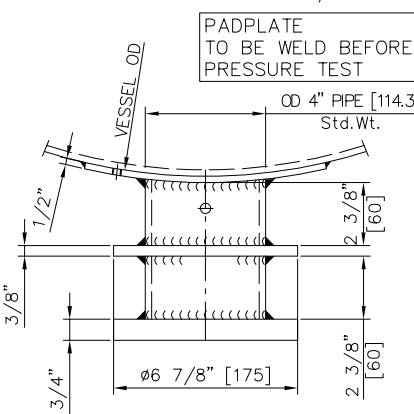
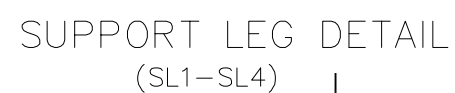


CONFORMEMENT A LA LOI NOS ETUDES
ET DESSINS SONT NOTRE PROPRIETE
EXCLUSIVE ET NE PEUVENT ETRE REPRODUITS
OU COMMUNIQUEES A DES TIERS MEME APRES
MODIFICATIONS SANS NOTRE AUTORISATION
ECRITE

PLAN — ORIENTATION
(AGITATOR NOT SHOWN)



POS.	SERVICE	QTY	NOMINAL DIA	FLANGE		SCHED. / THK.	REIN. PAD ODxTHK.	PROJ. LGTH.	REMARKS REF. DRG.	WELD TYPE
				RATING	TYPE					
N01	INLET FROM MIXER	1	6"	CLASS 150	SO-RF	SCH.40S		2'-11 7/16"		FW02/NW01
N02	OUTLET TO SEPARATOR	1	6"	CLASS 150	SO-RF	SCH.40S		2'-11 7/16"		FW02/NW01
N03	DRAIN TO W503AC	1	2"	CLASS 150	SO-RF	SCH.40S		2'-10 7/16"		FW02
N04	VENT	1	1"	CLASS 150	SO-RF	SCH.40S		2'-8 1/2"		FW02
N05	SPARE NOZZLE -BLINDED	1	6"	CLASS 150	SO-RF BF-RF	SCH.40S	9 13/16"x1/2"	1'-9 5/8"		SEE BODY FW02
N06	AGITATOR SEAT	1	30"	CLASS 150	WN-RF BF-RF ASME B16.47 SERIES 1	SCH.20S	3'-1 3/8" x1/2"	2'-9 1/16"		SEE BODY FW09
N07	BOTTOM BEARING+DRAIN	1	12"	CLASS 150	SO-RF BF-RF	SCH.40S	1'-4 15/16"x1/2"	2'-1 7/2"	SEE BODY	FW02/NW10
L01	CONNECTION FOR LEVEL SWITCH	1	1 1/2"	CLASS 150	SO-RF	SCH.40S		9'-3/16"		FW02
L02	CONNECTION FOR LEVEL SWITCH	1	1 1/2"	CLASS 150	SO-RF	SCH.40S		9'-3/16"		FW02

ACCESSORIES

LT1-LT2	LIFTING TRUNNIONS	2					SEE DETAIL	
SL1-SL4	SUPPORT LEGS	4					SEE DETAIL	
TL1	TAILING LUG	1					SEE DETAIL	
NP1	NAMEPLATE	1					100170601	
SAF1	WARNING PLATE TYPE 4	1					00430529	

MATERIALS / CERTIFICATES

ITEM	MATERIAL	CERT.	ITEM	MATERIAL	CERT.
SHELL/DISHED ENDS	SA-240 304	✓	EXTERNAL GASKETS	GARLOCK 3500	
NOZZLE NECKS	SA-312 TP304	✓	INTERNAL GASKETS	GARLOCK 3500	
NOZZLE FLANGES	SA-182 F304	✓	SUPPORT FOR NAMEPLATE	SA-240 304	
AGITATOR NECK	SA-240 304	✓	TRUNNIONS	SA-240 304	✓
AGITATOR FLANGE	SA-182-F304	✓	PIPE/PLATE	SA-106 B/SA-36	✓
INTERNALS	SA-240 304	✓	TAILING LUG	PADPLATE	SA-240 304
ROUND BAR	SA-479 304	✓	PLATE	SA-36	
EARTHING LUG	SA-240 304	✓	LEGS	PADPLATE	SA-240 304
INTERNAL BOLTS/NUTS	SA 193-BB/SA 194-8	✓	PROFILE/PLATE	SA-36	✓
EXT. BOLTS/NUTS	SA 193-BT/SA 194-2H	✓	NOZZLE PAD PLATES	SA-240 304	
INSULATION RINGS	SA-240 304	✓	SUPPORT FOR WARNING PLATE	SA-240 304	

