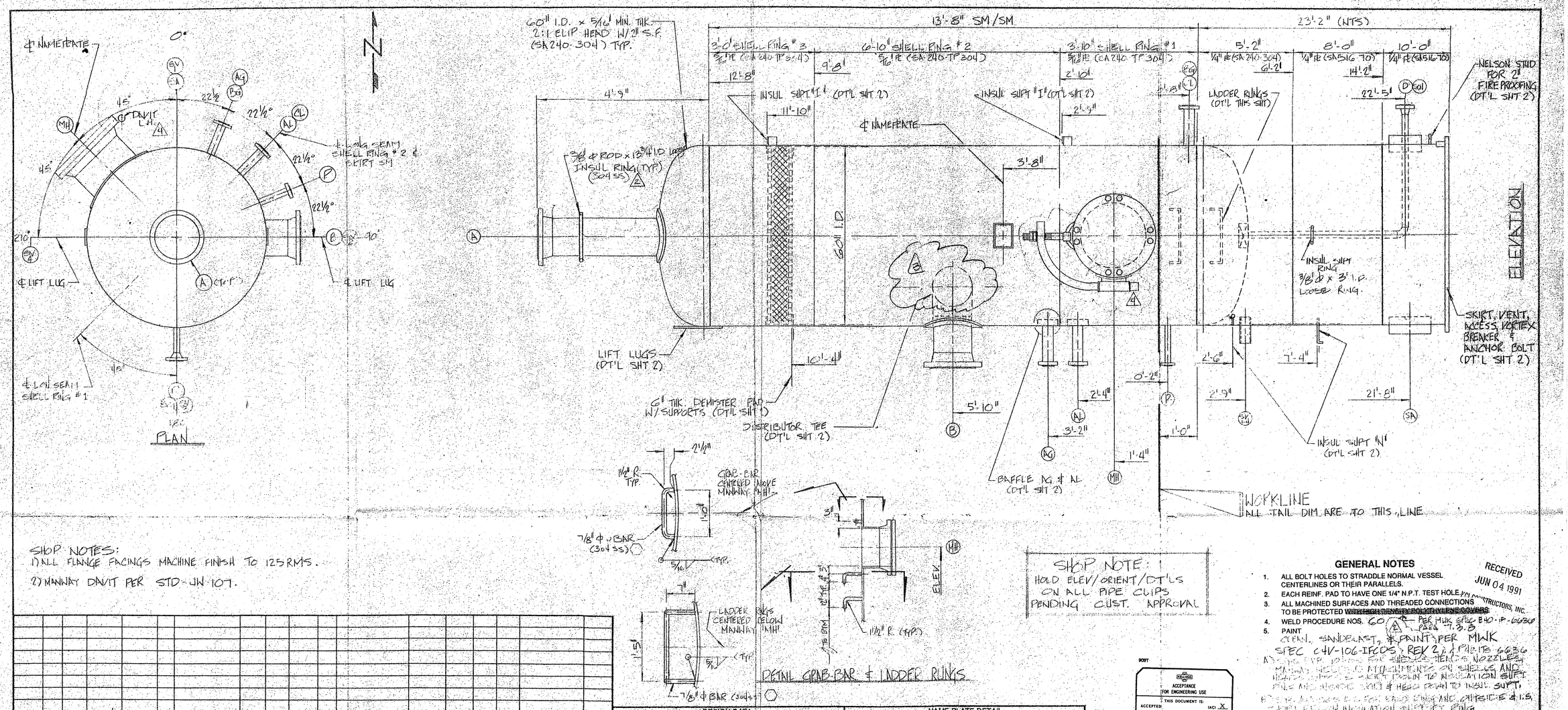
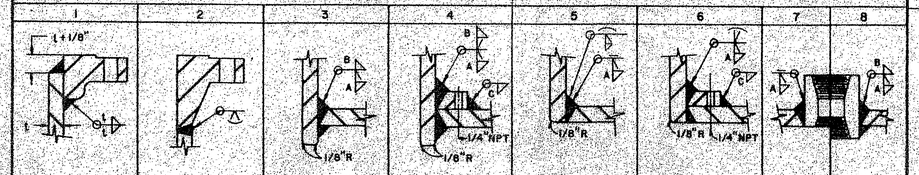


SHOP NOTES:
1) ALL FLANGE FACINGS MACHINE FINISH TO 125 RMS.
2) MANWAY DAVIT PER STD-JW-107.

