

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

114219

1. Manufactured and certified by ALLOY FAB, INC., 200 RYAN STREET, SOUTH PLAINFIELD, NJ 07080  
(Name and address of manufacturer)
2. Manufactured for AMERICAN HOECHST CORPORATION, COVENTRY, RHODE ISLAND  
(Name and address of purchaser)
3. Location of installation AMERICAN HOECHST CORPORATION, COVENTRY, RHODE ISLAND  
(Name and address)
4. Type VERT. TANK 2887 -- D-1707 1755 1986  
(Mount. or con., tank) (Mfg.'s serial No.) (CRN) (Drawing) (Mat'l. Bd. No.) (Date)
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 1983  
Year

WINTER 1985

Addenda (date)

Code Case No.

Special service per UC-120(d)

Items 6-11 incl. to be completed for single wall vessels, jackets of jacketed vessels, or sheets of heat exchangers

6. Shell: SA-240-316L 325 -- -- --  
HALF PIPE (Mat'l. Spec. No., Grade) (Nom. Thk. (in.)) (Corr. Allow. (in.)) (Diam. I.D. (ft & in.)) (Length (ft & in.))

7. Seams: FILLET -- -- -- --  
(Long. (Dbl., Sngl.)) (R.T. (Spot or Full)) (Eff. (ft)) (R.T. (ft))  
-- FILLET -- -- --  
(Time) (Cath. (Dbl., Sngl.)) (R.T. (Spot, Partial, or Full)) (18) TURNS  
(No. of Turns)

8. Heads: (a) Mat'l. SA-312-316L (Spec. No., Grade) (b) Mat'l. -- (Spec. No., Grade)

	Location (Top, Bottom, Ends)	Minimum Thickness	Corrosion Allowance	Crown Radius	Knuckle Radius	Elliptical Ratio	Coneical Apex Angle	Hemispherical Radius	Flat Diameter	Side (Concave or Convex)
(a)	BOTTOM	.120"	--	1.75"	--	--	--	--	--	CONCAVE
(b)										

If removable, bolts used (describe other fastenings) WELDED TO HEAD

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

9. Type of Jacket 3" HALF PIPE COIL (5) TURNS @ 4" Proof Test UG-101 (a)

10. Jacket Closure END PLATE 3/16" TK. If bar, give dimensions -- If bolted, describe bolts --  
(Describe as ogee & weld, bar, etc.)

11. MAWP 90 psi at max. temp. 390 °F. Min. temp. (when less than -20° F) --  
Hydro., pneum., or comb. test press. 137 psi.

Items 12 and 13 to be completed for tube sections

12. Tubesheets: -- -- -- -- --  
Stationary Mat'l. (Spec. No., Gr.) (Diam. (in.) (Subject to pressure)) (Nom. Thk. (in.)) (Corr. Allow. (in.)) (Attached to Vessel or Not)  
-- -- -- -- --  
Floating Mat'l. (Spec. No., Gr.) (Diam. (in.)) (Nom. Thk. (in.)) (Corr. Allow. (in.)) (Attached to Vessel or Not)

13. Tubes: -- -- -- -- --  
Mat'l. (Spec. No., Gr.) (O.D. (in.)) (Nom. Thk. (in. or Gauge)) (Number) (Type (Spiral, etc.))

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

14. Shell: SA-240-316L 325 -- 6'-0" O.D. 8'-7"  
(Mat'l. Spec. No., Grade) (Nom. Thk. (in.)) (Corr. Allow. (in.)) (Diam. I.D. (ft & in.)) (Length (ft & in.))

15. Seams: WELDED DBL. BUTT SPOT 85 1  
(Long. (Dbl., Sngl.)) (R.T. (Spot or Full)) (Eff. (ft)) (R.T. (ft))  
-- WELDED DBL. BUTT PARTIAL 1  
(Time) (Cath. (Dbl., Sngl.)) (R.T. (Spot, Partial, or Full)) (No. of Turns)

16. Heads: (a) Mat'l. SA-240-316L (Spec. No., Grade) (b) Mat'l. -- (Spec. No., Grade)

	Location (Top, Bottom, Ends)	Minimum Thickness	Corrosion Allowance	Crown Radius	Knuckle Radius	Elliptical Ratio	Coneical Apex Angle	Hemispherical Radius	Flat Diameter	Side (Concave or Convex)
(a)	TOP &	.375	--	6.6"	4.75	--	--	--	--	CONCAVE
(b)	BOTTOM	--	--	--	--	--	--	--	--	CONVEX

If removable, bolts used (describe other fastenings) --

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

17. MAWP E.V./90 psi at max. temp. 390 °F. Min. temp. (when less than -20° F) --  
Hydro., pneum., or comb. test press. 137 psi.



