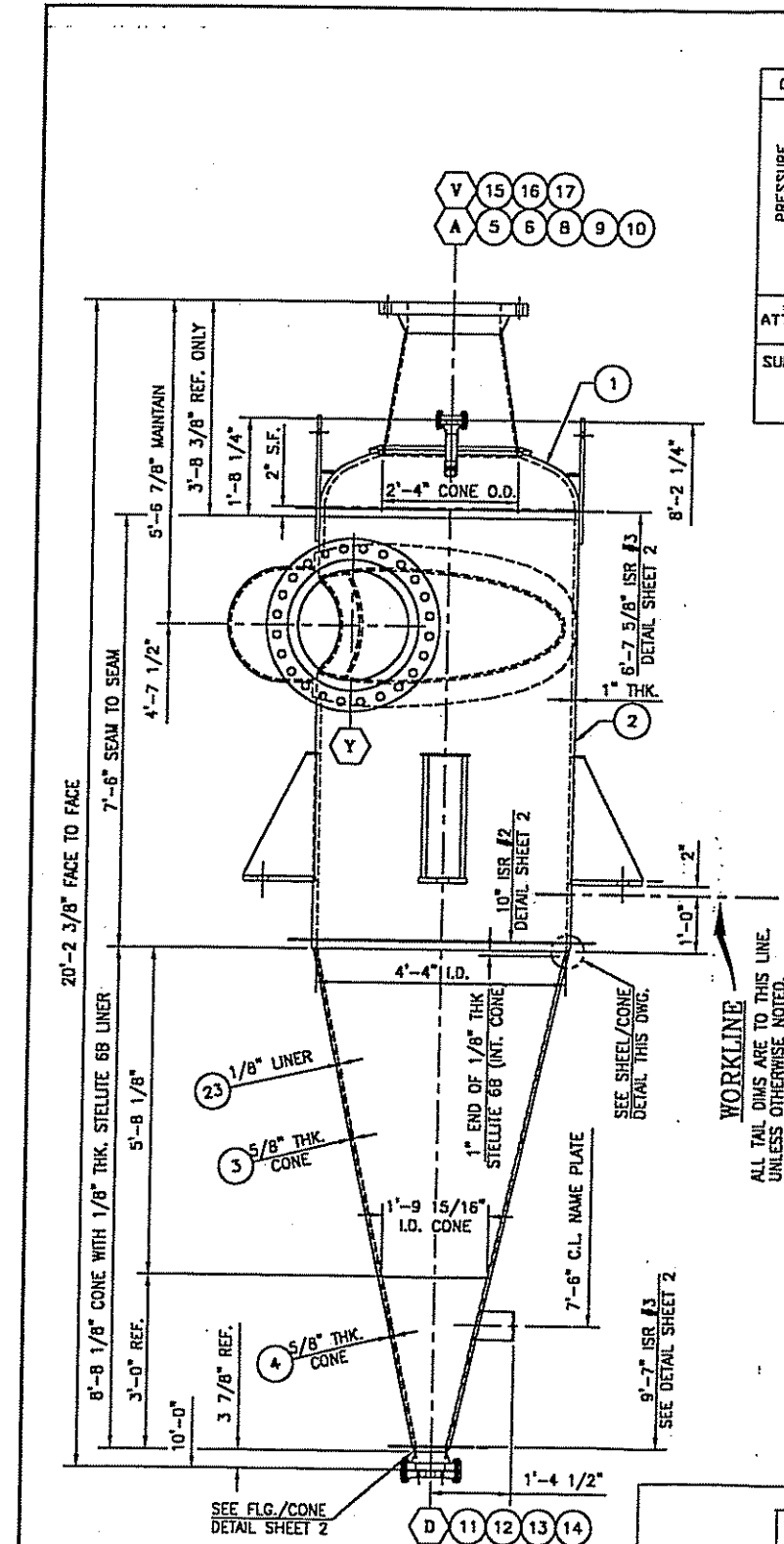




ELEVATION

CATEGORY		WPS NUMBERS	
PRESSURE ENVELOPE	A	PB-131-GT PB-132-SH	
	B	PB-131-GT PB-132-SH PB-133-SA	
	C	N/A	
	D	PB-131-GT PB-132-SH	
ATTACHMENTS		PB-131-GT PB-132-SH	PB-P43-4 PB-6B (LATER)
SUPPORTS		PB-131-GT PB-132-SH	

