

STANDARD NOTES:

- A. PROJECTION MEASURED FROM OUTSIDE OF VESSEL TO EXTREME GASKET FACE OF NOZZLE, UNLESS OTHERWISE SPECIFIED.
B. NOZZLE BOLT HOLES TO STRADDLE 0-180/ VERTICAL CENTERLINE OR ITS PARALLEL UNLESS NOTED OTHERWISE.
C. GASKET FINISH: 125 TO 250 uin AVERAGE ROUGHNESS PER ASME B16.5-2003, PARA. 6.4.5.3
D. HYDRO-TEST SHALL BE PERFORMED WITH WATER CONTAINING NO MORE THAN 50 PPM CHLORIDE.
E. WELDING PROCEDURES:

ADDITIONAL CUSTOMER SPECIFIC NOTES:

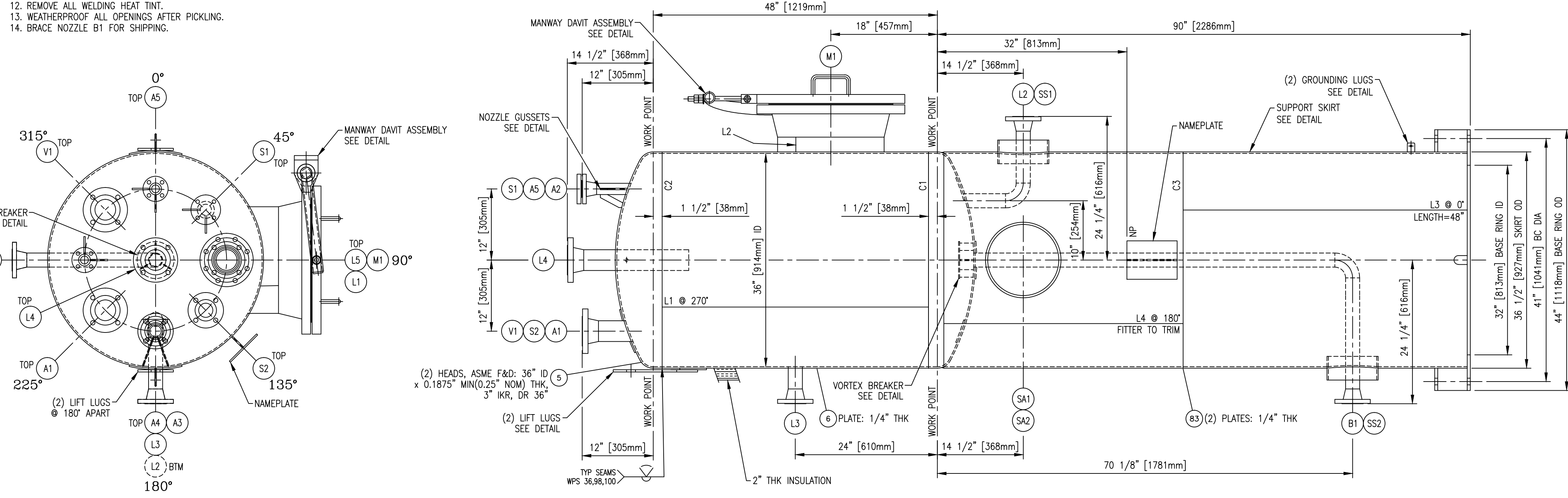
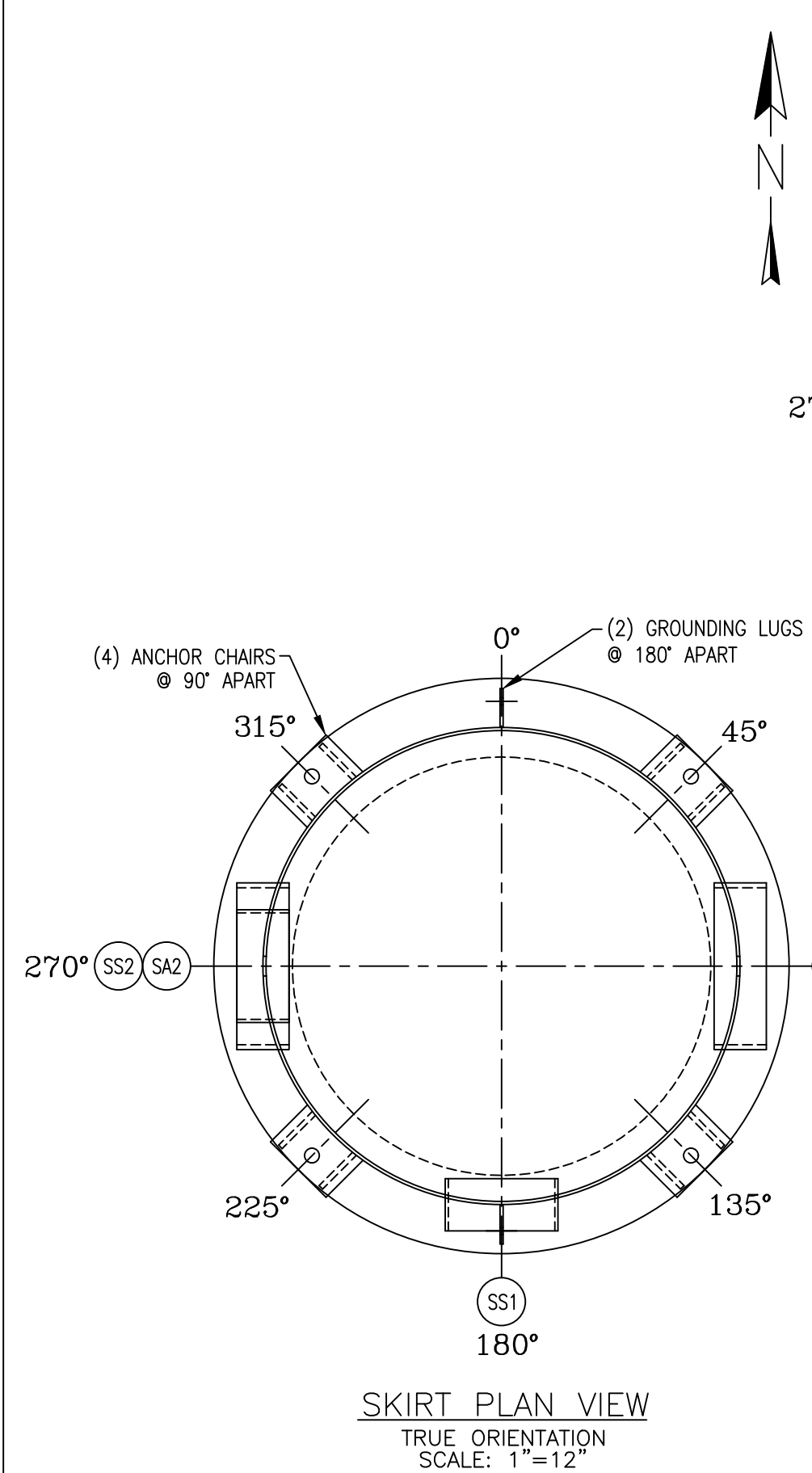
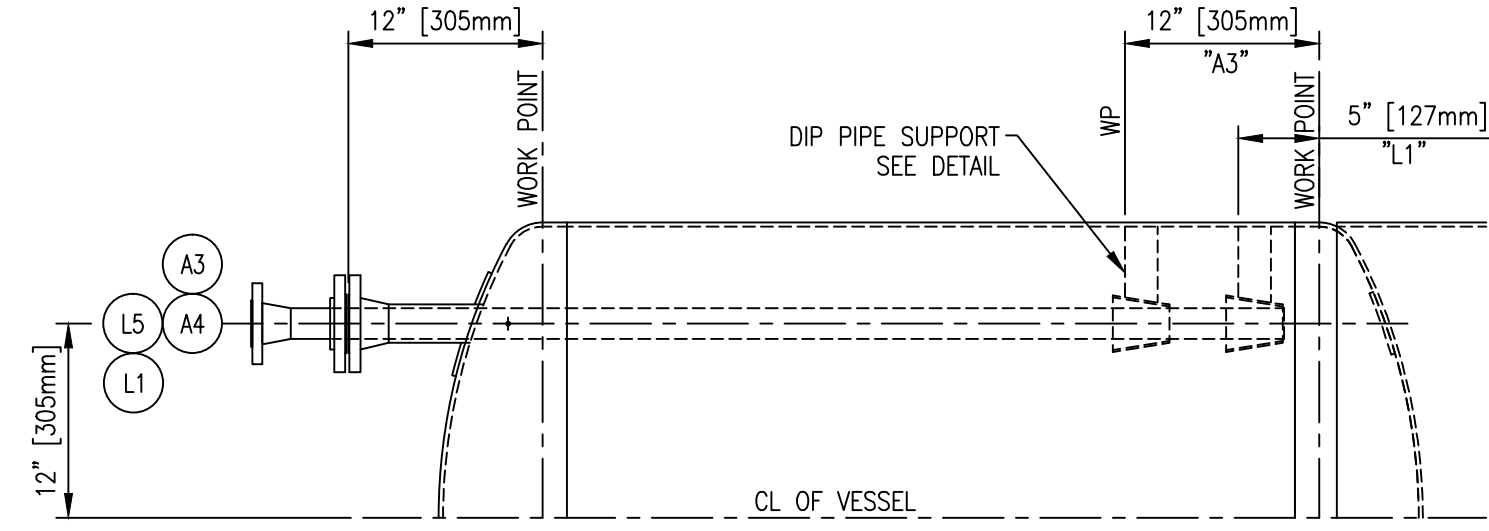
- 1. APPLICABLE EVONIK SPECIFICATIONS:
- 20.230.030 - PRESSURE VESSEL REQUIREMENTS
- 20.230.013 - GENERAL EQUIPMENT REQUIREMENTS
- 20.230.036 - WELDING PRESSURE VESSELS
- VESV1002 - DESIGN & FABRICATION OF VESSELS
- VEFV1102 - VESSEL TOLERANCES
- TS-25-0902 - NAMEPLATE BRACKET
- TS 25-0205-2 - SURFACE TREATMENT OF STAINLESS STEEL
2. WELD PREP SHALL BE MECHANICALLY AND SOLVENT CLEANED, INCLUDING 2" EITHER SIDE OF THE WELD, PRIOR TO WELDING.

NDE DOCUMENTATION TABLE

Table with columns: REQUIRED w/ REPORTS, REQUIREMENT DESCRIPTION, COMMENTS, INSPECTOR, DATE. Includes entries for LIQUID PENETRANT TEST, MAGNETIC PARTICLE TEST, BUBBLE LEAK TEST, FERROXYL TEST, POSITIVE MATERIAL IDENTIFICATION, BASELINE THICKNESS MEASUREMENT.

DESIGN TABLE

Table with columns: SHELL, MAWP LIMITER, TEMP, F/C, C.A., SPECIFIC GRAVITY, RADIOGRAPHIC REQUIREMENTS w/REPORTS, OTHER RADIOGRAPHY, HYDROSTATIC TEST, PRESSURE, DURATION, CHART RECORD.



ALLOWABLE NOZZLE LOADS table with columns: NOZZLE, SIZE, P, V1, V2, M1, M2, MT. Lists allowable loads for different nozzle sizes and materials.

