

DESIGN INFORMATION	
DESIGN PRESS. PSIG:	250 / VV
DESIGN TEMP. DEG F:	675 / 525
MMT DEG F:	32
CORROSION ALLOW. IN.:	0.125
	BARE: 2675.1 FT*2
	EXTENDED: 56,079 FT*2

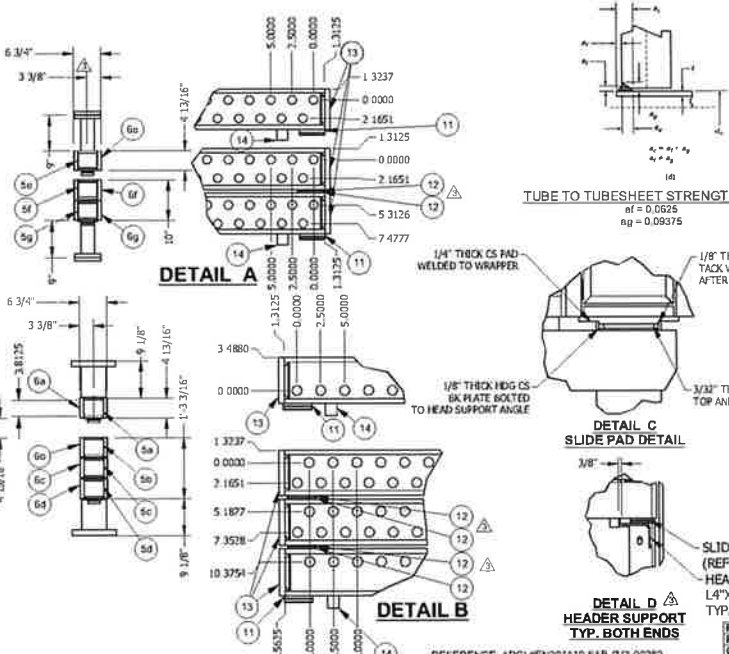
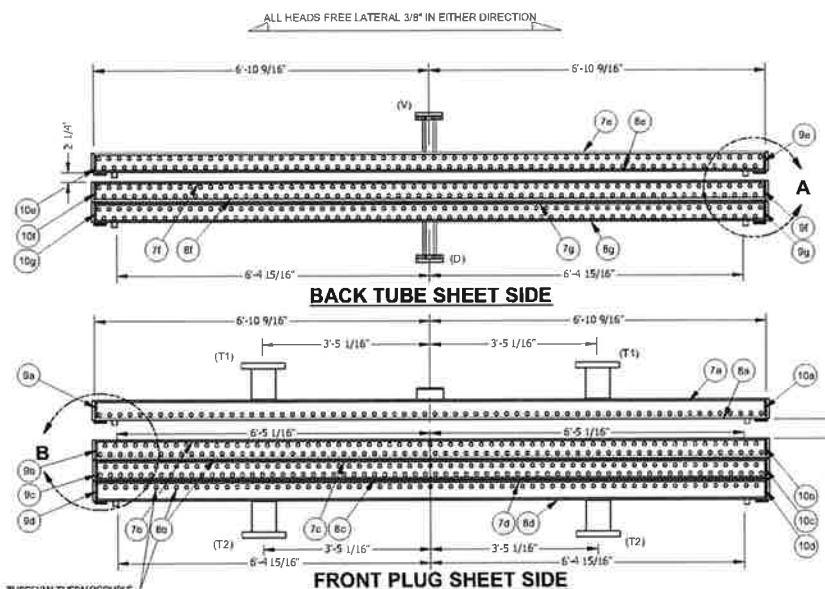
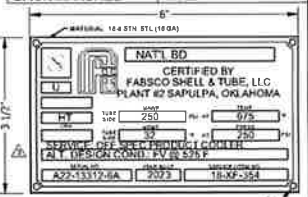
CYCLIC SERVICE	
100% RT/UT	

HYDROTEST PSIG:	
353	
DESIGN & STAMP:	
ASME	

ASME SECT. VIII, DIV. 1 ED. 2021  
 CHARTER EXEMPT UG20(f) AND/OR UCS 66

PLUG HOLE INFORMATION	
PREDRILL DIAMETER	0.9688
TUBE REAM	1.01
TAP REAM	1.0469
TPI	12
SPOTFACE OD	1.5
SPOTFACE DEPTH	0.01
GROOVES/HOLE	FRONT (2) / BACK (2)
PLUG DIAM	1.125

ROLL TOOL INFO	
FRONT ROLLER	1245C / R17
FRONT MANDREL	M62C
BACK ROLLER	1245D / R17
BACK MANDREL	M62D



REV.	DATE	COMMENT	BY
Δ	02-03-2022	FOR APPROVAL	BH
Δ	6/14/22	CUST COMM	BH
Δ	12/8/22	DESIGN CHANGE/ SPLIT HEAD PER PASS	BH
Δ	2/17/2023	CORRECTIONS/ CUST COMM	BH
Δ	3/8/2023	CUST COMM	BH

NOZZLE:		CONNECTIONS:	
(T1)	(INLET)	(2) 4" 600# RFLWN (4.00" ID)	
(T2)	(OUTLET)	(2) 4" 600# RFLWN (4.00" ID)	
(V)	(VENT)	(1) 2" 300# RFLWN W/BLIND	
(D)	(DRAIN)	(1) 2" 300# RFLWN W/BLIND	

TUBES: (393)	1" OD	0.109" MW	312"
FIN:	5/8" HI	0.016" THK	10/FPI EMBEDDED
PLUGS: (786)	1.125" OD	1" UH SHOULDER	

QTY	ITEM	DESCRIPTION	THICKNESS	LENGTH	WIDTH	BEVEL
14	(9, 9)	TIP SHEET	1.0000	185.125	4.8125	30 LONG
14	(7, 8)	WRAPPER	0.5000	185.125	4.5000	30 LONG
14	(8, 10)	END PLATE	0.5000	3.5825	4.5000	45 ALL
8	(11)	HEADER PAD	0.2500	5.000	3.5000	NONE
12	(12)	HEADER PAD	0.1675	5.000	3.5000	NONE
14	(13)	HEADER WING	0.2500	4.8125	0.6250	NONE
8	(14)	LAT. STOP BLOCK	1.2500	5.000	1.2500	NONE

