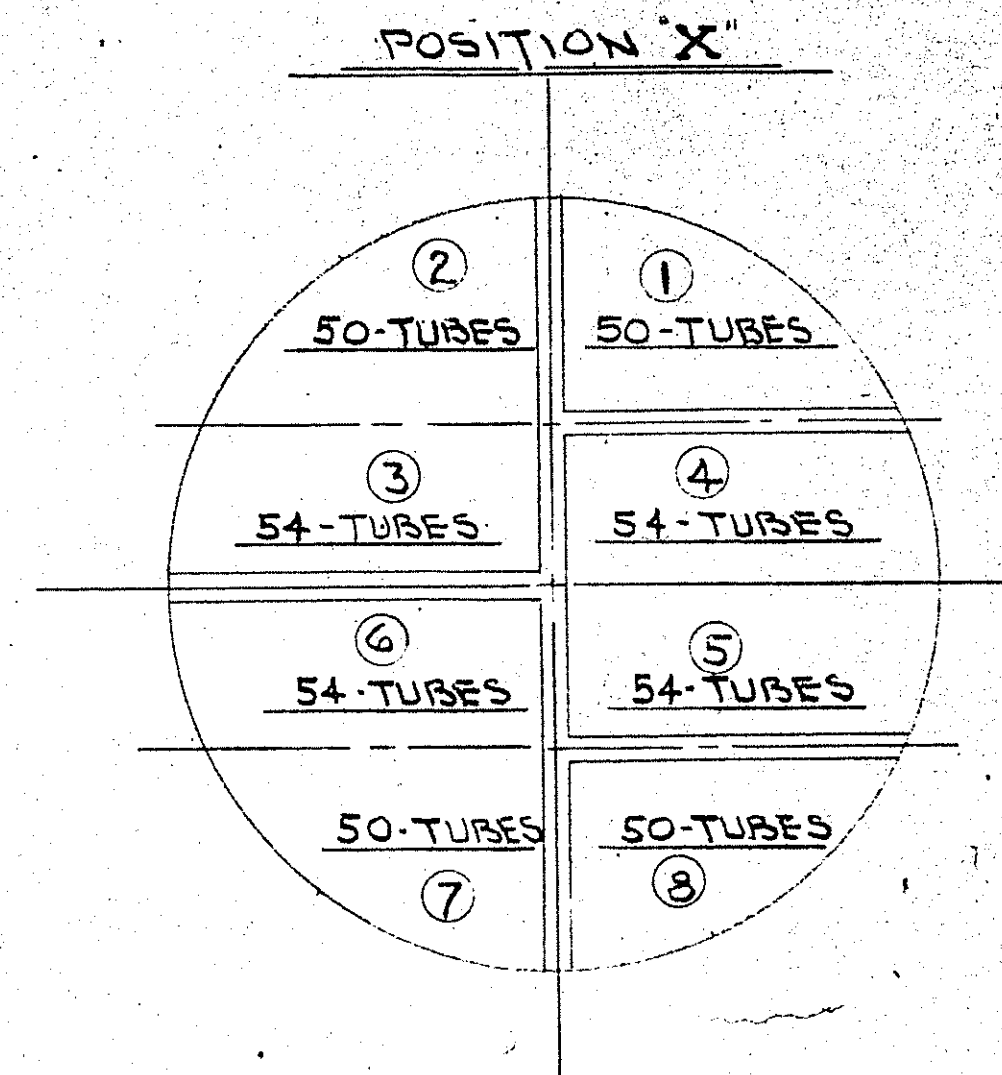
