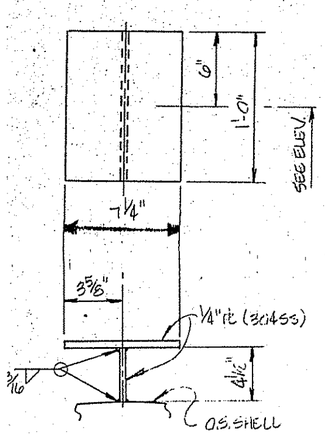
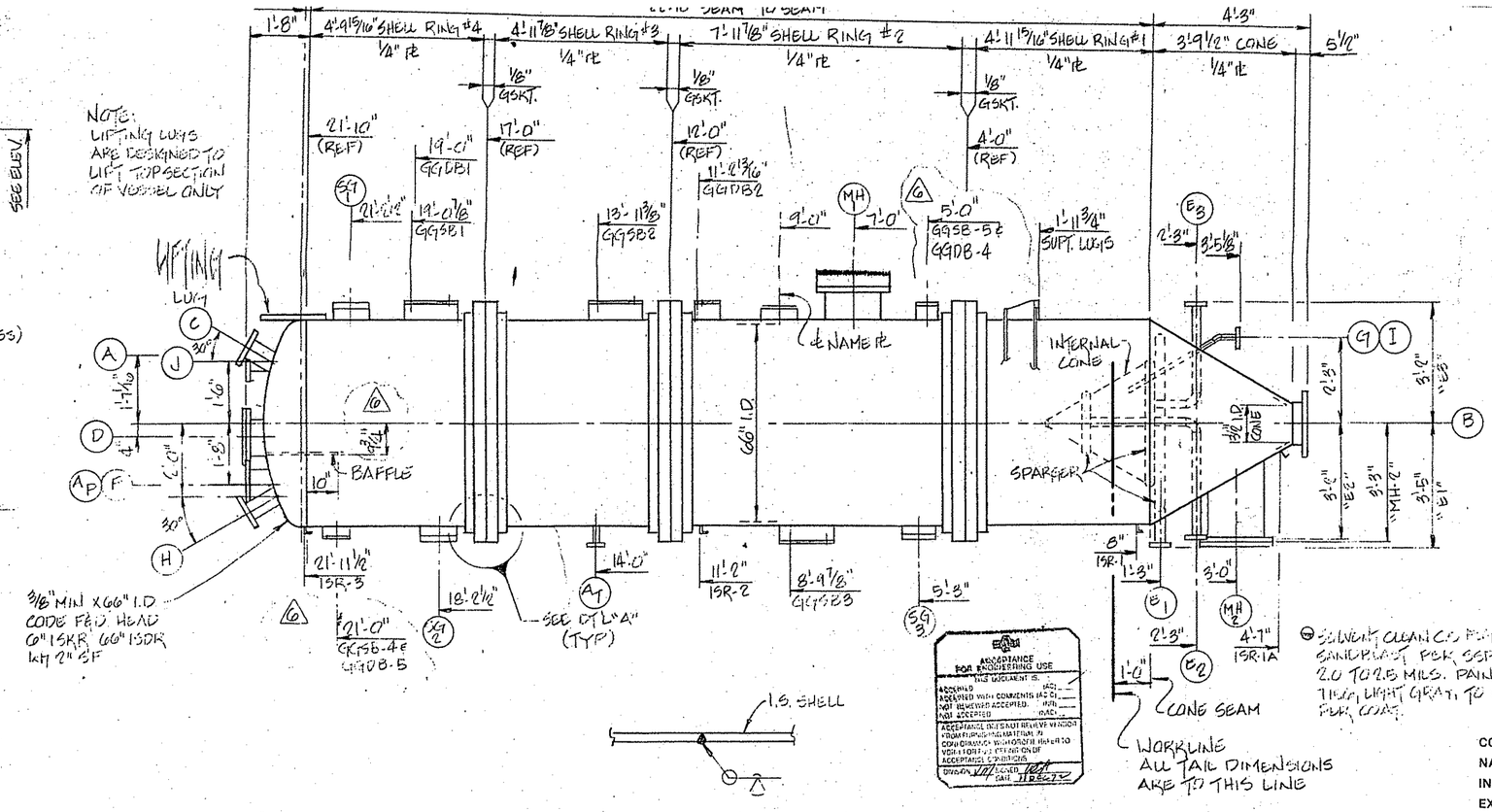