MATERIALS:		STRUCTURAL:		TUBE SPACERS:	
PLATE:	SA-516-70N	SIDEFRAME:	C 0.375" X 0.375" X 0.925" A	TUBE SPACERS REQ'D:	138
FLANGE:	SA-350-LF2	SUPPORT:	(5) 4" X 6" X 0.1875" RT	SCALLOPED CHANNELS:	
PLUG:	SA-350-LF2	BINDER:	(5) 1/2" X 2" X 2.5"	1" X 2.5" PITCH	
GASKET:	KAMMPROFILE	TIP AIRSEAL:	Z SHAPE	ALUMINUM	
SIDE FRAME:	A3B	BTM AIRSEAL:	Z SHAPE		
TUBE:	SA-179	LUG:	A38 604 WELDED		
FIN:	ALUMINUM	HDR FINISH:	SSPC SP10	TOLERANCES: (INCH)	
STAY PLATE:	SA-516-70N	Coating System 5 AFTER HYDRO		LENGTH:	± 0.125
		SFR FINISH:	HAND TOOL CLEAN	WIDTH:	± 0.125
		Galvanneal		TUBE PROJECTION:	0.0025 - 0.0050
		REFERENCE: ABKN-9P-200-56554-A			± 0.0625
				DRY WEIGHT (LBS):	29687
				HYDRO WEIGHT (LBS):	32661

CERTIFIED  
 BY: [Signature] DATE: 04/16

REFERENCE: APCI #EK20/115-FAB-2/3-00280  
 HEAT TREATMENT  
 A) HEAT FROM 800°F TO 1150°F @ 400°F PER HOUR.  
 B) HOLD @ 1150°F ± 25°F FOR (60 MIN.).  
 C) COOL FROM 1150°F TO 800°F @ 500°F PER HOUR.  
 D) FURTHER COOLING MAY BE IN STILL AIR.

PROJECT NAME:	World Energy Renewables Project
PROJECT NO./UNIT:	EN-20-719 / REF ID: B
CUSTOMER/CLIENT:	World Energy Paramount
EQUIPMENT OWNER:	Air Products Manufacturing LLC
ITEM NO.:	18-XF-354
SERVICE:	OFF SPEC PRODUCT COOLER
LOCATION:	World Energy, Paramount, CA, USA
P.O. NO.:	456586636 / ABKN-4-406-PO-1
FABSCO JOB NO.:	A22-13312-6A

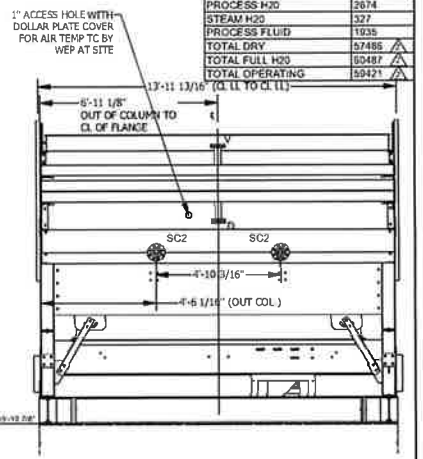
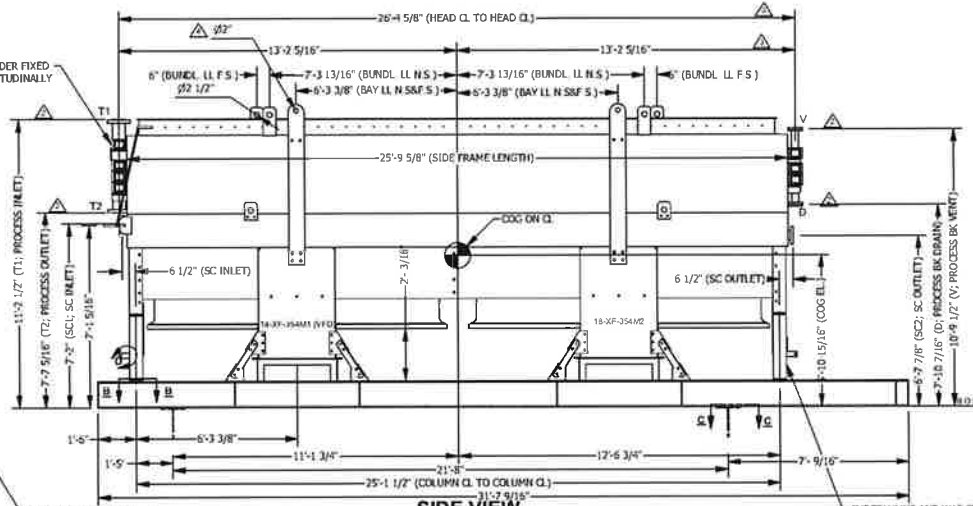
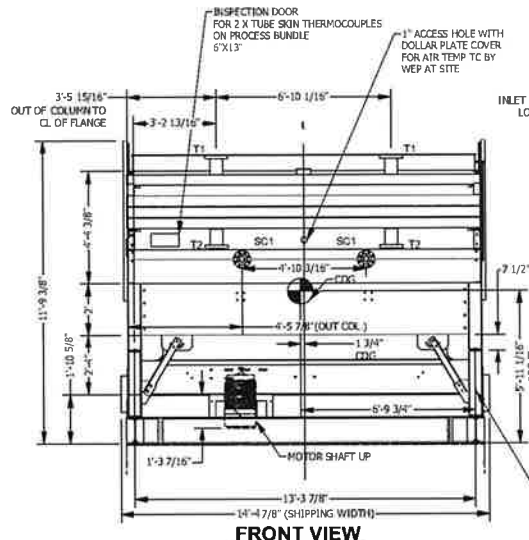
DRAWING TITLE PART TO FABSCO FIN-IR, LLC AND IS NOT TO BE RELEASED TO ANY THIRD PARTY, EXCEPT WITH NOTIFICATION AND APPROVAL IN WRITING OF FABSCO FIN-IR, LLC OFFICER.	
DRAWN BY:	BH
DATE:	02-03-2022
CHECKED BY:	
DRAWING NO.:	A22-13312-6A-300
REV.:	4



BUNDLE ARRANGEMENT DRAWING - 18-XF-354

SECTION / DESCRIPTION	MAWP	TEST PRESS	DESIGN TEMP	MDMT	ALTERNATE DESIGN	BUNDLE VOL.	BUNDLE WT.	LOUVER	HAILSCREENS	MOTOR HP:	FAN MFGR:	DIAM (FT):	SPECIFICATION NOTES:	COOLER WT #:
UNITS	PSIG	PSIG	DEG F	DEG F	CONDITION	CU FT	LBS			TYPE: TFCG	MOORE	11		SEE TABLE
18-XF-354 OFF SPEC PRODUCT COOLER	250	353	675	32	FV @ 575F	43	29067	MANUAL	NONE	1800	10000	11.3930	VIBE SENSOR: WILCOXON	STRUCTURE FINISH: PER ABMA PP-000-50520-A
										VAC: 460/360	BLADES: 4	HP@DES.: 19.12	VIBE SENSOR MODEL NO.: 781A-D2	NON FIREPROOFED STR TO BE GALVANIZED
										FRAME: 284T	PITCH: 8.27			HEADER FINISH: PER ABMA PP-000-50520-A
										SHAFT: 1.875	RPM: 313	DRIVE: HTD		COATING SYSTEM & AFTER HYDROTEST
										MOTOR WT: 445 lbs	SERIES: 36	RATIO: 5.75:1		
										QTY: 2	TYPE: EG	DRIVE WIDTH: 35		
											TIP: VE	AIR BRAKE: YES		
											QTY: 2			
STEAM COIL	222	302	430	32	FV @ 430F	5	6385	NONE	NONE					