WELDING PROCEDURES

BILL OF MATERIALS:			DESCRIPTION:	MATERIAL
ITEM	QTY.			
(1)	1		HEAD 2:1 ELLIP. HEAD ASME CODE 52" I.D. X 1" MIN. THK. TOP HD. WITH 20" INSIDE BEVEL WITH 1/8" LAND	SA-240 316H
(2)	1		PL. 1" THK. X 90" X 186 1/2" LG. (SHELL) ROLL TO 52" I.D. WITH INSIDE 20" BEVEL ON LONG SEAM AND ONE GIRTH SEAM WITH 1/8" LAND WITH OUTSIDE 20" BEVEL ON ONE GIRTH SEAM WITH 1/8" LAND	SA-240 316H
(3)	1		PL. 5/8" THK. X 52" I.D. X 21 15/16" LG. X 68 1/8" HT. (CONE)	SA-240 316H
(4)	1		PL. 5/8" THK. X 21 15/16" LG. X 6 1/16" I.D. X 36" HT. (CONE)	SA-240 316H
(5)	1		2"-300# RFWN FLANGE W/SCH. 40# BORE (NOZZLE A)	SA-182 F-316H
(6)	1		2" SCH. 40# PIPE X 10 1/2" LG. (NOZZLE A NECK)	SA-312 316H
(7)	1		DELETED ITEM	
(8)	1		2"-300# RF BLIND FLANGE (NOZZLE A)	SA-182 F-316H
(9)	1		1/8" THK. GASKET FOR 2"-300# RF. FLANGE (NOZZLE A)	GE3V786 PER U2A
(10)	4		5/8" DIA. X 3 3/4" LG. STUDS W/2) NUTS EA. (NOZZLE A)	SA-182 F-316H
(11)	1		6"-300# RFWN FLANGE W/SCH. 40# BORE (NOZZLE D)	SA-182 F-316H
(12)	1		6"-300# RF BLIND FLANGE (NOZZLE D) SEE DETAIL SHEET #2	SA-182 F-316H
(13)	1		1/8" THK. GASKET FOR 6"-300# RF. FLANGE (NOZZLE D)	GE3V786 PER U2A
(14)	8		3/4" DIA. X 5" LG. STUDS W/2) NUTS EA. (NOZZLE D)	SA-182 F-316H
(15)	1		20"-300# RFWN FLANGE W/SCH. 40# BORE (NOZZLE V)	SA-182 F-316H
(16)	1		PL. 3/8" THK. X 27 1/4" LG. X 19 1/4" I.D. X 25 3/16" HT. REF. ONLY(CONE)	SA-240 316H
(17)	1		PL. 1" THK. X (28" LG. REF.) X 33 3/8" O.D. (NOZZLE V 2 5/8" W. PAD)	SA-240 316H
(18)	1		24"-300# RFWN FLANGE W/SCH. 80# BORE (NOZZLE Y)	SA-182 F-316H
(19)	1		24" SCH. 80# 90° S. RAD. ELBOWS (NOZZLE Y) (MAKE TWO 45°)	SA-403 WP316H
(20)	1		PL. 1" THK. X 72 1/4" X 25 1/2" LG. (NOZZLE Y NECK) ROLL TO 22" I.D.	SA-240 316H
(21)	2		24" 1" THK. 90° S. RAD. ELBOWS (FOR WRAP AROUND NOZZLE W/ Y)	SA-403 WP316H
(22)	1		PL. 1" THK. X 35 1/2" X 108" LG. (NOZZLE Y 5" WIDE PAD)	SA-240 316H
(23)	1		PL. 1/8" THK. X 51 5/16" I.D. X 8 1/4" I.D. X (102 3/16" HT. (INT. CONE) UNLESS OTHERWISE NOTED.	SA-240 316H
(24)	1		PL. 3/16" THK. X 7" X 23 1/4" LG. (NAME PLATE BRACKET)	SA-240 316H

GENERAL NOTES:

- ONE CYCLONE REQUIRED MARK NO. 1801-7015-01
- CYCLONE FABRICATOR SHALL FURNISH AND INSTALL ALL PARTS UNLESS OTHERWISE NOTED.
- FLANGE FACE FINISH TO BE 125-250 MICRO INCH RA.
- NOZZLE PROJECTIONS ARE FROM CENTER LINE OF CYCLONE TO EXTREME FACE OF FLANGE.
- ORIENTATION IS FROM CENTER LINE OF CYCLONE.
- FABRICATION TOLERANCES:

FACE SHALL NOT DEVIATE FROM NORMAL PLANE (WHEN MEASURED ACROSS BOLT CIRCLE) MORE THAN:	
NO. IN	TOLERANCE (IN)
0 TO 6	.015
7 TO 18	.020
19 AND OVER	.025
- ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED SHALL BE SHOWN ON FABRICATION DRAWINGS.
- ALL NOZZLES, AND LUGS BE HELD TO WITHIN ± 1/8" UNLESS OTHERWISE INDICATE ON DRAWING.
- ALL NOZZLES (EXCEPT NOZZLES WITH ATTACHED INTERNAL RINGS), AND MANWAYS SHALL BE FLUSH WITH VESSEL I.D. AND ROUNDED TO ELIMINATE ALL SHARP CORNERS.
- ALL REINFORCING PADS AND WEAR PLATES SHALL HAVE AT LEAST ONE 1/4" HPT HOLE FOR VENTING CONFIGURED VERTICALLY.
- ALL REINFORCING PADS SHALL BE TESTED TO 15 PSIG WITH AN AIR AND SOLUTION SPECIFICALLY MANUFACTURED FOR BUBBLE TESTING.
- ALL BOLT HOLES STRADDLE CENTER LINES EXCEPT AS NOTED.
- FABRICATOR TO PROVIDE GASKETS FOR HYDROTESTING.
- NOZZLES A AND D SHALL BE FURNISHED WITH BLIND FLG., STUDS & GASKET.

