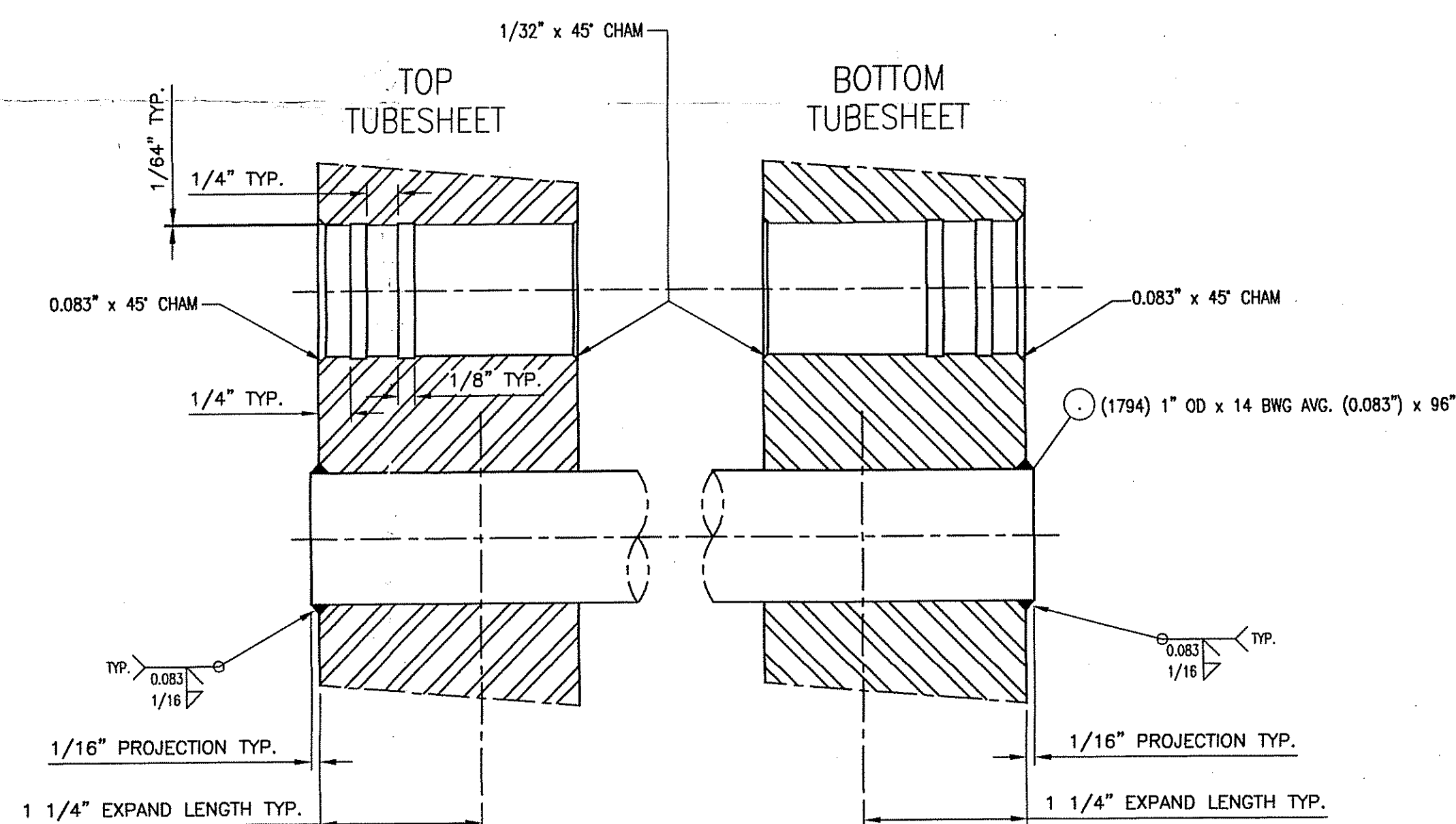
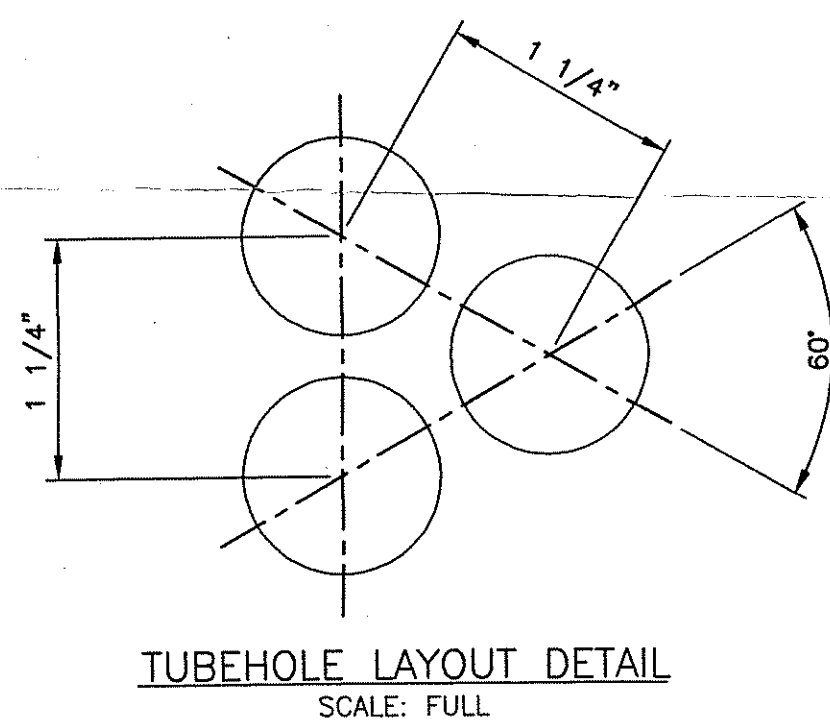
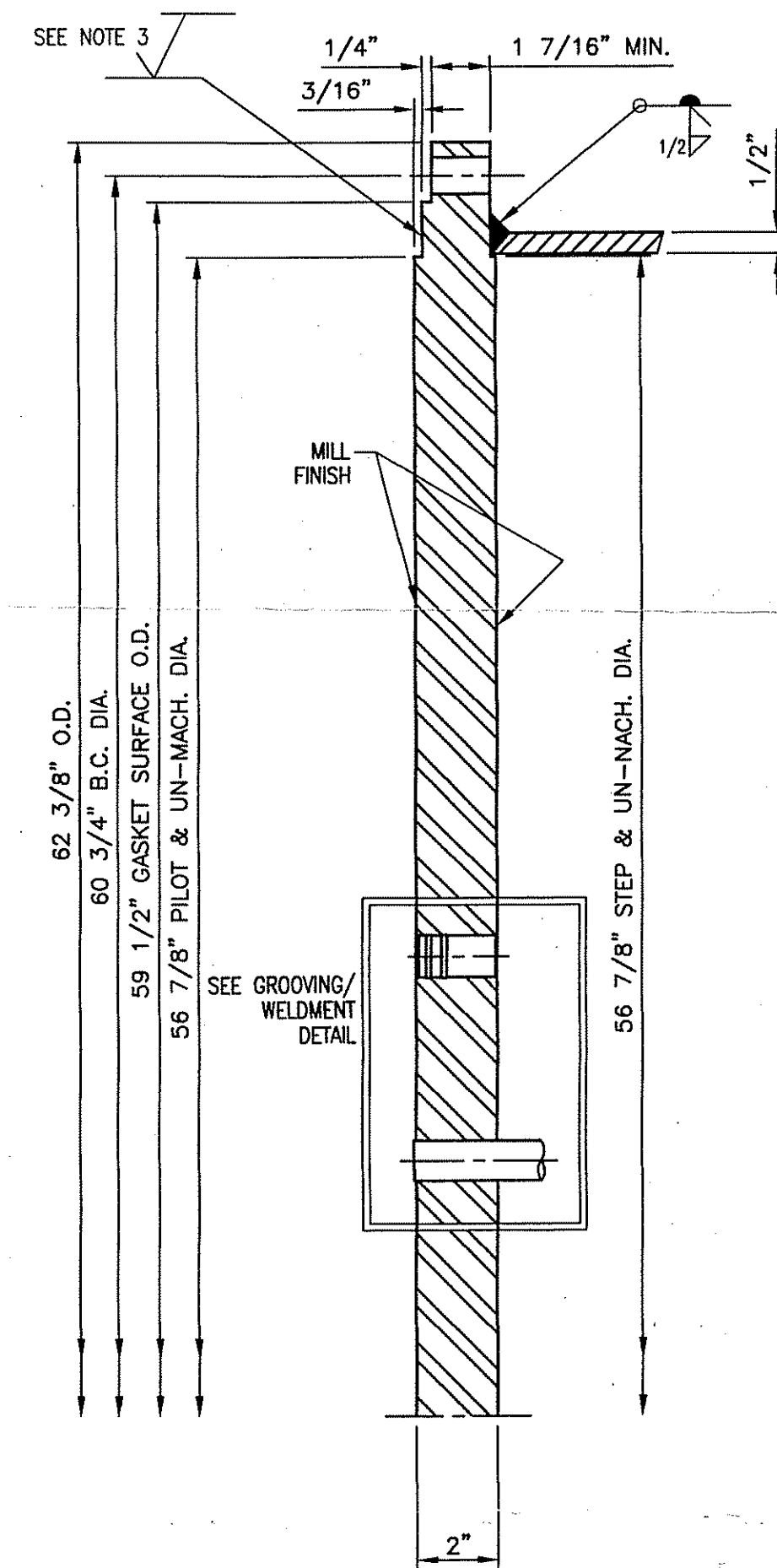
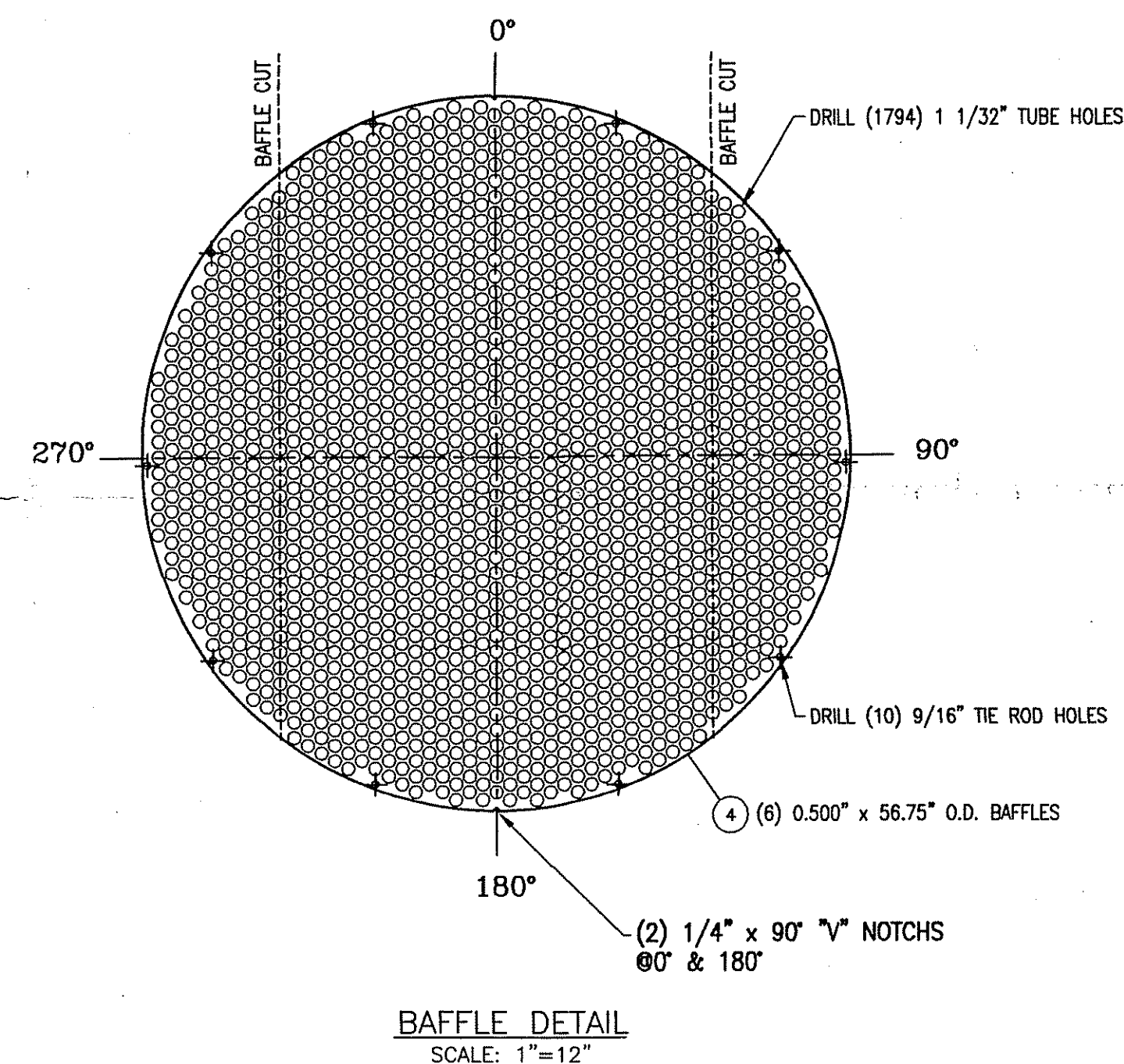
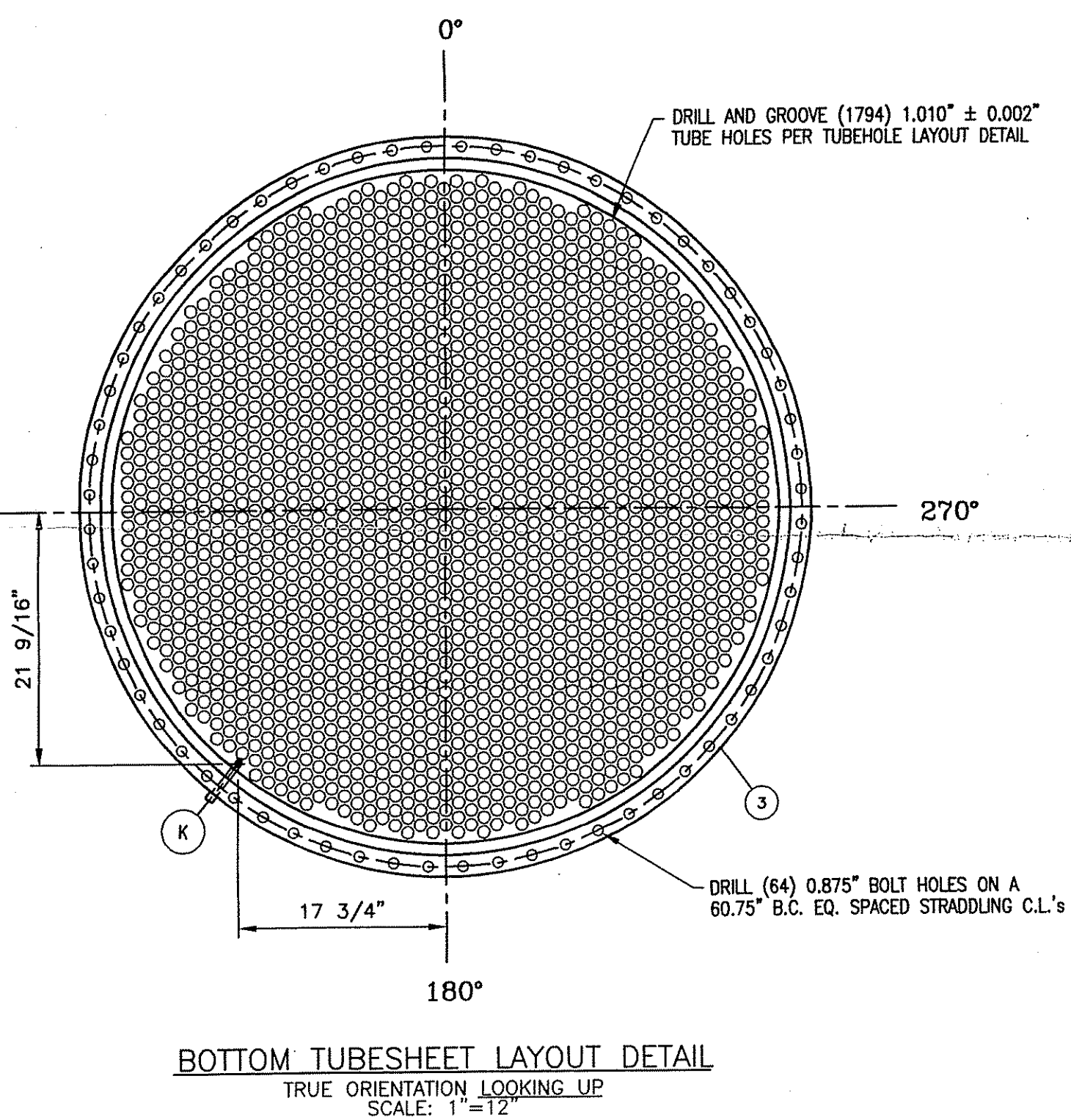
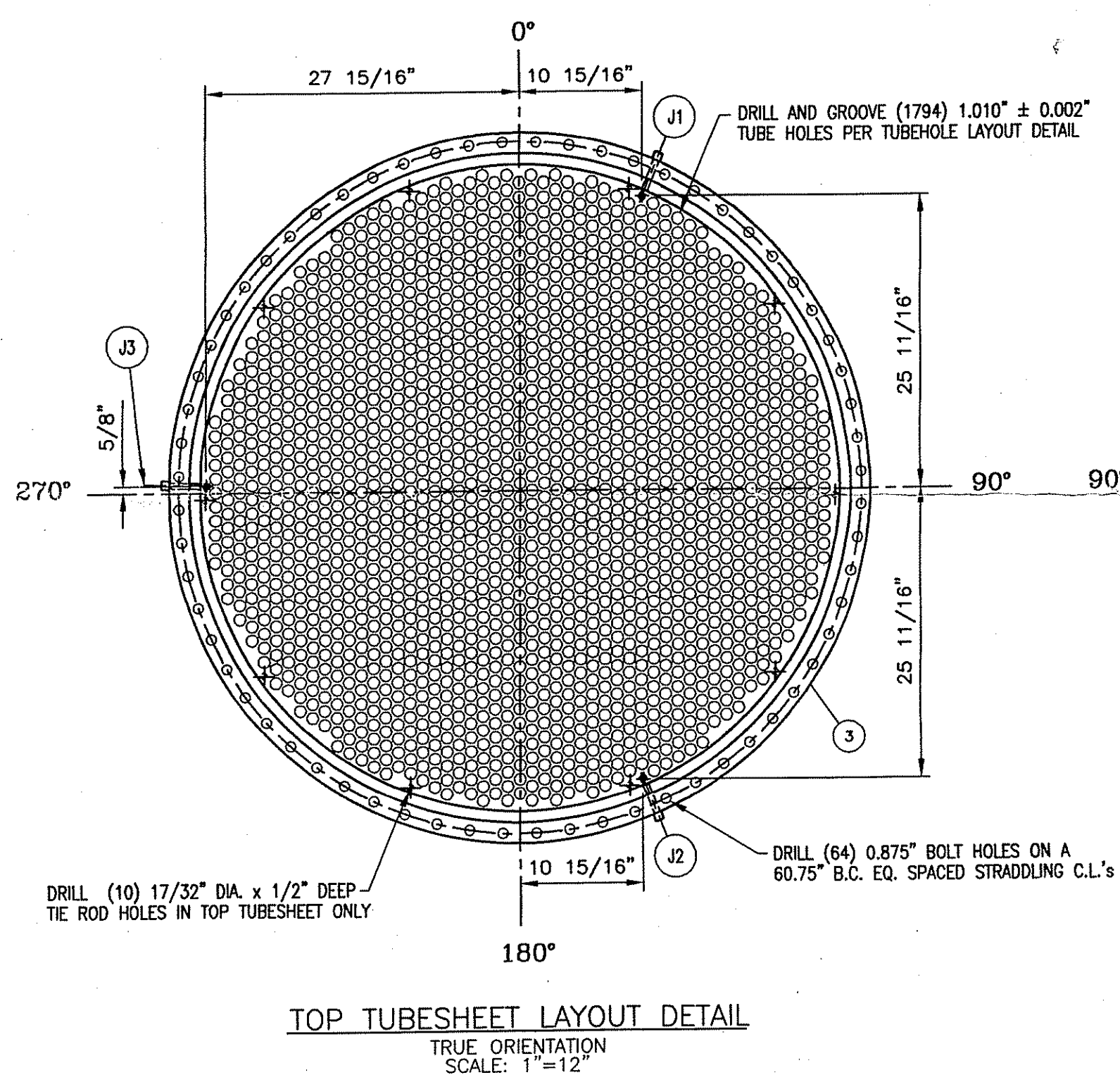
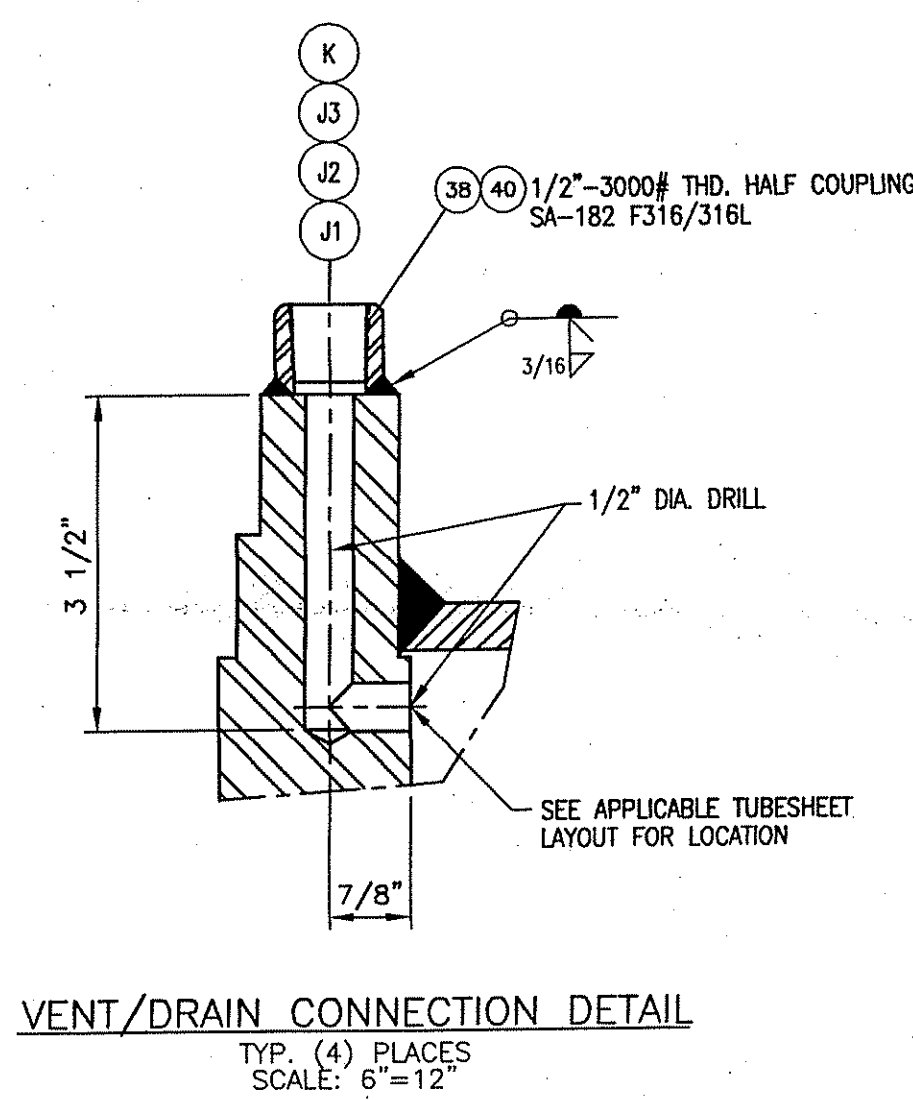