WEIGHTS PER BAY (LBS)	
ITEM	WEIGHT
COOLER	48551
SPAN BEAMS	3433
LOUVER	1042
WALKWAY	1751
PROCESS H2O	2674
STEAM H2O	127
PROCESS FLUID	1935
TOTAL DRY	67485
TOTAL FULL H2O	69487
TOTAL OPERATING	59421



**APPROVED BY:** \_\_\_\_\_  
**DATE:** \_\_\_\_\_

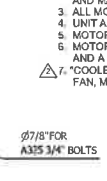
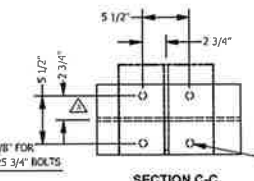
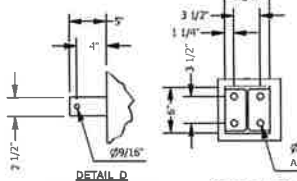
- NOTE: 1. (1) BAYS REQUIRED  
 2. SPANNING BEAMS, STUB COLUMNS, TRANSV & LONG DIAG BRACES, AND MANUAL LOUVER ROD REMOVED FOR SHIPPING.  
 3. ALL MOTORS ARE VFD COMPATIBLE, NO SPACE HEATER.  
 4. UNIT ADJACENT TO 18-XF-350 WITH CONNECTING HEADER WALKWAYS AND AIR SEALS.  
 5. MOTOR REMOVAL BEAM PROVIDED.  
 6. MOTORS SHALL BE RATED FOR CLASS 1, DIV. 2, GROUPS B,C,D AND A T3C TEMPERATURE CODE.  
 7. "COOLER WEIGHT" LISTED ABOVE INCLUDES BUNDLE, STEAM COIL, FAN, MOTOR, STUB COLUMNS AND BRACES PER BAY.

NOZZLE SCHEDULE			
LABEL	ITEM	QTY	FLANGE
T1	PROCESS INLET	2	4" 600# RFLWN, 4" ID 5" OD
T2	PROCESS OUTLET	2	4" 600# RFLWN, 4" ID 5" OD
V	PROCESS BK VENT	1	2" 300# RFLWN, BLIND
D	PROCESS BK DRAIN	1	2" 300# RFLWN, BLIND
SC1	STEAM INLET	2	3" 300# RFWN
SC2	STEAM OUTLET	2	3" 300# RFWN

<b>PROJECT NAME:</b>	World Energy Renewables Project
<b>PROJECT NO./UNIT:</b>	EN-20-7119 / RF-U-8
<b>CUSTOMER/CLIENT:</b>	World Energy Paramount
<b>EQUIPMENT OWNER:</b>	Air Products Manufacturing LLC
<b>ITEM NO.:</b>	18-XF-354
<b>SERVICE:</b>	Off Spec Product Cooler
<b>LOCATION:</b>	World Energy, Paramount, CA, USA
<b>PO NO.:</b>	4505608036 / ABMA-4-406-PO-1
<b>FABSCO JOB NO.:</b>	A22-13312-6

DRAWING PROPRIETARY TO FABSCO, LLC AND IS NOT TO BE RELEASED TO ANY THIRD PARTY, EXCEPT WITH NOTIFICATION AND APPROVAL IN WRITING OF FABSCO, LLC OR PGR.

NOZZLE LOADS						
FRONT HEAD	Y	Z	W	W	W	W
W	15.00	13.00	15.00	13.00	18.00	13.00
W	15.00	13.00	15.00	13.00	18.00	13.00
W	15.00	13.00	15.00	13.00	18.00	13.00
W	15.00	13.00	15.00	13.00	18.00	13.00
W	15.00	13.00	15.00	13.00	18.00	13.00
W	15.00	13.00	15.00	13.00	18.00	13.00
W	15.00	13.00	15.00	13.00	18.00	13.00
W	15.00	13.00	15.00	13.00	18.00	13.00
W	15.00	13.00	15.00	13.00	18.00	13.00
W	15.00	13.00	15.00	13.00	18.00	13.00



REFERENCE DOCUMENTS	
FABSCO DOC. #	APCI DOC. #
A22-13312-6A-300	EN207119-FAB-0V3-00044
A22-13312-6B-300	EN207119-FAB-0V3-00045
A22-13312-6A-ASME	EN207119-FAB-0V3-00210
A22-13312-6B-ASME	EN207119-FAB-0V3-00211
A22-13312-6-L1	EN207119-FAB-0V3-00048
A22-13312-6-LAYOUT	EN207119-FAB-0V3-00043
A22-13312-6-NOTES	EN207119-FAB-0V3-00285
A22-13312-6-STR	EN207119-FAB-0V3-00058

GENERAL ARRANGEMENT - 18-XF-354				
REV.	DATE	DESCRIPTION		
0	2/10/2022	FOR APPROVAL		
1	7/11/2022	CUST. COMM.		
2	12/8/2022	DESIGN CHANGE/ SPLIT EACH PASS		
3	2/7/2023	CUST. COMM.		
4	3/9/2023	CUST. COMM. / UPDATED LL DIMS		

**DRAWN BY:** BH

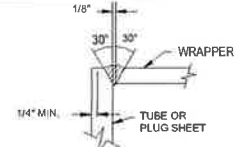
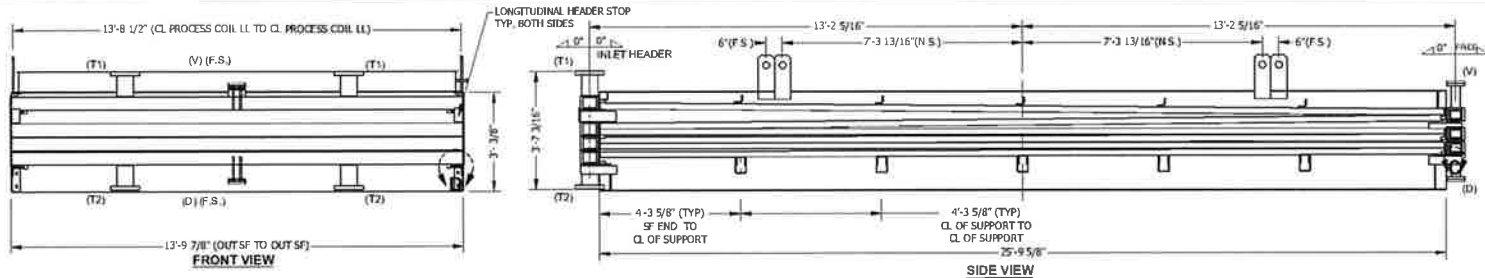
**DATE:** 2/10/2022

