

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

1. Manufactured and certified by OHMSTEDE, INC. - LAPORTE PLANT 12415 LAPORTE RD. LAPORTE, TX 77571  
(name and address of manufacturer)

2. Manufactured for M.W.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. 28394 N/A 28394 162 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)

1989A 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: SA106B .500" .125" 1' - 7" 22' - 7 7/16"  
(mat'l. spec. no., grade) (nom. thickness (in.)) (corr. allow. (in.)) (dia. ID (ft. & in.)) (length (overall) (ft. & in.))

7. Seams: N/A (SMLS) N/A 100% N/A \* N/A DBL-BUTT FULL  
(long. (dbl., singl.)) (RT (spot or full)) (eff. (%)) (HT temp. (°F)) (time) (girth (dbl., singl.)) (RT (spot, partial, or full)) (no. of courses)

8. Heads: (a) SHELL COVER CYL: SA106B (b) SHELL COVER HD.: SA516-70  
(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	1/2"	1/8"			2:1				CONCAVE
(b)	N/A									

If removable, bolts used (describe other fastenings): (32) 3/4" 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: 395 at max. temp. 650° Min design metal temp.: 10° at 395 Hydro., XXXXXX test pressure 593  
(psi) (°F) (°F) (psi) (psi) (pne. or comb.) (psi)

Items 12 and 13 to be completed for tube sections.

12. Tubesheets: SA350-LF2 18 7/8" 1 7/8" 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 18 3/4" 1 7/8" 1/8" ROLLED TO TUBES  
(floating mat'l. spec. no., gr.) (dia. (in.)) (nom. thickness (in.)) (corr. allow. (in.)) (attachment)

13. Tubes: SA214 3/4" .083" (MW) 272 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: SA106B .500" 1/8" 1' - 7" 1' - 7 15/16"  
(mat'l. spec. no., gr.) (nom. thickness (in.)) (corr. allow. (in.)) (dia. ID (ft. & in.)) (length (overall) (ft. & in.))

15. Seams: N/A N/A N/A \* N/A DBL-BUTT SPOT 1  
(long. (dbl., singl.)) (RT (spot or full)) (eff. (%)) (HT temp. (°F)) (time) (girth (dbl., singl.)) (RT (spot, partial, or full)) (no. of courses)

16. Heads: (a) CHANNEL COVER: SA350-LF2 (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	1 7/8"	1/8"						24 1/4"	FLAT
(b)	N/A									

If removable, bolts used (describe other fastenings): (24) 3/4" SA193-B7 STUDS WITH (2) SA194-2H NUTS EACH.  
(mat'l., spec. no., gr., size, no.)

17. MAWP: 260 at max. temp. 200° Min design metal temp.: 10° at 260 Hydro., XXXXXX test pressure 390  
(psi) (°F) (°F) (psi) (psi) (pne. or comb.) (psi)

# 103372



PER UG 125 NOTE 39

PER UG 125

18. Nozzles, inspection and safety valve openings:	
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19. Supports: Skirt NO Lugs 6 Legs NO Other (2) HORIZ. SUPPORTS Attached WELDED TO SHELL  
(yes or no) (no.) (no.) (describe) (where and how)

19. Supports: Skirt NO Lugs 6 Legs NO Others NO (describe)  
(yes or no) (no.) (no.)

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 PER UCS-56.  
(name of part, item number, mfr's. name and identifying stamp)

TEMPERATURE PER UG20.

MINIMUM DESIGN METAL TEMPERATURE PER UG20.  
CUSTOMER ITEM # 06E-116.

**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.  
"U" Certificate of Authorization no. 18673 expires JUNE 27, 1992  
Date 9-30-91 Name OHMSTEDE, INC. - LAPORTE PLANT Signed [Signature] (representative)  
(manufacturer)  
**CERTIFICATE OF SHOP INSPECTION**  
LAPORTE, TX

CERTIFICATE OF SHOP INSPECTION  
OHMSTEDE, INC.

CERTIFICATE OF SHOP INSPECTION

at LA FORT

OHMSTEDE, INC.

Vessel constructed by \_\_\_\_\_

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.

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 property damage or a loss of any kind arising from or connected with this inspection.

Date 9-30-91 Signed E. Smith Commissions NB 9223  
(Authorized Inspector) (Nat'l. Bd. (incl. endorsements) state, prov. and no)

FIELD ASSEMBLY COMPLIANCE

(Section VIII, Division 1 of the

CERTIFICATE OF FIELD ASSEMBLY COMPLIANCE

Date 9-30-91 Signed [Signature] (Authorized Inspector)

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\_\_\_\_\_. Signed \_\_\_\_\_ (representative)

Date \_\_\_\_\_ Name \_\_\_\_\_ (assembler that certified and constructed field assembly)

FIELD ASSEMBLY INSPECTION

**CERTIFICATE OF FIELD ASSEMBLY INSPECTION**

**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 \_\_\_\_\_ of \_\_\_\_\_ 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.  
 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.)