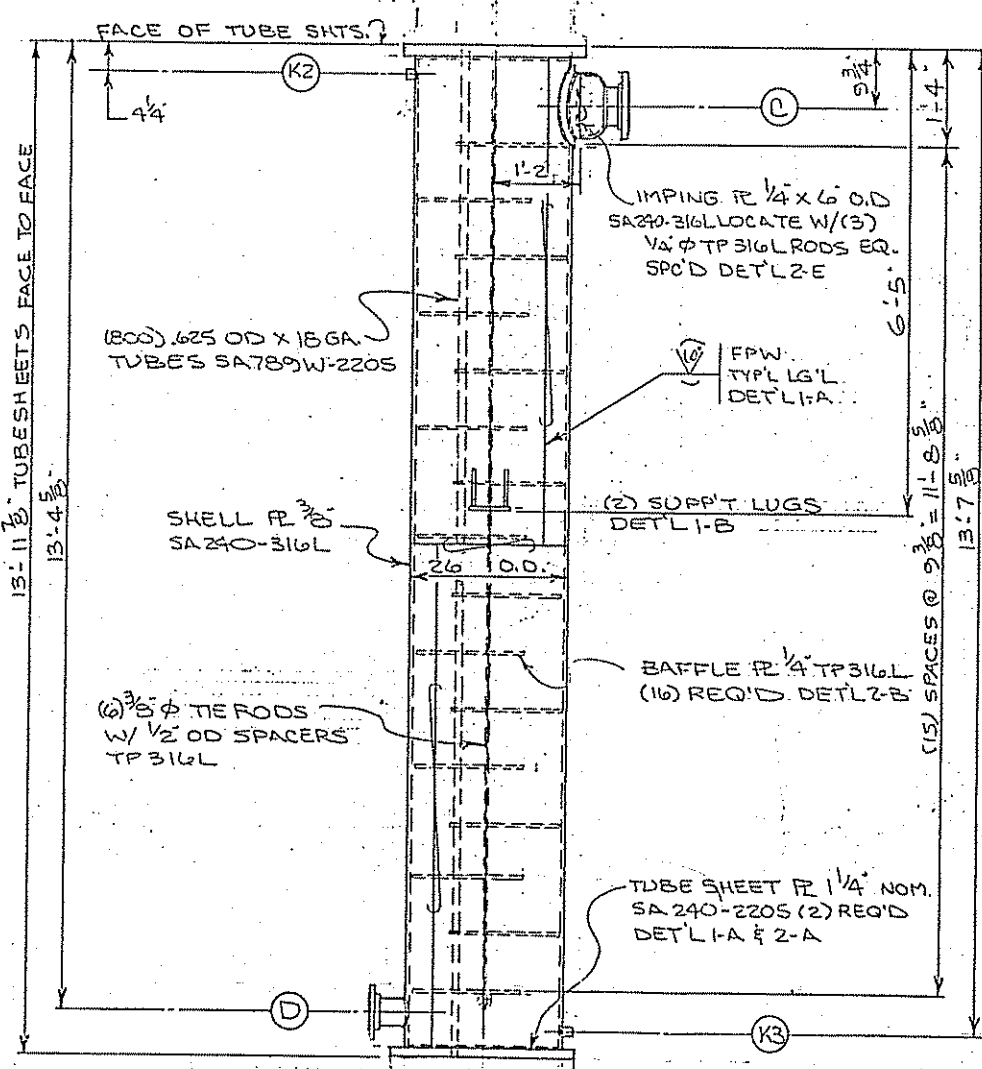
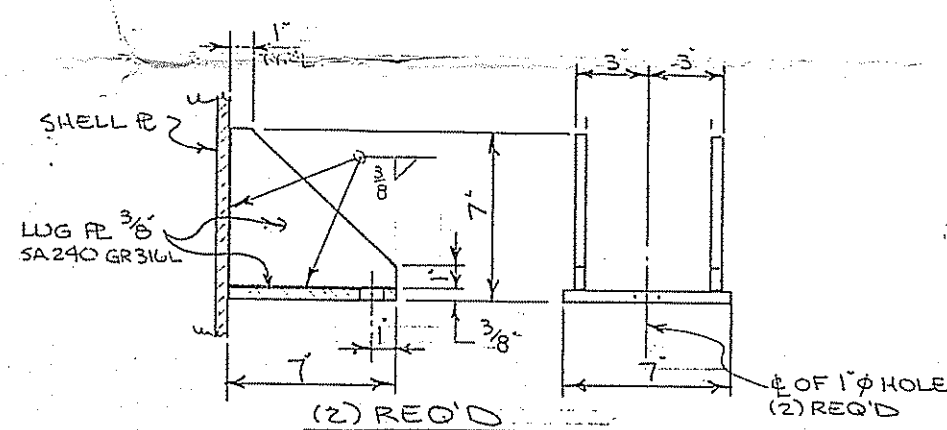