DESIGN DATA

EQUIPMENT			SHELL	
PRESSURE	OPERATING	borg	4 (58 psig)	
	DESIGN	borg	10 (145 psig)	
	TEST	borg	13.3 (193 psig)	OK
TEMPERATURE	OPERATING	°C	80 (176° F)	
	DESIGN	°C	0/120 (32-248° F)	
	TEST	°C	AMBIENT	
MIN. DESIGN METAL TEMP.		°C	-10 (14° F)	
CORROSION ALLOWANCE	STAINLESS STEEL	mm	0	
	CARBON STEEL	mm	1/16" (1.6)	
RADIOGRAPHY			SPOT	OK
MIN. JOINT EFFICIENCY			0.85	
HEAT TREATMENT			NONE	
DESIGN CODE			ASME SEC VIII DIV.1 ED: 2019	
WIND / SEISMIC DESIGN			101 mph / SDS = 1.077g, SD1 = 0.664g (ASCE 7-16)	
FLUID			OIL + NaOH	
FLUID-GROUP			NA	
PED 2014/68/EU			NA	
ASME "U" STAMP			YES	
WEIGHT	EMPTY	kg	4960 (10935 Lbs)	
	ASSEMBLED	kg	6101 (13450 Lbs)-(AGITATOR WEIGHT INCLUDED)	
	INSULATION	kg	171 (377 Lbs)	
	OPERATING	kg	15579 (34346 Lbs)	
	FULL OF WATER	kg	16772 (36976 Lbs)	
VOLUME		m³	10.5 (371 Ft.³)	
HEAT TRANSFER AREA		m²	-	
INSULATION	SURFACE AREA / THK.	m²/mm	28.5/50 (307 Ft.²/2")	
INSPECTED BY			ASME INSPECTOR	

NOTE : LIQUID DENSITY : 886.37 kg/m³ (62.1 Lbs/Ft.³)
- SPREADER BEAM USED FOR LIFTING

006	04.05.2022	UPDATED AS MARKED					RSS		
REV	DATE	DESCRIPTION OF MODIFICATION				NBR OF MOD	BY		
Desmet Ballestra Group						DOCUMENT TYPE	ASSY		
						PROJECT DESCRIPTION	WORPAR		
ITEM NBR DISPOSITION	W503B.1 (19-RA-751)					SECD PROC.E	SA A GVK	SCALE	FORMAT
DOCUMENT DESCRIPTION	REAGENT REACTOR					PROJ.M	JCG	AUTHOR	RSS
						DOM	PRA		
D=1829-H=3505-ARRANGEMENT						DATE	DRAWING NUMBER		REVISION
							19.12.2020	100170599	

IF IN DOUBT, ASK DO NOT SCALE !	1	CAD DRWG. DO NOT MODIFY
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1

C

A

D

C

B

A

A1 (594 x 841)



INSPECTION REPORT

A. FINAL INSPECTION REPORT: BY RDR

B. Project code : WORPAR
Workshop : EQUIPROMEX
Item : W503B.1
Drawing Nr : ASSY 100170599 Rev06, BODY 100170600 Rev02
Order Nr : 2724
PO nr : 2724
Inspector : RODRIGO DIAZ
Date : 05/13/2022

C. ACCEPTED FOR DELIVERY BY: RDR

PROGRESS : 100%
ESTIMATED READINESS DATE: 05/13/2022

D. GENERAL CONSIDERATIONS

✓ Painting quality : OK
✓ Welding quality : OK
✓ Cleanliness : OK
✓ Material certificates : OK
✓ Packing quality : OK
✓ Handling, securing facilities: OK
✓ Vessel thickness : OK
✓ Dimensions according drawings : OK
✓ Nozzles orientation and projections : OK
✓ Internals attachments : OK

E. TESTING RESULTS : All tests have been completed with satisfactory results.

Type of test	Degree of examination	Results
Hydrotest shell side	100%	Satisfactory
R.T. on shell	Spot	Satisfactory

This inspection does not in any way discharge the responsibility of the workshop nor impact on the mechanical warranty



R.T. on dished ends welded seams.	100%	Satisfactory
PMI	SS material.	Satisfactory
Vertical alignment with laser	100%	Satisfactory
Visual inspection	100%	Satisfactory



90 degrees view. Fabrication of reagent reactor W503B.1 is complete and ready for shipment. Final visual appearance of base metal and welding are satisfactory. Verified that MOC complies with the fabrication drawings with EQUIPROMEX PMI reports and MTR's.



