

#101490

FORM U-1 MANUFACTURER'S DATA REPORT FOR PRESSURE VESSELS
As Required by the Provisions of the ASME Code Rules, Section VIII, Division 1

1. Manufactured and certified by OHMSTEDE, INC., ST. GABRIEL PLANT, 4250 HWY. 30, ST. GABRIEL, LA 70776
(Name and address of Manufacturer)

2. Manufactured for BECHTEL CORPORATION GAITHERSBURG, MARYLAND
(Name and address of Purchaser)

3. Location of installation EXXON CHEMICAL
(Name and address)

4. Type: HORIZONTAL HEAT EXCHANGER 738045
(Horizontal, vertical, or sphere) (Tank, separator, jacket, vessel, heat exch., etc.) (Mfg's serial No.)

730845 1197 1997
(ICRPN) (Drawing No.) (Rev.) (Nat'l. Bd. No.) (Year Built)

5. ASME Code, Section VIII, Division 1 1995 ED/1996 AD Rev.2 1197 1997
Edition and Addenda (date) Code Case No. Special Service per UG-120(d)

Items 6-11 incl. to be completed for single wall vessels, jackets of jacketed vessels, shell of heat exchangers, or chamber of multi-chamber vessels.

6. Shell (a) No. of course(s): 1 (b) Overall length (ft & in.): 7' 7 3/4"

No.	Course(s)		Material Spec./Grade or Type	Thickness		Long. Joint (Cat. A)			Circum. Joint (Cat. A, B, & C)			Heat Treatment	
	Diameter, in.	Length (ft & in.)		Nom.	Corr.	Type	Full, Spot, None	Eff.	Type	Full, Spot, None	Eff.	Temp.	Time
1	24"OD	7' 7 3/4"	SA106B	.687	.06"	S	NONE	1.0	--	--	--	--	--

No.	Location (Top, Bottom, Ends)	Thickness		Radius		Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure		Category A		
		Min.	Corr.	Crown	Knuckle					Convex	Concave	Type	Full, Spot, None	Eff.
(a)														
(b)														

If removable, bolts used (describe other fastening) SA193-B7, 3/4" (32)
(Mat'l. Spec. No., Grade, size, No.)

8. Type of jacket -- Jacket closure --
(Describe as ogee & weld, bar, etc.)

If bar, give dimensions -- If bolted, describe or sketch.
9. MAWP 210 -- psi at max. temp. 366 -- °F. Min. design metal temp. 10 °F at 210 psi.
(internal) (external) (internal) (external)

10. Impact test NO PER UCS-66(a)
(Indicate yes or no and the component(s) impact tested)

11. Hydro., pneu., or comb. test press. 428 PSI Proof test --

Items 12 and 13 to be completed for tube sections.

12. Tubesheet: (2) SA240-304L 22.626" 2 1/8" .06" WELDED
Stationary (Mat'l Spec. No.) Dia., in. (subject to press.) Nom. thk., in. Corr. Allow., in. Attachment (welded or bolted)

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Floating (Mat'l Spec. No.) Dia., in. Nom. thk., in. Corr. Allow., in. Attachment

13. Tubes: SA249TP304 3/4" .065" 481 STRAIGHT
Mat'l Spec. No., Grade or Type O.D., in. Nom. thk., in. or gauge Number Type (Straight or U)

Items 14-18 incl. to be completed for inner chambers of jacketed vessels or channels of heat exchangers.

14. Shell (a) No. of course(s): 2 (b) Overall length (ft & in.): 2' 7 7/16"

No.	Course(s)		Material Spec./Grade or Type	Thickness		Long. Joint (Cat. A)			Circum. Joint (Cat. A, B, & C)			Heat Treatment	
	Diameter, in.	Length (ft & in.)		Nom.	Corr.	Type	Full, Spot, None	Eff.	Type	Full, Spot, None	Eff.	Temp.	Time
1	24"OD	1' 8 1/2"	SA106B	.687	0"	S	NONE	1.0	1	SPOT	--	--	--
1	*	0' 10 15/16	SA516-70	.625	0"	1	SPOT	.85	1	SPOT	--	--	--

No.	Location (Top, Bottom, Ends)	Thickness		Radius		Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure		Category A		
		Min.	Corr.	Crown	Knuckle					Convex	Concave	Type	Full, Spot, None	Eff.
(a)	END	2"	0"	--	--	--	--	--	28 5/8"	FLAT	FLAT	--	--	--
(b)														

If removable, bolts used (describe other fastening) SA193-B7, 3/4" (32)
(Mat'l Spec. No., Grade, size, No.)

