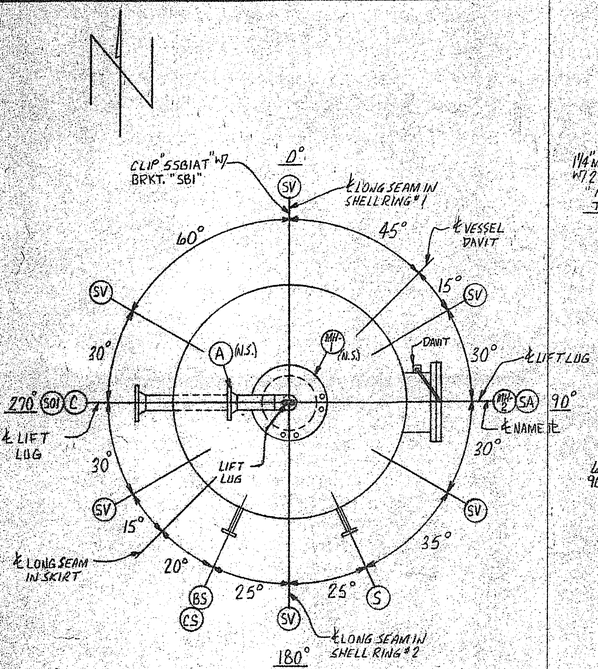
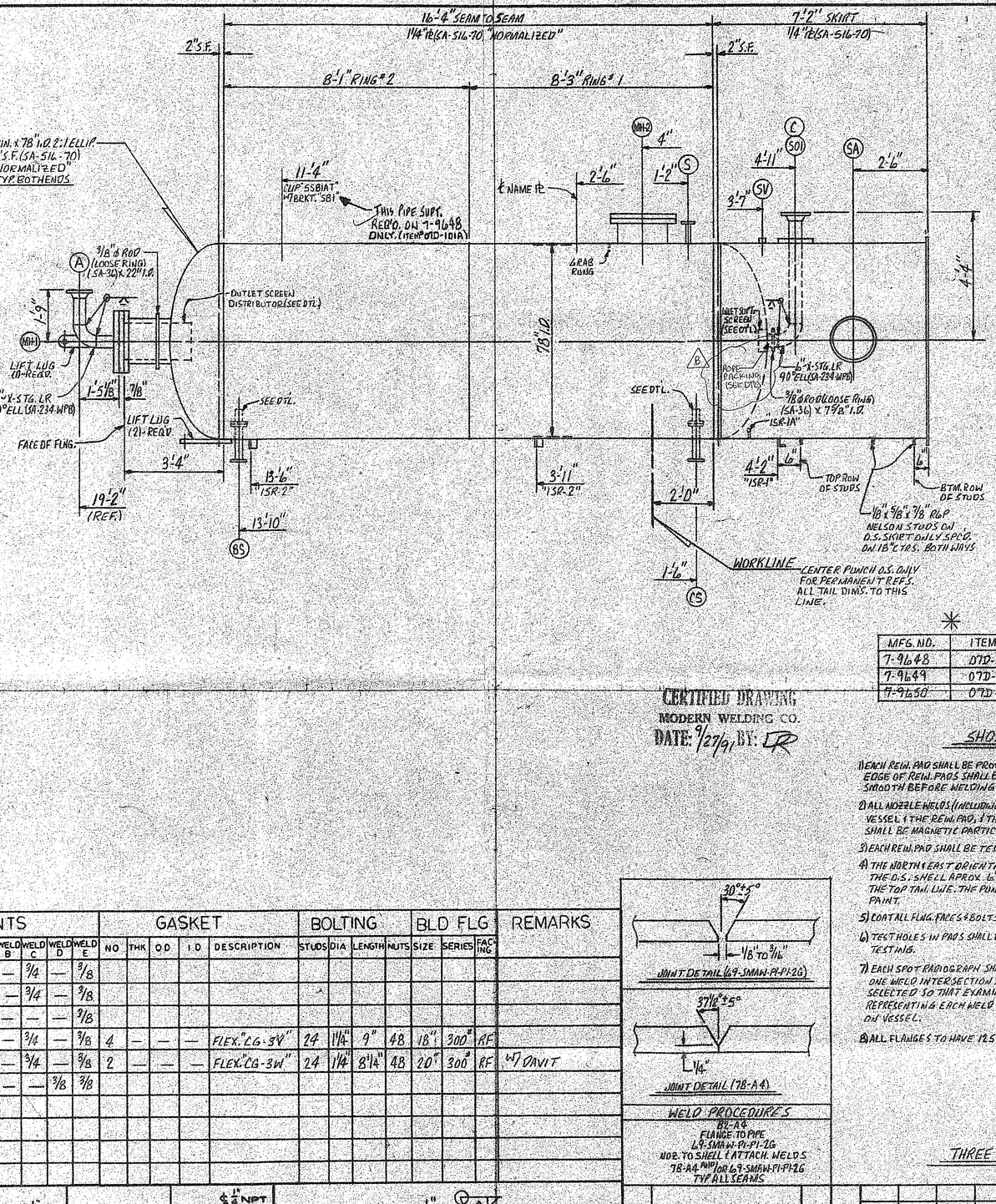
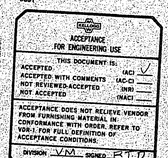


PLAN



MFG. NO.	ITEM NO.
7-9648	07D-101A
7-9649	07D-101B
7-9650	07D-101C

CERTIFIED DRAWING
MODERN WELDING CO.
DATE: 9/27/91 BY: LR



3045S NAMEPLATE ON A ¼" THK. "T" BRACKET (C.S.)