SHOP NOTE:
HOLD ELEV/ORIENT/DT'LS ON ALL PIPE CLIPS PENDING CUST. APPROVAL

MARK	QTY.	SIZE	RATING	TYPE	LGN.	SERVICE	NECK O.D.	NECK SCH.	PROJECTION O.S.	PROJECTION I.S.	REINF. PAD SIZE	WELDING DETAIL NO.	WELD SIZE A	WELD SIZE B	WELD SIZE C	REMARKS	T.O. NO.
SO1	1	10"	STD. WT	PIPE		"D" SKIRT OPNG	10¾"	.365"	SHT 2	SHT 2	—	SHT 2	—	—	—		
SV/EV	4	3"	STD. WT	PIPE		VENT	3½"	.216"	SHT 2	SHT 2	—	SHT 2	—	—	—		
SA	1	18" ID	—	PLATE		ACCESS	18¾"	3/8" PL	SHT 2	SHT 2	—	SHT 2	—	—	—		
BG	1	2"	300#	RFLWN		LEVEL GAUGE	3 5/16"	.654"	12 11/16"	FC	—	5	1/4"	—	—		12
NG	1	2"	300#	RFLWN		LEVEL GAUGE	3 5/16"	.654"	12 11/16"	FC	—	5	1/4"	—	—	W/BAFFLE	12
CL	1	2"	300#	RFLWN		LEVEL TRANS.	3 5/16"	.654"	12 11/16"	FC	—	5	1/4"	—	—		12
NL	1	2"	300#	RFLWN		LEVEL TRANS.	3 5/16"	.654"	12 11/16"	FC	—	5	1/4"	—	—	W/BAFFLE	12
P	1	1"	300#	RFLWN		PURGE	2 1/8"	.343"	12 11/16"	FC	—	5	1/4"	—	—		11
D	1	1½"	300#	RFWN		LIQUID OUT	1.90	.281"	ELEV.	AWN	—	5	1/4"	—	—	W/VORTEX BRKR	10,14
MH	1	20"	150#	RFWN		MANWAY	20"	3/8" PL	14 11/16"	FC	1/8" TK x 5" WD	2 & 6	3/8"	—	1/4"	W/BLIND & DAVIT	8,9,23
B	1	12"	150#	RFWN		INLET	12¾"	3/8" PL	13 11/16"	3"	1/8" TK x 3" WD	2 & 4	3/8"	—	1/4"	W/TEE	7,22
A	1	12"	150#	RFWN		I/NOR OUTLET	12¾"	3/8" PL	ELEV.	FC	1/8" TK x 2½" WD	2 & 6	3/8"	—	1/4"		7,21

NOZZLE SCHEDULE & WELDING DETAILS



DESIGN DATA

CONSTRUCTION ACCORDING TO A.S.M.E. CODE, SEC. VIII, DIV. I
CODE STAMP YES ED: 1983 ADDENDA 1989
DESIGN PRESS 105 INT / 15 EXT P.S.I.G. 155/185 INT. 300 EXT
M.A.W.P. 125 P.S.I.G. LIMITED BY SHELL
M.A.P. (N. & C.) 165 P.S.I.G. LIMITED BY SHELL
HYDROSTATIC TEST 248 P.S.I.G.
CORROSION ALLOW. SHELL 1/16" HEADS 1/16" NOZZ. 1/16"
HEAT TREAT NONE EFFICIENCY SHELL 85% HEAD 85%
RADIOGRAPH UW-52
INSPECTION BY CUST. AND DELTA LLOYDS
EST. SHIPPING WEIGHT 9,000 LBS.
EST. WEIGHT FULL OF WATER 20,000 LBS.