FORM U-1 (Back)

16. MAWP 265 -- psi at max. temp. 366 -- °F. Min. design metal temp. 15 °F at 265 psi.
(internal) (external) (internal) (external)

17. Impact test NO PER UCS66(a)

(Indicate yes or no and the component(s) impact tested)

18. Hydro., pneu., or comb. test press. 432 PSI Proof test --

19. Nozzles, inspection, and safety valve openings:

Purpose (Inlet, Outlet, Drain, etc.)	No.	Diameter or Size	Flange Type	Material		Nozzle Thickness		Reinforcement Material	How Attached		Location (Insp. Open.)
				Nozzle	Flange	Nom.	Corr.		Nozzle	Flange	
IN/OUT	1EA	8"	150#WN	SA106B	SA105	.500"	.060"	INHERENT	FPW	FPW	--
IN	1	14"	300#WN	SA106B	SA105	.750"	0"	INHERENT	FPW	FPW	--
OUT	1	14"	300#WN	**	SA105	**	0"	INHERENT	--	FPW	--
PRESSURE	2	3/4"	CPLG	SA105	--	6000#	.060"	INHERENT	FPW	--	--
TEMP.	2	1"	CPLG	SA105	--	6000#	.060"	INHERENT	FPW	--	--
PRESSURE	1	3/4"	CPLG	SA105	--	6000#	0"	INHERENT	FPW	--	--
TEMP.	1	1"	CPLG	SA105	--	6000#	0"	INHERENT	FPW	--	--

20. Supports: Skirt NO Lugs -- Legs -- Others (2) SADDLES Attached SHELL, WELDED
(Yes or no) (No.) (No.) (Describe) (Where and how)

21. Manufacturer's Partial Data Reports properly identified and signed by Commissioned Inspectors have been furnished for the following items of the report:
 (List the name of part, item number, mfg's. name and identifying number)

22. Remarks: #14 CONT: *23 7/8"OD X 14 3/8"OD CONE,
*19 CONT: *FLANGE WELDED DIRECTLY TO CONE, SPOT RADIOGRAPHY REQ., EFF. .85, UG46(a)
END FLANGES: SA105N
ITEM# BM-E-1 PO# 23402-POA-ME14

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. 10562 Expires 7-14, 19 2000

Date 1-14-98 Name OHMSTEDE, INC., ST. GABRIEL PLANT Signed Kell B. Barge
(Manufacturer) (Representative)

CERTIFICATE OF SHOP INSPECTION

I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State or Province of LA and employed by H.S.B.I. & I. CO. of HARTFORD, CT have inspected the pressure vessel described in this Manufacturer's Data Report on 12-5-, 19 97, 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 1-20-98 Signed John Stoyard Commissions NB 8016 A LA 1191
(Authorized Inspector) (Nat'l Board Incl. endorsement, State, Province and No.)

CERTIFICATE OF FIELD ASSEMBLY COMPLIANCE

We certify that the statements on this report are correct and that the field assembly construction of all parts of this vessel conforms with the requirements of ASME Code, Section VIII, Division 1.

U Certificate of Authorization No. _____ Expires _____, 19 _____

Date _____ Name _____ Signed _____
(Assembler) (Representative)

CERTIFICATE OF FIELD ASSEMBLY INSPECTION

I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State or Province of _____ and employed by _____ of _____ have compared the statements in this Manufacturer's Data Report with the described pressure vessel and state that parts referred to as data items _____, not included in the certificate of shop inspection, have been inspected by me and to the best of my knowledge and belief, the Manufacturer has constructed and assembled this pressure vessel in accordance with ASME Code, Section VIII, Division 1. The described vessel was inspected and subjected to a hydrostatic test of _____ psi. 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 _____ Signed _____ Commissions _____
(Authorized Inspector) (Nat'l Board Incl. endorsement, State, Province and No.)