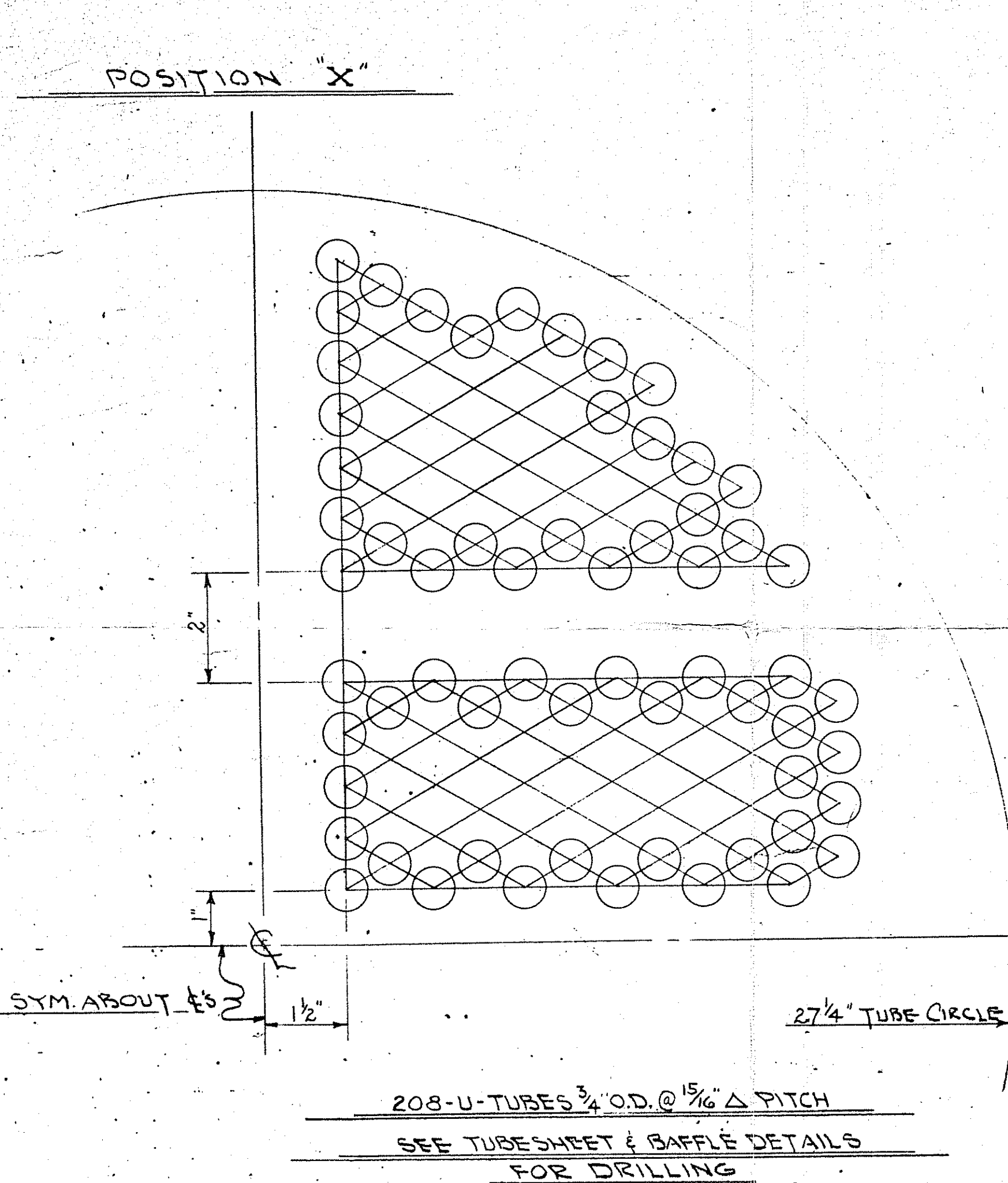


