

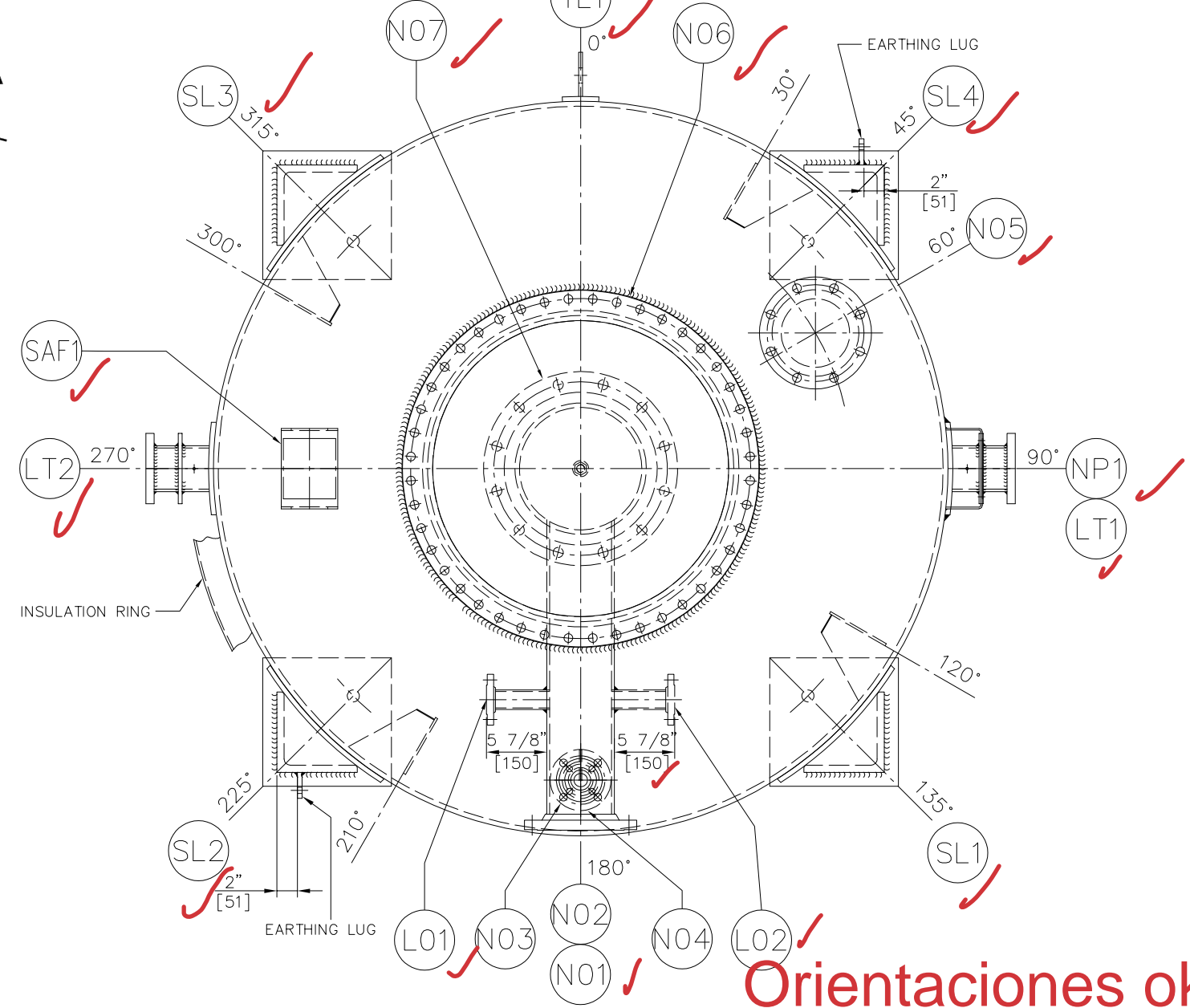
ACCORDING TO THE LAW OUR SURVEYS AND DRAWINGS ARE OUR EXCLUSIVE PROPERTY AND MAY NOT BE REPRODUCED OR COMMUNICATED TO THIRD PARTIES EVEN AFTER MODIFICATIONS WITHOUT OUR WRITTEN CONSENT

