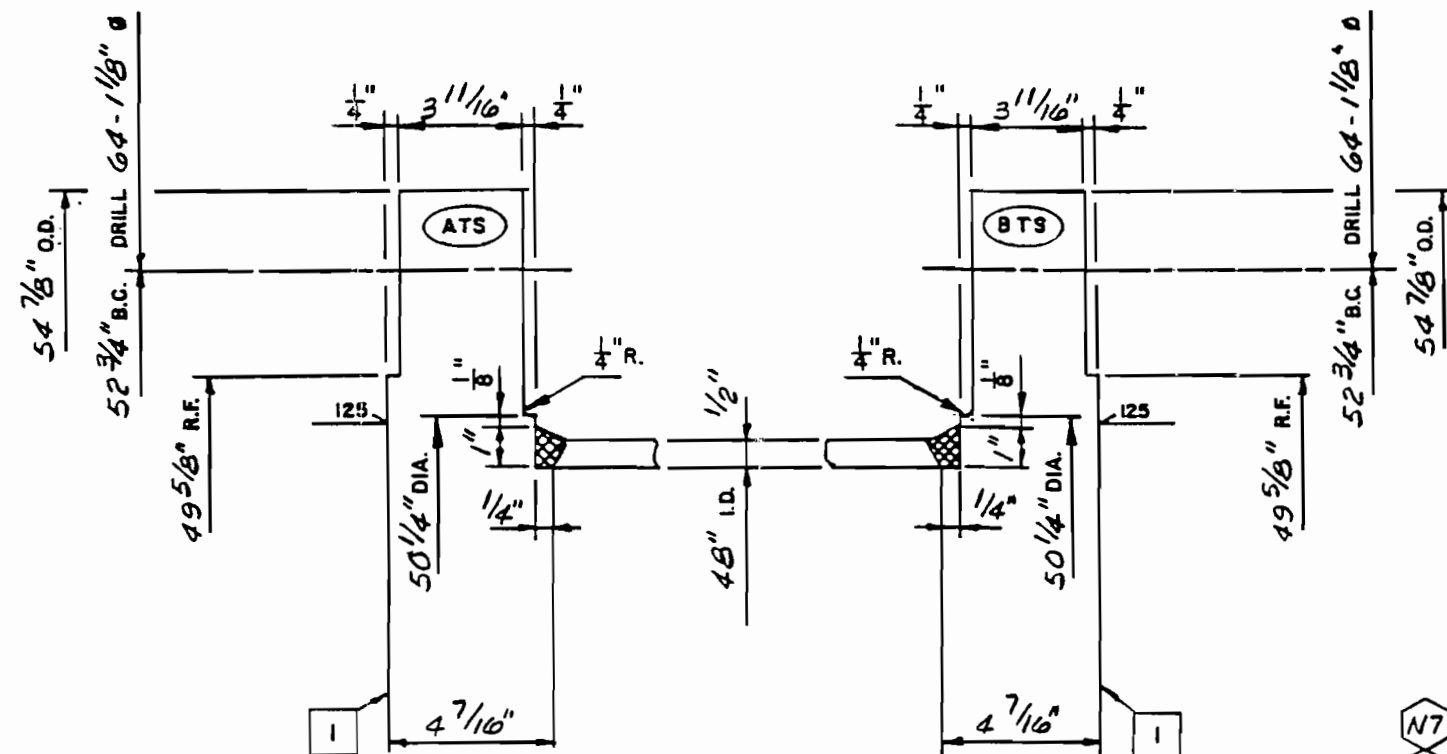
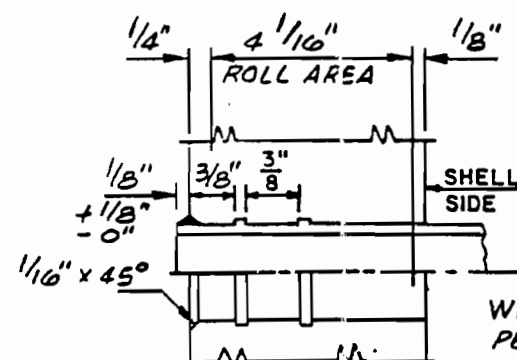


