

FORM U-1 MANUFACTURERS' DATA REPORT FOR PRESSURE VESSELS
as required by the provisions of the ASME Code rules, Section VIII, Division 1

06E114

1. Manufactured and certified by OHMSTEDE INC. - LAPORTE PLANT 12415 LAPORTE RD. LAPORTE, TX 77571
(name and address of manufacturer)
2. Manufactured for KELLOGG / TENNECO OIL CO. P.O. BOX 1307 LAPORTE, TX 77572-1307
(name and address of purchaser)
3. Location of installation TENNECO OIL CO. 1200 N. BROADWAY LAPORTE, TX 77571
(name and address)
4. Type: HORIZ. HT. EXCH. 28392 N/A 28392 161 1991
(horiz. or vert. tank) (mfr's. serial no.) (CRN) (drawing no.) (Nat'l. Bd. no.) (year built)
5. The chemical and physical properties of all parts meet the requirements of material specifications of the ASME BOILER AND PRESSURE VESSEL CODE. The design, construction and workmanship conform to ASME Code, Section VIII, Division 1: 1989
(year)
- 1989 A N/A N/A
(addenda (Date)) (Code Case no.) (special service per UG-120(d))

Items 6-11 inclusive to be completed for single wall vessels, jackets of jacketed vessels, or shells of heat exchangers.

6. Shell: SA516-70N 3/4" 1/8" 4' - 8" 21' - 10 3/16"
(mat'l. spec. no., grade) (nom. thickness (in.)) (corr. allow. (in.)) (dia. ID (ft. & in.)) (length (overall) (ft. & in.))
7. Seams: DBL-BUTT FULL 100% N/A * N/A DBL-BUTT FULL 3
(long (dbl., sngl.)) (RT (spot or full)) (eff. (%)) (HT temp. (°F)) (time) (girth (dbl., sngl.)) (RT (spot, partial, or full)) (no. of courses)
8. Heads: (a) SA516-70N (ELLIPTICAL HEAD) (b) SHELL COVER CYLINDER: SA516-70N
(mat'l. spec. no., grade) (mat'l. spec. no., grade)

	Location (top, bottom, ends)	Minimum Thickness	Corrosion Allowance	Crown Radius	Knuckle Radius	Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure (convex or concave)
(a)	END	3/4"	1/8"			2:1				CONCAVE
(b)	N/A									

If removable, bolts used (describe other fastenings): (80) 1" SA193-B7 STUDS WITH (2) SA194-2H NUTS EACH.
(mat'l. spec. no., gr., size, no.)

9. Type of jacket: N/A Proof test: _____
10. Jacket closure: N/A If bar, give dimensions: _____ If bolted, describe or sketch.
(describe as ogee & weld, bar, etc.)
11. MAWP: 382 at max. temp. 650° Min design metal temp.: 10° at 382 Hydro., ~~XXXXXXX~~ test pressure 573
(psi) (°F) (°F) (psi) (psi)

Items 12 and 13 to be completed for tube sections.

12. Tubesheets: SA350-LF2 55 7/8" 4 3/8" 1/8" BOLTED
(stationary mat'l. spec. no., gr.) (dia. (in.) (subject to pressure)) (nom. thickness (in.)) (corr. allow. (in.)) (attachment (welded, bolted))
- SA350-LF2 55 1/2" 4 3/8" 1/8" ROLLED TO TUBES
(floating mat'l. spec. no., gr.) (dia. (in.)) (nom. thickness (in.)) (corr. allow. (in.)) (attachment)
13. Tubes: SA214 1" .074" (MW) 1238 STRAIGHT
(mat'l. spec. no., gr.) (OD (in.)) (nom. thickness (in. or gauge)) (no.) (type (straight or U))

Items 14-17 inclusive to be completed for inner chambers of jacketed vessels or channels of heat exchangers.

14. Shell: SA516-70 3/4" 1/8" 4' - 8" 3' - 11 1/16"
(mat'l. spec. no., gr.) (nom. thickness (in.)) (corr. allow. (in.)) (dia. ID (ft. & in.)) (length (overall) (ft. & in.))
15. Seams: DBL-BUTT SPOT 85% N/A * N/A DBL-BUTT SPOT 1
(long (dbl., sngl.)) (RT (spot or full)) (eff. (%)) (HT temp. (°F)) (time) (girth (dbl., sngl.)) (RT (spot, partial, or full)) (no. of courses)
16. Heads: (a) CHANNEL COVER: (b) N/A
(mat'l. spec. no., grade) (mat'l. spec. no., grade)

	Location (top, bottom, ends)	Minimum Thickness	Corrosion Allowance	Crown Radius	Knuckle Radius	Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure (convex or concave)
(a)	END	4 1/2"	1/8"						63"	FLAT
(b)										

If removable, bolts used (describe other fastenings): CHAN. TO SHELL FLG. (80) 1" SA193-B7 STUDS WITH (2) SA194-2H NUTS EA.
(mat'l. spec. no., gr., size, no.)

