

CSF-23003

FORM U-1 MANUFACTURERS' DATA REPORT FOR PRESSURE VESSELS
As Required by the Provisions of the ASME Code Rules, Section VIII, Division 1

E 74-12-55-B

1. Manufactured by Atlas Industrial Manufacturing Co., 81 Somerset Place, Clifton, N. J.
(Name and address of manufacturer)
2. Manufactured for Hoffmann-La Roche, Inc., Nutley, New Jersey
(Name and address of purchaser)
3. Location of installation Hoffmann-La Roche, Inc., Holvidere, N. J.
(Name and address)
4. Type Horiz. Ht. Exch. Vessel No. 5004 D-7973-1 4156 Year Built 1982
(Horiz. or vert. tank) (Mfr's Serial No.) (CHN) (Drawing) (Net Brd 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 (Year)
Spec. 81 and Code Case no. _____ Special service per UG-120(d) _____
(Date)
Manufacturers' Partial Data Reports properly identified and signed by Commissioned Inspectors have been furnished for the following items of the report: Expansion Joint Co. Item #8, Zallea Bros. Inc. S/N 43389-2
(Name of part, item number, mfr's name and identifying stamp)

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

6. Shell: Material SA-240, 316L Nominal Thickness 3/16 in. Corrosion Allowance 0 in. Diam. 2 ft 6 in. Length 11 ft 7 7/8 in.
(Spec. No., Grade)
7. Seams: Longitudinal Welded, Dbl. Butt R.T. None Efficiency 70 % H.T. Temp. _____ F
(Welded, Dbl., Sngl., Lap, Butt) (Spot or Full)
Time _____ Girth Welded, Dbl. Butt, Dbl. Fillet, Sngl. R.T. None No. of Courses 3
(Welded Dbl., Sngl., Lap, Butt) (Spot, Partial or Full)
8. Heads: (a) Material SA-240, SS-316L (b) Material _____
(Spec. No., Grade) (Spec. No., Grade)

	Location (Top, Bottom, Ends)	Minimum Thickness	Corrosion Allowance	Crown Radius	Knuckle Radius	Elliptical Ratio
(a)						
(b)						
	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 open & weld, bar, etc.)
11. Constructed for max. allowable working pressure 75 psi at max. temp. 300° F Min. temp. (when less than -20 F) _____ F.
Hydrostatic, pneumatic, or combination test pressure 113 psi

Items 12 and 13 to be completed for tube sections

12. Tubesheets: Stationary—Material SA-240, SS-316L Diam. 34 1/8 in. Nominal Thickness 1 3/8 in. Corrosion Allowance 0 in. Attachment Welded Floating—Material _____ Diam. _____ in.
(Spec. No., Gr.) (Subject to pressure) (Welded, Bolted) (Spec. No., Grade)
Nominal Thickness _____ in. Corrosion Allowance _____ in. Attachment _____
13. Tubes: Material SA-240, SS-316L O.D. 3/4 in. Nominal Thickness .065 in. or gauge Number 16 Type Straight
(Spec. No., Gr.) (Straight or "U")

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

14. Shell: Material SA-240, 316L Nominal Thickness 3/16 in. Corrosion Allowance 0 in. Diam. 2 ft 6 in. Length 2 ft 1 3/8 in.
(Spec. No., Gr.)
15. Seams: Longitudinal Wld. Dbl. Butt R.T. None Efficiency 70 % H.T. Temp. _____ F Time _____
(Welded, Dbl., Sngl., Lap, Butt) (Spot or Full)
Girth Dbl. Fillet, Sngl. R.T. None No. of courses 1
(Welded, Dbl., Sngl., Lap, Butt) (Spot, Partial, or Full)
16. Heads: (a) Material SA-515-70 (b) Material _____
(Spec. No., Grade) (Spec. No., Gr.)

	Location (Top, Bottom, Ends)	Minimum Thickness	Corrosion Allowance	Crown Radius	Knuckle Radius	Elliptical Ratio
(a)	<u>Ends</u>	<u>1 3/8"</u>	<u>0</u>			
(b)						
	Conical Apex Angle	Hemispherical Radius		Flat Diameter	Side to Pressure (Convex or Concave)	
(a)				<u>34 1/8"</u>		
(b)						

If removable, bolts used (describe other fastenings) Low Alloy, SA-193-B7, 3/4" 32
(Material, Spec. No., Gr., Size, No.)

(12/31/77)

This form (E00100) may be obtained from the Order Dept., ASME, 345 E. 47th St., New York, N.Y. 10017

FORM U-1 (BACK)
17. Constructed for max. allowable working pressure 75 psi at max temp. 3000 F. Min. temp. (when less than -20 F) 113 F.
Hydrostatic, pneumatic, or combination test pressure 113 psi.

Items below to be completed for all vessels where applicable

18. Safety Valve Outlets: Number Size Location

19. Nozzles:

Purpose (Inlet, Outlet, Drain)	Number	Diam. or Size	Type	Material	Nominal Thickness	Reinforcement Material	How Attached
Inlet	1	8"	LJ	SA-240 T316L	3/16"		Welded
Outlet	1	3"	LJ	SA-312W T306L	.120"		Welded
Inlet	1	4"	LJ	SA-312W T306L	.120"		Welded
Outlet	2	12"	LJ	SA-240 T316L	3/16"		Welded
Outlet	2	3"	LJ	SA-312W T-316L	.120"		Welded

20. Inspection Openings:

Manholes No. Size Location

Handholes No. Size Location

Threaded No. Size Location

21. Supports: Skirt No Lugs No Legs 2 Other Attached Shell-Welded
(Yes or no) (No.) (No.) (Describe) (Where and how)

22. Remarks: Col. 8 Reboiler Tema Type "AEL"
Hoffmann, La Roche P.O. No. R-7142255-B Equip. Code CSF-23003
Atlas Job# 4647

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 6-2-82 Signed Atlas Industrial Mfg. Co. by
(Manufacturer) (Representative)

"U" Certificate of Authorization No. 5027 expires April 30, 19 84

CERTIFICATE OF SHOP INSPECTION

Vessel made by Atlas Industrial Manufacturing Co. at 81 Somerset Place, Clifton, N. J.

I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State or Province of N. J. and employed by Lumbermens Mutual Casualty

of Long Grove, Ill. have inspected the pressure vessel described in this Manufacturers' Data Report on JUL 9 1982

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 JUN 14 1982 Signed Commissions
(Inspector) (Not' 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/or 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 CSF-23003

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) (Not' Board, State, Province and No.)

4647

NATIONAL BOARD NO.		71156217
ATLAS		INDUSTRIAL MFG. CO. CLIFTON, N. J.
SHELL	11774521100	P.S. 1 AT 3000 P.S.
TUBES	11774521100	P.S. 1 AT 3000 P.S.
SERIAL	13002716	
YEAR	19082111	
POINT OF 744226521100S 1100N1100211 11027110011001100S 110000110011 110111100S 1100S 1100S 1100S 1100S 1100S 1100S 1100S 1100S 1100S 1100S 1100S		