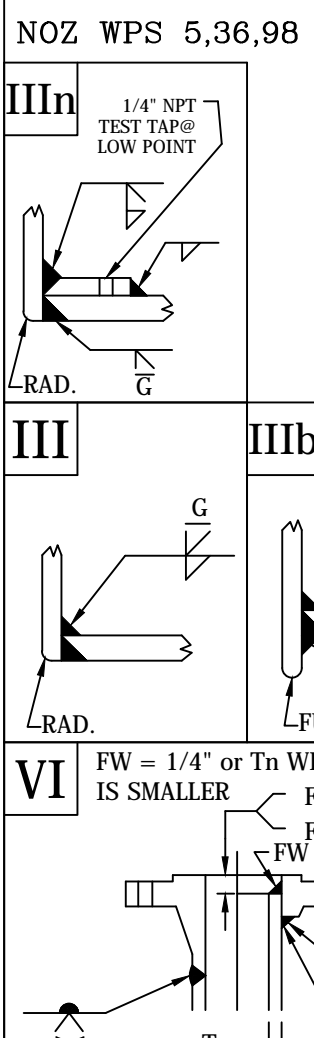
AS-BUILT PRINT
WARD TANK AND HEAT EXCHANGER CORP
By: JOHN WYATT
Date: 1/20/2016

SECONDARY NAMEPLATE STAMPING DETAIL

SHELL: MAWP = FV/4.27 BARG @ 200 °C
SHELL: MDMT = -28.9 °C @ FV/4.27 BARG

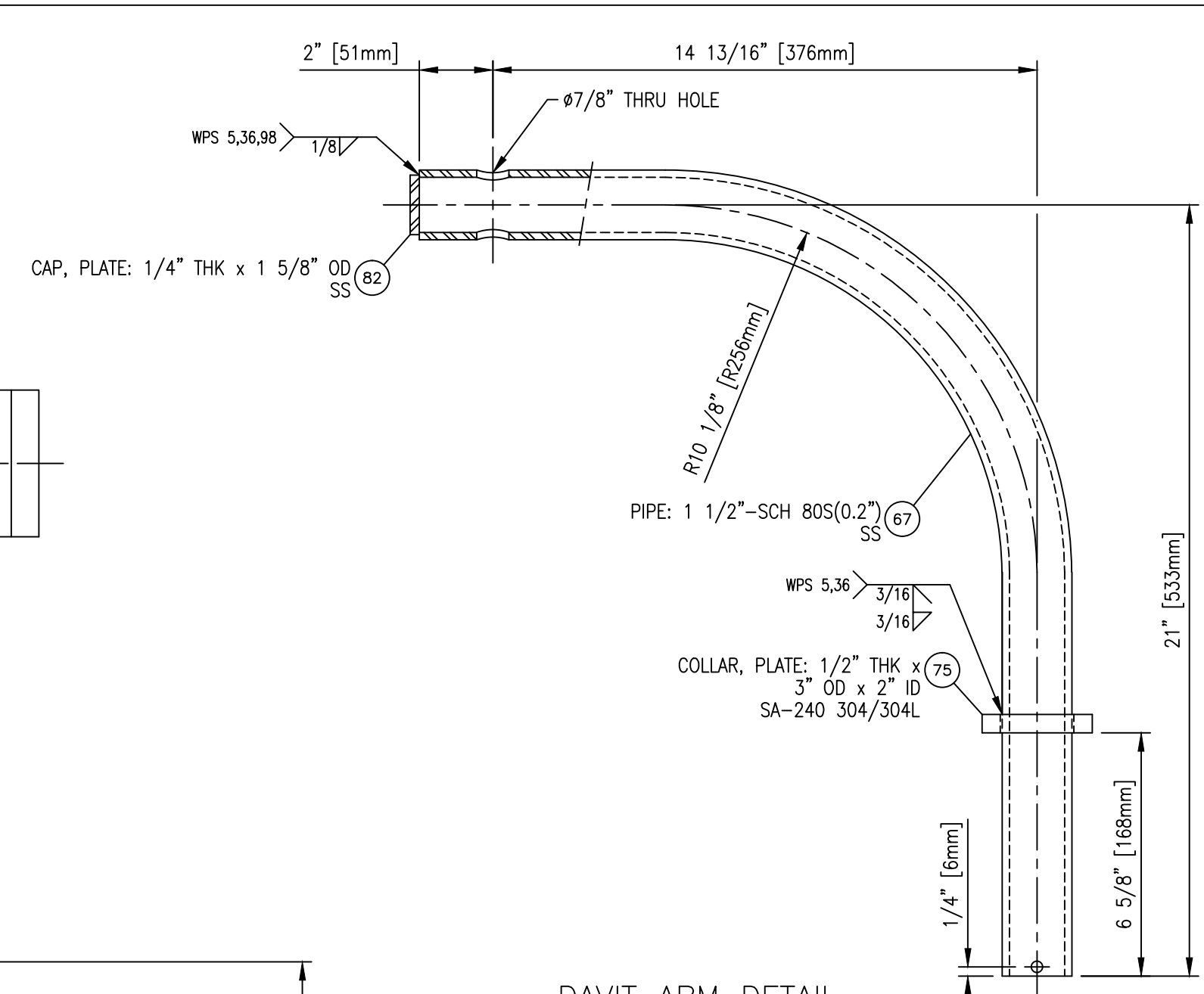
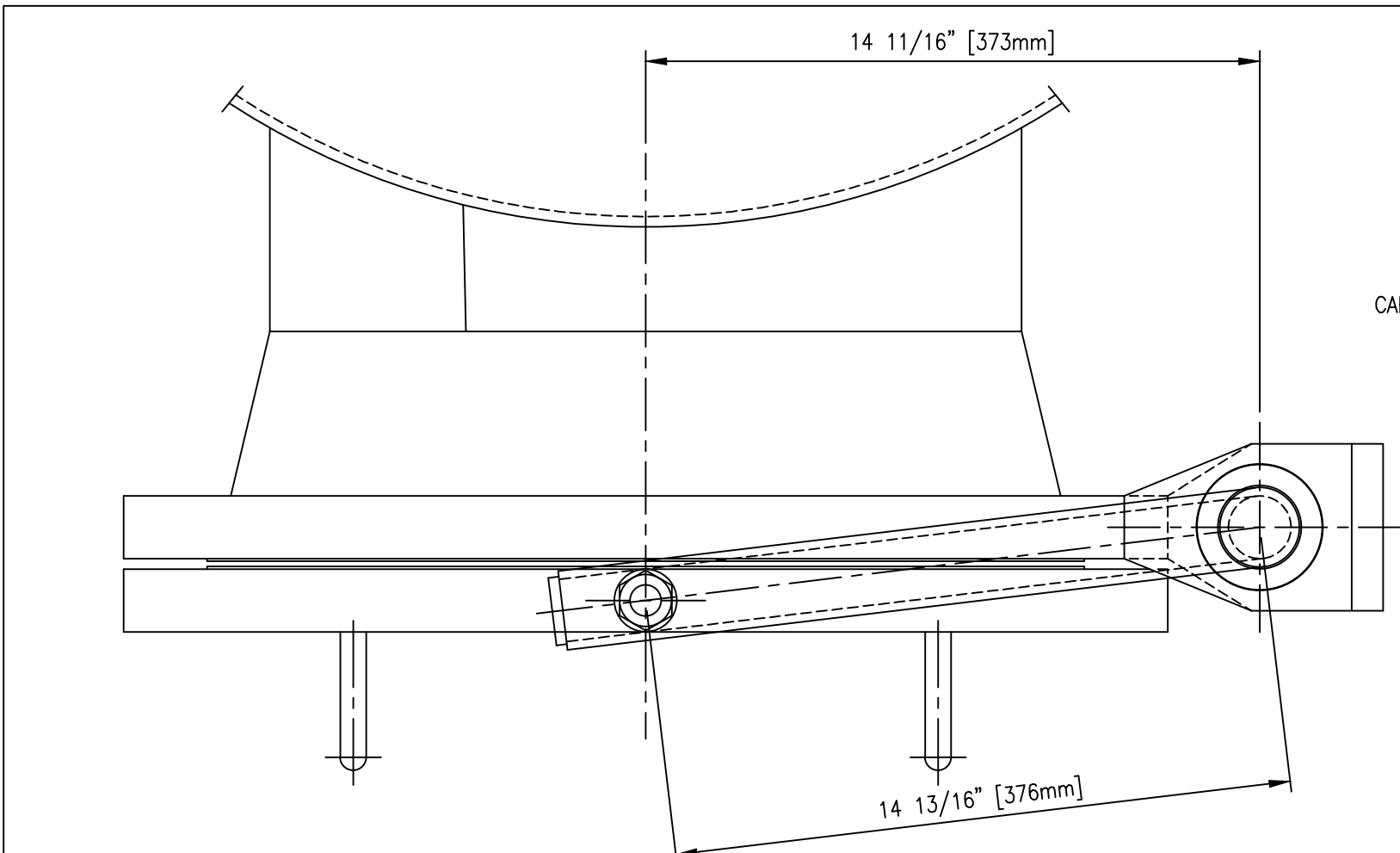
NAMEPLATE STAMPING DETAIL

NAMEPLATE stamping area containing a WARD logo, identification number 5164, and technical specifications for shell and gaskets.

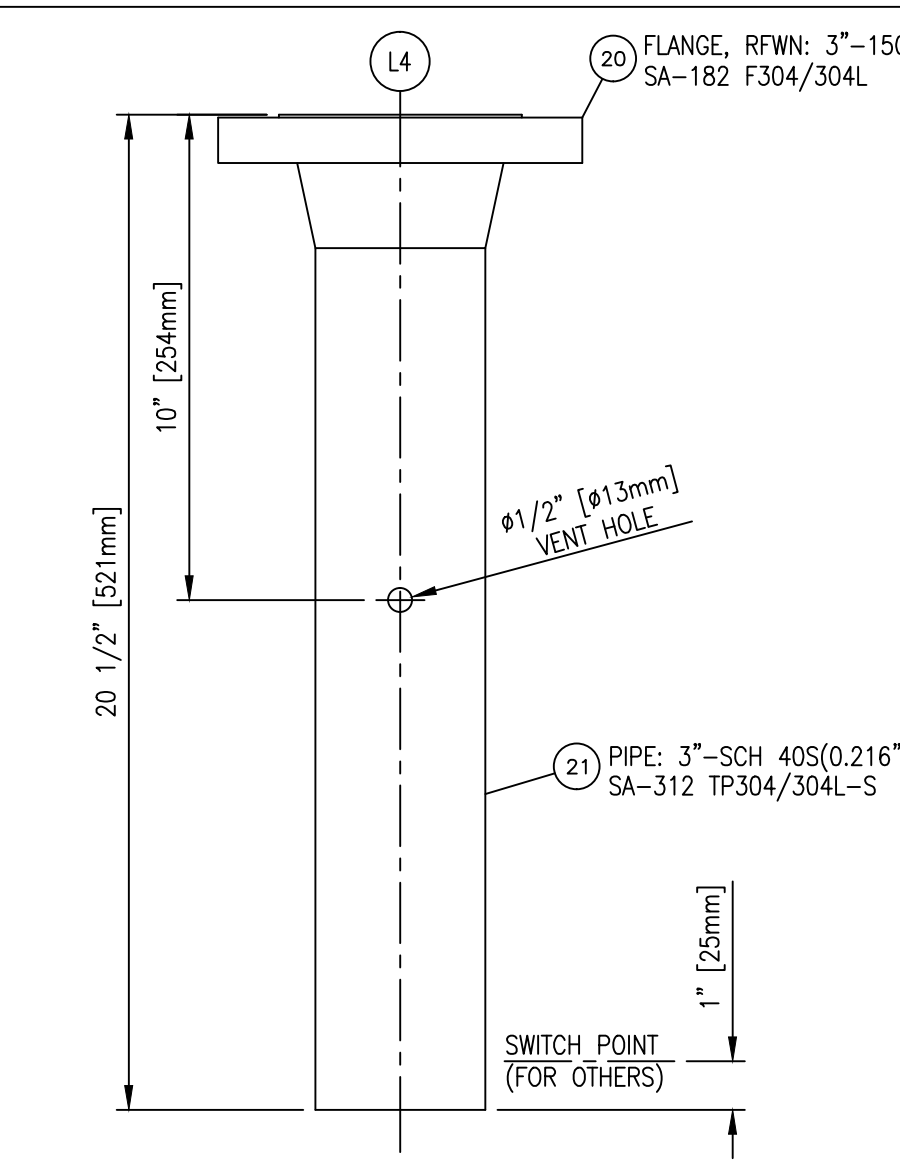


SCHEDULE OF OPENINGS table with columns: MARK, QTY, SIZE, SERIES, TYPE, MAT'L, BORE, SERVICE, ITEM NO., WALL THK, SCH., MAT'L, INT. RAD., THK., WIDTH, MATERIAL, PROJ., NECK, PAD, FLANGE HUB, ATTACHMENT NO., REMARKS, MARK.