DE CONFORMIDAD CON LA LEY, NUESTROS ESTUDIOS, DISEÑOS, SON PROPIEDAD EXCLUSIVA DE NUESTRA FIRMA Y NO SERÁN REPRODUCIDOS NI COMUNICADOS A TERCERAS PERSONAS SIN NUESTRA AUTORIZACIÓN ESCRITA. AUNQUE HAYAN SIDO MODIFICADOS

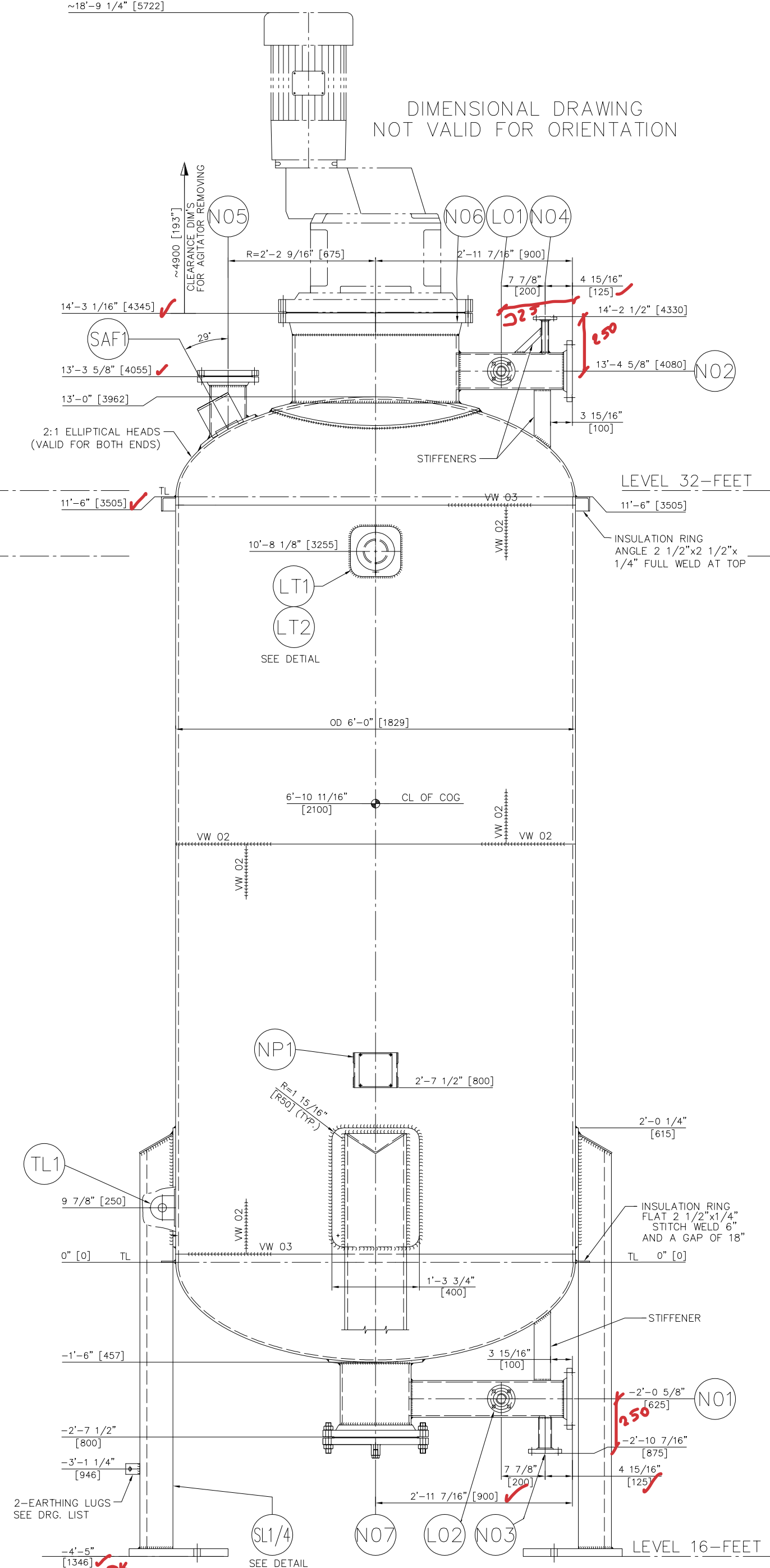
ET DESSEINS SONT NOTRE PROPRIÉTÉ EXCLUSIVE ET NE PEUVENT ÊTRE REPRODUITS NI COMMUNIQUÉS À DES TIERS SANS NOTRE AUTORISATION ÉCRITE

IF IN DOUBT, ASK – DO NOT SCALE !