DETAIL NAMEPLATE BRACKET
ONE REQ'D



ELEVATION
FOR TRUE ORIENTATION SEE PLAN

ACCEPTANCE FOR ENGINEERING USE
THIS DOCUMENT IS:
ACCEPTED (NO)
ACCEPTED WITH COMMENTS (NO)
NOT REVIEWED ACCEPTED (NO)
NOT ACCEPTED (NO)
ACCEPTANCE DOES NOT RELIEVE VENDOR FROM FURNISHING MATERIAL IN CONFORMANCE WITH ORDER WITH RESPECT TO SATISFACTORY PERFORMANCE OF EQUIPMENT
ACCEPTANCE CONDITIONS
DIVISION MT SIGNED DATE 11/26/92

NAT'L BD.	CURTIS KELLY INC.
NAT'L BD SERIAL NO.	*
CERTIFIED BY	CURTIS KELLY INC.
MAX. PRESS	INT. 77 - PSIG MIN. 315 °F EXT. 7.5 MAX. 315 °F
MFR'S SERIAL NO.	1219C
YEAR BUILT	1992
SPECIFIED	HC-1024-A 140EA - 95-3195
BUILT FOR	PHILLIPS PETROLEUM CO.
SIZE & SERVICE	66" I.D. X 22'-10" SM/SM PRIMARY PURGE COLUMN
MFR'S PURCH. NO.	4092-1219C
CO. ORDER NO.	PCB-2615-V-336
P.O. NO.	6788-0101-0615-02
TEST PRESS	147 PSIG
PWHT NO	10640
SHELL	TK 1/4" MAT-SB-625-9014L CORR. ALLOW. 0"
HEAD TYPE	F&D TK 3/8" MIN. MAT-SB-625-9014L CORR. ALLOW. 0"
WT. NO.	95001783 HT NO VT RT-3
EMPTY WT.	16,200 # MDMT -20°F @ 77 PSIG

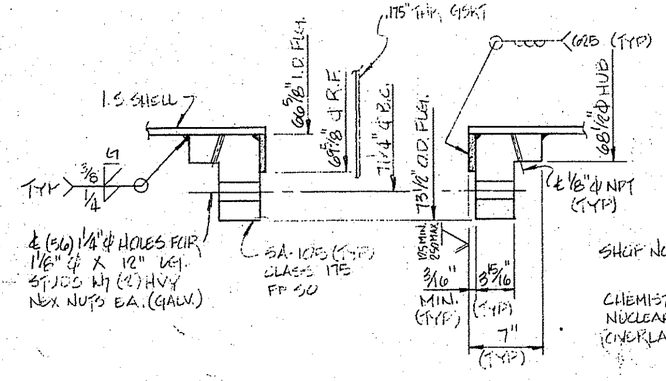
SHOP NOTE: NAMEPLATE FURNISHED BY PHILLIPS.

SOLVENT CLEAN CS PER SSPC-SP1 & SANDBLAST PER SSPC-SP10 TO PROFILE OF 2.0 TO 2.5 MILS. PAINT W/ (2) COATS OF PLASITE 7169 LIGHT GRAY TO DFT OF 5.0 TO 6.5 MILS PER COAT.

GENERAL NOTES 1989 ED. 1991 ADD

CONSTRUCTION ACCORDING TO ASME SECT. VIII DIV. 1 CODE SYMBOL IS REQ'D
NATIONAL BOARD REQUIRED: NO NATIONAL BOARD NUMBER: #
INTERNAL DES. PRESSURE: 50 P.S.I. DESIGN TEMP: 315 °F. MDMT = -20 °F
EXTERNAL DES. PRESSURE: 7.5 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
MAX. ALLOWABLE WORKING PRESSURE: 77 P.S.I. LIMITED BY: CONE
HYDROSTATIC TEST @ 147 P.S.I. BASED ON: 1.5 x (MAWP + HD) x 17600/149035
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 ¼" N.P.T. TELLTALE HOLES.
WELD PROCEDURE NO. 59, 64, 65, 65A, 66, 102, 114, 128, 159
SANDBLAST: SSPC-SP10
PAINT: SSPC-SP1
SHIP DISASSEMBLED.
GASKET SURFACE FINISH TO BE 125-250 RMS.
REMOVE MANWAY PLUGS 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. LW BLD. FLG.
APPROX. VOL. 4440 GALS