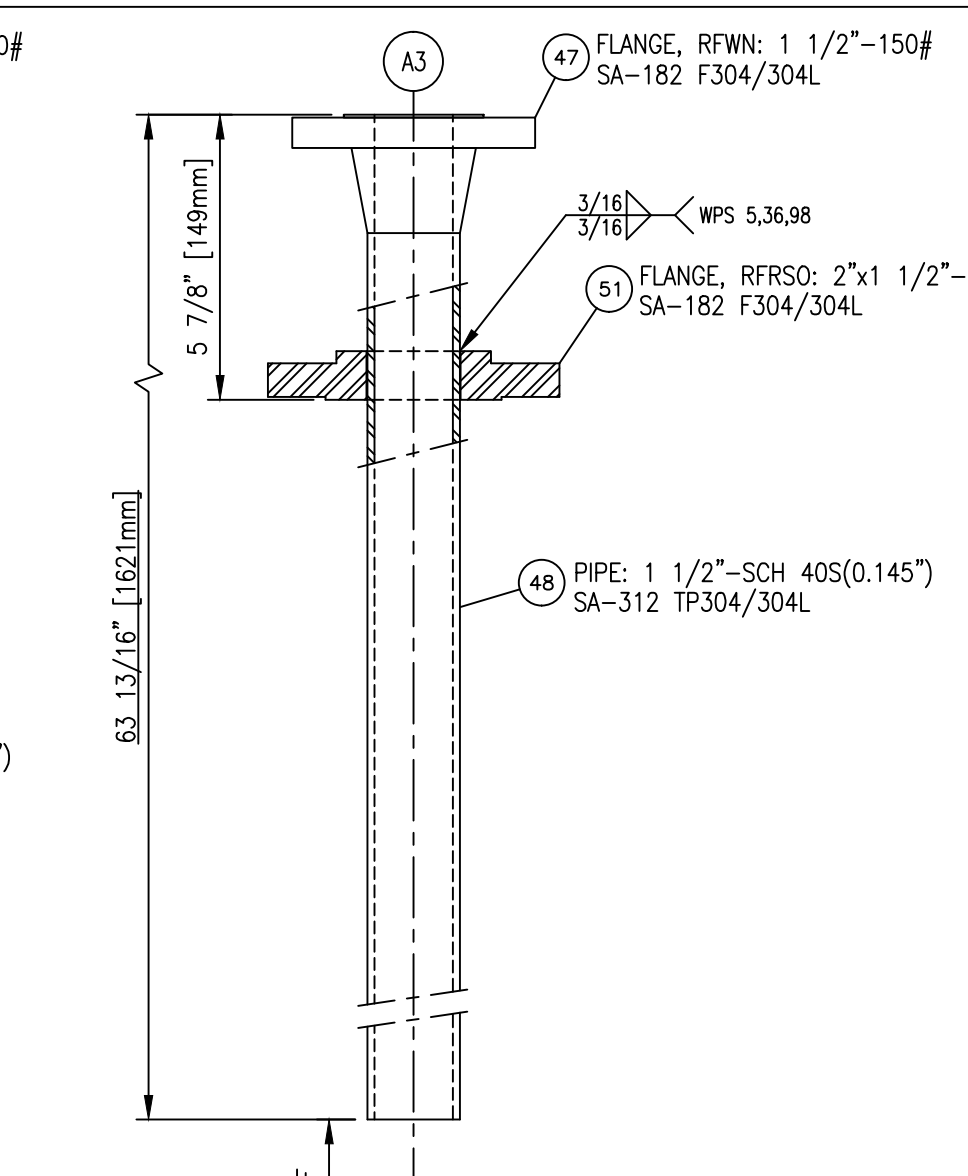
Revision table and project information table. Includes columns for date, description, and by. Project info includes customer name (EVONIK CORP THEODORE, AL), purchase order number (4700898293), and drawing number (2015-WC-9193).



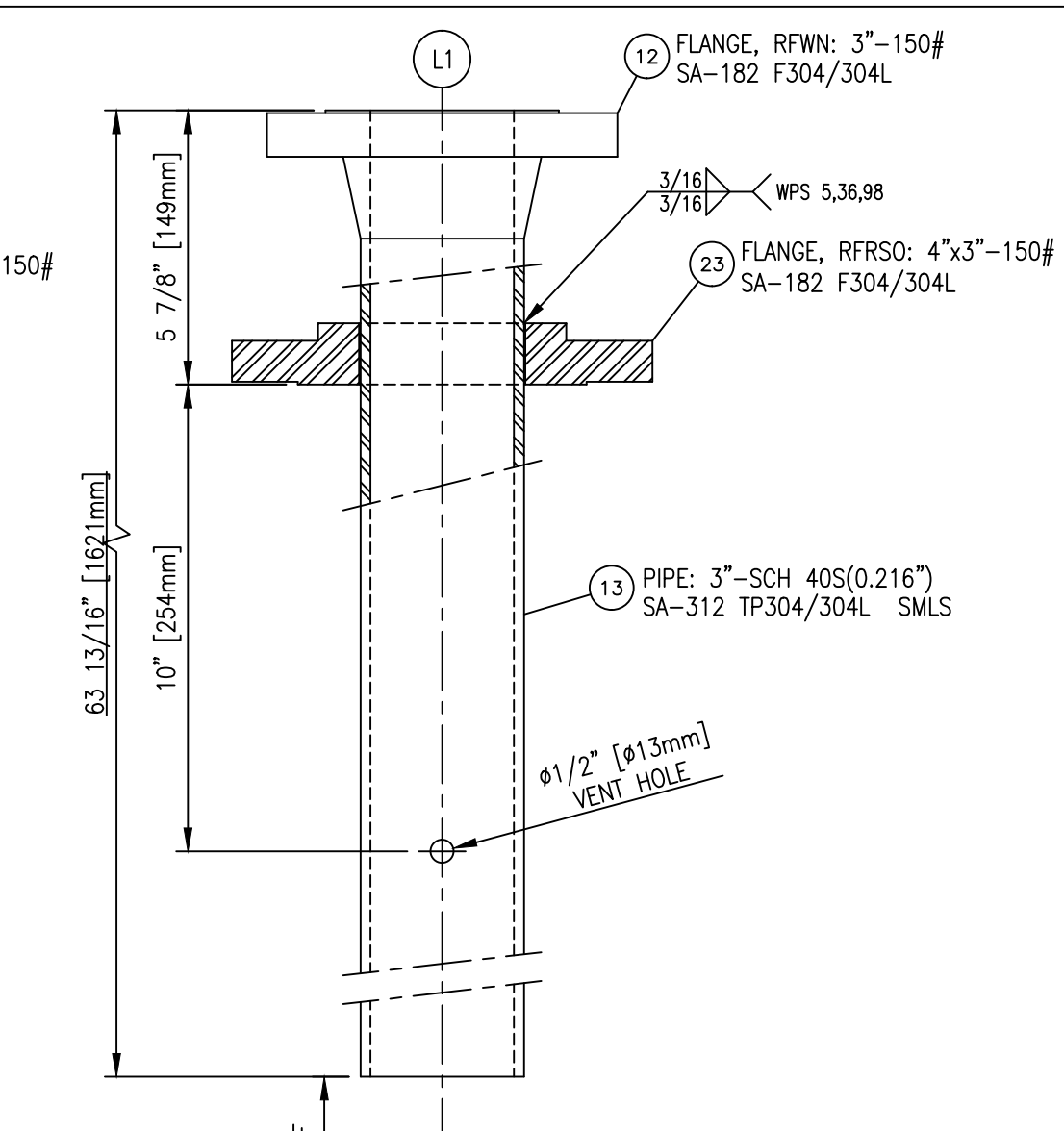
DAVIT ARM DETAIL
SCALE: 3"=12"



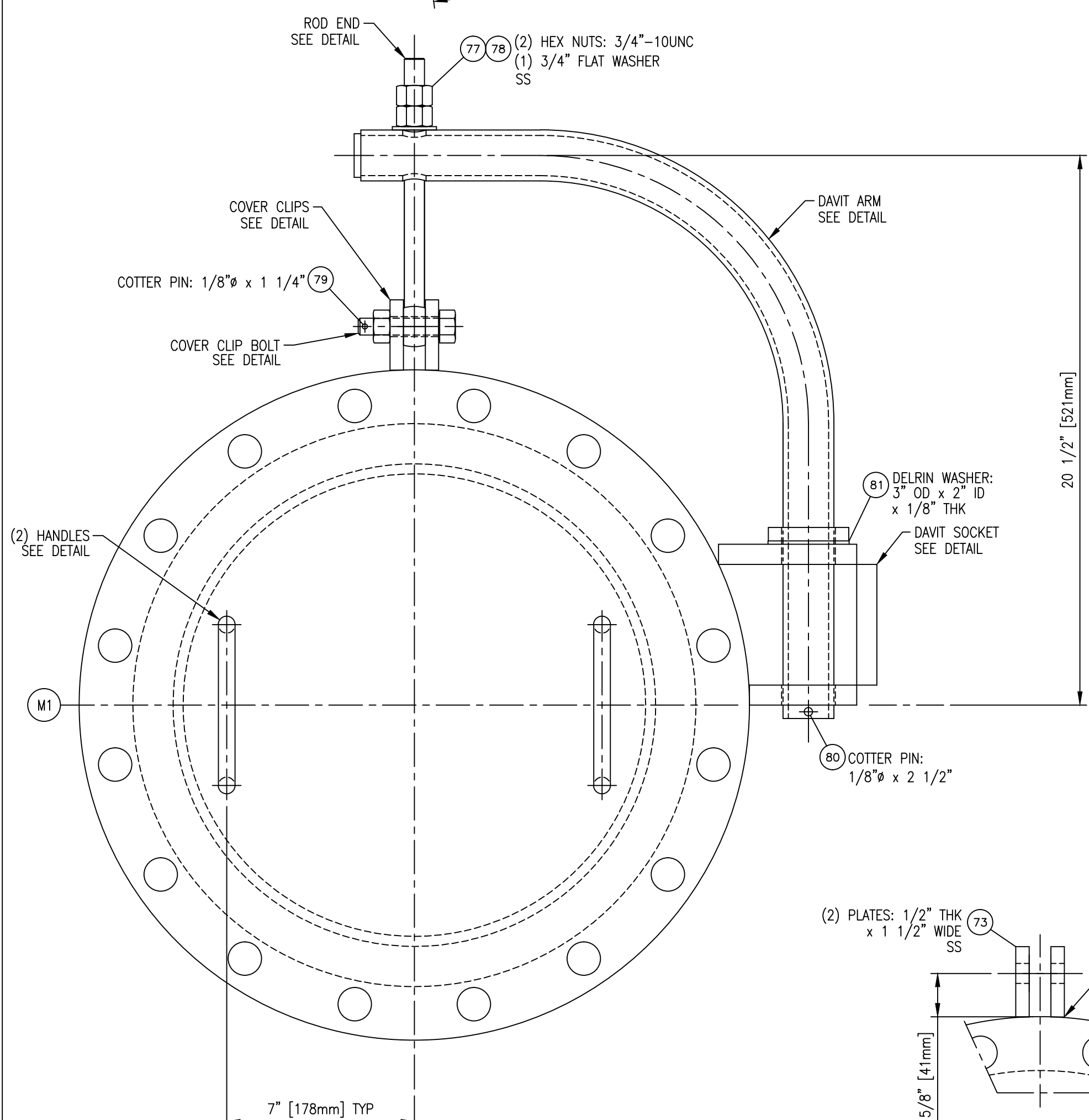
NOZZLE 'L4' DETAIL
SCALE: 3"=12"