PLAN – ORIENTATION
(AGITATOR NOT SHOWN)

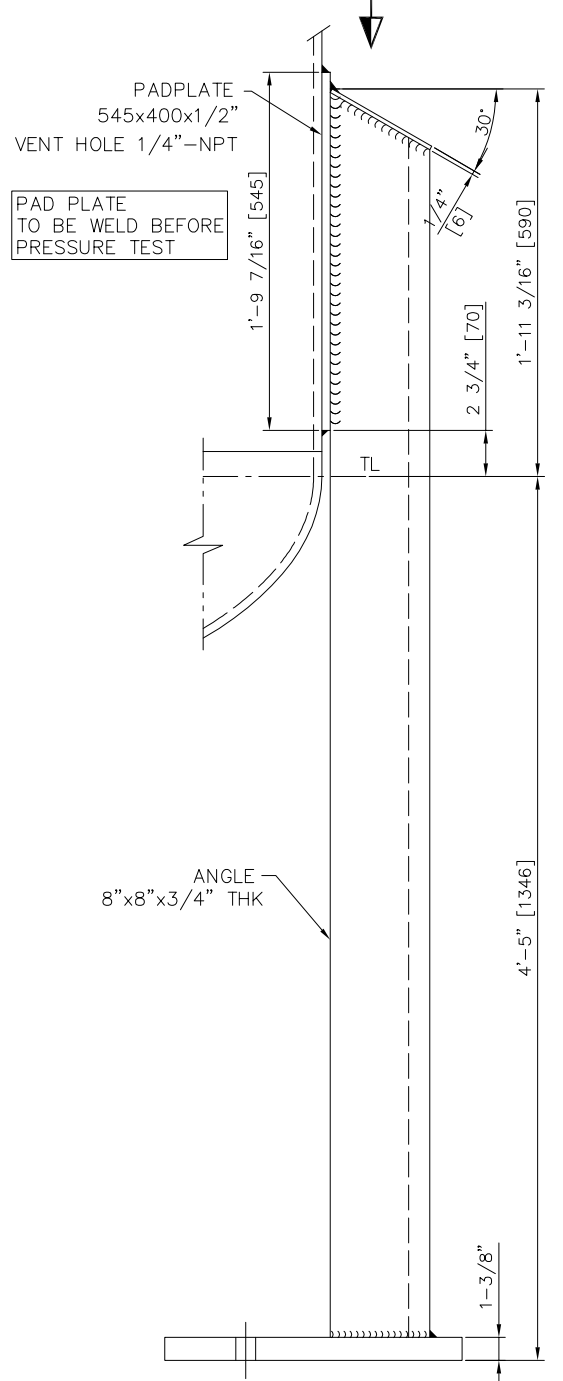


DIMENSIONAL DRAWING
NOT VALID FOR ORIENTATION

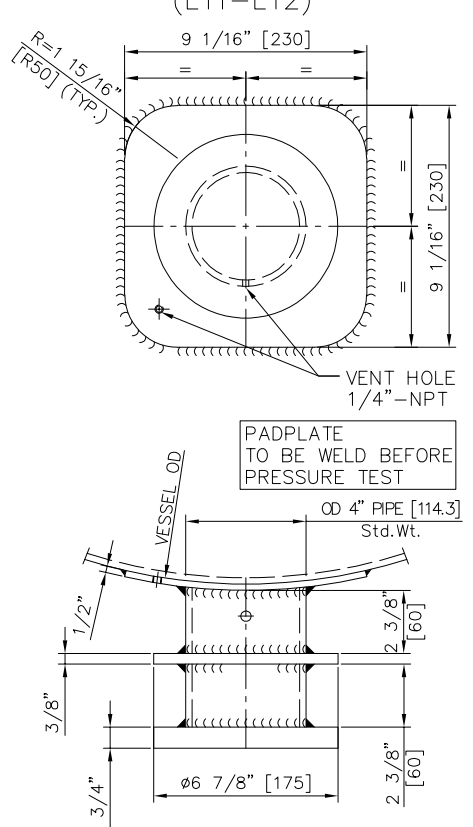


Dimensiones ok

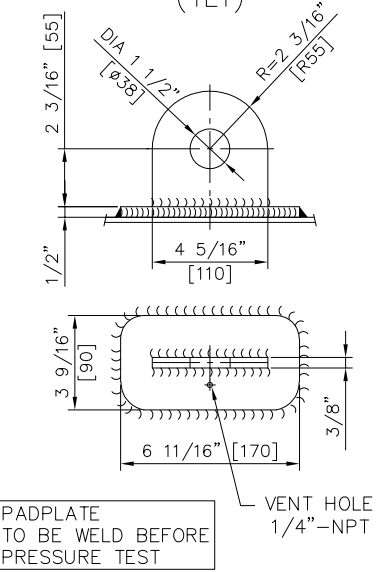
SUPPORT LEG DETAIL
(SL1–SL4)