**CHECKED BY:** \_\_\_\_\_

**DRAWING NO.:** A22-13312-6-100

**REV.:** 4

**FABSCO**  
 Fin-Air, LLC.



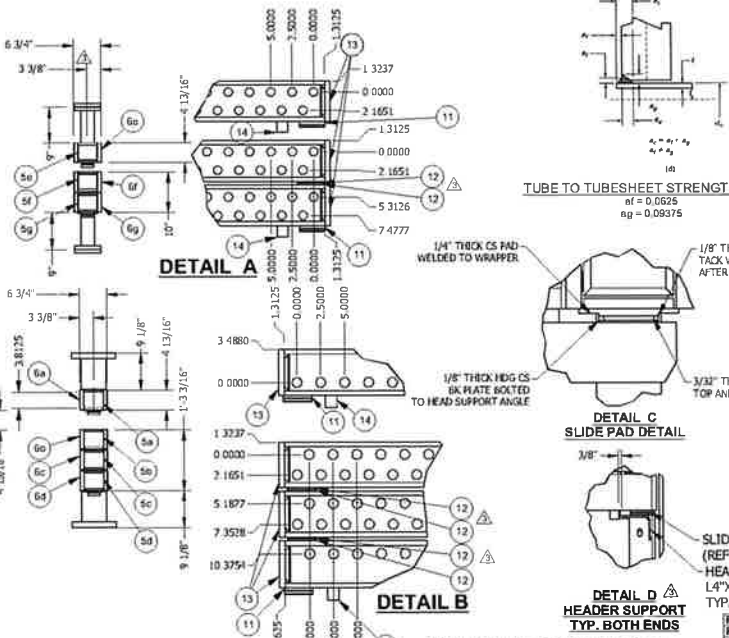
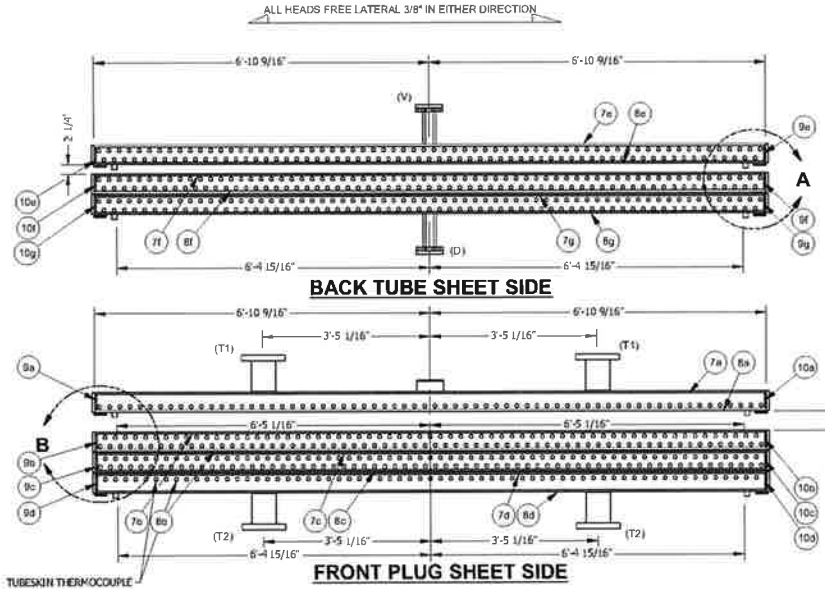
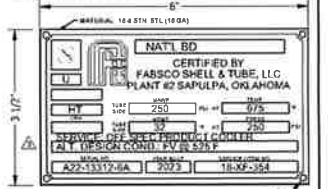
DESIGN INFORMATION	
DESIGN PRESS. PSIG:	250 / VV
DESIGN TEMP. DEG F:	675 / 525
MMT DEG F:	32
CORROSION ALLOW. IN.:	0.125
	BARE: 2675.1 FT*2
	EXTENDED: 56,079 FT*2

CYCLIC SERVICE	
100% RT/UT	

ASME SECT. VIII, DIV. 1 ED. 2021  
CHARPY EXEMPT UG20(f) AND/OR UCS 66

PLUG HOLE INFORMATION	
PREDRILL DIAMETER	0.9688
TUBE REAM	1.01
TAP REAM	1.0469
TPI	12
SPOTFACE OD	1.5
SPOTFACE DEPTH	0.01
GROOVES/HOLE	FRONT (2) / BACK (2)
PLUG DIAM	1.125

ROLL TOOL INFO	
FRONT ROLLER	1245C / R17
FRONT MANDREL	M62C
BACK ROLLER	1245D / R17
BACK MANDREL	M62D



REV.	DATE	COMMENT	BY
1	02-03-2022	FOR APPROVAL	BH
2	6/14/22	CUST COMM	BH
3	12/8/22	DESIGN CHANGE/ SPLIT HEAD PER PASS	BH
4	7/17/2023	CORRECTIONS/ CUST COMM	BH
5	3/8/2023	CUST COMM	BH

NOZZLE:		CONNECTIONS:	
(T1)	(INLET)	(2) 4" 600# RFLWN (4.00" ID)	
(T2)	(OUTLET)	(2) 4" 600# RFLWN (4.00" ID)	
(V)	(VENT)	(1) 2" 300# RFLWN W/B/LIND	
(D)	(DRAIN)	(1) 2" 300# RFLWN W/B/LIND	

QTY	ITEM	DESCRIPTION	THICKNESS	LENGTH	WIDTH	BEVEL	PLATE:	MATERIALS:
14	(9, 9)	TIP SHEET	1.0000	185.125	4.8125	30 LONG	SA-516-70N	STRUCTURAL:
14	(7, 8)	WRAPPER	0.5000	185.125	4.5000	30 LONG	SA-350-LF2	SIDEFRAME: C 0.375" 38.375" 309.625" 2.5
14	(8, 10)	END PLATE	0.5000	3.5625	4.5000	45 ALL	SA-350-LF2	SUPPORT: (5) 4" X 6" X 0.1875" RT
8	(11)	HEADER PAD	0.2500	5.000	3.5000	NONE	KAMMPROFILE	BINDER: (5) 1/2" X 2" X .25
12	(12)	HEADER PAD	0.1875	5.000	3.5000	NONE	A3B	TIP AIRSEAL: Z SHAPE
14	(13)	HEADER WING	0.2500	4.8125	0.6250	NONE	SA-119	BTM AIRSEAL: Z SHAPE
8	(14)	LAT. STOP BLOCK	1.2500	5.000	1.2500	NONE	ALUMINUM	LUG: A38.604 WELDED
							SA-516-70N	HDR FINISH: SSPC SP10
								Coating System 5 AFTER HYDRO
								SFR FINISH: HAND TOOL CLEAN
								Galvanneal
								REFERENCE: ARKM-9P-200-56554-A