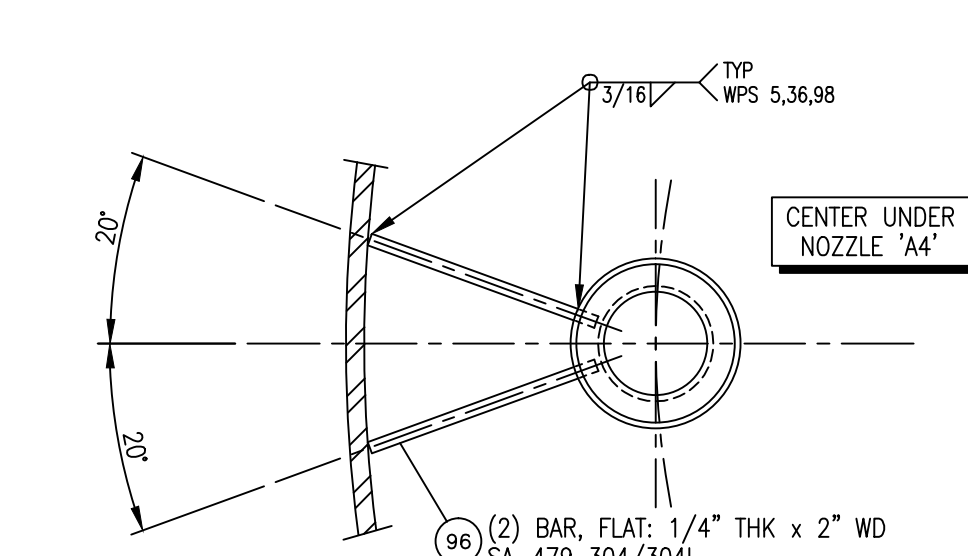
DIP PIPE 'A3' DETAIL
SCALE: 3"=12"



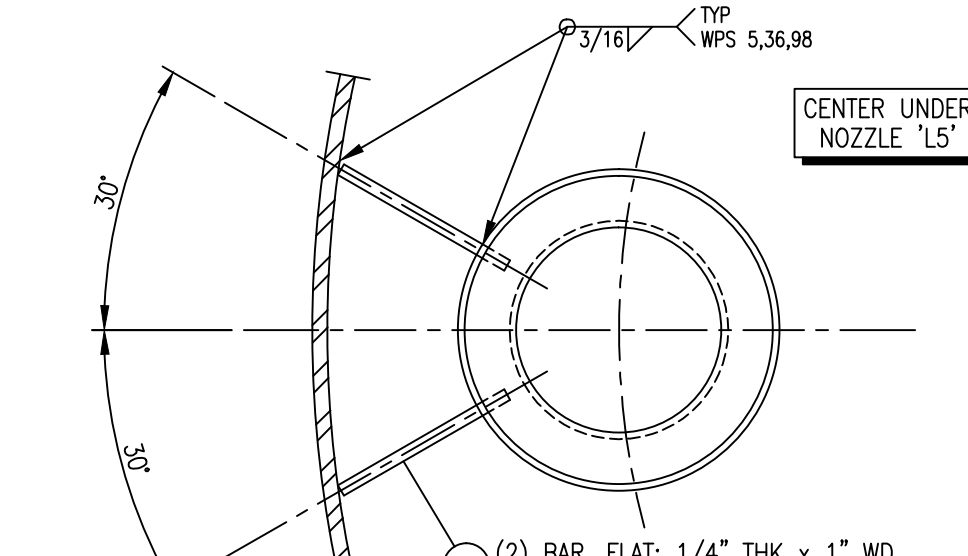
STILLING WELL 'L1' DETAIL
SCALE: 3"=12"



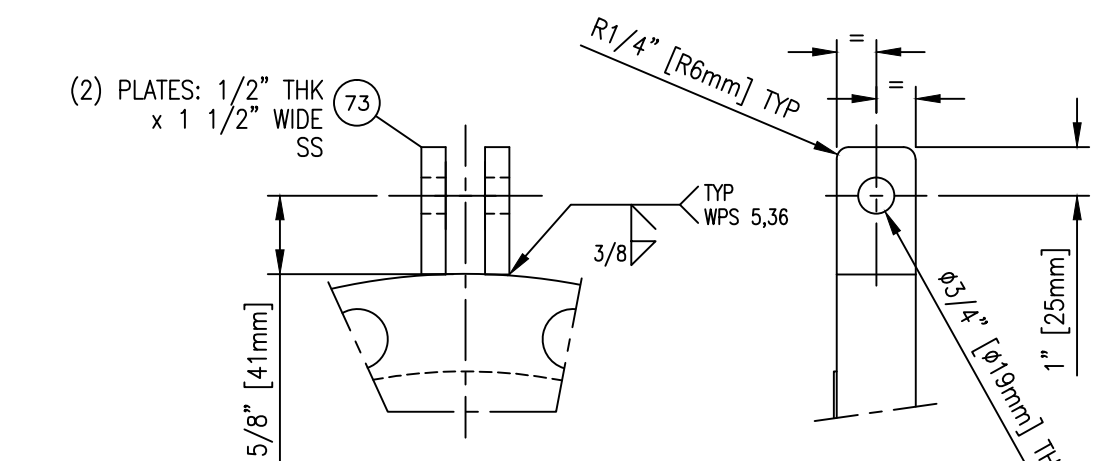
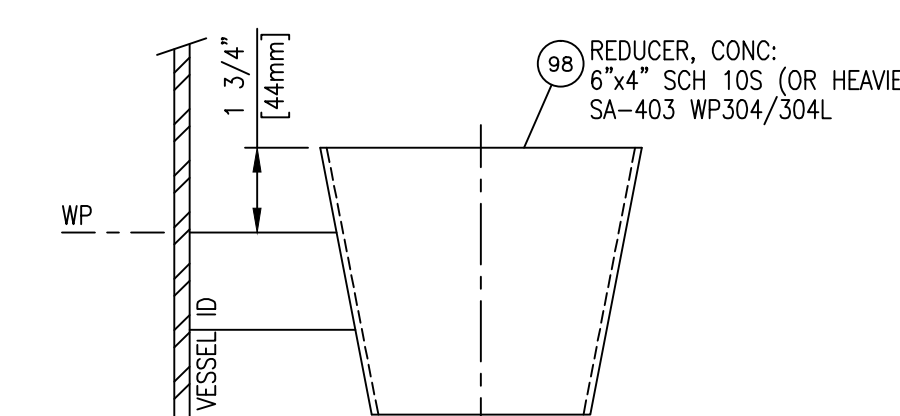
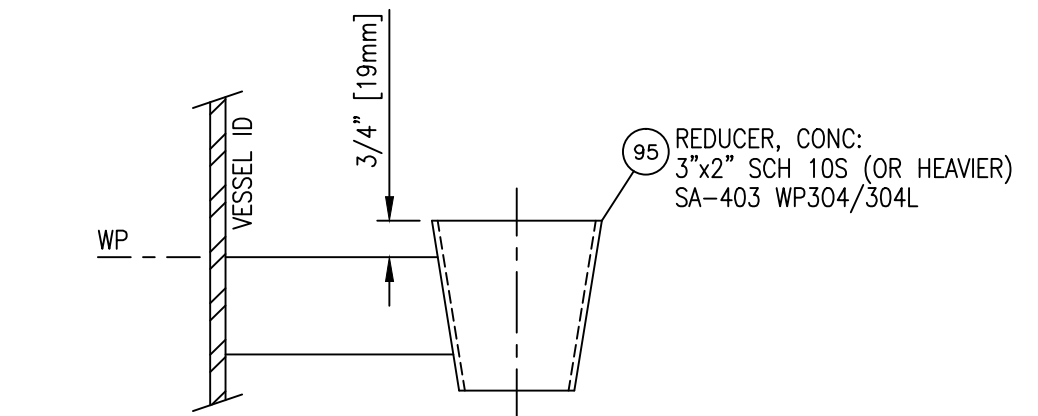
MANWAY DAVIT ASSEMBLY DETAIL
SCALE: 3"=12"



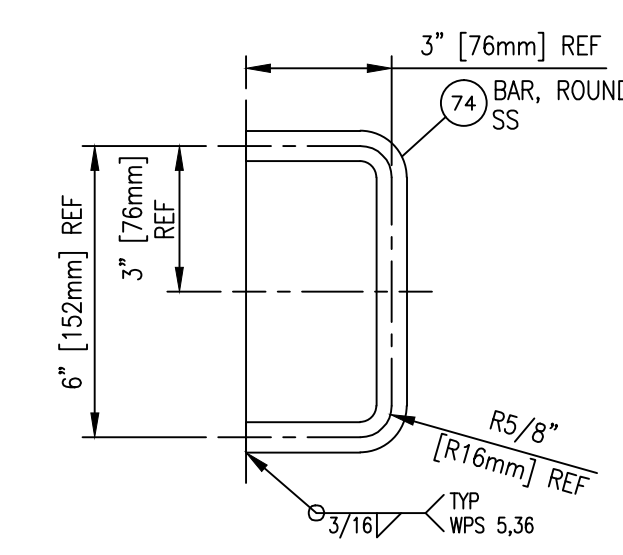
DIP PIPE 'A3' SUPPORT DETAIL
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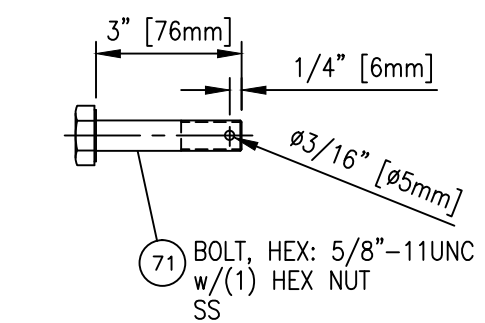
DIP PIPE 'L1' SUPPORT DETAIL
SCALE: 3"=12"



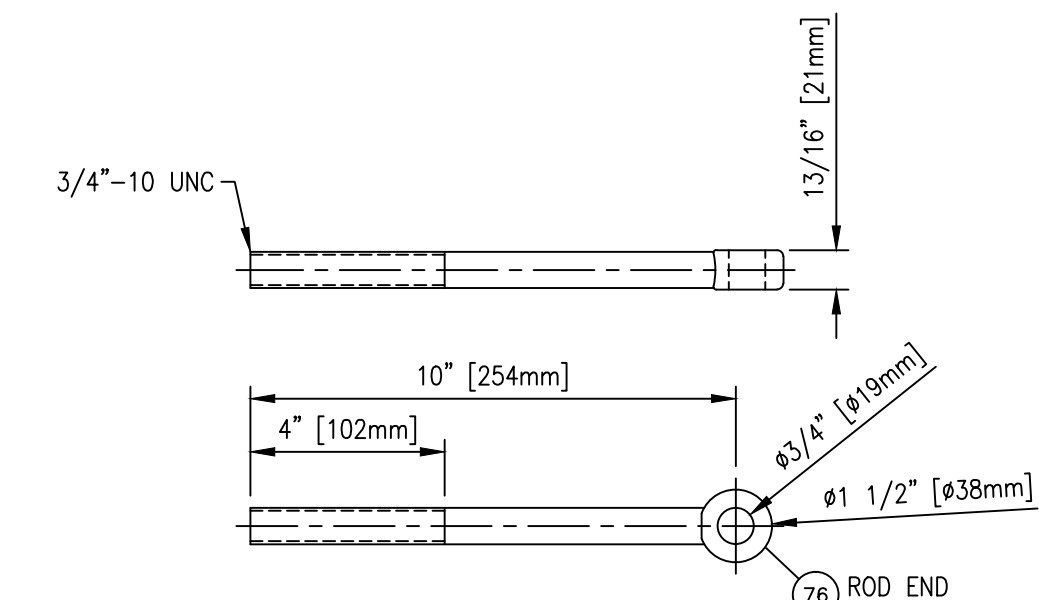
COVER CLIP DETAIL
SCALE: 3"=12"