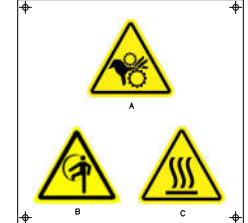
DETAIL TRUNNION
(LT1–LT2)



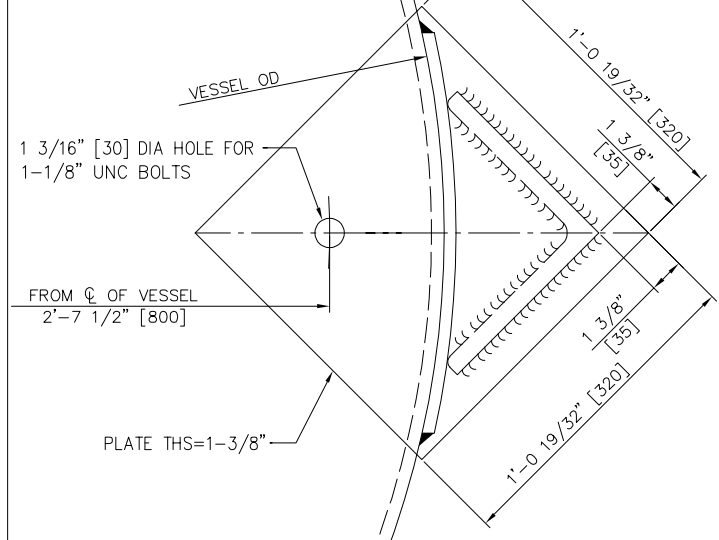
DETAIL TAILING LUG
(TL1)



WARNING PLATE
TYPE–4



VIEW A



NOZZLES

POS.	SERVICE	QTY.	NOMINAL DIA	RATING	FLANGE TYPE	NECK SCH./THK.	REIN. PAD ODxTHK.	PROJ. LGT.	REMARKS REF. DRG.	WELD 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 W502	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–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 ASME B16.47 SERIES A	SCH. 20S	3'-1 3/8" x1/2"	2'-9 1/16"		SEE BODY FW09/NW11
N07	BOTTOM BEARING+DRAIN	1	12"	CLASS 150	SO–RF BF–RF	SCH. 40S	1'-4 15/16" x1/2"	2'-7 1/2"		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							SEE DRG. LIST	
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	✓
INTERNAL	SA–240 304	✓	TAILING LUG	SA–240 304	✓
ROUND BAR	SA–479 304	✓	PLATE	SA–36	✓
EARTHING LUG	SA–240 304	✓	PADPLATE	SA–240 304	✓
INTERNAL BOLTS/NUTS	SA 193–BB/SA 194–8	✓	SUPPORT LEGS	PROFILE/PLATE	SA–36
EXT. BOLTS/NUTS	SA 193–BT/SA 194–2H	✓	NOZZLE PAD PLATES	SA–240 304	✓
INSULATION RINGS/PROFILE/PLATE	SA–240 304	✓	SUPPORT FOR WARNING PLATE	SA–240 304	✓

Materiales ok

DESIGN DATA

EQUIPMENT	OPERATING	barg	4 (58 psig)
PRESSURE	DESIGN	barg	10 (145 psig)
	TEST	barg	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	STAINLESS STEEL	mm	0
ALLOWANCE	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			PRE MIXED RENDERED FAT+ WATER + CITRIC ACID
FLUID–GROUP			NA
PED 2014/68/EU			NA
ASME "U" STAMP			YES OK
WEIGHT	EMPTY	kg	4960 (10935 Lbs)
	ASSEMBLED	kg	6101 (13450 Lbs)–(AGITATOR WEIGHT INCLUDED)
	INSULATION	kg	171 (377 Lbs)
	OPERATING	kg	15509 (34192 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 : 879.73 kg/m3 (54.92 Lbs/Ft.³)
– SPREADER BEAM USED FOR LIFTING