SHOP NOTES:

- ALL INTERNAL WELDS SHALL BE GROUND SMOOTH.
- CARBON STEEL CLAMPS, SUPPORTS, BRACES OR FIT-UGS SHALL NOT BE WELDED TO ANY SURFACE OF THIS VESSEL.
- ALL BUTT WELDS SHALL HAVE A T.I.G. ROOT PASS AND SHALL BE DYE CHECKED ON THE FACE OF THE ROOT. THE FINAL PASS OF ALL BUTT WELDS SHALL BE DYE CHECKED INSIDE AND OUTSIDE.
- DUPONT REPRESENTATIVE SHALL WITNESS ALL JOINT FIT-UPS.
- DUPONT REPRESENTATIVE SHALL WITNESS ALL DYE CHECK OF THE ROOT PASS AND FINAL PASS OF ALL WELDS, INSIDE AND OUTSIDE.
- MARKING PAINTS OR INK, SHALL NOT CONTAIN HARMFUL QUANTITIES OF LOW MELTING METALS OR METAL SALTS, SUCH AS ZINC, LEAD, CADMIUM OR CHLORIDES. ACCEPTABLE BRAND NAMES ARE TEXPEN AND NISSAN, WHITE OR YELLOW.
- AFTER FABRICATION VESSEL SHALL BE CLEANED OF ALL WELD FLUX, SPATTER, ARC BURNS, COUGES, TOOL MARKS, GREASE AND GENERAL SHOP OIL.
- HYDROTEST WATER SHALL CONTAIN NO MORE THAN A MAXIMUM OF 30 PPM CHLORIDES.
- AFTER HYDRO TEST CYCLONE SHALL BE COMPLETELY DRAINED OF ALL WATER AND WIPE DRY WITH LINT AND CHLORIDE FREE MATERIAL. HEAT OR BLOWN AIR SHALL NOT BE USED.
- ALL OPENING WITH PERMANENT BLINDS SHALL BE SEALED BY TAPING WITH WATER PROOF CLOTH BACKED, CHLORIDE FREE PRESSURE SENSITIVE TAPE. THE TAPE IS TO BE PROTECTED WITH 1/4" THK. EXTERIOR PLYWOOD EACH COVER SHALL BE PAINTED BOTH SIDES AND HELD IN PLACE WITH A MIN. OF 4 BOLTS (NOT GALVANIZED)

DESIGN DATA:

- DESIGN BASIS: ASME SECT. VIII DIV. 1 2001 LATEST ADDENDUM AND DUPONT STD. 5615
- STAMPING REQUIREMENTS: YES
- DESIGN INT. PRESS. @ TEMP. 125 PSIG @ 1200°F
- DESIGN EXT. PRESS. @ TEMP. 0 PSIG @ 1200°F
- MINIMUM DESIGN METAL TEMP. 15 °F @ 125 PSIG
- SPECIFIC GRAVITY OF LIQUID 1.0
- RADIOGRAPHING RT-3
- JOINT EFFICIENCY: SHELL 85% HEADS 100%
- NONCORROSION: SHELL 0" HEADS 0" NOZ. 0"
- HYDROSTATIC TEST PRESS.(NEW & COLD) 1.5X PSIG
- MAX.W.P.DESIGN TEMP. 125 PSIG LIMITED BY NOZZLE Y
- LOADS: WIND 120 MPH EARTHQUAKE N/A
- INSULATION LATER THK. BY OTHERS.

