

Purchaser: Wilputte Coke Oven Division  
Allied Chemical Corporation  
P. O. No. 38-555, Item V-25

Sharpsville Steel Fabricators, Inc  
Order P-9550A

FORM U-1A MANUFACTURERS' DATA REPORT FOR UNFIRED PRESSURE VESSELS

Alternate Form for Single Chamber Completely Shop-Fabricated Vessels Only

1. Manufactured by	Sharpsville Steel Fabricators, Inc., Sharpsville, Penna.									
(Name and address of Manufacturer)										
2. Manufactured for	installation at Clark Oil & Refining Co., Blue Island, Ill.									
(Name and address of Purchaser)										
3. Type	Vert.	Vessel No.	(573)	(Mfrs. Serial)	(State & State No.)	Natl. Bd. No.	573	Yr. Built	1963	
(Horiz. or Vert.)										
4. SHELL: Matl.	Type 304	T.S.	75000	Nom. Thk.	1/4	In.	Corr. Allow.	Outside	6	In.
(Kind and Spec. No.) (Plg. or P.B. & Spec. Min. T.S.)										
5. SEAMS: Long	welded butt	S.R.	No	X.R.	Spot	Sectioned	No	Efficiency	80	%
(Yes or No) (Spot or Complete) (Yes or No)										
6. HEADS: (a) Material	SA-240, Type 304	T.S.	75000	(b) Material	SA-240, Type 304	T.S.	75000			
(Material, Spec. No., T.S., Size, Number)										
(a)	Top	Thick.	1/4	Crown Radius	48"	Knuckle Radius	3-1/4"	Elliptical Ratio		Conical Apex Angle
(b)	Bottom	Thick.	1/4	Crown Radius		Knuckle Radius		Elliptical Ratio		Conical Apex Angle
If removable, bolts used										
Other fastening										
(Describe or Attach Sketch)										
7. Constructed for max. allowable working press.	50	psi.	at max. temp.	300	°F.	Min. temp. (when less than -20°)		°F.	Hydrostatic Test	75
8. SAFETY OR RELIEF VALVE OUTLETS: Number 1 Size 3" Location center of top head										
9. NOZZLES:										
Purpose (Inlet, Outlet, Drain)	Number	Diam. or Size	Type	Material	Thickness	Reinforcement Material	How Attached			
5-1", 1-2", 2-2 1/2", 1-3", 1-6"			nozzle	SA-312, Type 304			welded			
10. INSPECTION Manholes, No.	1	Size	20"	Location	shell near bottom					
OPENINGS: Handholes, No.		Size		Location						
Threaded, No.		Size		Location						
11. SUPPORTS: Skirt	no	Lugs		Legs	4	Other		Attached	welded to shell	
(Yes or No) (Number) (Number) (Describe) (Where & How)										
12. REMARKS: Vessel to be used as a cumene water separator in phenol plant.										

(Brief description of purpose of the vessel as Air Tank, Water Tank, L.P.G., Etc.—State Contents.  
List other internal or external pressures with coincident temperature when applicable.)

We certify that the statements made in this report are correct and that all details of material, construction, and workmanship of this vessel conform to the ASME Code for Unfired Pressure Vessels.

Date AUG 16 1963 19 Signed Sharpsville Steel Fabricators, Inc. By J. R. O'Han (Manufacturer)

Certificate of Authorization Expires December 31, 1964

CERTIFICATE OF SHOP INSPECTION

Inspection Agency's Serial No. HSB-573

VESSEL MADE BY Sharpsville Steel Fabricators, Inc., Sharpsville, Penna.

I, the undersigned, holding a Certificate of Competency as an Inspector of Boilers and Unfired Pressure Vessels in THE STATE OF Natl. Bd. and employed by Hartford Steam Boiler Inspection & Ins. Co., Hartford, Conn., inspected internally and externally, the vessels described in this report on AUG 16 1963 19, and certify that the statements made in this report are correct corresponding with mill test reports of materials furnished by the builders, and measurements made of the vessel and that this vessel is constructed in accordance with the ASME Code for Unfired Pressure Vessels.