005	04.05.2022	UPDATED AS MARKED		RSS
REV	DATE	DESCRIPTION OF MODIFICATION	DOCUMENT TYPE	ASSY
			PROJECT DESCRIPTION	WORPAR
ITEM NBR	DISPOSITION	W503W.2 (19–RA–855)	SEC'D	SAA
			PROC.E	GVK
DOCUMENT DESCRIPTION		WATER WASH REACTOR	PROJ.M	JCG
			DOM	PRA
			DATE	DRAWING NUMBER
			27.04.2021	100191046
				005

D=1829–H=3505–ARRANGEMENT

IF IN DOUBT, ASK
DO NOT SCALE !

CAD DRWG.
DO NOT MODIFY



INSPECTION REPORT

A. FINAL INSPECTION REPORT: BY RDR

B. Project code : WORPAR
Workshop : EQUIPROMEX
Item : W503W.2
Drawing Nr : ASSY 100191046 Rev05, BODY 100191047 Rev01
Order Nr : 2722
PO nr : 2722
Inspector : RODRIGO DIAZ
Date : 05/18/2022

C. ACCEPTED FOR DELIVERY BY: RDR

PROGRESS : 100%
ESTIMATED READINESS DATE: 05/18/2022

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 water wash reactor W503W.2 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 1/2".



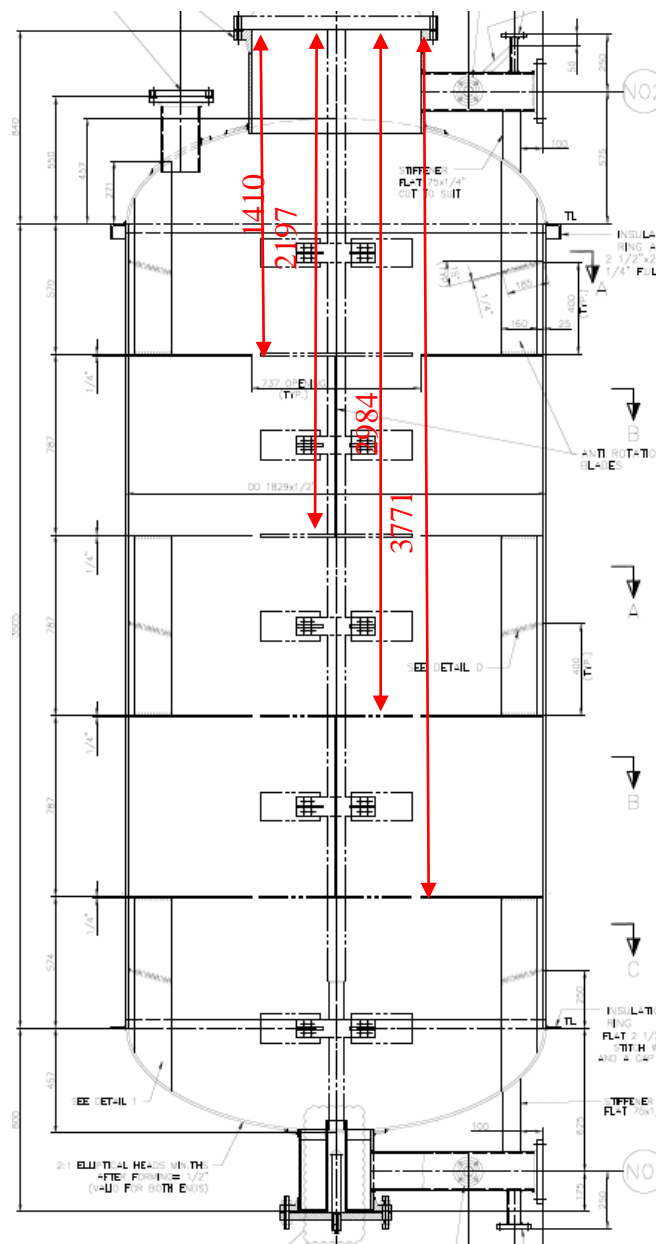
Verified shaft's limiting device is properly installed with one slot facing to nozzle N01.

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

desmet ballestra

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	1412	1412	1411	1414	1410	4
Baffle 2	2197	2197	2198	2200	2197	3
Baffle 3	2986	2984	2984	2986	2984	2
Baffle 4	3772	3772	3772	3772	3771	1



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

desmet ballestra

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.



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