NAME PLATE DETAIL

NAT'L BD. NO. 757
U W RT. 3
CERTIFIED by JETTWELD INC.
MAWP 125/15 EXT PSIG @ 185 °F
MIN. DESIGN METAL TEMP -155 °F @ 125 PSIG
SERIAL NO. 2062 YEAR BUILT 1991
MAX. TEST PRESSURE PSIG 248
WEIGHT 9,000 LBS. CORR. ALLOW. .0625
O.D. 60.625 SHELL THK. .3125 HD. THK. .3125 MIN.
P. O. NO. 6636-01D1-D413-01 ITEM 041-106
EXPANDER L.P. SEPARATOR DRUM

MATERIAL

SHELL SA240-TP304 SUPPORTS 304SS/CS
HEADS SA240-TP304 INTERNALS 304SS
FLG/CPLG SA182-F304 BOLTING SA-320-B8-1
FITTINGS SA403-304SS & SA194-8
PIPE SA312-TP304 GASKET FLEXITALLIC CG
REINF. PADS SA 240-TP304 TYPE 304SS NON-ASB.

GENERAL NOTES

1. ALL BOLT HOLES TO STRADDLE NORMAL VESSEL CENTERLINES OR THEIR PARALLELS.
2. EACH REINF. PAD TO HAVE ONE 1/4" N.P.T. TEST HOLE.
3. ALL MACHINED SURFACES AND THREADED CONNECTIONS TO BE PROTECTED WITH HIGH-BRIDGE PROTECTIVE COVERS.
4. WELD PROCEDURE NOS. 60 PER MWK SPEC B40-IP-6636
5. PAINT
A) PER MWK SPEC C4V-106-IFC05, REV 2 & PER ITS 6636
B) SHOP TO PROVIDE (1) SPARE GASKET @ EACH BLIND CONNECTION
7. ALL WELDING TO BE IN ACCORDANCE WITH MWK SPEC 4-ITS-6636
8. ELEVATIONS TO BE IN ACCORDANCE WITH MWK SPEC B40-IP-6636
11. NORTH & EAST ORIENTATIONS TO BE MARKED PER SPEC B40-IP-6636 PARA 7.2.5
12. NOZZLE HEIGHTS TO BE PER SPEC B40-IP-6636 TABLE IV
14. ALLOY VERIFICATION IS REQUIRED PER MWK SPEC 2-ITS-90

RECEIVED JUN 04 1991 J.W. CONSTRUCTORS, INC.

ACCEPTANCE FOR ENGINEERING USE
THIS DOCUMENT IS:
ACCEPTED (AC) X
ACCEPTED WITH COMMENTS (AC-C)
NOT REVIEWED-ACCEPTED (NR)
NOT ACCEPTED (NAC)
ACCEPTANCE DOES NOT RELIEVE VENDOR FROM FURNISHING MATERIAL IN CONFORMANCE WITH ORDER. REFER TO VDR-1 FOR FULL DEFINITION OF ACCEPTANCE CONDITIONS.
DIVISION VM SIGNED JOE DATE 10 APR 91

REVISED

CERTIFIED DRAWING

NO.	BY	REVISION	DATE
4	CEL	REV. DAVIT /RH HOLD	4-25-91
3		REV. FLOT TEE VIEW	3-26-91
2	CEL	REV AS NOTED	3-1-91
1	RA	CERT. FOR FABRICATION	2-8-91

S/O 2062 (1) REQ'D ITEM NO. 041-106

JETTWELD INC.
METAL FABRICATORS HOUSTON, TEXAS

CUSTOMER THE M.W. KELLOGG CO. (FOR TENNECO)
P.O. 6636-01D1-D413-01
LOCATION LA PORTE, TEXAS

60" I.D. x 13'-8" SM/SM
EXPANDER L.P. SEPARATOR DRUM

DRAWN BY FILLA DATE 10-29-90 CHKD BY DATE 1-11-91 REV
DWG. NO. 4110-2062 SHT. 1 OF 7

103385