

WELD # SCHEDULE									
WELD #	WPS #	WPS #	WELDER ID	WELDER ID	HEAT #	HEAT #	HEAT #	HEAT #	HEAT #
FLG	VESSEL A	VESSEL B	VESSEL A	VESSEL B	VESSEL A	VESSEL B	VESSEL A	VESSEL B	VESSEL C
1									
2	306	306	L	L	HT-F80971	HT-F80971			
3	302	302	L	L	5543JRM	5543			
4	302	302	L	L	HT-F80971	HT-F80971			
10	303	303	N	N	79813	79813			
11	303	303	L	L	23715	23715			
12	306	306	N	N	32670	32690			
13	302	302	N	N	23715	23715			
14	303	303	N	N	838413	838413			
15	303	303	L	L	HT-F80971	HT-F80971			
16	303	303	L	L	HT-80231	HT-80231			
17	303	303	L	L	67227	67227			
18	303	303	L	L	476994	476994			
19	303	303	L	L	4599	4599			
20	303	303	L	L	HT-808151	HT-808151			
21	303	303	L	L	HT-0934	0934			
22	306	306	N	N	HT-22932				
23	302	302	L	L	HT-22345	HT-L23145			
24	302	302	L	L	HT-24482	HT-24482			
25	306	306	N	N	23715	23715			
26	302	302	L	L	32690	32690			
27	306	306	N	N	67227	67227			
28	302	302	L	L	80971	80971			
29	306	306	N	N	67227	67227			
30	306	306	N	N	476994	476994			
31	302	302	L	L	838413	838413			
32	306	306	N	N	L23145	L23145			
33	302	302	L	L	838413	838413			
34	306	306	N	N	23715	23715			
35	306	306	N	N	838413	838413			