TUBE SPACERS:	
TUBE SPACERS REQD:	138
SCALLOPED CHANNELS:	1"
PITCH:	2.5"
MATERIAL:	ALUMINUM
TOLERANCES: (INCH)	
LENGTH:	± 0.125
WIDTH:	± 0.125
TUBE PROJECTION:	0.0025 - 0.0050
	+ 0.0625

PROJECT NAME:	
World Energy Renewables Project	
PROJECT NO./UNIT:	EN-20-719 / REF ID: B
CUSTOMER/CLIENT:	World Energy Paramount
EQUIPMENT OWNER:	Air Products Manufacturing LLC
ITEM NO.:	18-XF-354
SERVICE:	OFF SPEC PRODUCT COOLER
LOCATION:	World Energy, Paramount, CA, USA
P.O. NO.:	456586636 / ARKM-4-406-PO-1
FABSCO JOB NO.:	A22-13312-6A

TUBES: (393) 1" OD 0.109" MW 312"		FIN: 5/8" HI 0.016" THK 10/FPI EMBEDDED		PLUGS: (786) 1.125" OD 1" UH SHOULDER	
DRIVING THESE PARTS TO FABSCO FIN-IR, LLC ARE NOT TO BE RELEASED TO ANY THIRD PARTY, EXCEPT WITH NOTIFICATION AND APPROVAL IN WRITING OF FABSCO FIN-IR, LLC OFFICER.	DRAWN BY: BH	DATE: 02-03-2022	CHECKED BY:	DRAWING NO: A22-13312-6A-300	REV: 4

Item	Note
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**PURCHASING NOTES (REF. SPEC-ENG-M0042)**

MATERIAL ORIGIN VERIFICATION PER APPENDIX B FOR HAZARDOUS SERVICE  
 Minimum material certification requirement shall be either:  
 •A mill certificate (for material originating within the USA) -OR-  
 •An EN 10204 Type 3.1 certificate (for material originating outside the USA)

Applicable to:

- Pressure containing parts, attachment to header and auxiliary connection bolting
- Weld consumables – must be EN 10204 Type 3.1 cert
- Load-bearing structural members (all Wide-flange beams, angles braces, splice plates)
- Load-bearing structural bolt assemblies
- Lifting Lugs

Countries of origin currently "qualified" by Air Products are: Austria, Belgium, Canada, Czech Republic, Denmark, Finland, France, Germany, Ireland, Italy, Japan, Luxembourg, Liechtenstein, The Netherlands, Norway, Mexico, Poland, Spain, South Korea, South Africa, Sweden, Switzerland, Taiwan, the United Kingdom, and the United States of America.

- P2 Tube and plugsheet shall be 100% UT for laminations and other defects
- P3 Kamprofile plug gasket

**WELDING NOTES (REF. ABKM-PP-000-500550-A AND 4WEQ-1051) REF. ABKM-PP-000-500550-A**

- W1 Structure weld per AWS D1.1
- W2 Pressure weld per API RP582
- W3 Welder ID map required for pressure welds
- W4 GTAW root pass

**BUNDLE NOTES (REF. SPEC-PP-000-500730-A)**

- B1 CYCLIC SERVICE. ALSO FLAMMABLE REQUIREMENTS IN ATTACHMENT C APPLY.
- B2 All pass/stay plates to include 1/4" hole for drainage and venting
- B3 Slide plates shall be stainless steel or PTFE
- B4 Lateral movement 0.375" in both directions or 0.75" in one direction
- B5 For PWHT thermocouple shall be attached to each header box
- B6 All PWHT exchangers shall have the following stenciled in 3" letters on both sideframes: POSTWELD HEAT TREATED-DO NOT WELD OR BURN
- B7 Auxiliary connections. To include spiral wound gasket 304SS w/ flexible graphite filler, w/ 304SS inner ring and CS outer ring. Flexillic CGI brand.
- B8 CS & SS: Auxiliary Connections: Bolts SA-193-B7; Nuts SA-194-2H. Two nuts (and hardened washer) shall be provided for each end of the studs for blind flanges (i.e., total of four nuts and two washers)
- B9 FEA Fatigue Analysis per the conditions of cyclic service operation described in the Air Cooled Heat Exchanger Cyclic Service Data sheet ABKM-18-096-540318-A sheet 6 of 6

**STRUCTURE NOTES (REF. ABKM-PP-000-40002-A, ABKM-PP-000-40003-A, ABKM-PP-000-40005-A)**

- ST1 California PE stamp required for structural steel design
- ST2 Space between adjacent bays shall be 12" to include air gap to avoid hot air recirculation
- ST3 Motor removal beams installed in each plenum above motor.
- ST4 Motors mounted vertical shall up and shall be rotated up for shipment
- ST5 The motors will have a 1.15 SF on sine-wave power (constant frequency/speed) and will have a 1.0 SF at variable frequency.
- ST6 Manual louvers provided with drop rod so that accessible from header walkway
- ST7 Columns and beams shall be ASTM A992. Baseplates, column splice plates, clips shall be ASTM A572/A572A Grade 50. Angles shall be ASTM A36/A36M.
- ST8 Ladder and grating fabrication per ABKM-PP-000-40006/7-A
- ST9 For high strength connections (knee braces, column's splices, walkway support beam), high strength bolt assembly required: 3/4" A325 bolt + F436 washer + F659 DTI washer (galv) + A563 nut (wax dip). All other standard bolt assemblies shall be A325 bolt + F436 washer + A563 nut.
- ST10 Structural welding in accordance with AWS D1.1
- ST11 PT or MT lifting lug welds
- ST12 MT 5% structure welds (clips, baseplates, gussets)

**HEADER BOX TESTING NOTES (REF. SPEC-PP-000-500550-A)**

- H1 Prior to fill up (CS): PT or WFMT plate edges for thickness less than 1", WFMT plate edges for thicknesses 1" and greater. Defects shall not be greater than the limits shown in ASME SA-20.
- H2 MT or PT nozzle cutout prior to nozzle attachment
- H3 NDE performed after PWHT (CS)
- H4 For welds in amine, wet H2S or fatigue service. WFMT exterior welds
- H5 WFMT nozzle attachment root pass
- H6 100% visual inspection of pass/stay plate welds
- H7 100% RT header box exterior welds; 100% UT nozzle attachment welds; 100% PT stay/pass plate welds
- H8 Hardness testing per API 661

**COATING NOTES (REF. SPEC-PP-000-500520-A)**

- C1 Headers: Paint tubsheet prior to hydro; remainder of header box (including welds) to be coated after hydrotest. When a split header design is used, the top or bottom of the split will be painted prior to hydro due to inaccessibility after hydro. Paint report required
- C2 Header System 5:  
Surface Prep: SSPC-SP1 / SSPC-SP10  
Coat 1: Inorganic CoPol/MultiPol (5.0-6.0 mil DFT)  
Coat 2: Inorganic CoPol/MultiPol (5.0-6.0 mil DFT)  
Final Color: RAL 7035 Light Gray
- C3 Non-fireproofed structural steel to be hot dipped galvanized per ABKM-PP-000-500540-A HDG repair per ASTM A760/A760M.
- C4 Damage to galvanize shall be repaired per ASTM A780/A780M, PIP STS05120 Para 4.7.4, ABKM-PP-000-500520-A
- C5 Air cooler short legs and spanning beams shall be fireproofed by others. Fabco shall provide surface preparation and primer for intumescent fireproofing per ABKM-PP-000-50520-A TABLE A-2, SYSTEM 4B. Structural steel that will be prepared for fireproofing shall not be galvanized.