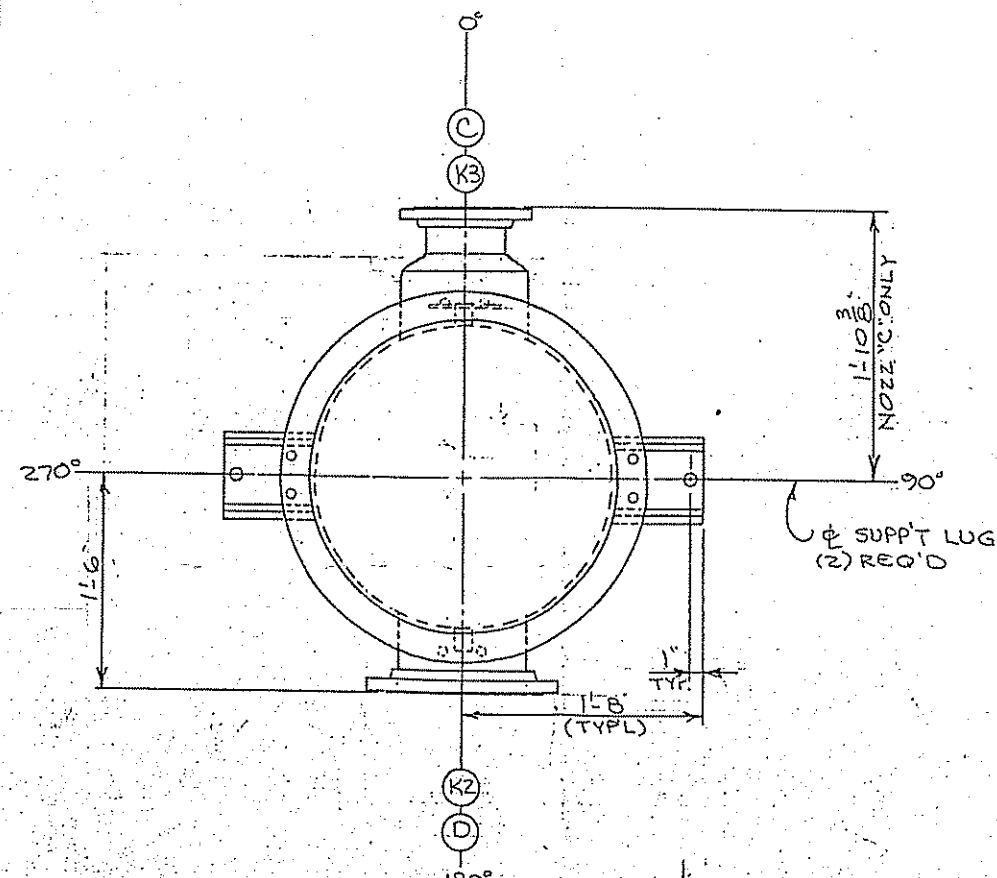