270 degrees view. Shipment preparations are complete.

This inspection does not in any way discharge the responsibility of the workshop nor impact on the mechanical warranty

The logo for Desmet Ballestra, consisting of the company name in a white sans-serif font on a dark blue rectangular background.

Top and bottom dished ends. Thickness after forming is over ½”.



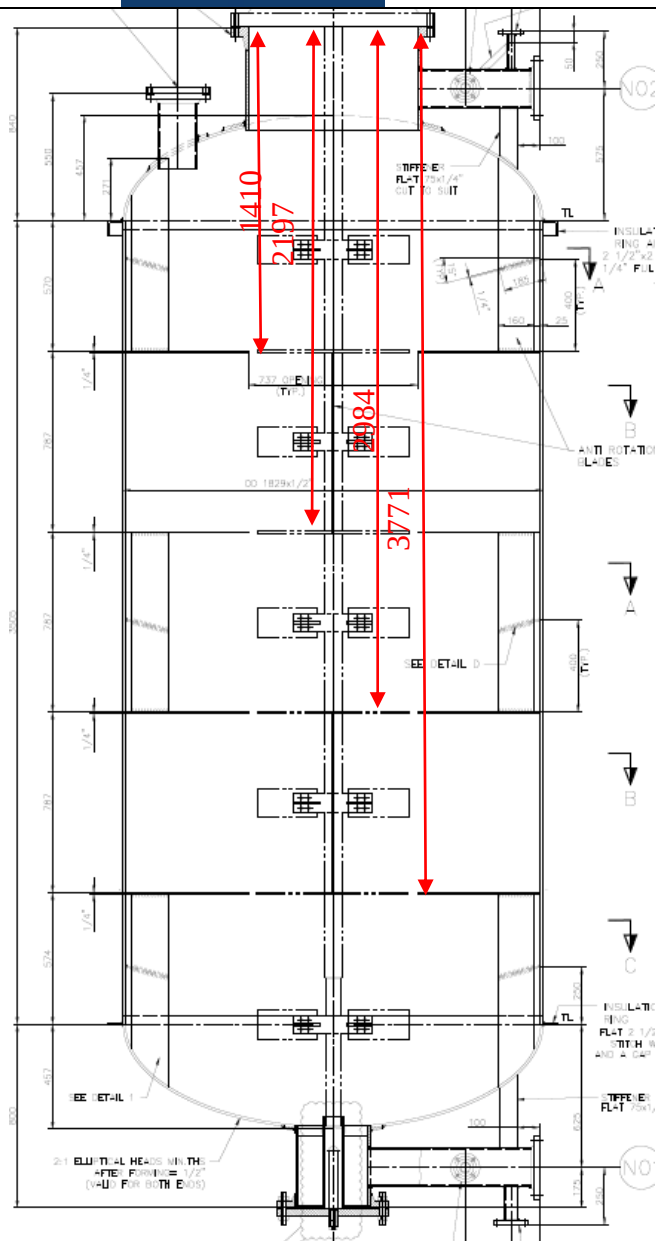
Verified shaft's limiting device is properly installed with one slot facing to nozzle N01.

This inspection does not in any way discharge the responsibility of the workshop nor impact on the mechanical warranty

Verified internal baffles deviation as follows (maximum allowable tolerance 6 mm):

W503B.2 (Measurements in mm)						
	Orientation				Dimensions in drawings	Maximum deviation
	0 degrees	90 degrees	180 degrees	270 degrees		
Baffle 1	1410	1410	1410	1414	1414	4
Baffle 2	2197	2197	2197	2202	2197	5
Baffle 3	2986	2984	2989	2986	2984	2
Baffle 4	3771	3774	3774	3771	3771	3

This inspection does not in any way discharge the responsibility of the workshop nor impact on the mechanical warranty



Measurements were taken from the top face of the agitator seat nozzle N06 to the edge of the inside diameter e of each baffle at each 90 degrees.

This inspection does not in any way discharge the responsibility of the workshop nor impact on the mechanical warranty



ASME nameplate, warning plates and data plate are properly attached.



Performed random spot positive material identification test with satisfactory results on material type SS-304 and reviewed Equipromex QC PMI reports of SS components with positive results on MOC SS-304.

END REPORT.

This inspection does not in any way discharge the responsibility of the workshop nor impact on the mechanical warranty