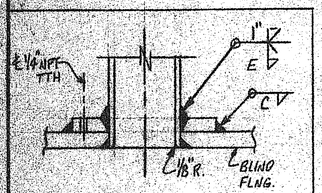
NAT'L BD. NO. Lazar

CERTIFIED BY
MODERN WELDING CO. INC.
HOUSTON, TEXAS

M.A.W.P.	412 ✓	P.S.I. AT	615 °F
MIN. DESIGN METAL TEMP.	10 °F AT	412 P.S.I.	
MFG'S. NO.	*	YEAR BUILT	1991
VACUUM		P.S.I. AT	°F
CUST. NO.	6636-02D1-D410-01	DWG. NO.	D7-9648
HYDRO	699 ✓ P.S.I. NEW AND COLD		
ITEM NO.	*	WT.	33500 LBS.

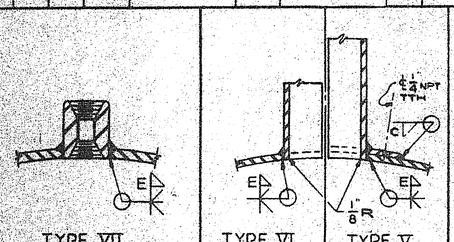
DESIGN PRESS: 390 PSI @ 615°F

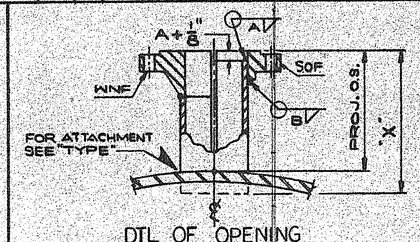
NAME PLATE DETAIL
PROJECT 4" FROM O.S. OF SHELL



TYPE VIII

MARK NO	NO REQD	FLANGE SIZE	SERIES	DESCRIPTION	NECK O.D	DESCRIPTION	REIN PAD THK	WIDTH	ATTACHMENTS TYPE	PROJ O.S.	"X"	WELD A	WELD B	WELD C	WELD D	WELD E	GASKET NO	THK	O.D	I.D	DESCRIPTION	BOLTING STUDS	DIA	LENGTH	NUTS	BLD FLG SIZE	SERIES	FACING	REMARKS
A	ONE	6"	300#	RF WNF	6 5/8"	X-STG. PIPE	1¼"	2½"	VIII	SEE ELEV.	—	—	—	¾	—	⅜													
C	ONE	6"	300#	RF WNF	6 5/8"	X-STG. PIPE	1¼"	2½"	V	SEE ELEV.	—	—	—	¾	—	⅜													
S	ONE	1"	300#	RF LWN x 12" LG.	2⅛"	LWN	—	—	VI	9¼"	—	—	—	—	—	⅜													
MH-1	ONE	18"	300#	RF LWN x 20" LG.	21"	LWN	1¼"	3"	V	SEE ELEV.	—	—	—	¾	—	⅜	4	—	—	—	FLEX. "CG-3W"	24	1¼"	9"	48	18"	300#	RF	
MH-2	ONE	20"	300#	RF LWN x 14" LG.	23⅛"	LWN	1¼"	4"	V	10¼"	—	—	—	¾	—	⅜	2	—	—	—	FLEX. "CG-3W"	24	1¼"	8¼"	48	20"	300#	RF	W/ DAVIT
BS, CS	ONE EA	1"	300#	RF LWN x 18" LG.	2⅛"	LWN	—	—	II	9¼"	SEE DTL.	—	—	—	⅜	⅜													





DTL OF OPENING

WELD PROCEDURES
B2-A4
FLANGE TO PIPE
L9-SMAW-P1-P1-2G
NOZ. TO SHELL & ATTACH. WELDS
7B-A4 AND/OR L9-SMAW-P1-P1-2G
TYP ALL SEAMS

SHOP NOTES

1) EACH REIN. PAD SHALL BE PROVIDED W/ (2) - ¼" N.P.T.T.H. THE OUTSIDE EDGE OF REIN. PADS SHALL BE GROUND OR OTHERWISE MADE REASONABLY SMOOTH BEFORE WELDING TO THE VESSEL.

2) ALL NOZZLE WELDS (INCLUDING WELDS BETWEEN NOZ. & THE REIN. PAD, VESSEL & THE REIN. PAD, & THE NOZ. & VESSEL UNDER THE REIN. PAD) SHALL BE MAGNETIC PARTICLE EXAMINED.

3) EACH REIN. PAD SHALL BE TESTED @ 25 PSIG W/ DRY AIR.