100727-4677



HERCULES INC.

CUST. ORD. NO. 336-026-01090-11-000-PCD

EQUIP. NO. E-203-12 & E-2203-12

MECH. PREHEATER (ITEM B)

S.W. ORD. NO. 66-94-6220

TWO (2) UNITS REQ'D.

B.P.F. NO. 37339 DATE 3/30/67

SHEET 2 APPARATUS E-203-12

PROJECT & NO. E-2203-12

ACCOUNT 26001 2001

2014

ORDER NO. 336-026-01090

PLANT Wilmington

APPROVED *H. A. Atkinson*

REV. Δ CKD: Δ CKD: Δ

#104123

TUBE LAYOUT

DRAWN: H.E.B. 12-29

CHECKED: *W.H.* 12-30

APPROVED: *W.H.*

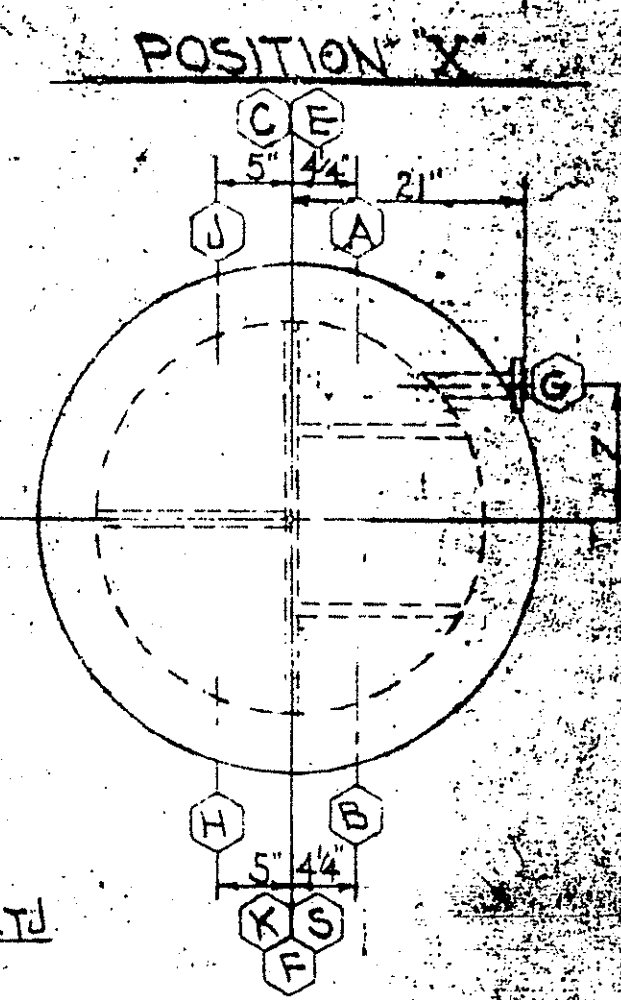
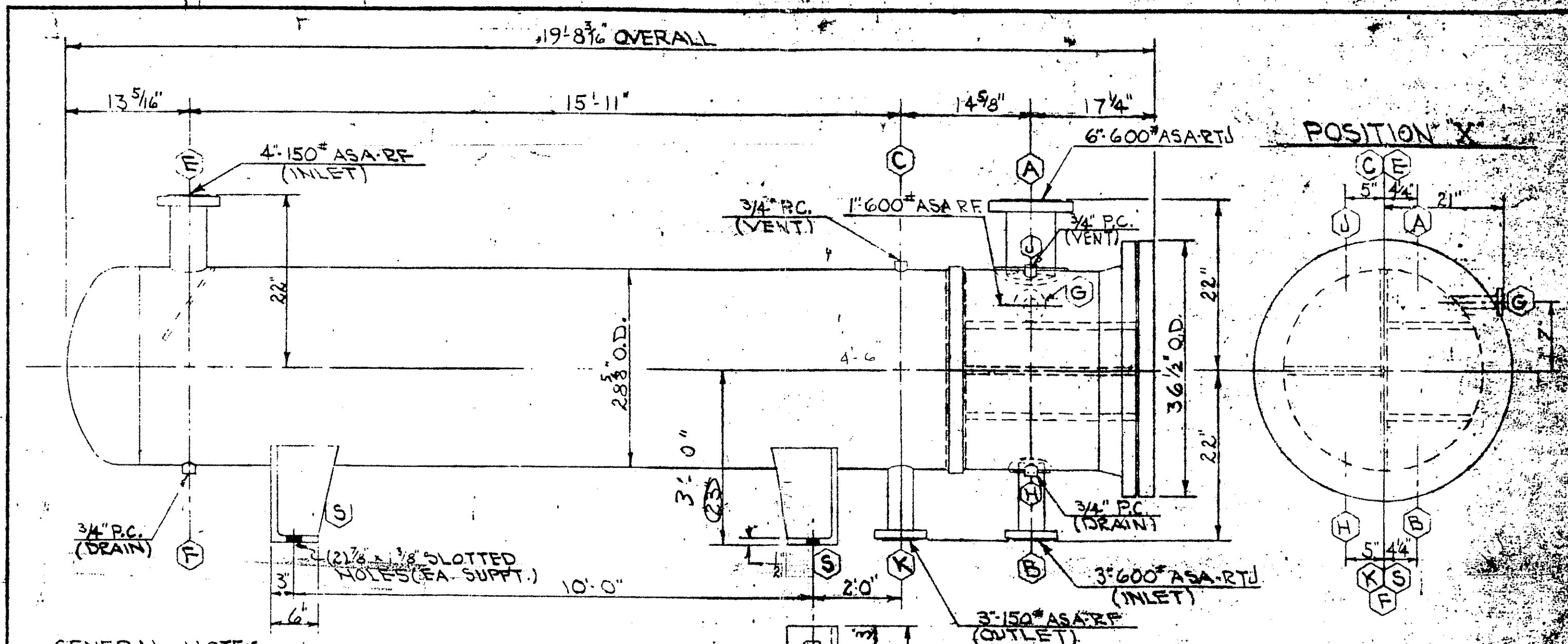
SCALE: $\frac{1}{2}$ " = 1" DATE

66-94-6220C1

GULFPORT, MISS.

STRUTHERS WELLS CORPORATION · WARREN, PA.

STRUTHERS WELLS CORPORATION · WARREN, PA.