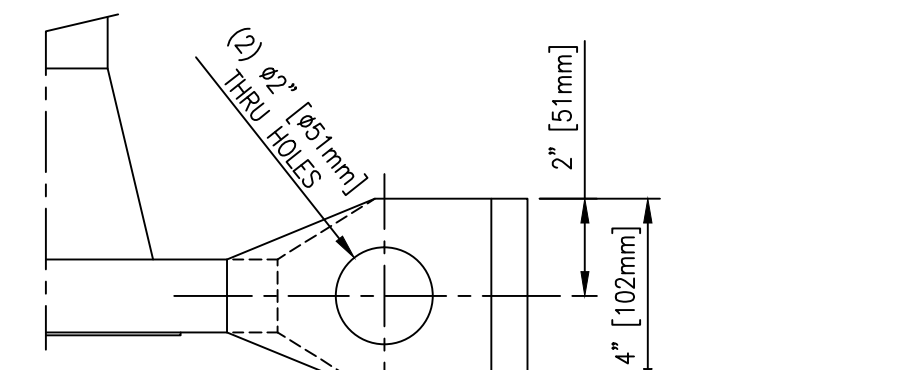
HANDLE DETAIL
TYP (2) PLACES
SCALE: 3"=12"



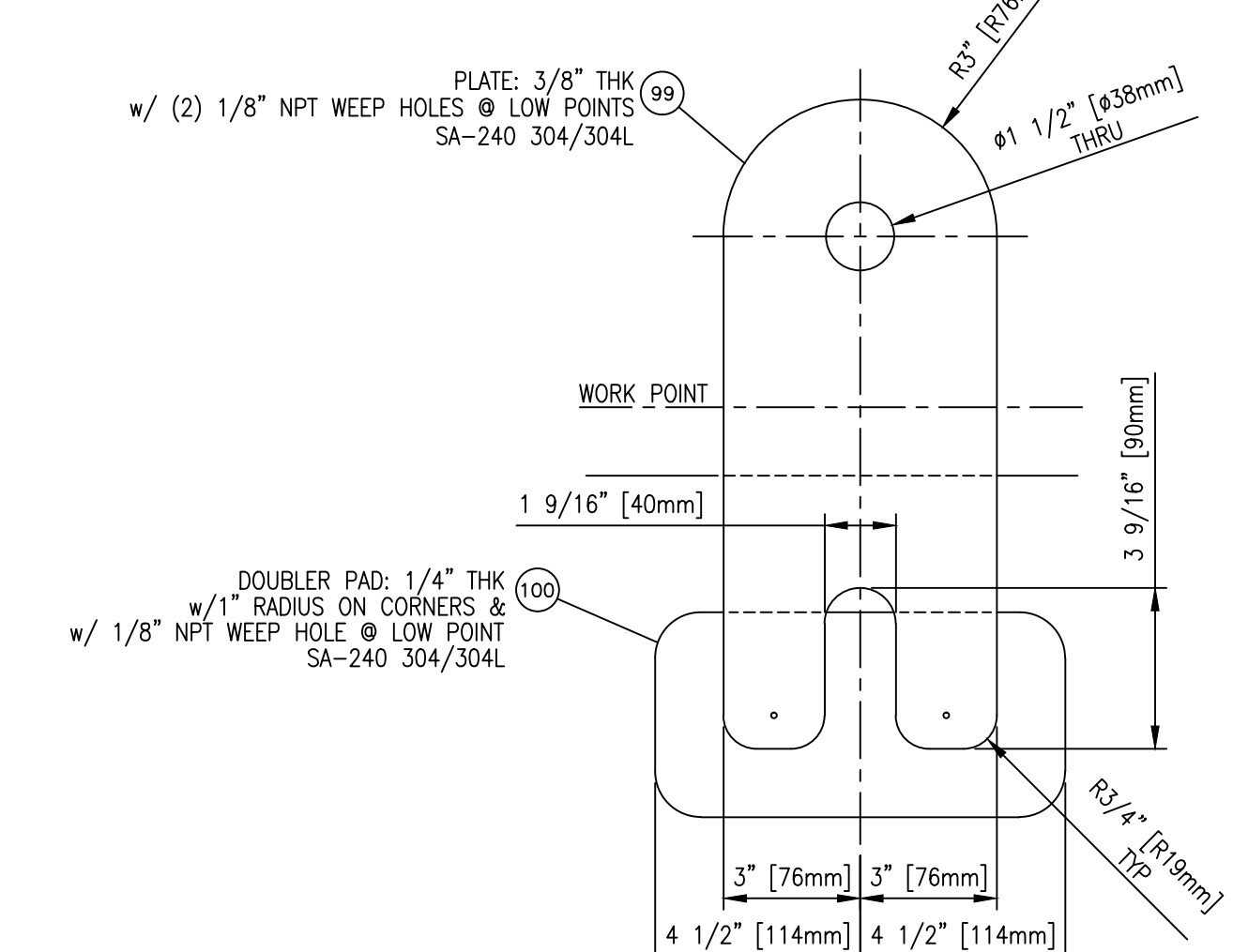
COVER CLIP BOLT DETAIL
SCALE: 3"=12"



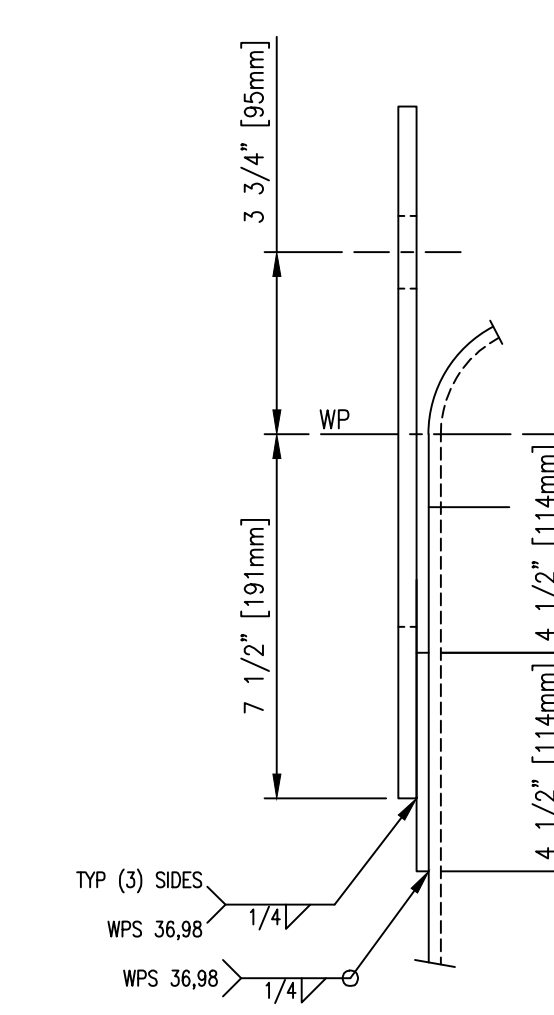
ROD END DETAIL
SCALE: 3"=12"



DAVIT SOCKET DETAIL
SCALE: 3"=12"



LIFT LUG DETAIL
TYP (2) PLACES
SCALE: 3"=12"