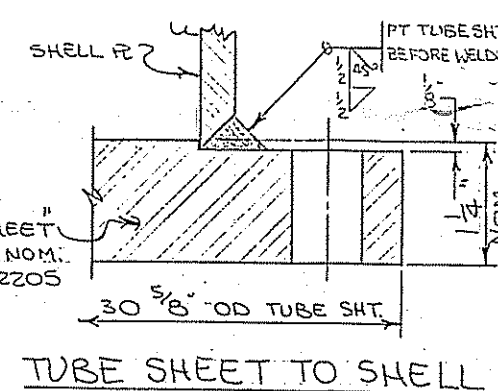
VESSEL SIDE ELEV.
3/4" = 1'-0"



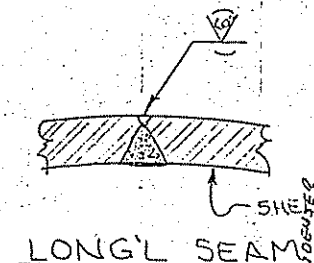
DET'L 1-B SUPPT LUGS
1/4" = 1'



PLAN AT TOP
1 1/2\"/>



TUBE SHEET TO SHELL



LONG'L SEAM

NOZZLE SCHEDULE									
MARK	NOZZLE			FLANGE			SERVICE		
	SIZE	SCH	THK	PRES	TYPE	FACE FIN.			

- NOTES:
1. VESSEL FABRICATED PER ASME SECT. VIII, DIV. 1, 1989 ED. 1991 ADDENDA, TEMA "C".
 2. ALL BOLT HOLES SHALL STRADDLE VESSEL MAJOR ϕ 'S.
 3. SHOP HYDRO. SHELL @ 450 PSI. TUBES @ 325 PSI.
 4. ALL S/S WELDS PER AHE-800. ALL S/S TO 2205 WELDS PER AHE-2208.

DESIGN DATA			
DESCRIPTION	SHELL	TUBE	
DESIGN PRESSURE	INTERNAL - PSIG 300	EXTERNAL - PSIG 215	
DESIGN TEMPERATURE	INTERNAL - $^{\circ}$ F 175/20	EXTERNAL - $^{\circ}$ F 150/20	
MAWP PSIG @	175/150	300/215	
CORR. ALLOW.	(.125)	.0	
HYDRO. PRESS. PSIG	(.125)	450/325	
WELD PROCEDURE	CODE: STD'S	STD'S	
RADIOGRAPHY	DESIGN JOINT EFF.	NONE	
HEAT TREATMENT	NOT REQ'D	70%	70%

MATERIAL SPECIFICATIONS - ASME	
VESEL	TUBE SIDE
SHELL HEADS	SA 240-316L
SUPPORTS	SA 240-316L
FLANGES	SA 182 F316L
PIPE	SA 312-316L (WLD)
TUBES	SA 182W-2205
TUBE SHEETS	SA 240-2205
BOLTS/NUTS	SA 193B7M
GASKETS	
BODY FLGS.	

CERTIFIED BY NAT'L. BD. 24
ALABAMA HEAT EXCHANGERS INC.

W SHELL 300 175
TUBES 215 PSI @ 150 $^{\circ}$ F
MAWP TEMP

SHELL -20 300
TUBES -20 $^{\circ}$ F @ 215 PSI
M.D.M.T.

MFG. SERIAL NO. AHE-205
YEAR BUILT 1993

HEAD THK. .3125" SHELL THK. .375"
JOB NO. 2241 HYDRO PSIG 450/325
CORR. ALLOW. 0" VESSEL WT. 8000# DRY
ITEM NO. B-HE-420 P.O. NO. 8X1376-0192
FA. NO. 544-586 DATE TESTED 3-93

ALABAMA HEAT EXCHANGERS INC.
SCALE: 3/4"=1'-0"
DATE: 11/10/92
NH₃ RECOVERY CONDENSER
DRAWING NO. 2241-92-1
SHEET 1 OF 2

Rev.	Project No.	Description	Drawn By	Checked By	Design Eng.	Prod. Eng.
1	AS BUILT 3-3-93	JCL				

CIBA-GEIGY Corporation
McIntosh, Alabama

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CERTIFIED DRAWING
Signature: *[Signature]* Date: 3-17-93

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