5-18-78



1. PREPARE THE JOINT.
 - A. CHAMFER TUBE HOLES 1/16" X 45 DEGREES.
 - B. CLEAN THE FACE OF THE TUBESHEET, ALL TUBE HOLES, AND ALL TUBES WITH ACETONE FOR A MINIMUM LENGTH OF 1 FOOT FROM EACH END.
 - C. SET TUBES TO PROJECT 1/8" (+1/8", -0") FROM THE FACE OF THE TUBESHEET.
2. GIVE TUBES A LIGHT ROLLING TO OBTAIN METALLIC CONTACT PRIOR TO WELDING. DO NOT USE LUBRICANT FOR THIS STEP.
3. GTAW WELD CARBON STL. JOINTS WITH AWS A5.18 ER 70S-2 FILLER METAL.
4. LIQUID PENETRANT EXAMINE ALL WELDS AND THEN CLEAN THEM WITH ACETONE. REPAIR ANY DEFECTIVE WELDS AND RECHECK.
5. WELD 2ND PASS, GTAW WITH AWS A5.18 ER 70S-2 FILLER METAL.
6. REPEAT STEP NO. 4 FOR 2ND PASS.
7. LEAK TEST: APPLY SOAP SUDS SOLUTION TO TUBE WELDS WHILE MAINTAINING 15 PSI AIR PRESSURE ON SHELL SIDE OF TUBESHEET.
8. ROLL TUBES WITH OIL USING CONTROLLED METHOD (4 1/2 TO 5% TUBE WALL REDUCTION). DO NOT ROLL IN WELD AREA.
9. REPEAT STEP NO. 7.
10. FINAL LIQUID PENETRANT EXAMINE.
11. HYDRO TEST AT FULL SHELL SIDE TEST PRESSURE.



WELD TUBES TO TUBESHEET
PER TMF PROC. SP-205C

$\frac{1}{8}$ " WIDE X $\frac{1}{64}$ " DEEP GROOVES
(+) 0.003" (-) 0.003" TUBE HOLE DIA
DEBURR TUBE HOLES BOTH SIDES

REAM TO 1.261"

* CV = 15/12 FT. LBS. @ 30°F

1 SA-266-2 *

CERTIFIED
PRINT

APR 25 1995
TEXAS METAL
FABRICATING CO.
A TRINITY INDUSTRIES CO.
HOUSTON, TEXAS



FABRICATION DETAIL - TUBESHEETS

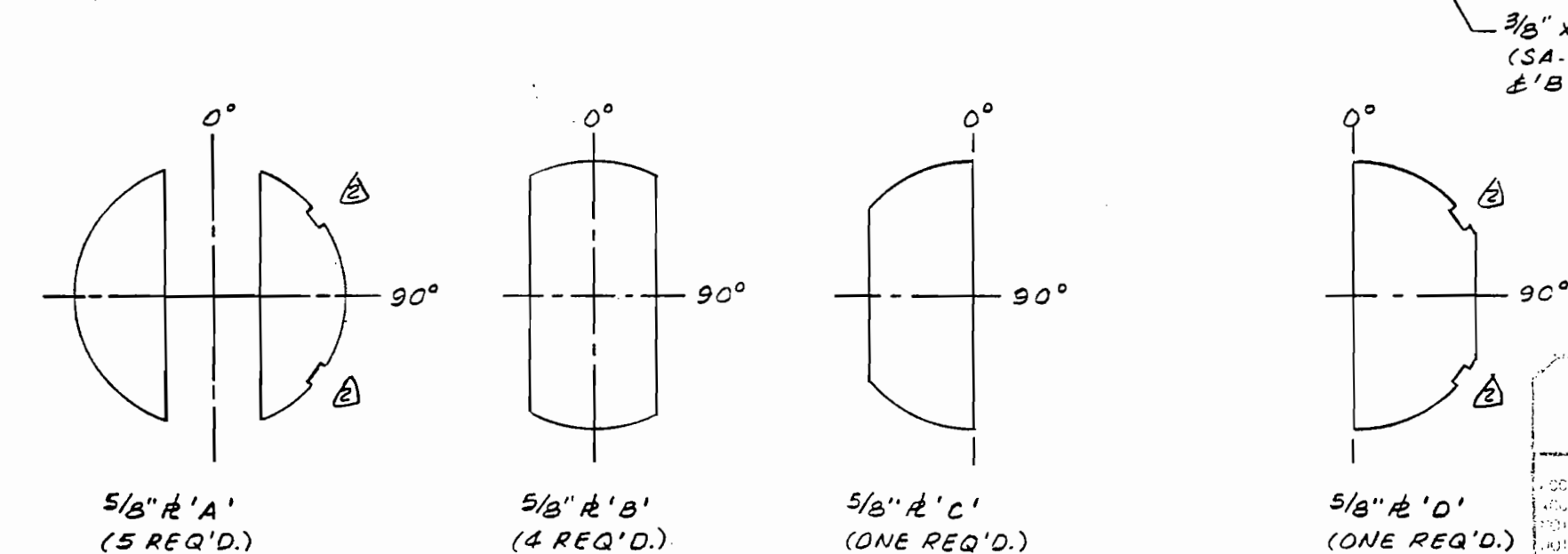
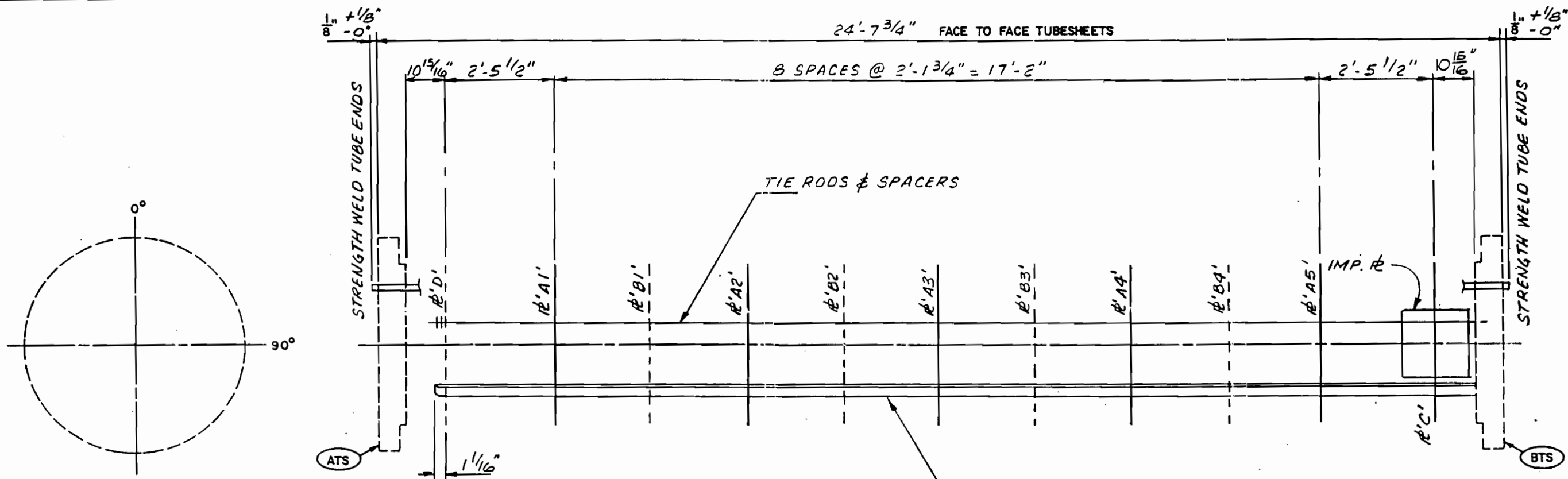
REFERENCE
94262

