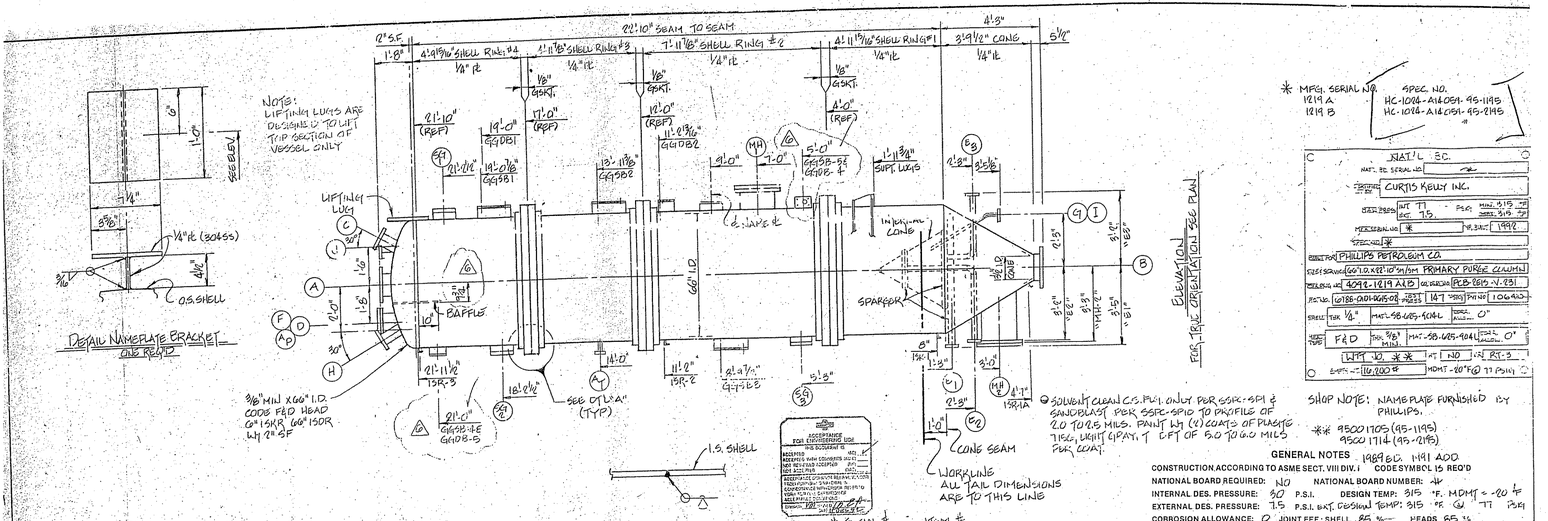


* SERIAL # 1219 A, 1219 B — ITEM # HC-1024-A14059-95-1195, HC-1024-A14059-95-1295

* MFG. SERIAL NO. 1219 A, 1219 B — SPEC. NO. HC-1024-A14059-95-1195, HC-1024-A14059-95-1295

NAT'L BD.			
MFG. BD. SERIAL NO.			
MANUFACTURED BY	CURTIS KELLY INC.		
DESIGN PRESS.	INT. 77 / EXT. 15	PSIG	MINT. 315 °F / MAXT. 315 °F
MFG. SERIAL NO.	*	YR. BLT.	1992
SPECIFIED	*		
SHIPPED TO	PHILLIPS PETROLEUM CO.		
SIZE & SERVICE	66" I.D. X 22'-10" S/S/SM PRIMARY PURGE COLUMN		
DRAWING NO.	4092-1219 A & B	OR VERSION	PCB-2615-V-231
PO NO.	6188-0001-0015-02	DESIGN PRESS.	147 PSIG
SHELL	TOK 1/4"	MAT'L SA-105-1204L	CORR. ALLOW. 0"
HEADS	F&D	TOK 5/8" BUILD	MAT'L SA-105-1204L CORR. ALLOW. 0"
	WPT NO. * *	HT NO	NO. RT-3
SHIPPING WT. 116,200 #		MDMT -20°F @ 77 PSIG	

SHOP NOTE: NAMEPLATE FURNISHED BY PHILLIPS.