MATERIALS

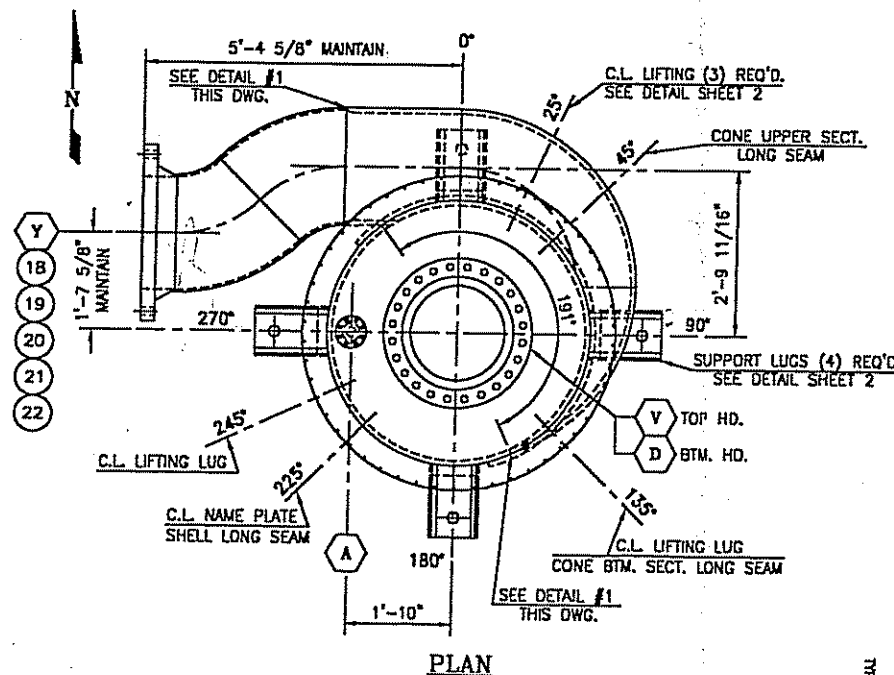
SHELL	SA-240 316H	FLANGES	SA-182 F-316H
HEADS	SA-240 316H	SUPPORTS	SA-240 316H
LIFTING/LUGS	SA-240 316H	INTERVALS	STELLITE 6B
STUDS	SA-182 F-316H	REF. PADS	SA-240 316H
NUTS	SA-182 F-316H	NOZ. HEADS	SA-240 & 312 316H

GASKETS GE3V786 PER U2A

WELDING PROCEDURES

VESSEL WEIGHT

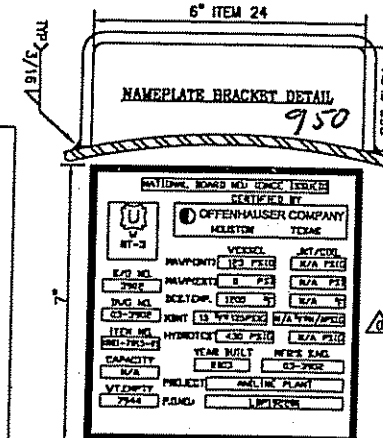
FABRICATED:	14,500 LBS.
EMPTY:	14,500 ± INSUL. WT. LBS.
FULL OF WATER:	19,600 LBS.



PLAN

Field & Shop Note

This vessel shall be lifted using spreader bar or its equivalent during all lifting operations.



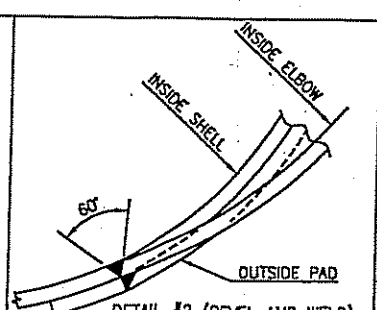
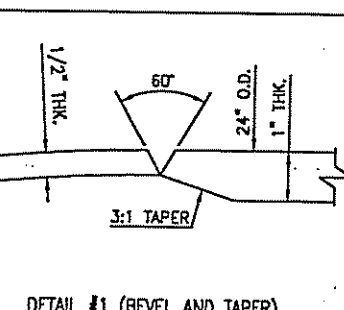
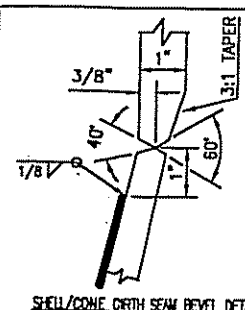
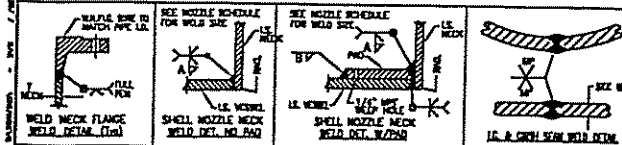
NOZZLE SCHEDULE

MARK	QTY.	SIZE	RATE	FACE	BORE	SERVICE	THK. WIDE	WELD SIZE	NECK	PROJECTION
A	1	2"	300#	R.F.	2.067		1/4"	40#	.154	SEE ELEV. 0"
D	1	6"	300#	R.F.	15.065		DETL			SEE ELEV. 0"
V	1	20"	300#	R.F.	19.25		1" X 1 3/4" W/ 1/2" PL.	3/8"		SEE ELEV. 0"
Y	1	24"	300#	R.F.	23.00		1" X 3" W/ 3/8" PL.	3/8"		SEE ELEV. 0"