220635-
GENERAL
ARRANGEMENT

REFERENCE DRAWINGS	
DWG. NO.	TITLE

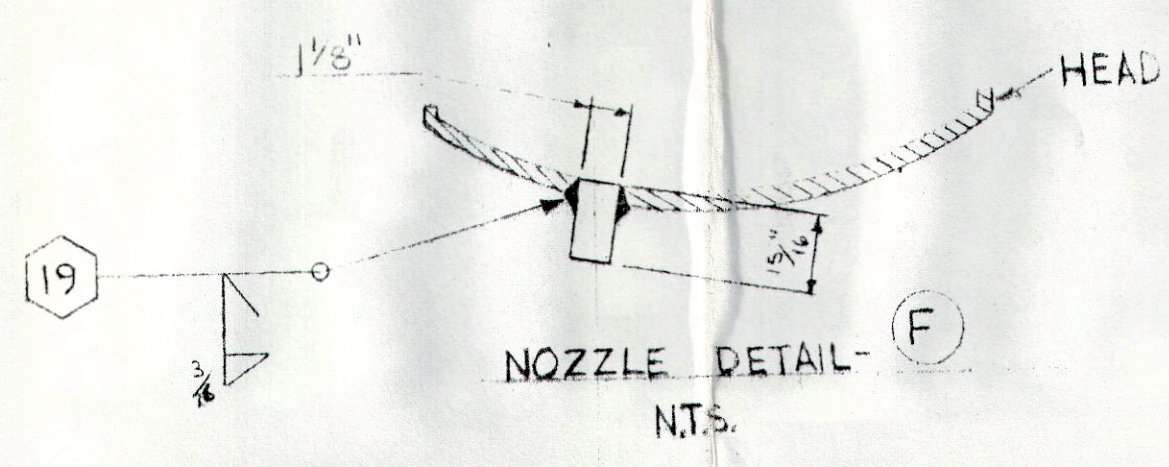
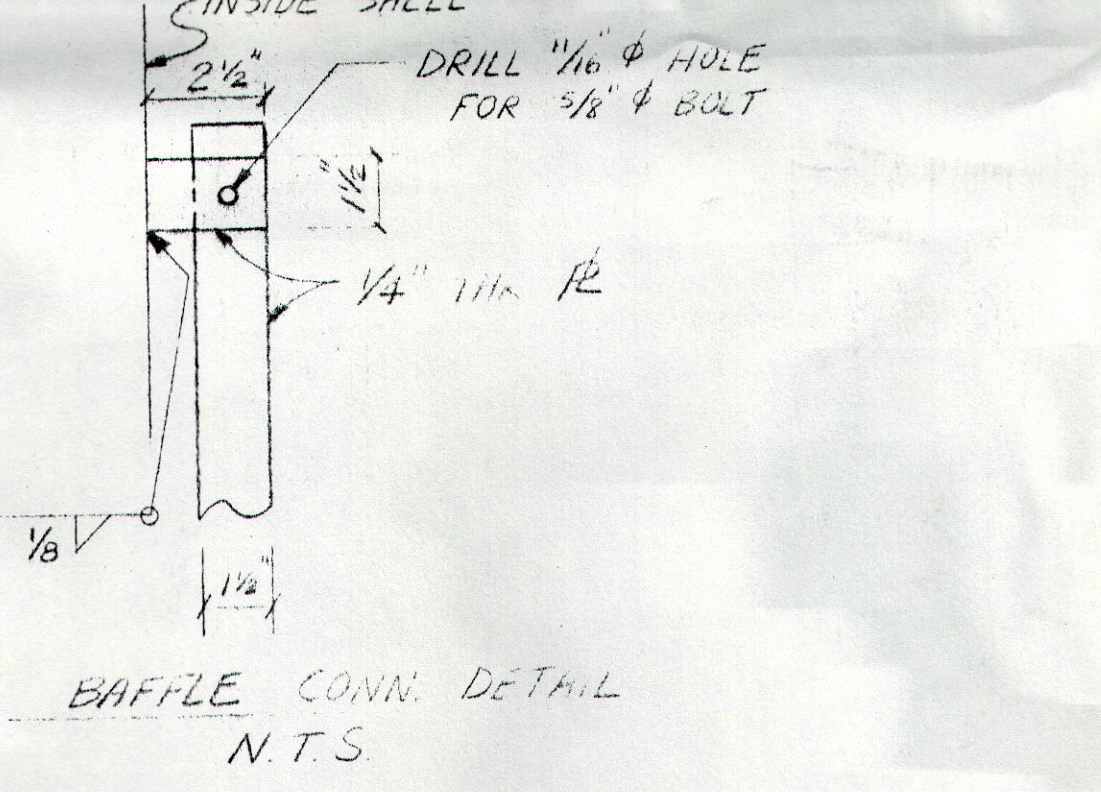
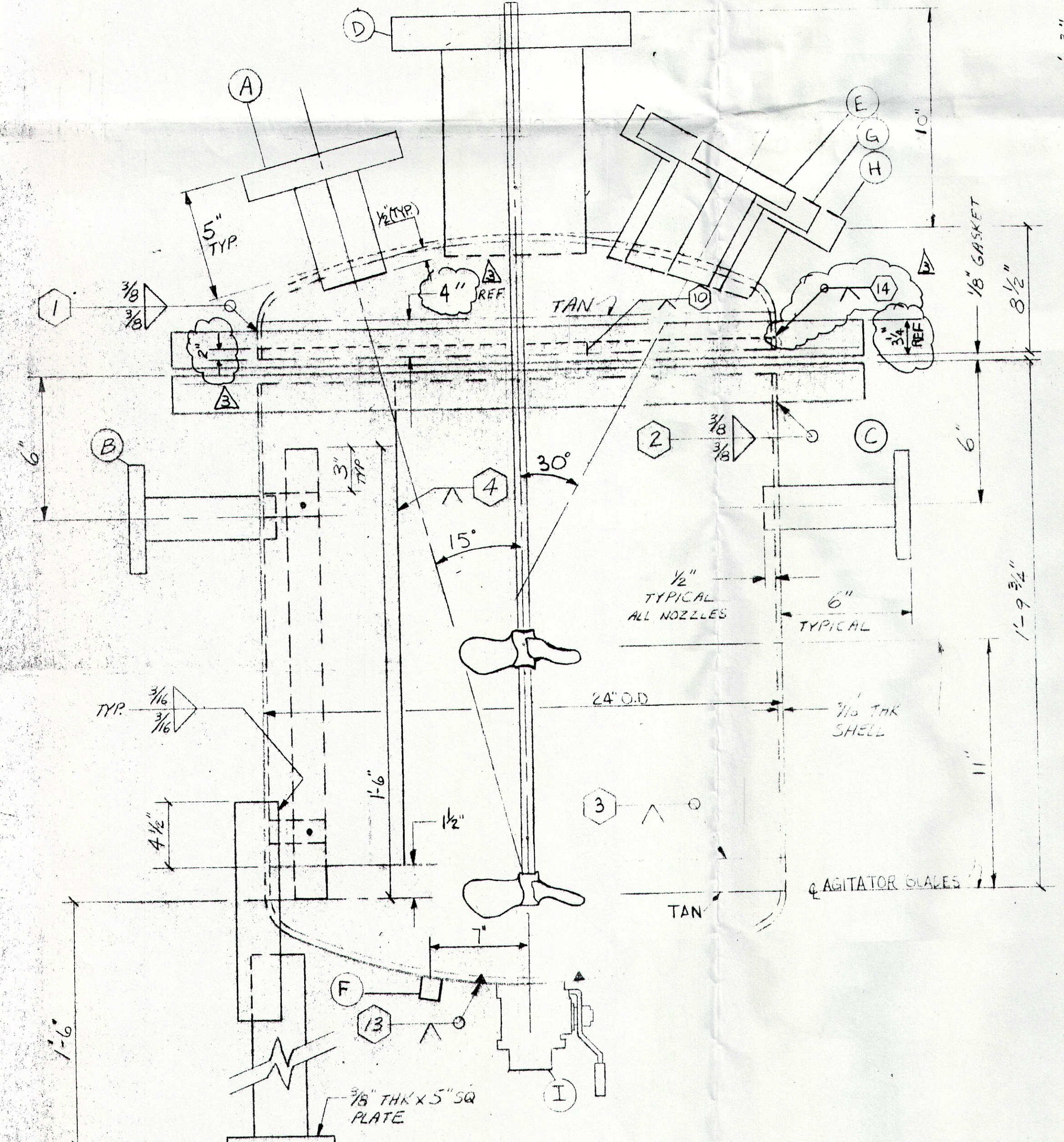
NOZZLE SCHEDULE						
MARK	QTY	SIZE	SCHED	FLANGE	TYPE	DESCRIPTION
A	1	3"	30	150#	RFSO	SRV
B	1	1 1/2"	40			STYRENE TOLUOL INLET
C	1	1 1/2"	40			SYRUP INLET & RETURN
D	1	6"	80		RFSO	AGITATOR
E	1	1 1/2"	80		RFSO	VENT # CAGE
F	1	1/2"			1/2" 2500# HALF CPLS	THERMOCOUPLE
G	1	4"	80	150#	RFSO	VIEW PORT
H	1	6"	80	150#		CHARGE PORT
I	1	2"				THIRD FLYT CHARGE ON P&M - FLUSH WATER DRIVE