** 9500 1705 (95-1195)
9500 1714 (95-1295)

GENERAL NOTES

1989 ED. 1991 ADD

CONSTRUCTION ACCORDING TO ASME SECT. VIII DIV. I — CODE SYMBOL IS REQ'D

NATIONAL BOARD REQUIRED: NO — NATIONAL BOARD NUMBER: N/A

INTERNAL DES. PRESSURE: 30 P.S.I. — DESIGN TEMP: 315 °F. MDMT = -20 °F

EXTERNAL DES. PRESSURE: 15 P.S.I. EXT. DESIGN TEMP: 315 °F @ 77 PSIG

CORROSION ALLOWANCE: 0 — JOINT EFF.: SHELL 85 % HEADS 85 %

STRESS RELIEVE: NO — RADIOGRAPH: RT-3 — MFG'S. SERIAL NO. 1219 A & B

MAX. ALLOWABLE WORKING PRESSURE: 77 — P.S.I. LIMITED BY: CONS

HYDROSTATIC TEST @ 147 P.S.I. BASED ON: 1.5x(MAWP + HD) x 17800/18705

INSPECTION BY: OLD REPUBLIC INSURANCE CO. & CUSTOMER

ALL BOLT HOLES TO STRADDLE NORMAL CENTER LINES UNLESS NOTED.

ALL MACHINED SURFACES & THREADED CONNECTIONS TO BE PROTECTED.

INSTALL WOOD OR METAL PROTECTORS ON FLANGES.

VESSEL TO BE DRAINED AND CLEANED BEFORE SHIPMENT.

ALL VESSEL PADS TO HAVE 1/4" N.P.T. TELLTALE HOLES.

WELD PROCEDURE NO. 59, 69, 95, 95A, 96, 102, 114, 128, 159

SANDBLAST: ⊙

PAINT:

FINAL CERTIFIED PRINTS

SHIP DISASSEMBLED.

GASKET SURFACE FINISH TO BE 125-150 RMS.

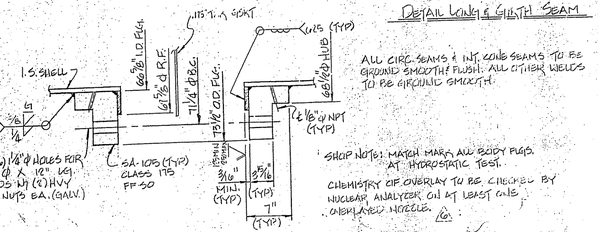
REMOVE MANWAY PLATES BEFORE HYDROTEST & REINSTALL AFTER TESTING

LIQUID PENETRANT EXAMINATION OF WELDS IS REQ'D

SHOP TO FURNISH (1) SPARE GSKT. FOR EA. SET OF BODY FLGS. & (2) SPARE GSKTS. FOR MANWAYS & EA. NOZZ. W/ BLD. FLG.

ENTERED ... 07 1993

APPROX. VOL. 440 GALS



DETAIL "A"

SHOP NOTE: MATCH MARK ALL BODY FLGS. AT HYDROSTATIC TEST.

CHEMISTRY OF OVERLAY TO BE CHECKED BY NUCLEAR ANALYZER ON AT LEAST ONE OVERLAYED NOZZLE.