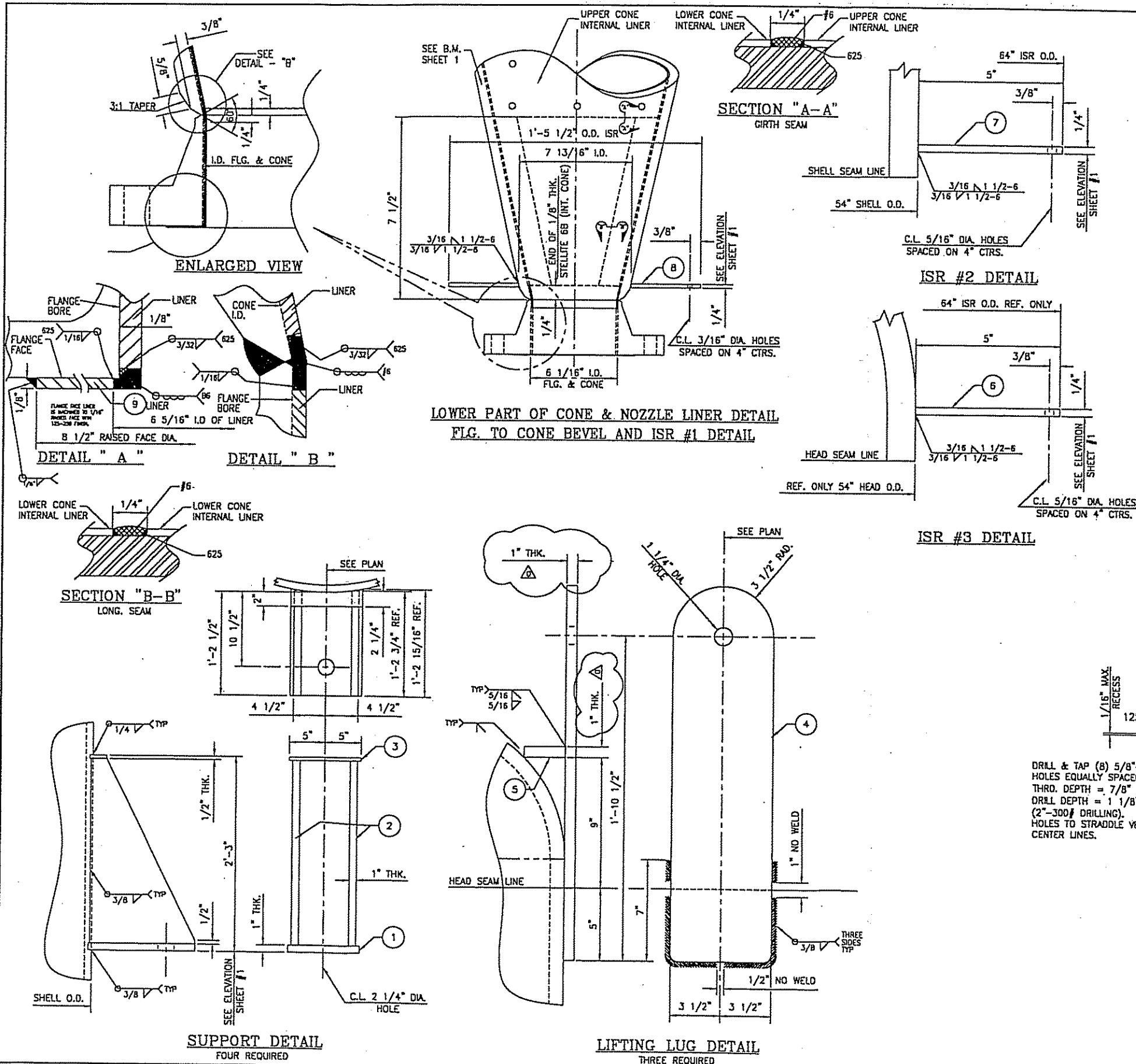
REV.	DESCRIPTION	DATE	BY	APPROVED
1	ADDED FABRICATED WEIGHT AS SHOWN	11-21-03	GP	PG
2	RE ISSUED THIS DWG. WITH OFFENHAUSER DWG. NO. FOR FAB.	9-22-03	GP	PG
3	ISSUED FOR FABRICATION	04/03/03	GP	AB
4	RE-ISSUED FOR APPROVAL	03/13/03	GP	AB
5	ISSUED FOR APPROVAL	12/18/02	GP	RD