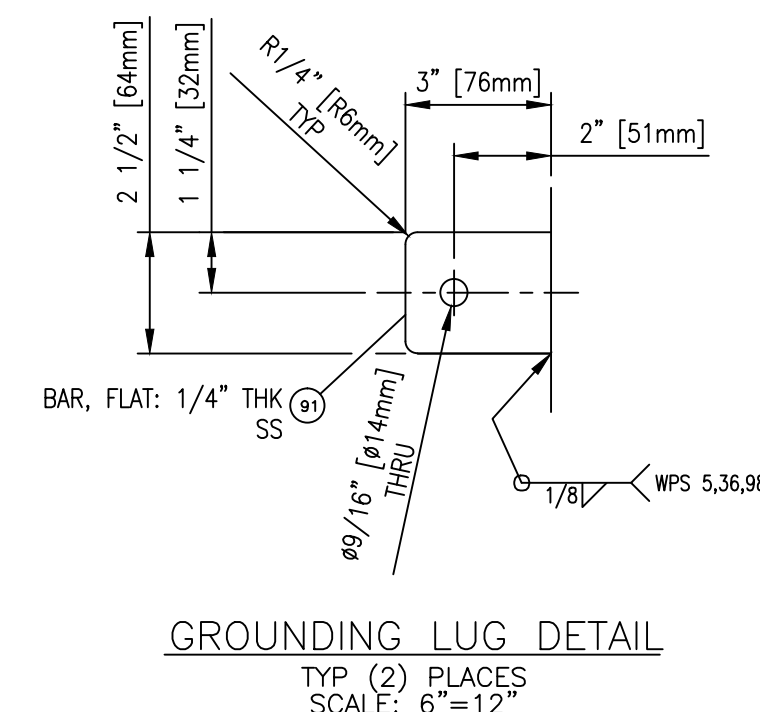
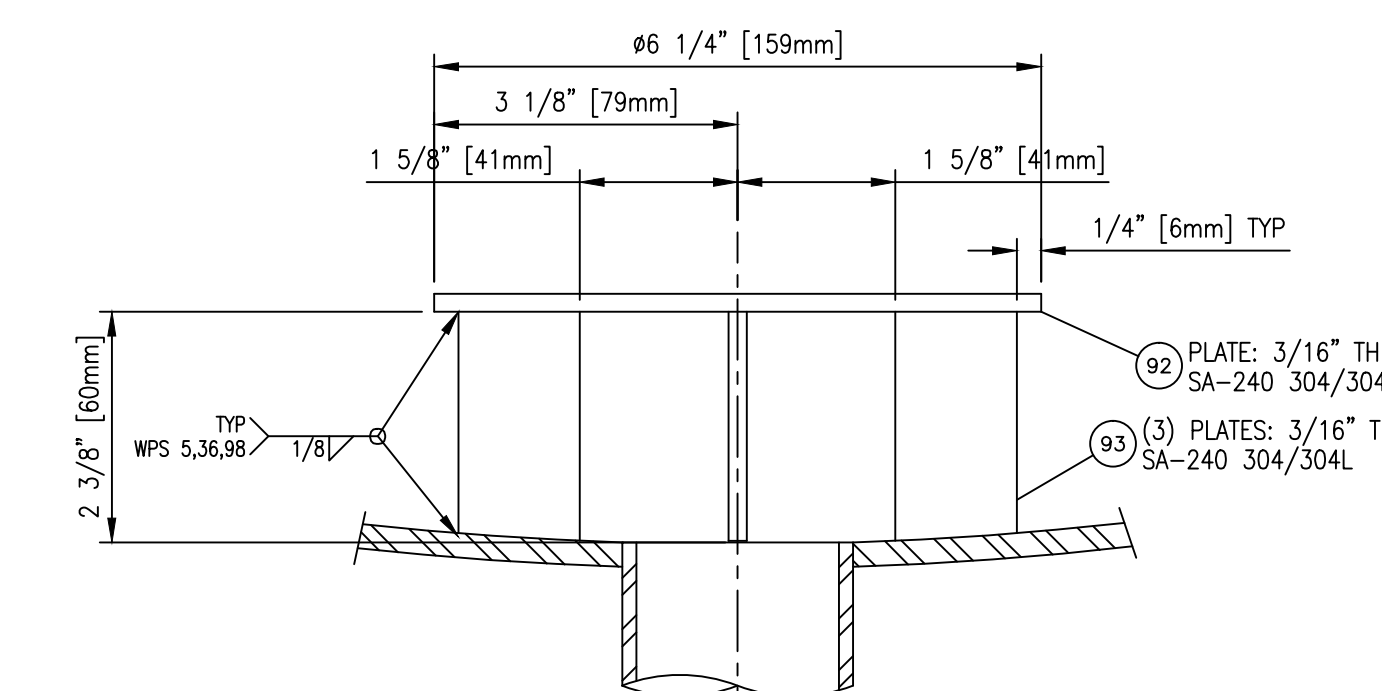
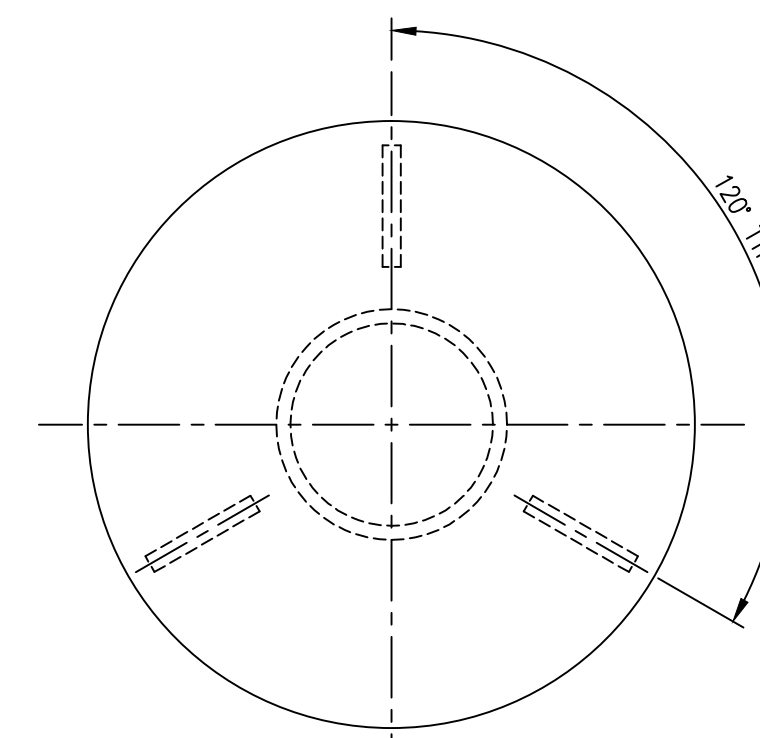
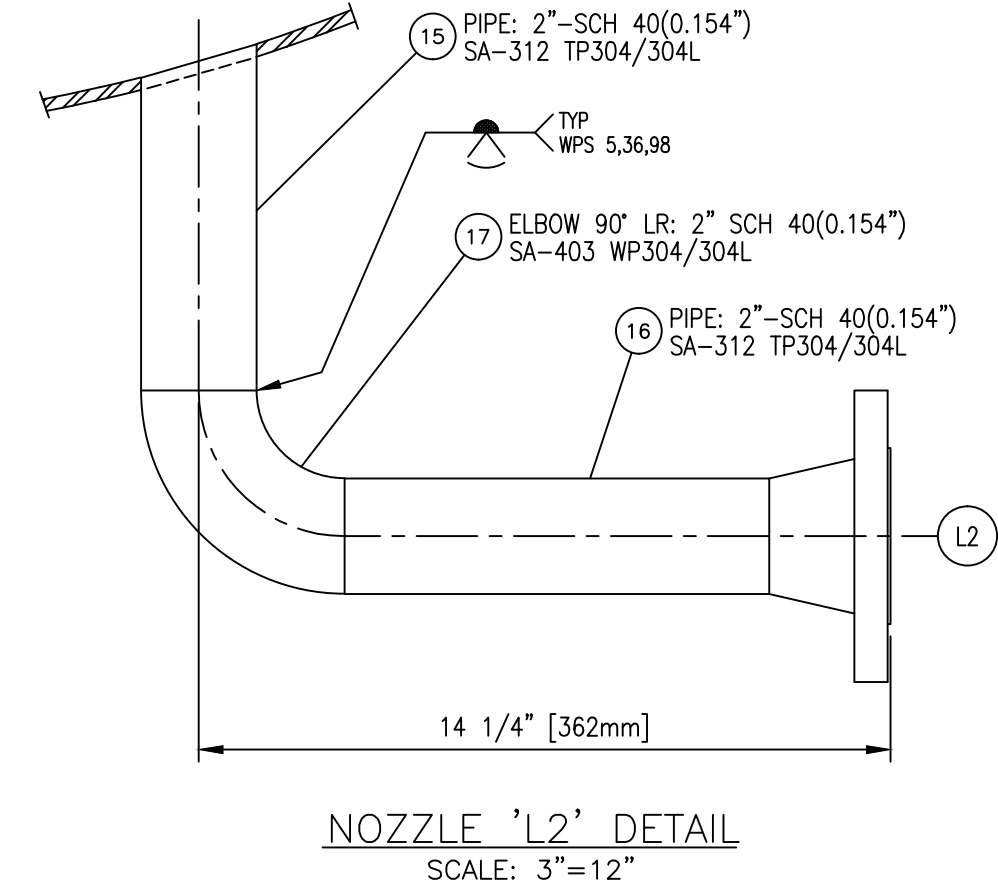
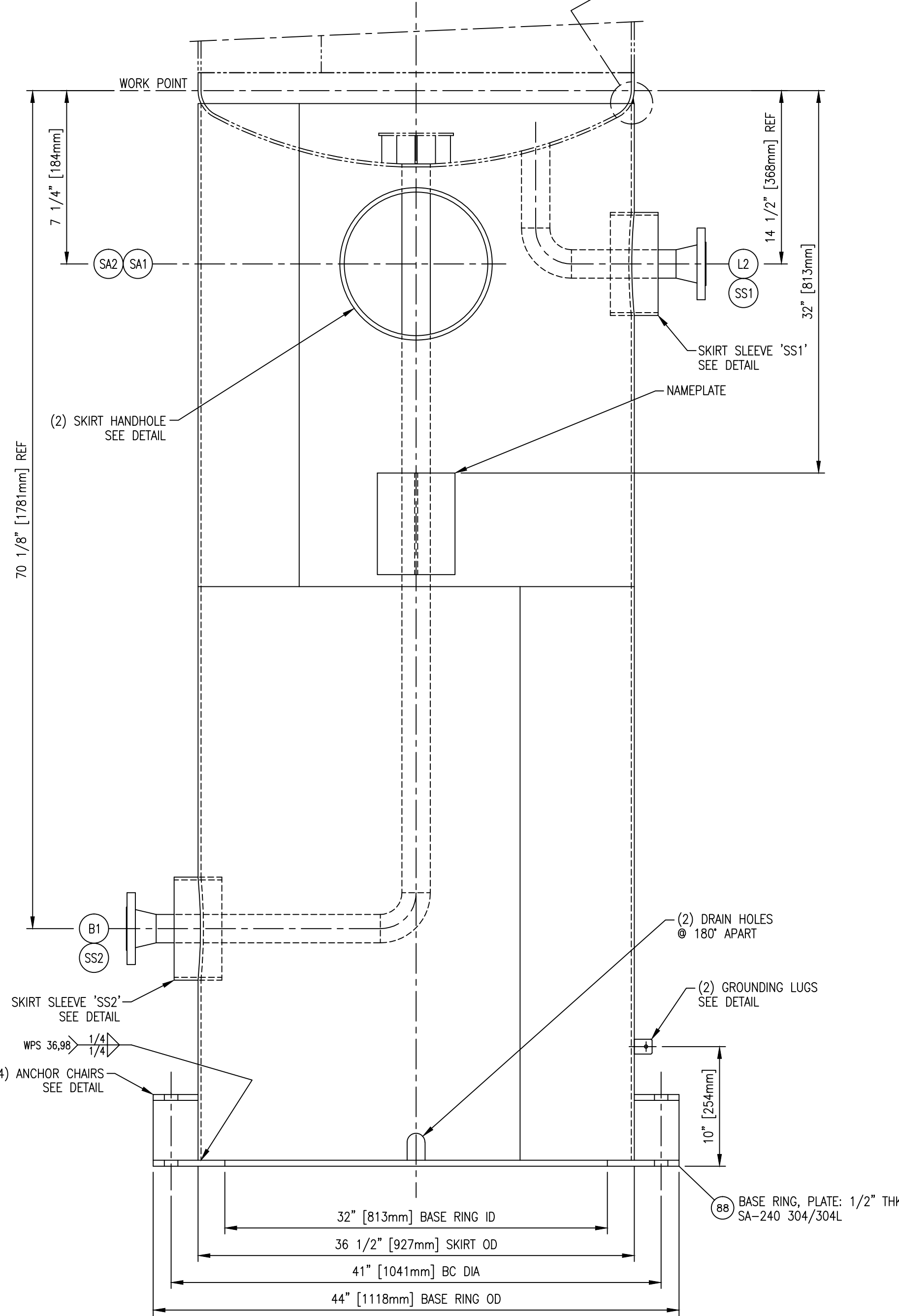