Date AUG 16 1963 19

Inspector's Signature

Commissions NB-4225

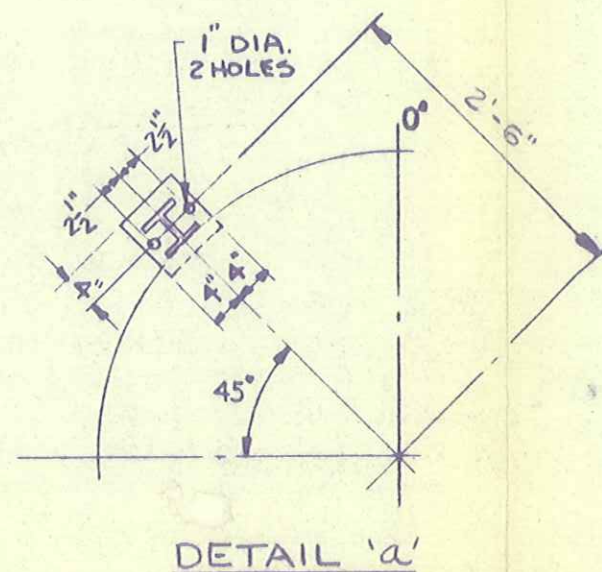
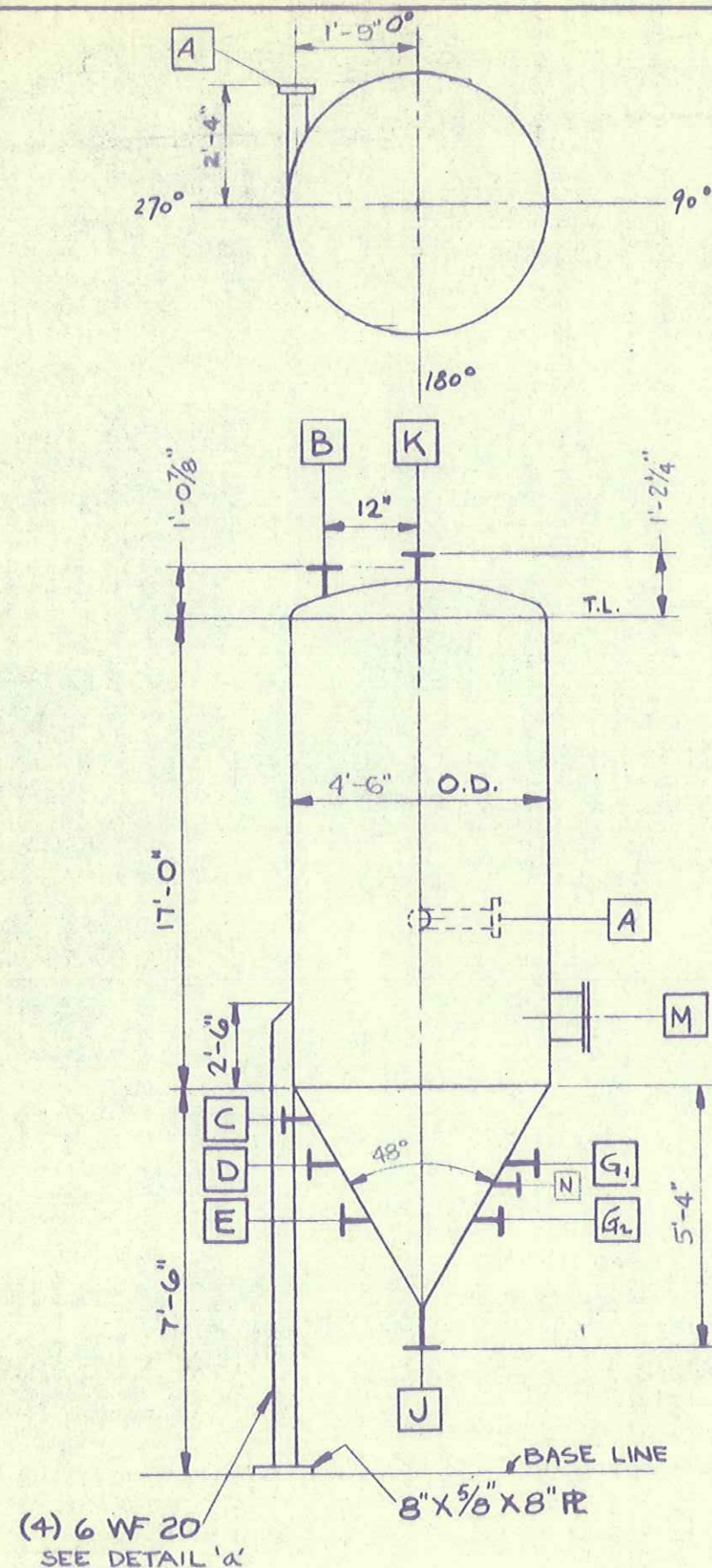
State or Natl. Bd. & Number