OFFENHAUSER COMPANY
HOUSTON TEXAS

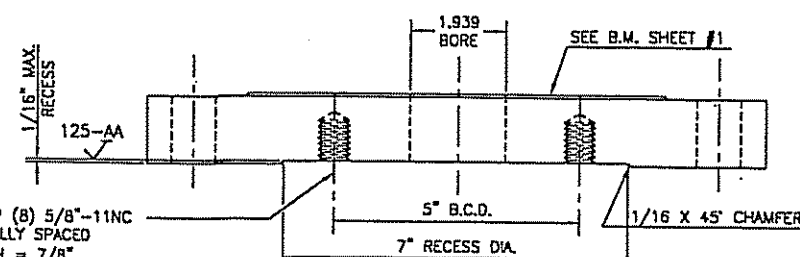
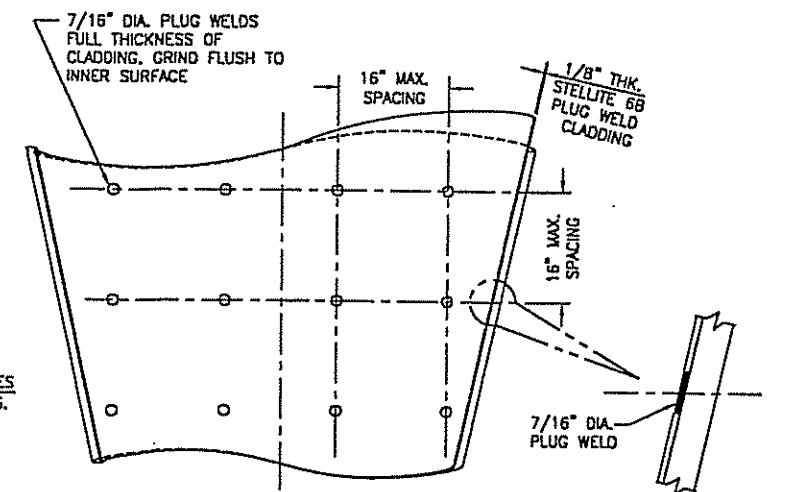
PARTIAL FABRICATION BY R.C. TECHNICAL WELDING & FAB. INC. SHOP ORDER NO. 9645	CUSTOMER: E.I. DU PONT DE NEMOURS & CO., INC. PURCHASE ORDER NO.: LBP192281 PROJECT NO.: ANILINE PLANT LOCATION: BEAUMONT, TEXAS
DRAWN BY: <i>Richard Longley</i> REVISED BY: S.D. DATE: 03/05/03 CHK'D BY: RAY DELAUNCE DATE: 12/18/02	52" I.D. X 20'-2 3/8" LG. FACE TO FACE LUG SUPPORTED VERTICAL VESSEL ADP CYCLONE SEPARATOR 1801-7015-01 DESIGN DATA & SCHEDULE OF OPENINGS DRAWN BY: GP CHK'D BY: GP DATE 9/16/03
SHOP ORDER NO.: 3902 DRAWING NO.: 03-3902 SHEET 1 OF 1	



1801-7015-01



BILL OF MATERIALS:			
ITEM	QTY.	DESCRIPTION:	MATERIAL
(1)	4	PL. 1" THK. X 10" X 15" LG. (BASE PLATES) SEE DETAIL	SA-240 316H
(2)	8	PL. 1" THK. X 14 3/4" X 23 1/2" LG. (GUSSETS) SEE DETAIL	SA-240 316H
(3)	4	PL. 1/2" THK. X 2 1/4" X 10" LG. (TOP PLATES) SEE DETAIL	SA-240 316H
(4)	3	PL. 1" THK. X 7" X 28" LG. (LIFTING LUGS) SEE DETAIL	SA-240 316H
(5)	3	PL. 1" THK. X 3 1/2" X 7" LG. (LIFTING LUGS GUSSETS) SEE DETAIL	SA-240 316H
(6)	1	PL. 1/4" THK. X 54 1/16" LD. REF. X 64" O.D. REF. (ISR #3) SEE DETAIL	SA-240 316H
(7)	1	PL. 1/4" THK. X 54 1/16" LD. X 64" O.D. (ISR #2) SEE DETAIL	SA-240 316H
(8)	1	PL. 1/4" THK. X 7 13/16" LD. X 17 1/2" O.D. (ISR #1) SEE DETAIL	SA-240 316H
(9)	1	PL. 1/8" THK. X 6 5/16" LD. X 8 1/2" O.D. FLG. FACE SEE DETAIL	STELLITE 69



DRILL & TAP (8) 5/8"-11NC HOLES EQUALLY SPACED THRO. DEPTH = 7/8" DRILL DEPTH = 1 1/8" MAX. (2"-300# DRILLING). HOLES TO STRADDLE VESSEL CENTER LINES.

REV.	DESCRIPTION	DATE	BY	APPROVED
0	ISSUED THIS DWG. WITH OFFENHAUSER DWG. No. FOR FAB.	9-22-03	GP	PG
0	ISSUED FOR FABRICATION	04/03/03	SG	AB
B	RE-ISSUED FOR APPROVAL	03/13/03	SC	AB
A	ISSUED FOR APPROVAL	12/19/03	SC	RD

PARTIAL FABRICATION BY R.C. TECHNICAL WELDING & FAB. INC. SHOP ORDER NO. 9645		CUSTOMER: E.I. DU PONT DE NEMOURS & CO., INC. PURCHASE ORDER NO.: LBP192291 PROJECT NO.: ANILINE PLANT LOCATION: BEAUMONT, TEXAS	
DRAWN BY: <i>Johnnie Dwyer</i> REVISED BY: AS DATE: 03/11/03	CHK'D BY: RAY DELAFORCE DATE: 12/19/02	SHOP ORDER NO.: 3902 DRAWING NO.: 03-3902 SHEET 2 OF 2	REV 0
DRAWN BY: GP CHK'D BY: GP DATE: 9/16/03			