- TUBE TO TUBESHEET WELDING PROCEDURE:**
1. CLEAN TUBE ENDS (FOR THE TUBESHEET THICKNESS +3") AND ALL TUBE HOLES.
 2. IMMEDIATELY BEFORE INSERTING TUBE IN TUBE HOLE, CLEAN HOLE W/A SUITABLE SOLVENT/CLEANER, TO INSURE THAT NO FOREIGN MATTER REMAINS BETWEEN TUBE AND TUBE HOLE AFTER FINAL POSITIONING.
 3. POSITION TUBES FOR WELDING USING A TACK WELD OR OTHER SUITABLE MEANS IMMEDIATELY BEFORE WELDING.
 4. WELD TUBES TO TUBESHEET PER ABOVE DETAIL.
 5. TEST ALL TUBE TO TUBESHEET WELDS USING LIQUID PENETRANT TEST PER ASME.
 6. REPAIR DEFECTS BY REMOVING FAULTY WELD METAL AND REWELDING. RETEST PER PROCEDURE 5.
 7. FOLLOWING SUCCESSFUL LIQUID PENETRANT TEST, ROLLER EXPAND TUBES.
 8. APPLY HYDROSTATIC TEST.



AS-BUILT PRINT
WARD TANK AND
HEAT EXCHANGER CORP
By: T.J. Whalen
Date: 3/25/2003