**ASSEMBLY NOTES**

- A1 Tube-tubsheet joint:  
•Full strength weld joint type per UW-20 sketch (d). Joint efficiencies according to ASME Sec VIII Div 1 Table A-2, joint types e, f, g, or h  
•Single mockup provided for Tags 18-XF-350/18-XF-352A&B/18-XF-353A&B/18-XF-354. Hardness not to exceed 200 BHN  
•PT after each weld pass  
•Expansion rolled  
•Helium leak test required
- A2 Complete test erection of each bay
- A3 Fan shaft sling EDPM x 0.125" thk
- A4 Rotate motors up for shipment
- A5 Anirrotation device
- A6 Grounding lug per PIP VEFY1103

**BUNDLE/UNIT TESTING NOTES (REF. SPEC-PP-000-500730-A)**

- BU1 Hydrotest for 1 hour minimum with chart  
Shop run-in test (motor, drive and fan assembly for minimum 30 minutes), test includes the follows as a minimum:  
• Check fan tip clearance  
• Set fan pitch to design angle  
• Perform functioning test on assembled louvers with stops as required for loss of instrument air  
• Vibration levels shall be measured and reported  
• Noise emission levels shall be measured and reported  
Noise requirement 85 dBA overall. Noise test to include breakdown per octave and shall be measured at the centerline of the fan 3-ft below the inlet of the fan. Noise datasheet "A8KM-16-Noise DS" shall be completed with noise measurements. Where multiple bays are provided per tag, test is only required for one bay per design
- BU2
- BU3

**SHIPMENT PREP NOTES (REF. 4WGN-1000)**

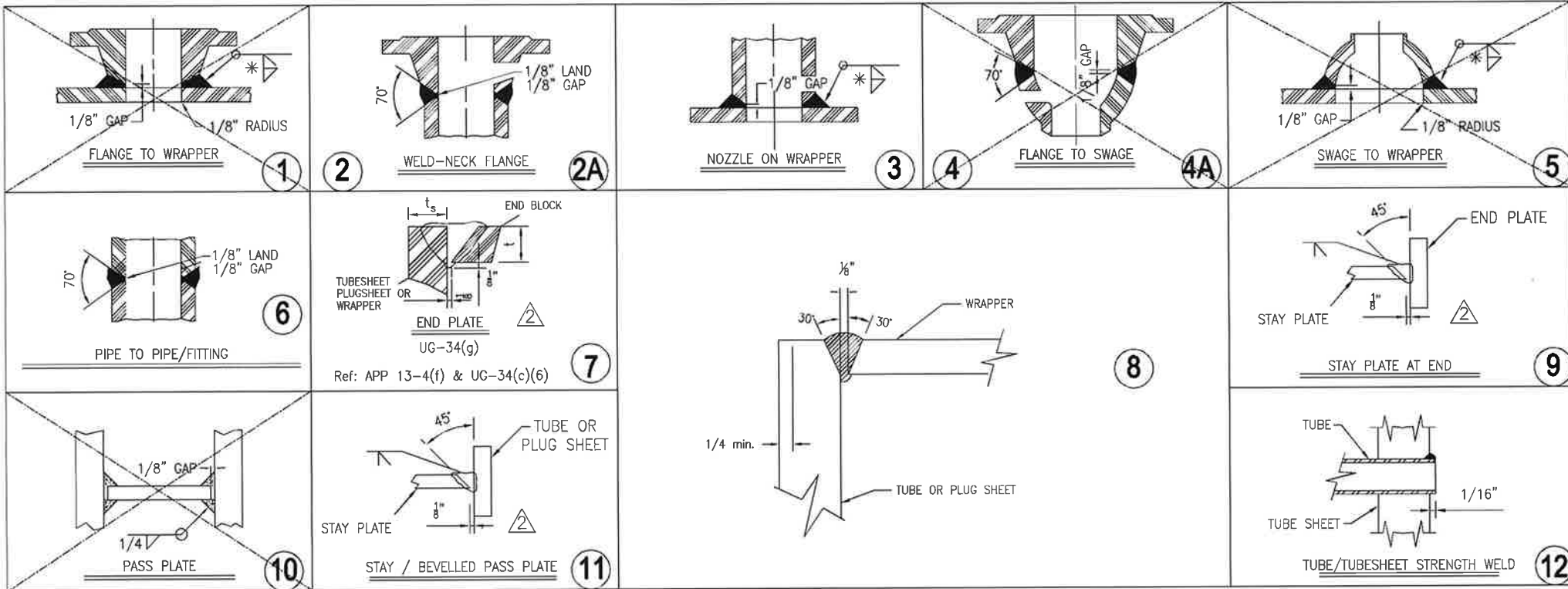
- SH1 10% spare plugs and gaskets to be packaged/sealed in waterproof container per Tag number  
Vacuum dry bundle to 1 Torr followed by nitrogen purge. Mark each connection "Warning: Contents Under Nitrogen Pressure". Pressure gauge should be protected to avoid damage during shipment, but still accessible. Process nozzles and auxiliary connections to be shipped with service gaskets
- SH2 Plywood cover over top of bundle. Timber per ISPM15
- SH3 Motors and vibration switches shall be shinnk wrapped and packed with desiccant
- SH4 All pieces shall be clearly marked with field erection mark number
- SH5 Ship loose bolt assemblies shall be packaged in weatherproof containers
- SH6 Supply documents certifying measured equipment weight along with crane calibration cert.
- SH7 Service/process gasket shipped separately.

REV	DATE	COMMENT	BY
02	02-09-2022	FOR APPROVAL	BH
01	3/15/23	UPDATED JOB NOTES	BH
01	8/18/23	UPDATED JOB NOTES	BH
01	10/25/23	UPDATED JOB NOTES	MS

DRAWING PROPRIETARY TO FABSCO FIN-AIR, LLC AND IS NOT TO BE RELEASED TO ANY THIRD PARTY, EXCEPT WITH NOTIFICATION AND APPROVAL IN WRITING OF FABSCO FIN-AIR, LLC OFFICER.