NE

950



W
RT-3

CERTIFIED BY



OFFENHAUSER COMPANY
HOUSTON TEXAS

S/O NO.
3902
DWG NO
03-3902
ITEM NO.
1801-7015-01
CAPACITY
N/A
WT EMPTY
7944

	VESSEL	JKT/COIL
MAWP (INT)	125 PSIG	N/A PSIG
MAWP (EXT)	0 PSI	N/A PSI
DES TEMP	1200 °F	N/A °F
MMMT	15 °C 125 °SIG	N/A °F 0 N/A °PSIG
HYDROTEST	430 PSIG	N/A PSIG
YEAR BUILT	2003	MFR'S S.NO. 03-3902
PROJECT	ANILINE PLANT	
P.O. NO.	LBPI92281	

FORM U-1A MANUFACTURER'S DATA REPORT FOR PRESSURE VESSELS
(Alternative Form for Single Chamber, Completely Shop-Fabricated Vessels Only)
As Required by the Provisions of the ASME Code Rules, Section VIII, Division 1

1. Manufactured and certified by OFFENHAUSER COMPANY, 2201 Telephone Road, Houston, TX 77023

Manufactured for E.I.DUPONT NEMOURS & CO., P.O.BOX 4924, BEAUMONT,, TX 77704

3. Location of Installation E.I.DUPONT, 5470 TWIN CITY HWY., BEAUMONT,, TX 77705

4. Type Vertical 03-3902 03-3902 950 2003
(Horiz. or vert. tank) (Mfg's serial No.) (CRN) (Drawing no.) (Nat'l Bd. No.) (Year built)

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

to 2003 N/A
Addenda (Date) Code Case Nos. Special Service per UG 120(d)

6. Shell: SA-240-316H 1" 0 4'-4" 7'-6" SM/SM
Mat'l (Spec. No., Grade) Nom. Thk. (in.) Corr. Allow. (in.) Diam. I.D. (ft. & in.) Length (overall) (ft. & in.)

7. Seams: - - - - 1 Spot 1
Long. (Welded, Dbl., Sngl., Lap, Butl) R.T. (Spot or Full) Eff. (%) H.T. Temp (F) Time (hr) Girth (welded, Dbl., Sngl., Lap, Butl) R.T. (Spot, Partial, or Full) No. of Courses

8. Heads: (a) Mat'l. SA-240-316H (b) Mat'l. SA-240-316H
(Spec No., Grade) (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	1"	-			2:1				CONCAVE
(b)	Bottom	.625"	-				24.88			CONCAVE

If removable, bolts used (describe other fastenings)

9. MAWP INT. 125 EXT. 0 psi at max. temp. 1200 ° F
Min. design metal temp. 15 ° F at 125 psi. Hydro., ~~static~~, or ~~dynamic~~ test pressure 430 psi.

10. Nozzles, inspection and safety valve openings:

Purpose (Inlet, Outlet, Drain)	No.	Diam. or Size	Type	Mat'l.	Nom. Thk.	Reinforcement Mat'l.	How Attached	Location
Vent	1	2"	RFWN	SA-240-316H	S/40	INHERENT	UW16.1(d)	TOP HD.
Drain	1	6"	RFWN	SA-240-316H	S/40	INHERENT	UW16.1(d)	BOT CONE
Outlet	1	20"	RFWN	SA-240-316H	.375"	SA-240-316H	UW16.1(d)	TOP HD.
Inlet	1	24"	RFWN	SA-240-316H	1.0"	SA-240-316H	UW16.1(d)	SHELL

11. Supports: Skirt NO Lugs 4 Legs - Other - Attached SHELL / WELDED
(Yes or no) (No.) (No.) (Describe) (Where and how)

12. Remarks: Manufacturer's Partial Data Reports properly identified and signed by Commissioned Inspectors have been furnished for the following items of this report:
SHELL R.C TECHNICAL SN.9645-1 CONE R.C. TECHNICAL SN. 9645-2 NOZ. V NECK R.C. TECHNICAL 9645-3 SEE REMA
(Name of part, item number, Mfg's name and identifying stamp)
NOZ. Y NECK R.C. TECHNICAL SN. 9645-4 NOZ. Y NECK R.C. TECHNICAL SN. 9645-5 CONE R.C. TECHNICAL SN.9645-6
OFFENHAUSER COPMANY ASSEMBLED THE UNIT FROM PARTIAL DATA PIECES. OFFENHAUSER COMPANY IS RESPONSIBLE FOR CAT. "D" WELDS AND CAT. "B" OF THE ASSEMBLED UNIT. DESIGN WAS PERFORMED BY E. I. DUPONT.

CERTIFICATE OF SHOP 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. "U" Certificate of Authorization No. 2088 expires 12/31, 2003.

Date 12-24-03 Co. Name OFFENHAUSER COMPANY Signed [Signature]
(Manufacturer) (Representative)

CERTIFICATE OF SHOP INSPECTION

Vessel constructed by OFFENHAUSER COMPANY at Houston, TX 77023
I, the undersigned, holding a valid commission issued by The National Board of Boiler and Pressure Vessel Inspectors and the State or Province of TEXAS and employed by ONEBEACON AMERICA INSURANCE COMPANY Boston, MA have inspected the component described in this Manufacturer's Data Report on 12-31-2003 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 this Manufacturer's 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.