FORM R-1, REPORT OF WELDED ☐ REPAIR OR ☐ ALTERATION  
as required by the provisions of the National Board Inspection Code

1. Work performed by M & M Welding & Fabricating Co., Inc. 92-211  
(name of repair or alteration organization) (P.O. no., job no., etc.)  
Route 117 Coventry, RI 02816  
(address)
2. Owner Hoechst Celanese Corporation  
(name)  
500 Washington Street Coventry, RI 02816  
(address)
3. Location of installation SAME  
(name)  
(address)
4. Unit identification: Vessel Name of original manufacturer Alloy Fab, Inc.  
(boiler, pressure vessel)
5. Identifying nos.: 2887 1755 1986  
(mfr's. serial no.) (original National Board no.) (jurisdiction no.) (other) (year built)
6. Description of work: Weld Seam Repair  
(use back, separate sheet, or sketch if necessary)  
Vessel inspection by owner discovered corrosion of  
weld seam (I.D.) longitudinal seam. Ground seam  
7' in length. Liquid penetrant performed on weld  
prep. weld repaired seam using 309L-16 1/8 Dia.  
electrode & ground flush to original contour.  
liquid penetrant performed on final weld.  
Pressure test, if applied 90 psi

7. Replacement Parts. Attached are Manufacturers' Partial Data Reports properly identified and signed by Authorized Inspectors for the following items of this report:

- (name of part, item number, mfr's. name and identifying stamp)
8. Remarks: NDE (liquid penetrant) performed by Thielsch Eng.  
see attached reports.  
Pressure test applied @ working pressure  
Due to external piping/seal limitations  
with owner concurrence  
Used M & M WPS #2 & welder "p" Victor Pereira  
for weld repair.

Pharma #34  
STIL 2608  
(copy to Shari 9/22/93)

#### DESIGN CERTIFICATION

The undersigned certifies that the statements made in this report are correct and that the design changes described in this report conform to the requirements of the National Board Inspection Code.

ASME Certificate of Authorization no. 11,879 to use the U symbol expires 4/30, 19 94.

Date 6-10, 19 92 M & M Welding & Fabricating Co., Inc. Signed William J. Smith  
(name of organization) (authorized representative)

#### CERTIFICATE OF REVIEW OF DESIGN CHANGE

The undersigned, holding a valid Commission issued by The National Board of Boiler and Pressure Vessel Inspectors and certificate of competency issued by the state or province of \_\_\_\_\_ and employed by \_\_\_\_\_ of \_\_\_\_\_ has examined the design change as described in this report and verifies that to the best of his knowledge and belief such change complies with the applicable requirements of the National Board Inspection Code. By signing this certificate, neither the undersigned nor his employer makes any warranty, expressed or implied, concerning the work described in this report. Furthermore, neither the undersigned nor my employer shall be liable in any manner for any personal injury, property damage or loss of any kind arising from or connected with this inspection, except such liability as may be provided in a policy of insurance which the undersigned's insurance company may issue upon said object and then only in accordance with the terms of said policy.

Date \_\_\_\_\_, 19 \_\_\_\_\_ Signed \_\_\_\_\_ Commissions \_\_\_\_\_  
(Authorized Inspector) (National Board (incl. endorsements), state, prov., and no.)

#### CONSTRUCTION CERTIFICATION

The undersigned certifies that the statements made in this report are correct and that all construction and workmanship on this Repair conform to the National Board Inspection Code.  
(repair or alteration)

Certificate of Authorization no. 269 to use the R symbol expires 4/30, 19 94.

Date 6-10, 19 92 M & M Welding & Fabricating Co., Inc. Signed William J. Smith  
(repair or alteration organization) (authorized representative)

#### CERTIFICATE OF INSPECTION

The undersigned, holding a valid Commission issued by The National Board of Boiler and Pressure Vessel Inspectors and certificate of competency issued by the state or province of RI and employed by COMMERCIAL UNION INSURANCE of BOSTON MASS. has inspected the work described in this report on 6-10, 19 92 and state that to the best of my knowledge and belief this work has been done in accordance with the National Board Inspection Code. By signing this certificate, neither the undersigned nor my employer makes any warranty, expressed or implied, concerning the work described in this report. Furthermore, neither the undersigned nor my employer shall be liable in any manner for any personal injury, property damage or loss of any kind arising from or connected with this inspection, except such liability as may be provided in a policy of insurance which the undersigned's insurance company may issue upon said object and then only in accordance with the terms of said policy.

Date 8-26, 19 92 Signed Joseph V. Vachon Commissions NB39841 B RI 717  
(Authorized Inspector) (National Board (incl. endorsements), state, prov., and no.)