#110369

CLARK - 555







NOZZLE SCHEDULE					
MK	SIZE	SERVICE	PROJ.	ELEV.	ORIENT
A	2 1/2"	LIQUID INLET	SEE PLAN	14'-6"	SEE PLAN
B	2 1/2"	LIQUID OUTLET	-	-	90°
C	1"	SAMPLE CONN.	2'-4 1/2"	7'-0"	240°
D	1"	SAMPLE CONN.	1'-11 1/2"	6'-0"	270°
E	1"	SAMPLE CONN.	1'-6 1/8"	5'-0"	285°
G1	1"	GAUGE GLASS	2'-2 1/8"	6'-6"	330°
G2	1"	GAUGE GLASS	1'-3 1/2"	4'-6"	330°
J	2"	LIQUID OUTLET	-	-	⊥ BOTT HEAD
K	3"	VENT (SAFETY VALVE)	-	-	⊥ TOP HEAD
M	20"	MANHOLE WITH LIFTING LUG	2'-11"	9'-0"	90°
N	6"	LIQUID LEVEL CONTROL	2'-0"	5'-9"	90°

DESIGN CONDITIONS  
 50 psig @ 300 °F.  
 psig @ °F.  
 psig @ °F.  
 SPECIFIED CORROSION ALLOW. NONE

CODE ASME UPV CODE STAMP YES  
 STRESS RELIEF NO RADIOGRAPH SPOT  
 MAWP 50 LIMITED BY -  
 SHELL SPEC. ASTM A-240 TYPE 304  
 1/4" TK.  
 JOINT EFF. 80%  
 HEAD SPEC. ASTM A-240 TYPE 304, 1/4" MIN. TK. ASME F&D (TOP)  
 (BOTTOM) ASTM A-240 TYPE 304, 1/4" TK. 48° CONICAL  
 JOINT EFF. TOP - 100% BOTTOM - 80%  
 CLADDING OR LINING SPEC. NONE

GASKET SPEC. 1/16" TK. GARLOCK T021  
 SUPPORT SPEC. ASTM A-7  
 EXTERNAL PIPE SPEC. ASTM A-312 TYPE 304  
 INTERNAL PIPE SPEC.  
 FLANGE SPEC. ASTM A-181 GR 1  
 RATING 150\*ASA (EXCEPT MANHOLE TO CODE)  
 FACING LAP JOINT  
 PAINT AS PER ORDER  
 INSULATION 1" BOTTOM HD. ONLY (OPER. TEMP. = 100°F)  
 FIREPROOFING NONE

SHIPPING WT. OPERATING WT. TEST WT.  
 ELEVATION MEASURED FROM BASELINE  
 ORIENTATION MEASURED CLOCKWISE FROM 0°. NORTH IS 0°  
 PROJECTION MEASURED FROM ⊥ OF VESSEL TO EXTREME FACE OF FLANGE

BOLTING: FOR MANHOLES ASTM A-193 GRADE B7  
 STUD BOLTS THREADED FULL LENGTH. ASTM A-194  
 CLASS 2 OR 2H AMERICAN STANDARD HEAVY HEX. NUTS  
 ITEM NUMBER, 0°/180° CENTERLINE, SHIPPING WEIGHT &  
 NORTH ARROW, SHALL BE PAINTED ON VESSEL

### REFERENCE DRAWING

MANHOLE DAVIT & HINGE 2A-52405

FILE  
 PHC 16

ONE REQ'D

ITEM No V-25

ENGINEERING DEPT.

REQ. 555-12

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 CORE OVEN DIVISION  
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 NEW YORK 10011

REVISION  
 SCALE

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 BLUE ISLAND ILLINOIS  
 CUMENE WATER SEPARATOR  
 PHENOL PLANT  
 555 79  
 2A-52379