12-31-03 Signed [Signature] Commissions N.B. 8826A TX # 985
(Authorized Inspector) (Nat'l Board (incl. endorsements) State, Prov. and No.)

FORM U-2A MANUFACTURER'S PARTIAL DATA REPORT (ALTERNATIVE FORM)
A Part of a Pressure Vessel Fabricated by One Manufacturer for Another Manufacturer
As Required by the Provisions of the ASME Code Rules, Section VIII, Division 1

Revised *

1. Manufactured and certified by R.C. Technical Welding & Fab., Inc., 12814 Mula Lane, Stafford, Texas 77477

(Name and address of manufacturer)

Manufactured for E.I. DUPONT DE NEMOURS, PO BOX 4924, BEAUMONT, TX 77704

(Name and address of purchaser)

3. Location of installation E.I. DUPONT de NEMOURS AND COMPANY

(Name and address)

4. Type Shell 7' 6" S-S x 52" ID

(Description of vessel part (shell, two-piece head, tube bundle))

9645-1

(Mfg's serial No.)

(CRN)

RCT02-9645

(Nat'l Bd. No.)

(Drawing No.)

SG

(Drawing prepared by)

2003

(Year built)

5. ASME Code, Section VIII, Div. 1 Edition 2001, Addenda
2002

(Edition and Addenda (Date))

Code Case No.

Special Service per UG-120(d)

6. Shell: (a) No. of course(s) 1

(b) Overall length (ft & in)

7' - 6"

Course(s)			Material	Thickness		Long. Joint (Cat. A)			Circum. Joint (Cat. A, B & C)			Heat Treatment			
No.	Diameter, in.	Length (ft & in.)	Spec./Grade or Type	Nom.	Corr.	Type	Full	Spot, None	Eff.	Type	Full	Spot, None	Eff.	Temp.	Time
1	52" ID	7' - 6"	SA-240 316H	1"	nil	1	None		.85	n/a					

7. Heads: (a)

(b)

(Mat'l Spec No., Grade or Type) H.T. - Time & Temp

(Mat'l Spec No., Grade or Type) H.T. - Time & Temp

(Mat'l Spec No., Grade or Type) R.T. - Time & Temp													
Location (Top Bottom, Ends)	Thickness		Radius		Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure		Category A		
	Min.	Corr.	Crown	Knuckle					Convex	Concave	Type	Full, Spot, Non	Eff.
(a)													
(b)													

If removable, bolts used (describe other fasteners)

(Mat'l Spec. No., Grade, Size, No.)

8. MAWP psi at max. temp. ° F lin. design metal temp. ° F at psi.

Internal

External

Internal

External

Impact test

(Indicate yes or no and the component(s) impact tested)

10. Hydro. pneu., or comb. test press

Proof test

11. Nozzles, inspection, and safety valve openings:

Purpose (Inlet Outlet, Drain, etc.)	No.	Diameter or Size	Flange Type	Material		Nozzle Thickness		Reinforcement Material	How Attached		Location (Insp. Open.)
				Nozzle	Flange	Nom.	Corr.		Nozzle	Flange	

12. Supports: Skirt

Lugs

Legs

Others

Attached

(Yes or No)

(No.)

(No.)

(Describe)

(Where and How)

13. Remarks Shell was cut, rolled, beveled, LS welded & grind. Nozzle Y opening was cut, beveled & grind.

* No Calculation was done by R.C. Technical Welding & Fab., Inc. 12/15/03

CERTIFICATE OF SHOP / FIELD COMPLIANCE

We certify that the statements made in this report are correct and that all details of material, construction, and workmanship of this pressure vessel to the ASME Code for Pressure Vessels, Section VIII, Division 1.

U Certificate of Authorization N 26130

Expires

FEBRUARY 04

2004

Date August 13, 2003 Name R.C. Technical Welding & Fab., Inc.

Signed Al Brillantes

(Manufacturer)

(Representative)

CERTIFICATE OF SHOP / FIELD INSPECTION

I, the undersigned, holding a valid commission issued by The National Board of Boiler and Pressure Vessel Inspectors and the TEXAS and employed by IB & MRE of DALLAS have inspected the

pressure vessel part described in this Manufacturer's Data Report August 11 2003 and state that, to the best of my knowledge and belief, the Manufacturer has constructed this pressure vessel part in accordance with ASME Code, Section VIII, Division 1. By signing this certificate the

employer makes any warranty, expressed or implied, concerning the pressure vessel part described in this Manufacturer's Data Report. If 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 the inspection.

Date August 13, 2003 Signed Steve Riddles

(Authorized Inspector)

Commissions

10924A TX 1366

(Nat'l Board (incl. endorsements) State, Prov. and No.)