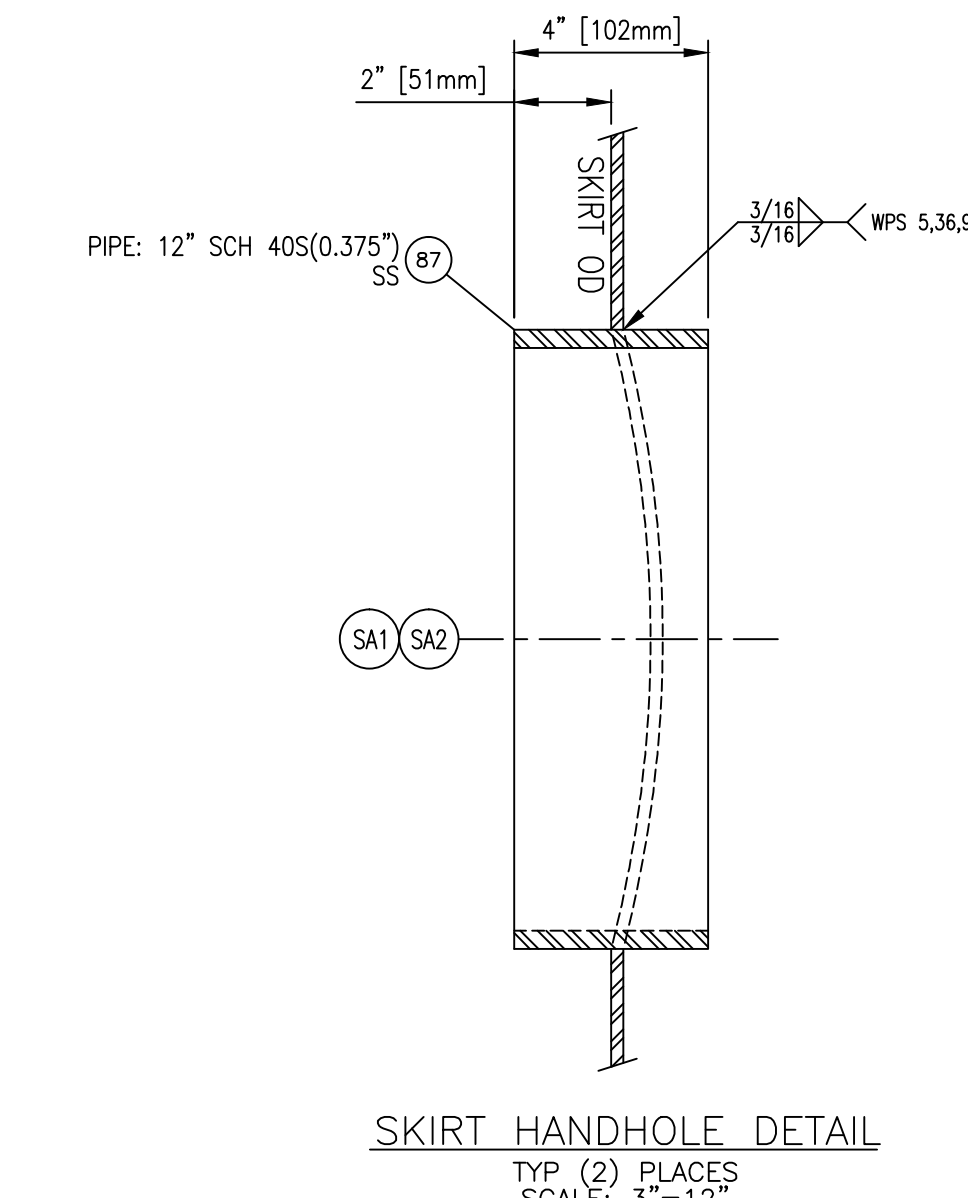
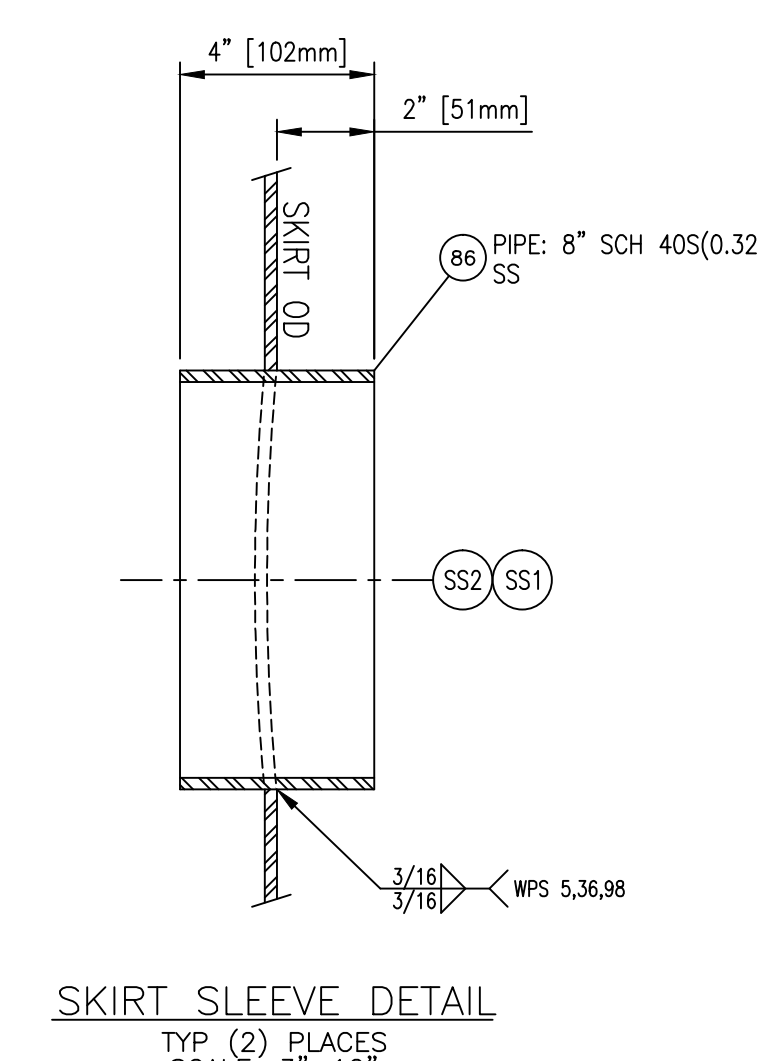
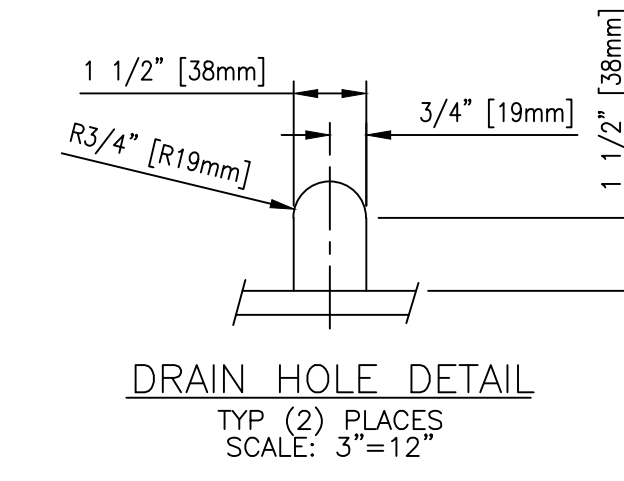
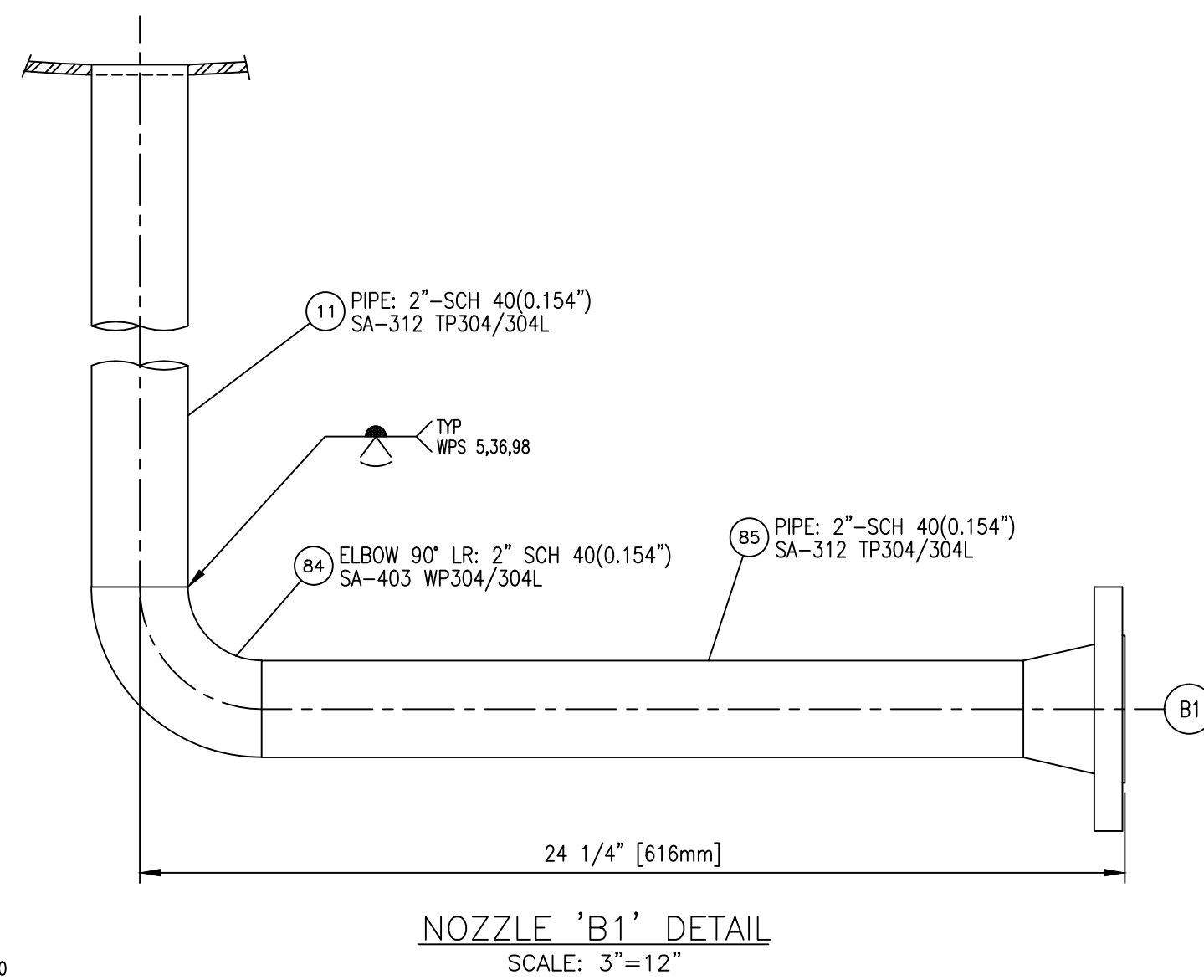
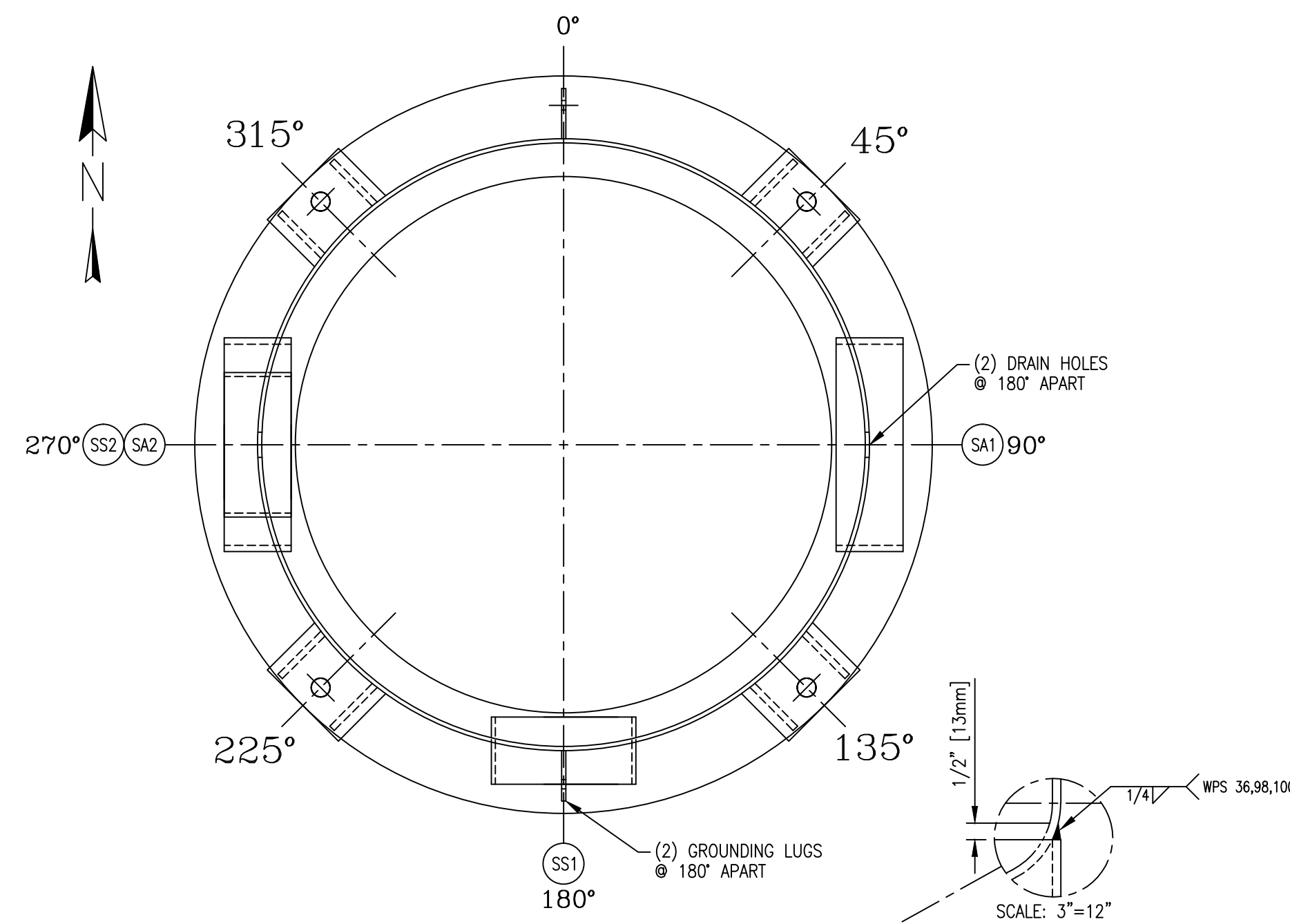