DESIGN CONDITIONS
 DESIGN PRESSURE 60 PSIG & FULL VACUUM
 DESIGN TEMP 100° F MAX, -20° F MIN
 CORR ALLOW NONE
 X-RAY NONE

MATERIALS OF CONSTRUCTION
 BOLT FLANGES SA182 F304 150#
 SHELL SA132 TP304 1/2" THK
 HEADS SA240 TP304 3/8" THK MIN
 TOP HEAD NOZZLE NECK SA312 TP304 SCH 80
 SHELL NOZZLE NECK SA312 TP304 SCH 40
 FLANGES AS NOTED 150# RFSO SA132 F304

LES SUPPORTS A589 OR EQUAL
 BOLT SA193 BX
 GASKETS 1/8" THK TEFLON
 BAFFLES SA240 TP304 1/4" THK
 LIFT LUGS SA36 OR EQUAL

- NOTES:
 1. VESSEL TO BE DESIGNED AND FABRICATED IN ACCORDANCE WITH ASME CODE SECTION VIII DIV. 1. - CODE STAMP REQ'D.
 2. HYDROTEST AT 90 PSIG, SAGE AT TOP
 3. ALL BOLT HOLES TO STRADDLE NORMAL VESSEL CENTERLINES
 4. VESSEL WEIGHT EMPTY: 850#
 FULL: 1225#
 AGITATOR: 140#
 5. ALL CARBON STEEL MATERIAL TO BE SHOP PRIME PAINTED
 6. ALL WELDS ROUND SMOOTH INS.
 7. DRAWING SHOWS ONE VESSEL, 2 REQUIRED



REV.	DATE	BY	CHKD	DESCRIPTION	DISC	PROJ	ENGR
4	1/2	AC		REV. LIFT LUG DET., WELD SCHEDULE			
3	1/15	AS		ADDED WELD 14, ADD 2 TO TOP HEAD			
2	1/16	CLC		REV SEC A-A DET.			
1	1/12	POS1R		REV NOZZLE DET. (SCH. ADDED LUG DET.)			

ARCO CHEMICAL CO.
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PROCESS INDUSTRIES, INC.
 ENGINEERS - FABRICATORS - CONSTRUCTORS
 801 Dawson Drive Newark, DE 19713
 TITLE: DYLAK FEED VESSELS A+B
 DWG. NO. 8840-1
 REV. NO. 4

PV1853