NO. 9459

SHEET 13

REVIEWS

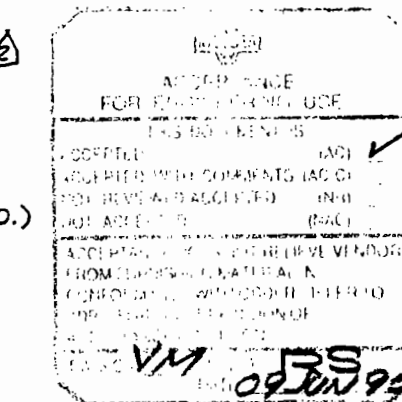
PHILLIPS SUMIKA POLYPROPYLENE COMPANY
PASADENA, TEXAS
M.W. KELLOGG P.O. NO. 6014-0201-C210-01
ITEM NO. PS-2001-220000-41-5004
1ST REACTOR 1ST GAS COOLER
MANUFACTURER'S SERIAL NO. 9459
WIT #41001027



CROSS BAFFLE & SUPPORT DETAILS

MAT'L: SA-36

BAFFLES VIEWED FROM SHELL SIDE OF (BTS)



CERTIFIED PRINT
MAY 12 1995
TEXAS METAL FABRICATING CO.
A TRINITY INDUSTRIES CO.
HOUSTON, TEXAS

NO.	SIZE	LENGTH
4	1/2" φ	20'-9"
4	1/2" φ	23'-2 1/2"
TIE RODS & NUTS		

NO.	SIZE	LENGTH
10	3/4" φ	4'-2 7/8"
32	1/4" φ	2'-1 1/8"
8	1/2" φ	2'-4 7/8"
4	1/2" φ	10 5/8"
4	3/4" φ	3'-4 1/8"
SPACERS		

PHILLIPS SUMIKA POLYPROPYLENE COMPANY
PASADENA, TEXAS
M.W. KELLOGG P.O. NO. 6014-02D1-C210-01
ITEM NO. PS-2001-220000-41-5004
1ST REACTOR 1ST GAS COOLER
MANUFACTURER'S SERIAL NO. 9459
WTT #41001027

FABRICATION DETAIL - BUNDLE ASSEMBLY					
MADE	DATE	CHKD	DATE	APVD	DATE
DLT	12/27/94	Jm	1-25-95	Jm	1-25-95
REFERENCE:					94062
NO. 9459					
SHEET 12					

REVISIONS
1 REV. BUNDLE TAPPING
DLT/4-20-95
2 ADDED SLIDE RAILS
DLT/5-8-95