

104545

**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 by Fabricated Products, 7900 Pence Road, Charlotte, NC 28212  
(Name and address of manufacturer)
2. Manufactured for Hercofina Corporation, Wilmington, NC  
(Name and address of purchaser)
3. Location of Installation Same as line 2  
(Name and address)
4. Type Vertical Vessel No. 2029-A n/a 2029-01&02 555 Year Built 1982  
(Horiz. or vert. tank) (Mfg's Serial No.) (CRN) (Drawing) (Heat Treat No.)
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 Rules, Section VIII, Division 1, 1980 and Addenda to (Date) and Code Case no. \_\_\_\_\_
- Special service per UG-120(d) \_\_\_\_\_
- Manufacturers' Partial Data Reports properly identified and signed by Commissioned Inspectors have been furnished for the following items of the report: \_\_\_\_\_  
(Name of part, item number, mfg's name and identifying stamp)

Items 6-11 incl. to be completed for single wall vessels, jackets of jacketed vessels, or shells of heat exchangers

6. Shell Material SA-516-70 Nom. Thickness .375 in. Corrosion Allowance .0625 in. Diam. 5 ft. 0 in. Length 16 ft. 2 in.  
(Spec. No., Grade)
7. Seams: Longitudinal dbl R.T. full Efficiency 100 % H.T. Temp. \_\_\_\_\_ F Time \_\_\_\_\_ Girth dbl R.T. full No. of Courses 2  
(Dbl., Sngl.) (Spot or Full) (Dbl., Sngl.) (Spot, Partial, or Full)
8. Heads: (a) Material \_\_\_\_\_ (Spec. No., Grade) (b) Material \_\_\_\_\_ (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)										
(b)										

If removable, bolts used (describe other fastenings) \_\_\_\_\_  
(Material, Spec. No., Gr., Size, No.)

9. Type of Jacket \_\_\_\_\_ Proof Test \_\_\_\_\_
10. Jacket Closure \_\_\_\_\_ If bar, give dimensions \_\_\_\_\_ If bolted, describe or sketch.  
(Describe as ogee & weld, bar, etc.)
11. Constructed for max. allowable working pressure 150 psi at max. temp. 350 F Min. temp. (when less than -20 F) \_\_\_\_\_ F.  
Hydrostatic, pneumatic, or combination test pressure 225 psi.

Items 12 and 13 to be completed for tube sections.

12. Tubesheets: Stationary Material SA-515-70 Diam. 60 in. Nominal Thick. 2.75 in. Corrosion Allow. .0625 in. Attachment welded  
(Spec. No., Gr.) (Subject to pressure) (Welded, Bolted)
- Floating Material \_\_\_\_\_ Diam. \_\_\_\_\_ in. Nominal Thick. \_\_\_\_\_ in. Corrosion Allow. \_\_\_\_\_ in. Attachment \_\_\_\_\_  
(Spec. No., Gr.)

13. Tubes: Material SA-249-T-304 O.D. 1.0 in. Nominal Thickness 14 in. or gauge Number 1920 Type straight  
(Spec. No., Gr.) (Straight or "U")

Items 14-17 incl. to be completed for inner chambers of jacketed vessels or channels of heat exchangers

14. Shell: Material SA-249-T-304 Nominal Thickness .1875 in. Corrosion Allowance 0 in. Diam. 5'-0" to 4'-6" in. Length 12 ft. 0 in.  
(Spec. No., Gr.)
15. Seams: Longitudinal dbl R.T. part Efficiency \_\_\_\_\_ % H.T. Temp. \_\_\_\_\_ F Time \_\_\_\_\_ Girth dbl R.T. part No. of courses 2  
(Dbl., Sngl.) (Spot or Full) (Dbl., Sngl.) (Spot, Partial or Full)

16. Heads: (a) Material \_\_\_\_\_ (Spec. No., Grade) (b) Material \_\_\_\_\_ (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)	Top	.1875	0				20°			
(b)	Bottom			54"		2:1				CONVEX

If removable, bolts used (describe other fastenings) \_\_\_\_\_  
(Material, Spec. No., Gr., Size, No.)

17. Max. allowable working pressure 75 psi at max temp. 350 F. Min. temp. (when less than -20 F) \_\_\_\_\_ F.  
Hydro. pneu. or comb. test pressure 112.5 psi.

Items below to be completed for all vessels where applicable

18. Safety Valve Outlets: Number \_\_\_\_\_ Size \_\_\_\_\_ Location In line by customer

This form may be obtained from the National Board of Boiler and Pressure Vessel Inspectors, 1055 Crupper Ave., Col's., O. 43220 NB-26 Rev. 4



**FORM U-1 (BACK)**

**19. Nozzles:**

Purpose (Inlet, Outlet, Drain)	Number	Diam or Size	Type	Material	Nominal Thickness	Reinforcement Material	How Attached
inlet	1	54	RFSO	SA-105	150#		Welded
outlet	1	36	RFSO	SA-105	150#		Welded
in & out	2	12"	RFSO	SA-105	150#		Welded
blowdown	1	1"	RFSO	SA-105	150#		Welded
spare	2	6"	RFSO	SA-105	150#		Welded
Vent	1	1"	F.cplq	SA-105	3000#		Welded
Vent	4	3/4"	F.cplq	T-304	3000#		Welded

**20. Inspection Openings:**

Manholes No. \_\_\_\_\_ Size \_\_\_\_\_ Location \_\_\_\_\_  
 Handholes No. \_\_\_\_\_ Size \_\_\_\_\_ Location \_\_\_\_\_  
 Threaded No. \_\_\_\_\_ Size \_\_\_\_\_ Location \_\_\_\_\_

21. Supports: Skirt \_\_\_\_\_ Lugs \_\_\_\_\_ Legs 4 Other \_\_\_\_\_ Attached Shell Welded  
(Yes or no) (No) (No) (Describe) (Where and how)

22. Remarks: 70" OD Expansion joint installed at Vertical center line

**CERTIFICATE OF 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.  
 Date 8-12-82 Signed Fabricated Products by Willie Hudson  
(Manufacturer) (Representative)

"U" Certificate of Authorization No. 10,264 expires January 15, 19 83

**CERTIFICATE OF SHOP INSPECTION**

Vessel made by Fabricated Products at 7900 Pence Road Charlotte, NC 28212  
 I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and the State or Province of North Carolina and employed by Department of Labor  
of North Carolina have inspected the pressure vessel described in this Manufacturers' Data Report on 8-12-82, 19\_\_\_\_ 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 8-12-82  
 Signed J. F. Ward Commissions NB 6072 NC 722  
(Inspector) (Nat'l Board, State, Province and No.)

**CERTIFICATE OF COMPLIANCE FOR FIELD WORK**

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.  
 Date \_\_\_\_\_ Signed \_\_\_\_\_ by \_\_\_\_\_  
(Manufacturer) (Representative)

"U" Certificate of Authorization No. \_\_\_\_\_ expires \_\_\_\_\_, 19\_\_\_\_

**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 this 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 \_\_\_\_\_ Commissions \_\_\_\_\_  
(Authorized Inspector) (Nat'l Board, State, Province and No.)