FINAL CERTIFIED PRINTS
ENTERED DEC 07 1992



DETAIL "A"

DETAIL WELD @ GIRTH SEAM

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

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

ALL CIRC. SEAMS & INT. CONE SEAMS TO BE GROUND SMOOTH & FLUSH. ALL OTHER WELDS TO BE GROUND SMOOTH.

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.	1219C DATE 1992 WT. 16,200#
MAX. TEST PRESS.	P.S.I. 147 O.D. 66½"
SHELL THK.	1/4" HD. THK. 3/8" ITEM NO. *
P.O. NO.	6788-0101-0615-02
EXT. PRESS. 7.5 PSIG @ 315 °F	
66" I.D. X 22'-10" SM/SEAM PRIMARY PURGE COLUMN	

* HC-1024-A140EA-95-3195

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 PRESSURE P.S.I.		
DESIGN TEMPERATURE °F.		
SERIAL NO.	WT.	DATE

NO.	BY	REVISION	DATE
6	BEV	REV. AS NOTED	5/4/92
5	BEV	REV. AS NOTED	5/4/92
4	BEV	REV. AS NOTED	4/24/92
3	BEV	REV. AS NOTED	3/19/92
2	BEV	REV. AS NOTED	3/5/92
1	BEV	ISSUED FOR CONST.	2/24/92
0	BEV	ISSUED FOR APPROVAL	9/30/91

AT	1	2"	300	RFSO	THERMOWELL
SGIN3	3	6"	150	STUD. OUTLET	SIGHT GLASS
MH&2	2	18"	150	RFSO	MANHOLE
AP	1	1"		RFWN	PRESS. XMTR
J	1	6"		RFSO	BIN VENT FLUFF IN
I	1	2"			SAMPLE
H	1	6"			BAG FLTR. FLUFF IN
G	1	2"			ROTARY VENT IN
F	1	10"			PURGE GAS OUTLET
EIN3	3	3"			PURGE INLET
D	1	12"			SPARE
C	1	2"		RFSO	PSE
B	1	14"		LAP JOINT	FLUFF OUTLET
A	1	12"	150	RFSO	FLUFF INLET
MARK	NO. REQ'D	SIZE	CLASS	TYPE	SERVICE

SCHEDULE OF OPENINGS

ATERIAL NOTE

THERWISE NOTED ALL MATERIAL RAWING ONLY TO BE AS FOLLOWS:

3-625-9014L	
SB-625-9014L	
UPPORTS	SA-240-304
TES	SA-240-304
LANGES	SA-105/SB-462-GR.60
ANGES	#
KS	1-1/4 - 20 Cb (W.D)
CKS	SB-625-9014L
ING PADS	SA-240-304
TINGS	SB-462-GR.60
SA-193-B7/SA-194-2H (GALV.)	
FLEX-TALLIC ALLOY 20 INT. FLEXITE SUPER FILLER	
S	SB-625-9014L/SB-462-GR.60
GSKTS. 1/16" VITON	INTERNAL BOLTS: ALLOY 20
PLUGS SA-240-304	
SUPT. RODS. SA-240-304	

-648

CUST. REF. DWGS.	PCB-2615-V-337 & V-344	
SHIPPING WT.	16,200#	TEST WT. 63,700#
S/O 1219C	ITEM HC-1024-A140EA-95-3195	ONE 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. BEV	DATE 4-6-92	FILE: 4092	
CHK. GHL	JOB NO.	DWG. NO. 4092-1219C	
APR. GHL	PURCHASE ORDER NO. 6788-0101-0615-02	SHT. NO. 1 OF 8	

338 A1