4) THE NORTH & EAST ORIENTATIONS SHALL BE CENTER PUNCHED ON THE O.S. SHELL APROX. ¼" ABOVE THE BTM. TAN. LINE & ¼" BELOW THE TOP TAN. LINE. THE PUNCH MARKS SHALL BE CIRCLED W/ WHITE PAINT.

5) ALL FLNG. FACES & BOLTS W/ RUST-VETO # 342 OR RUST-BAN # 324.

6) TEST HOLES IN PADS SHALL BE PLUGGED W/ A HEAVY GREASE AFTER TESTING.

7) EACH SPOT RADIOGRAPH SHALL BE A MIN. OF 6" IN LENGTH & AT LEAST ONE WELD INTERSECTION SHALL BE INCLUDED. SPOTS SHALL BE SELECTED SO THAT EXAMINATION IS MADE OF WELDS REPRESENTING EACH WELD PROCEDURE SPECIFICATION UTILIZED ON VESSEL.

8) ALL FLANGES TO HAVE 125 RB FINISH @ FACE.

NOTE
THREE VESSELS ARE REQ'D.

GENERAL NOTES

CONSTRUCTION ACCORDING TO SEC. VIII DIV. 1 1989 EDITION/ 89 ADD. CODE SYMBOL 15 REQ'D.
DESIGN PRESSURE 390 P.S.I. DESIGN TEMP. 615 °F
MAX. ALLOWABLE PRESSURE NEW & COLD 439 P.S.I. LIMITED BY SHELL
RADIOGRAPHING SPOT REQ'D. STRESS RELIEVE NO
JOINT EFF. SHELL 85 % HEADS 85 %
CORROSION ALLOWANCE SHELL 1/8" HEADS 1/8" NOZZLES 1/8"
HYDROSTATIC TEST 699 ✓ P.S.I. MFGRS. SERIAL NO. *
INSPECTION BY E.I.C. & CUSTOMER
MATERIAL SHELL SA-516-70 NORMALIZED" HEADS SA-516-70 "NORMALIZED"
NOZZLE NECKS SA-106-B/SA-105 PIPE SA-106-B
FLANGES SA-105 SUPPORTS # SKIRT SA-516-70
BAFFLES SA-516-70 PADS SA-516-70 "NORMALIZED"
BOLTING SA-193-B7 NUTS SA-194-2H
GASKETS FLEX. CG 304 S/S W/ 304 SS. COUPLING #
FILLER
SANDBLAST SOLVENT CLEAN PER SSPC-SP1 THEN WEAR WHITE BLAST PER SSPC-SP10
PAINT ONE COAT OF AMERON AMERCOAT 2138 (6-10 MILS D.F.T.)
ALL NOZZLES AND MANWAY BOLT HOLES TO STRADDLE NORMAL CENTER LINES OR THEIR PARALLELS UNLESS OTHERWISE NOTED.
ALL MACHINED SURFACES AND THREAD CONNECTIONS TO BE PROTECTED WITH 3/16" THK STEEL PROTECTORS BEFORE SHIPMENT. W/ 50% BOLT MIG-MAL
EST. WT. 33,500 LBS. EST. WT. FULL OF WATER 86,200 LBS.
PAINT PURCHASE ORDER # AND ITEM # IN 6" HEIGHT LETTERS ON EACH SIDE OF VESSEL AS LOADED
CUSTOMER STANDARDS E90-1F-6636, 4-7TS-6636
REF. DWGS.

MARK	REQ'D.	SIZE	RATING	TYPE	REMARKS
SOI	ONE	12"	STD. WT.	PIPE	SKIRT O.P.NG.
SV	SIX	3"	STD. WT.	PIPE	SKIRT VENTS
SA	ONE	18" I.D.	+	PLATE	ACCESS
BS, CS	ONE EA.	1"	300#	LWN	LEVEL INDICATOR
MH2	ONE	20"	300#	LWN	MANWAY
MH1	ONE	18"	300#	LWN	MANWAY
S	ONE	1"	300#	LWN	STEAMOUT
C	ONE	6"	300#	WNF	LIQ. IN / VAP. OUT
A	ONE	6"	300#	WNF	LIQ. OUT / VAP. IN

SCHEDULE OF OPENING

NO.	REVISION	BY	DATE
B	REVISED PER MOC 02-97-171	RR	11/5/97
A	REV. PER CUST. APR.	VR	9/24/91

CUSTOMER: M.W. KELLOGG CO. TO # 3-3091

THREE VESSEL REQ'D. ITEM NO. * 07D-101C

MODERN WELDING CO., INC.
PLANT NO. 7 715 SAKOWITZ ST., HOUSTON 20, TEXAS

78" I.D. x 116'-4" SEAM TO SEAM DYGENATE ABSORBER

TENNECO NGL CORP. LAPORTE, TEXAS

DWN.	DL	DATE 8-8-91	SCALE: N.T.S.
CHK.	VR	JOB NO. 7-9648, 9649, & 9650	DWG. NO. D7-9648 ✓
APR.	VR	ORDER NO. 6636-02D1-D410-01	SHT. NO. 1 OF 4

10337