MATERIAL NOTE

UNLESS OTHERWISE NOTED ALL MATERIAL ON THIS DRAWING ONLY TO BE AS FOLLOWS:

SHELL SB-625-904L
HEADS SB-625-904L
VESSEL SUPPORTS SA-240-304
BASE PLATES SA-105/SB-464-N08020
FORGED FLANGES #
PLATE FLANGES #
PIPE NECKS SB-464-20Cb (W.L.B.)
PLATE NECKS SB-625-904L
REINFORCING PADS SA-240-304
WELD FITTINGS SB-464-N08020
BOLTING SA-193-B7 / SA-194-2H (GALV.)
GASKETS FLEXITALLIC ALLOY 20 W/ "FLEXITE SPIR" FILLER
INTERNALS SB-625-904L / SB-464-20Cb
INTERNAL GSKTS. 1/16" VITON
LIFTING LUGS SA-240-304
INTERNAL BOLTS: ALLOY 20

AT	1	2"	300#	RF SO	THERMOWELL	
SGH-B	8	6"	150	STUD OUTLET	SIGHT GLASS	
MH 42"	2	18"	150	RF SO	MANWAY	
AP	1	1"		RFWN	PRESS. XMTR	
J	1	6"		RF SO	BIN VENT FLUFF IN	
I	1	6"			EA. MFLG	
H	1	6"			BAG FLTR. FLUFF IN	
G	1	2"			ROTARY VENT IN	
F	1	10"			PURGE GAS OUTLET	
EJ-B	8	3"			PURGE INLET	
D	1	12"			SPARE	
C	1	2"		RF SO	PSE	
B	1	18"		LAP JOINT	FLUFF OUTLET	
A	1	10"	150	RF SO	FLUFF INLET	
MARK	NO. REQ'D	SIZE	CLASS	TYPE	SERVICE	

SCHEDULE OF OPENINGS

NAT'L. BD. #

RT-3 W

CERTIFIED BY CURTIS KELLY INC. HOUSTON, TEXAS

MAX. ALLOW. WORK PRESS. 77 P.S.I. AT 315 °F
MIN. DESIGN METAL TEMP. -20 °F AT 77 P.S.I.
SERIAL NO. * DATE 1992 WT. 116,200#
MAX TEST PRESS. 147 P.S.I. O.D. 66 7/8"
SHELL THK. 1/4" MATRL. SA-105 ITEM NO. *
P.O. NO. 6188-0001-0015-02
TEST PRESS. 1.5 P.S.I.G @ 315 °F
66" I.D. X 22'-0" S/S PRIMARY PURGE COLUMN

NAT'L. BD. #

CERTIFIED BY CURTIS KELLY INC. METAL FABRICATORS HOUSTON, TEXAS

P.O. NO. ITEM NO.
O.D. SH. THK. HD. THK.
MAX. ALLOW. WORK PRES. P.S.I.
MAX. TEST PRESS. P.S.I.
DESIGN TEMPERATURE °F.
SERIAL NO. WT. DATE

NO.	BY	REVISION	DATE
G	BW	REV AS NOTED	7-7-92
E	BW	REV AS NOTED	7-6-92
D	BW	REV AS NOTED	6-26-92
B	BW	REV AS NOTED	6-16-92
B	BW	REV AS NOTED	6-16-92
A	BW	REVISED THE CONNECT	6-16-92

CUST. REF. DWGS. PCB-2615-V-231 ✓ V-233 ✓ V-269 ✓ V-272 & V-344

SHIPPING WT. 104,200# — TEST WT. 83,700#

S.O. 1219 A & B — ITEM HC-1024-A 1059-95-1195, HC-1024-A14059-95-1295 — (2) TWO REQ'D.

CURTIS KELLY, INC.

14875 WATERLOO — HOUSTON, TEXAS

66" I.D. X 22'-10" SEAM TO SEAM
PRIMARY PURGE COLUMN
CUST: THE M.W. KELLOGG CO / PHILLIPS PETROLEUM CO

DWN. BW	DATE 6-16-92		FILE 4092
CHK. SHW	JOB NO.		DWG. NO. 4092-1219 A & B
APP.	PURCHASE ORDER NO. 6188-0101-0015-02		SHT. NO. 1 OF 8

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