17. MAWP: 255 at max. temp. 200° Min design metal temp.: 10° at 255 Hydro., ~~XXXXXXX~~ test pressure 383
(psi) (°F) (°F) (psi) (psi)

103371

[illegible]

19. Supports: Skirt NO Lugs 6 Legs N/A Other (2) HORIZ. SUPPORTS Attached WELDED TO SHELL.
(yes or no) (no.) (no.) (describe) (where and how)

20. Remarks: Manufacturers' Partial Data Reports properly identified and signed by Commissioned Inspectors have been furnished for the following items of the report: * PWHT OF FLOATING HEAD COVER ONLY.
(name of part, item number, mfr's. name and identifying stamp)

MINIMUM DESIGN METAL TEMPERATURE PER UG20. ROLLED AND WELDED CYLINDERS MANUFACTURED BY OHMSTEDE - LAKE CHARLES UNDER AUTHORIZATION NUMBER 17397 AND SERIAL NUMBERS 28392-1; 28392-2 AND 28392-3

CERTIFICATE OF SHOP COMPLIANCE

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.

18672 JUNE 27, 1992

S. B. P.

"U" Certificate of Authorization no. 18673 expires JUNE 27, 1992

"U" Certificate of Authorization no. 10075 expires 9-30-91
Date 9-30-91 Name OHMSTEDE INC. - LAPORTE PLANT
(manufacturer)

Signed Xc 7/26
(representative)

CERTIFICATE OF SHOP INSPECTION

Vessel constructed by OHMSTEDE, INC. at LAPORTE, TX

Vessel constructed by CHRYSLER, INC.
I, the undersigned, holding a valid commission issued by The National Board of Boiler and Pressure Vessel Inspectors and the state or province of TEXAS and employed by H.S.B.I. & I. CO.
HARTFORD, CT certify that the pressure vessel described in this Manufacturers' Data

Inspector of _____ TEXAS _____ and employed by _____
of _____ HARTFORD, CT _____ have inspected the pressure vessel described in this Manufacturers' Data
Report on _____ 9-30, 19 91 _____, 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 the Manufacturers' Data Report. Furthermore, neither the inspector nor his employer shall be liable in any manner for any personal injury or loss of any kind arising from or connected with this inspection.

sonal injury or property damage or a loss of any kind arising from or connected with this inspection.
Date 9-30-91 Signed Ernest Spahr Commissions NB 9263
(Authorized Inspector) (Nat'l. Bd. (incl. endorsements) state, prov. and no.)

CERTIFICATE OF FIELD ASSEMBLY COMPLIANCE

CERTIFICATE OF FIELD ASSEMBLY COMPLIANCE

We certify that the field assembly construction of all parts of this vessel conforms with the requirements of Section VIII, Division 1 of the ASME BOILER AND PRESSURE VESSEL CODE.

"U" Certificate of Authorization no. _____ expires _____, 19____.

"U" Certificate of Authorization no. _____ expires _____
 Date _____ Name _____ (assembler that certified and constructed field assembly) Signed _____ (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 the state or province of _____ and employed by _____, hereby certify that the statements in this Manufacturers' Data

I, _____, of _____, and employed by _____, have compared the statements in this Manufacturers' 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 that 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.

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 the Manufacturers' 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 _____ (Authorized Inspector) Commissions _____ (Nat'l. Bd. (incl. endorsements) state, prov. and no.)

#103371



NAT. L. BD. NO. - 161

CERTIFIED AND MANUFACTURED BY



☐ ST. GABRIEL ☐ LAKE CHARLES
☒ LA PORTE TX. ☐ CORPUS CHRISTI

RT-1
S SIDE
RT-3
U SIDE
FI
ELONG

	SHELL	TUBE
MAWP	382 PSI	255
MAX DESIGN TEMP	650 °F	200 °F
TEST PRESS	573 PSI	385 PSI
METAL TEMP/PRESS	10 °F @ 382 PSI	10 °F @ 255 PSI
06E-114	SERIAL NO. 28392	
X238	TYPE A-1	YEAR BUILT 1991
6656-9901-0210-01		
EXT. PRESS. 15 PSIG AT 200 °F		

MAX ALLOW PRESS.

SHELLSIDE: 382 PSIG

TUBESIDE: 260 PSIG

SHOP TEST PRESS.

SHELLSIDE: 573 PSIG

TUBESIDE: 390 PSIG

SERVICE: DEPROPANIZER COLUMN

CYCLO CONDENSER

#103371