Vendor	Print File: 3/15/2004	Date: 4/3/03
Sheet(s): 7 of 7	Equipment Number: E-4220-7R	Account Number: 4025
Project Number: 147-2512	Purchase Order No.: 4800105039	Plant: 0147
Reviewed	Drafting Design:	Approved
Project Engineer:	Approved	Reliability Engineer:

WARD TANK AND HEAT EXCHANGER CORP
8670 E. HARRIS BLVD.
CHARLOTTE, NC 28215

2	3/25/2003	AS-BUILT	DMB	KOSA - WILMINGTON PLANT WILMINGTON, NC		4800105039			
1	11/7/2002	REVISED PER CUSTOMERS COMMENTS/RELEASED FOR FABRICATION	DMB	TITLE #57-96 BEM HEAT EXCHANGER					
0	9/30/2002	FOR CUSTOMER APPROVAL	DMB						
REV NO.	DATE	DESCRIPTION	BY	EQUIPMENT NO.	E-4220-7R	SCALE	AS NOTED	NO REQ'D	1
APPROVED BY <i>Tw</i>				DATE	3/25/03	DRAWING NUMBER		REV. NO.	2
DRAWN BY BRADSHAW				DATE	9/20/2002	2002-HC-4981		SHEET 4 OF 4	
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