GENERAL NOTES

ALL NOZZ BOLT HOLES TO STR. Q'S.
 ALL P.C. ARE 3000# SCREWED.
 TUBESHEET CARBON STL. W/ 3/8\"/>

	SHELL SIDE	TUBE SIDE
DESIGN PRESS	150#	600#
TEST PRESS	225#	900#
MAX TEMP.	375°F.	375°F.
CORR. ALLOW.	1/16" c.s.	—

HERCULES INC.
 CUST. ORD. N° 336-026-01090-11-000-FCD
 MECH. PREHEATER (ITEM B)
 EQUIP. N°S E203-12 & E-2203-12
 S.V. ORD. N° 66-94-6220
 TWO (2) UNITS REQ'D.

REV. A	CKD:	REV. A	CKD:
SETTING PLAN OF HEAT EXCHANGER 2815U186H			
DRAWN: HRT/12-30			
CHECKED: [Signature] 12-30			
APPROVED: [Signature] 66-94-6220B-1			

STRUTHERS WELLS CORPORATION GULFPORT, MISS.
HEAT EXCHANGER CONSTRUCTION SHEET

PURCHASER HERCULES, INCORPORATED WILMINGTON, DELEWARE

EQUIPMENT MECH PREHEATER - STEAM

INSTALLATION WILMINGTON, N.C.

ORDER NUMBER
66-94-6220PURCHASERS ORDER
336-026-01090-11-

000-FCD ITEM #E-2203-12

* ITEM #E-203-12

MADE
T.E.B.

CHECKED

NO. REQ'D. 2 SIZE 28" DIA. x 19'-8-3/160AL CODE SIZE 28-15U18-6H

SHELL SIDE MAX. PRESS. 150# TEST PRESS. 225# MAX. TEMP. 375°F CORR. ALL 1/16" ON C.S.

REVISIONS

TUBE SIDE MAX. PRESS. 600# TEST PRESS. 900 MAX. TEMP. 375°F CORR. ALL

FLUID SHELL SIDE 150# STEAM FLUID TUBE SIDE METHANOL

NO. TUBES 208 3/4" O.D. #16 BWG AVG. HX. WALL WELDED SA-249-TP304 STNLS.

ASME SECT. VIII INSPECTION CUST. & HART. NATIONAL BOARD STAMP ASME & TEMA C

PART	DRAWING NO.	MATERIAL	ASME SPEC.	REMARKS
SETTING PLAN	66-94-6220-B1			
SHELL	D1	FBX STL.	SA-265-C	FLGS.
SHELL NOZZLES	D1	FORG. STL. SMLS. STL.	SA-181-1 SA-106-B	SIZE (1) 4" & (1) 3" x 150# ASA RF
CHANNEL COVER				FLGS.
CHANNEL	D1	STNLS. STL.	SA-240-TP-304	FLGS. HUB TYPE SA-105-11 W/STNLS. OVERLAY
CHAN. NOZZLES	D1	FORG. STNLS. WELDED STNLS.	SA-182-F-304 SA-312-304	SIZE (1) 1" (1) 6" & (1) 3" x 60# ASA RING JOINT W.N.F.
CHANNEL COVER	D1	FBX STL. STNLS. STL.	SA-212-B SA-240TP-304	
FLUID TUBE COVER				PATT. NO.
TUBE SHEETS	D1	FBX STL. W/ 3/8 CLAD	SA-212-B SA-304 CLAD	
TUBE LAYOUT	C1			15/16" TRIANGULAR
TUBE GROOVING	D1			DOUBLE
CROSS BAFFLES	D1	STL.	NO. 7 THK. 3/8" CUT	RPV CL. PITCH EVEN DRILL REAM 49/64"
END CONNECTIONS			NO. THK. CUT	PITCH DRILL REAM
BAFFLES				
NOZZLES				
SPACERS				
TIE RODS	D1	STL.	C-1020	1/2" Ø
SPACERS	D1	STL.	SA-214	3/4" Ø
GASKETS	D1 & A2	STNLS. STL. JKT. ASBESTOS FILLED	304 STNLS.	1/8" THK.
BOLTS	D1	ALLOY	SA-193-B7	* ITEM NUMBERS TO BE PLAINLY PRINTED ON OUTSIDE OF EQUIPMENT.
NUTS	D1	STL.	SA-194-2H	(2") MIN. HEIGHT
SHELL SUPPORTS	B1 & D1	STL.	SA-7	
NAME PLATE & ATTACHMENT	A-14400	STNLS. STL.	18-8 H.R.	
WELDING	SW2A4			
	SW3A3			
FLANGING	NONE		HEAT TREAT:	NONE
WELDING	65 CODE			
WELD FINISH	NORMAL			
X-RAY	SPOT		SHIP. INST.	SHIP INTACT, PROTECT ALL OPENINGS.
SURFACE FINISH	SANDBLAST & PAINT SUPPORTS		SPECIAL INST.	