



NO OF HOLES 32
HOLE DIA. 1
STUD SIZE 7/8-9
BOLT CIRCLE 35 1/2



SCALE = 0.033

ALL DIMENSIONS ARE IN INCHES

CONSTRUCTION DETAILS

MATERIAL NOTES:	
A	STAINLESS STEEL ELC (EXTRA LOW CARBON) (0.03 % CARBON MAX.)
B	SA 312 IS WELDED PIPE UNLESS INDICATED BY "S" (FOR SEAMLESS)
C	THE LETTER "F" INDICATES FACING OF THE MATERIAL UNDER WHICH IT APPEARS.
D	SA 53 GR.B IS SEAMLESS PIPE.
E	STAINLESS STEEL NOZZLES THROUGH- 6" PIPE MADE FROM 6" PIPE OVER 6"PS MADE FROM PLATE.
F	NOZZLES FLANGES, SCREWED & WELDED FITTINGS CONFORM TO CURRENT ANSI STANDARDS UNLESS OTHERWISE STATED.
G	F&F EXP JOINT MOVEMENT = .1936 INCH OPEN

NOZZLE SCHEDULE							
MK.	SIZE	RTG.#	FACE	TYPE	NECK	REMARKS	SERVICE
A1	12	150	RF	SD	0.406		INLET
A2	12	150	RF	SD	0.406		OUTLET
A3	3/4	3000	—	FC	PLUG		VENT
A4	3/4	3000	—	FC	PLUG		DRAIN
B3	3/4	3000	—	FC	PLUG		VENT
B2	20	150	RF	LJ	.25		OUTLET
B1							
* BAFFLES					TUBES		
H=HORIZONTAL V=VERTICAL, D=SEE DETAIL					FOR U - TUBES LG=LENGTH OVER TUBE BUNDLE.		
NO. 10		PITCH 26		NO. 790		LG. 288	
DIA. 30 13/16		CUT 21 %		O.D. 3/4		PITCH 15/16	△
TK. 1/2		CUT H *		BW.G. 16		PASSES 1	

①	REV. PER CUSTOMERS MARKED PRINT DATED 6/28/02 AND REVISED CHANNEL		B	07/03/02	R
REV	DESCRIPTION		BY	DATE	CK
REFERENCE DRAWINGS					
T.S. DRILLING TEMPLATE <u>BT-24268</u>					
BENDING DETAILS _____					
DETAILS _____					
CERTIFIED CORRECT FOR JOB NO.					
BY		DATE			
SHOP	DATE		7/03/02		
CUST.	REPRO.				
	PRINTS				
	DATE				
ISSUED	REVISION	0	①		

FOR INSTALLATION IN STATE OF NC		
SHELL SIDE	CONDITIONS	TUBE SIDE
175	DES. PRESS. (P.S.I.G.)	150
50/375	DES. TEMP. (°F) ^{MIN} / _{MAX}	50/350
228	TEST PRESS. (P.S.I.G.)	199

DESIGN FLUID	
COOLING WATER	OXIDIZER OFF GAS
1/16	CORR. ALLOW. EXC. TUBES 0
WEIGHT (LBS)	EMPTY 17552
	FLOODED 25914

GENERAL NOTES				REQ'D.		NOT REQ'D.
				SHELL	CHAN.	
1	DEHYDRATE					X
2	HALOGEN TEST AT P.S.I.G.		M2892			X
3	AIR AND SOAP TEST AT P.S.I.G.		REINF. PADS FACINGS			X
4	X-RAY	SPOT ☒	FULL ☐	X	X	
5	POST WELD HEAT TREAT					X
6	SANDBLAST C.S. AFTER FAB, PER SSPC SP10			EXT. INT.	X X	
7	PICKLE					X
8	PAINT EXTERIOR UNIT			X	X	

(1) ONE COAT CARBOZINC 11 HC
(2) COATS CARBOLINE 4674 OR EQUAL

				REQ.	
9	TUBE END WELDING	NOTE 15	MANUAL	X	
10	CUSTOMER'S NAME PLATE		AUTOMATIC		X
11	NOZZLE PROTECTION		M & L STD.	X	
			SPECIAL		X
12	SPARE PARTS (1) SET UNIT GASKETS			X	
13	IMPACT TEST WELD ☐ BASE ☐ HEAT AFFECTED METAL ☐ METAL ☐ ZONE ☐		SHELL		X
14	ALL TUBES ARE TORQUE CONTROLLED ROLLER EXPANDED INTO THE TUBE SHEET TO A DEPTH OF 1.500 INCHES		CHAN.		X
15	TUBE TO TUBESHEET STRENGTH WELDING PER M&L PROCEDURE 22170				
16	LIQUID PENETRANT EXAMINE CUT SURFACES OF TUBESHEET BEFORE AND AFTER WELDING.				

1997

[illegible]

INSPECTION BY CUSTOMER	REQ'D ☐	NOT REQ'D ☐
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SCALE	MADE	CKD.	DATE	DRAWING NO.	REV
1:30,464	JB	TR	06/20/02	C-24267	1