AS-BUILT PRINT
WARD TANK AND HEAT EXCHANGER CORP
By: JOHN WYATT
Date: 1/20/2016

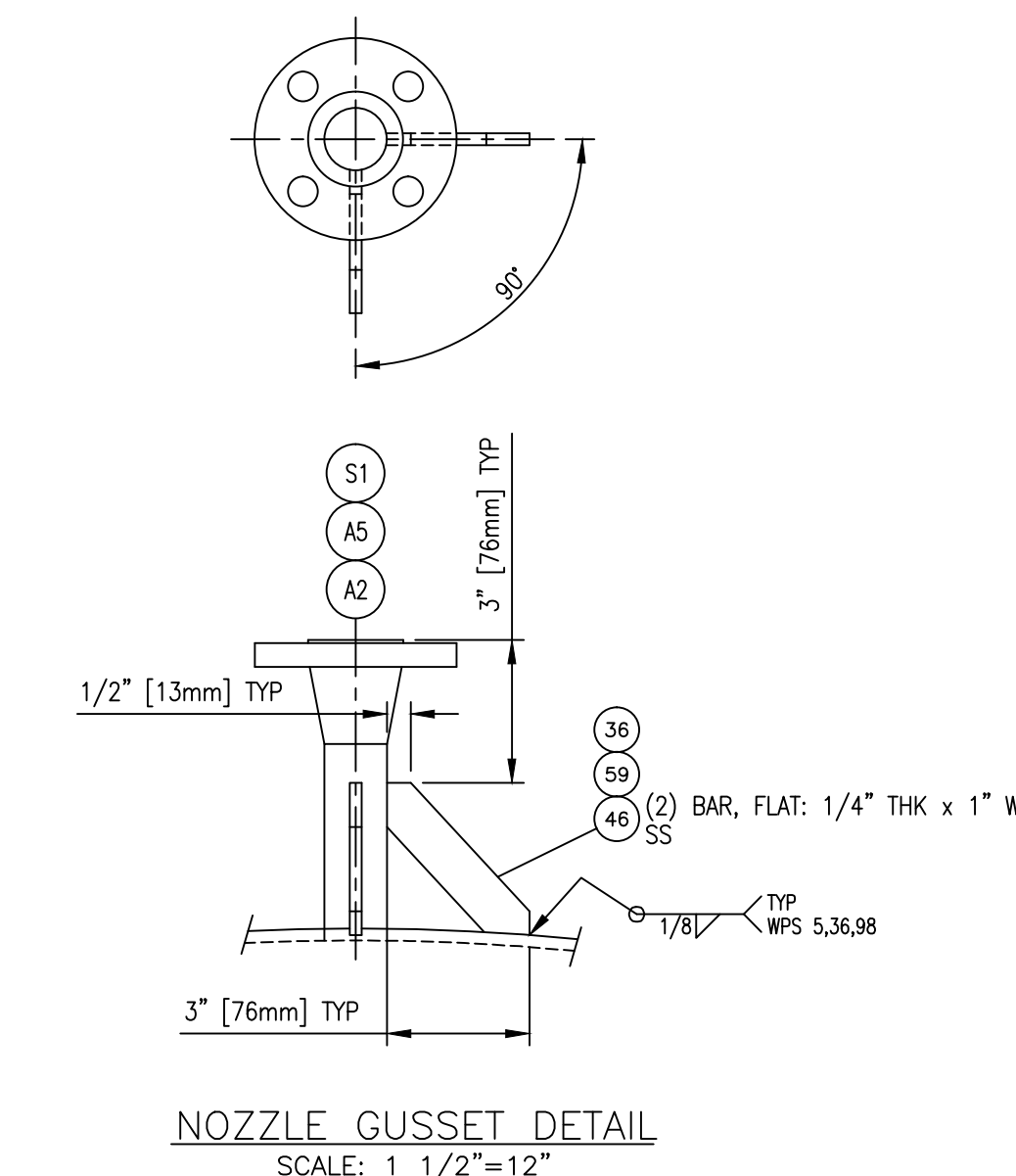
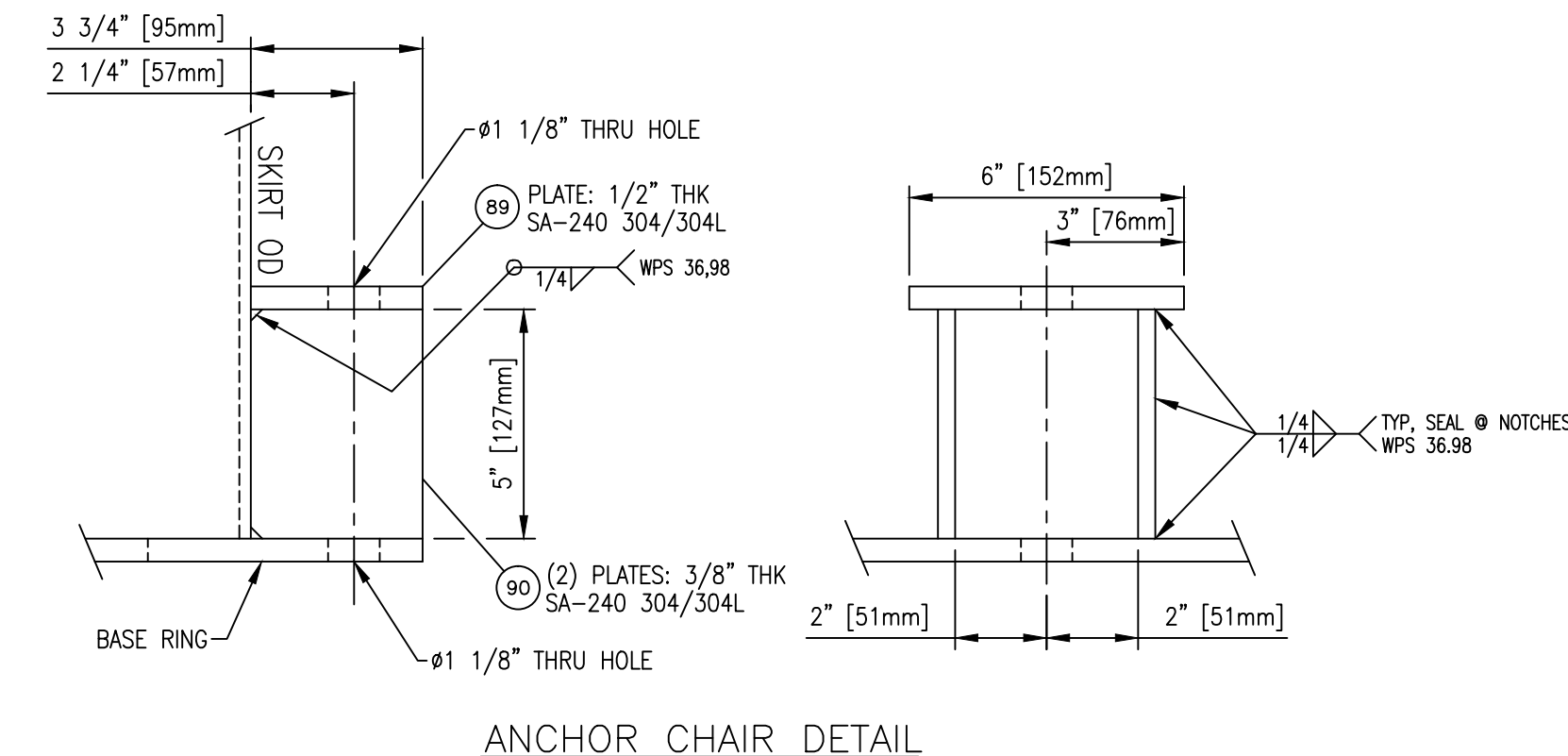
REV NO.	DATE	DESCRIPTION	BY
1/20/2016	AS BUILT		DSG
6	10/20/2015	NO CHANGES THIS PAGE / RE-ISSUE FOR FAB	DSG
5	9/30/2015	REVISED PER CUSTOMER COMMENTS /ISSUE FOR FAB	DSG
4	9/16/2015	REVISED PER CUSTOMER COMMENTS /ISSUE FOR FAB	DSG
3	9/1/2015	REVISED PER CUSTOMER COMMENTS /ISSUE FOR FAB	DSG
2	8/12/2015	REVISED PER CUSTOMER COMMENTS / FOR APPROVAL	DSG
1	5/15/2015	REVISED PER CUSTOMER COMMENTS / FOR APPROVAL	DSG
0	2/25/2015	FOR CUSTOMER APPROVAL	JRW

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		WARD TANK AND HEAT EXCHANGER CORP 6670 E. HARRIS BLVD. CHARLOTTE, NC 28215	
CUSTOMER	EVONIK CORP THEODORE, AL	PURCHASE ORDER NUMBER	4700898293
TITLE 36" ID X 48" CONDENSATE COLLECTION SYSTEM FLASH VESSEL			
EQUIPMENT NO.	V-8721	SCALE	AS NOTED
APPROVED BY	JRW	DATE	9/30/2015
DRAWN BY	DSG	DATE	2/23/2015
DRAWING NUMBER	2015-WC-9193	NO REQ'D	1
		REV. NO.	6
		SHEET 2 OF 3	



AS-BUILT PRINT
 WARD TANK AND
 HEAT EXCHANGER CORP
 By: JOHN NYATT
 Date: 1/20/2016



SKIRT ASSEMBLY
 SCALE: 1 1/2"=12"

ANCHOR CHAIR DETAIL
 TYP (4) PLACES
 SCALE: 3"=12"

NOZZLE GUSSET DETAIL
 SCALE: 1 1/2"=12"

REV NO.	DATE	DESCRIPTION	BY
1/20/2016	AS BUILT		JRW
6	10/21/2015	NO CHANGES THIS PAGE / RE-ISSUE FOR FAB.	DSG
5	9/30/2015	REVISED PER CUSTOMER COMMENTS /ISSUE FOR FAB.	DSG
4	9/16/2015	REVISED PER CUSTOMER COMMENTS /ISSUE FOR FAB.	DSG
3	9/1/2015	REVISED PER CUSTOMER COMMENTS /ISSUE FOR FAB.	DSG
2	8/12/2015	REVISED PER CUSTOMER COMMENTS / FOR APPROVAL	DSG
1	5/15/2015	REVISED PER CUSTOMER COMMENTS / FOR APPROVAL	DSG
0	2/25/2015	FOR CUSTOMER APPROVAL	JRW

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CUSTOMER	EVONIK CORP THEODORE, AL	PURCHASE ORDER NUMBER	4700898293
TITLE	36" ID X 48" CONDENSATE COLLECTION SYSTEM FLASH VESSEL		
EQUIPMENT NO.	V-8721	SCALE	AS NOTED
APPROVED BY	JRW	DATE	9/30/2015
DRAWN BY	DSG	DATE	2/23/2015
DRAWING NUMBER	2015-WC-9193		NO REQ'D 1
			REV. NO. 6
			SHEET 3 OF 3