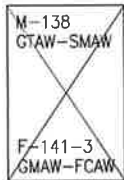
PROJECT NAME:	World Energy Renewables Project
PROJECT NO./UNIT:	EN-20-7119 / RFJU-B
CUSTOMER/CLIENT:	World Energy Paramount
EQUIPMENT OWNER:	Air Products Manufacturing LLC
ITEM NO.:	18-XF-354
SERVICE:	OFF SPEC PRODUCT COOLER
LOCATION:	World Energy, Paramount, CA, USA
PO NO.:	4505686036 / A8KM-4-406-PO-1
FABSCO JOB NO.:	A22-13312-6A

DRAWN BY:	BH	<b>FABSCO</b> Fin-Air, LLC.
DATE:	02-03-2022	
CHECKED BY:		COIL: <b>PROJECT NOTES</b>  DRAWING NO: <b>A22-13312-6A-NOTES</b>
		REV: <b>3</b>



JOINT DESIGNATION

APPLICABLE PROCEDURES:



M-138  
GTAW-SMAW

M-101-1  
GTAW

F-148-2  
FCAW

2A  
SEE NOTE 4

A-352  
SMAW-SAW

M-101-1  
GTAW

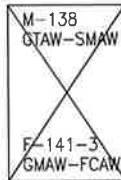
F-148-2  
FCAW

M-138  
GTAW-SMAW

M-138  
GTAW-SMAW

M-101-1  
GTAW

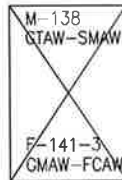
F-148-2  
FCAW



M-138  
GTAW-SMAW

M-101-1  
GTAW

F-141-3  
GMAW-FCAW



M-138  
GTAW-SMAW

M-101-1  
GTAW

F-141-3  
GMAW-FCAW

M-138  
GTAW-SMAW

M-101-1  
GTAW

F-148-2  
FCAW

M-138  
GTAW-SMAW

M-101-1  
GTAW

F-148-2  
FCAW

A-352  
SMAW-SAW

M-101-1  
GTAW

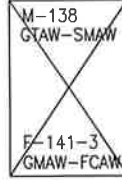
F-148-2  
FCAW

M-138  
GTAW-SMAW

M-138  
GTAW-SMAW

M-101-1  
GTAW

F-148-2  
FCAW



M-138  
GTAW-SMAW

M-101-1  
GTAW

F-141-3  
GMAW-FCAW

M-138  
GTAW-SMAW

M-101-1  
GTAW

F-148-2  
FCAW

T-300  
GTAW

NOTES:

- ALL WELDING TO BE IN ACCORDANCE WITH ASME CODE ( SECTION IX )
- GRIND ALL INTERNAL NOZZLE WELDS SMOOTH.
- ALL FILLET WELDS 3/8"(MIN.) - UNLESS OTHERWISE SPECIFIED ON DETAILS
- 2A, 4A ONLY APPLIES TO PIPE, SWAGE DIAM. 6" AND LARGER

A.S.M.E. CODE WELD MAP - 18-XF-354  
CARBON - HEAT TREATED

PROJECT NAME:	World Energy Renewables Project
PROJECT NO./UNIT:	EN-20-7119 / RFJU-B
CUSTOMER/CLIENT:	World Energy Paramount
EQUIPMENT OWNER:	Air Products Manufacturing LLC
ITEM NO.:	18-XF-354
SERVICE:	Off Spec Product Cooler
LOCATION:	World Energy, Paramount, CA, USA
PO NO.:	4505606036 / A8KM-4-406-PO-1
FABSCO JOB NO.:	A22-13312-6

REV.	DATE	DESCRIPTION
0	3/8/22	FOR APPROVAL
1	4/19/22	CORR WELD PROCEDURES & ADDED TITLE BLOCK
2	9/8/22	MOD BLKS 7,9,11, ADD T-300

DWG. BY:  
BMH

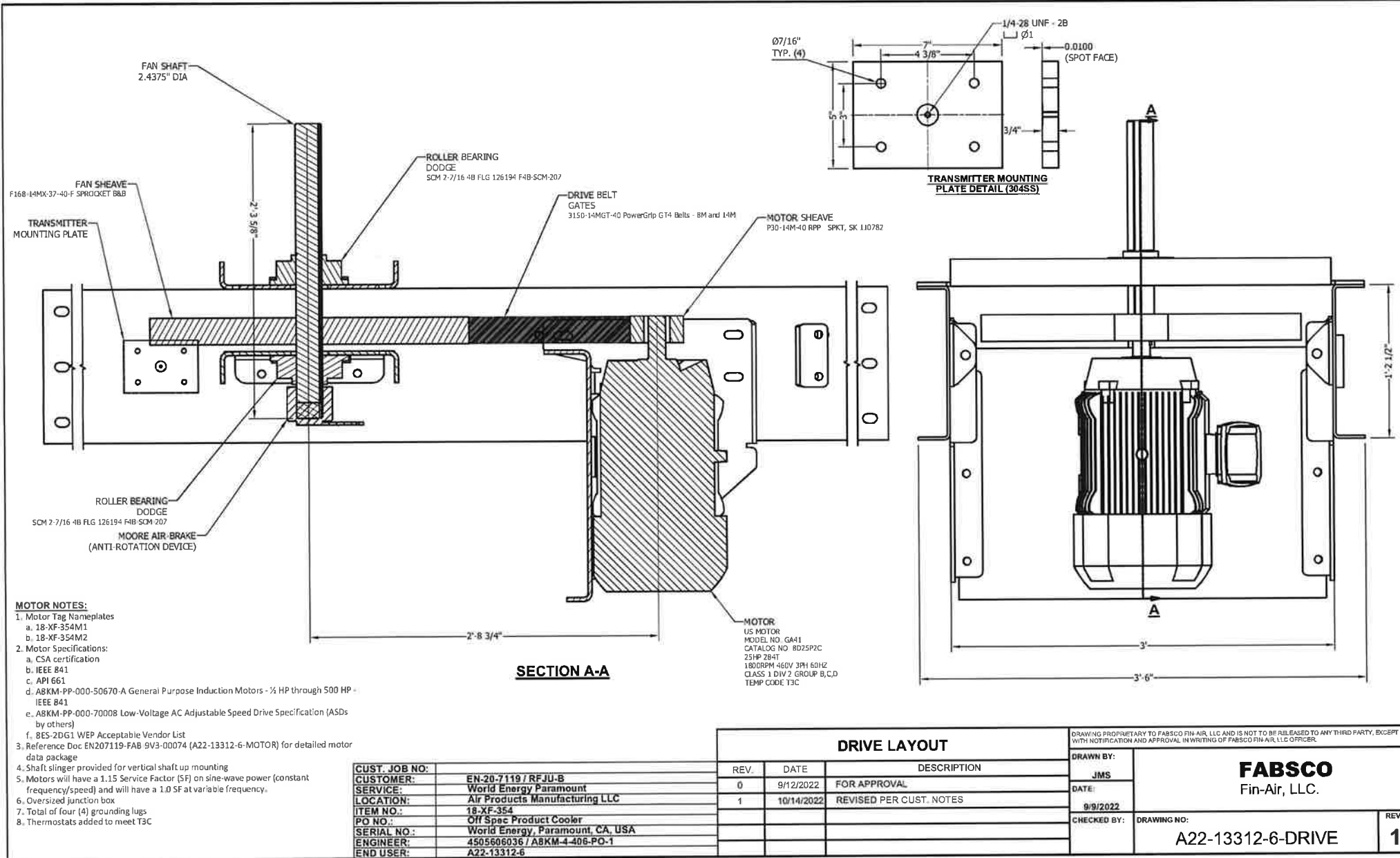
DATE:  
3/8/2022

CHK'D BY:

**Fabsco**

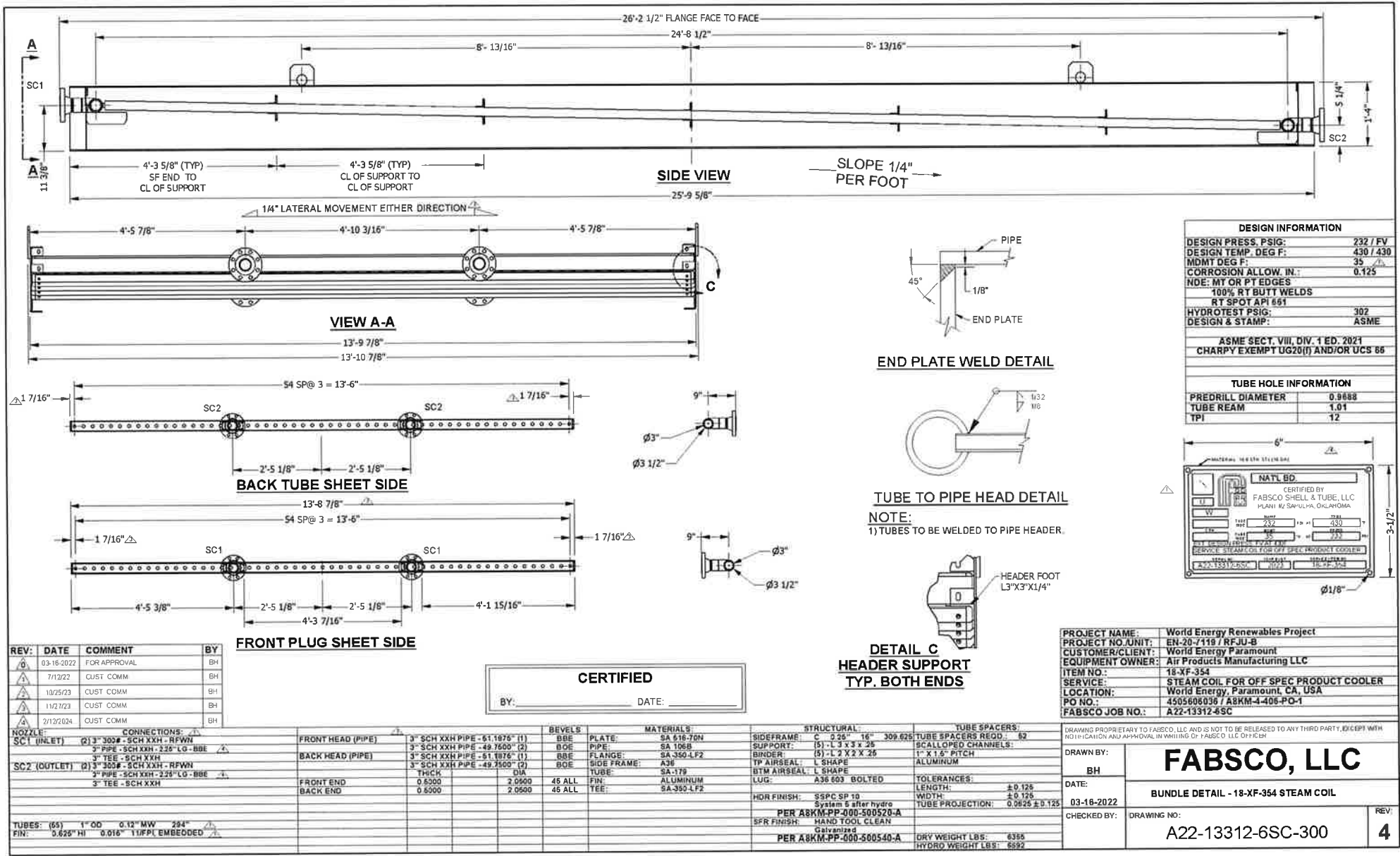
DRAWING NO.:  
A22-13312-6 WM HT

REV.  
2



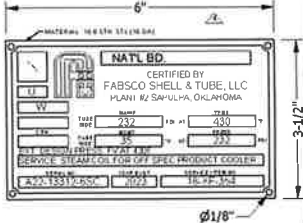
<b>CUST. JOB NO:</b>	EN-20-7119 / RFJU-B
<b>CUSTOMER:</b>	World Energy Paramount
<b>SERVICE:</b>	Air Products Manufacturing LLC
<b>LOCATION:</b>	18-XF-354
<b>ITEM NO.:</b>	Off Spec Product Cooler
<b>PO NO.:</b>	World Energy, Paramount, CA, USA
<b>SERIAL NO.:</b>	4505606036 / ABKM-4-406-PO-1
<b>ENGINEER:</b>	A22-13312-6
<b>END USER:</b>	

DRAWING PROPRIETARY TO FABSCO FIN-AIR, LLC AND IS NOT TO BE RELEASED TO ANY THIRD PARTY, EXCEPT WITH NOTIFICATION AND APPROVAL IN WRITING OF FABSCO FIN-AIR, LLC OFFICER.	
<b>DRAWN BY:</b>	<b>FABSCO</b> Fin-Air, LLC.
<b>JMS</b>	
<b>DATE:</b>	
<b>9/9/2022</b>	
<b>CHECKED BY:</b>	<b>DRAWING NO:</b>
	A22-13312-6-DRIVE
<b>REV:</b>	<b>1</b>



DESIGN INFORMATION	
DESIGN PRESS. PSIG:	232 / FV
DESIGN TEMP. DEG F:	430 / 430
MDMT DEG F:	35
CORROSION ALLOW. IN.:	0.125
NDE: MT OR PT EDGES	
100% RT BUTT WELDS	
RT SPOT API 661	
HYDROTEST PSIG:	302
DESIGN & STAMP:	ASME
ASME SECT. VIII, DIV. 1 ED. 2021	
CHARPY EXEMPT UG20(I) AND/OR UCS 85	

TUBE HOLE INFORMATION	
PREDRILL DIAMETER	0.9688
TUBE REAM	1.01
TPI	12



PROJECT NAME:	World Energy Renewables Project
PROJECT NO./UNIT:	EN-20-7119 / RFJU-B
CUSTOMER/CLIENT:	World Energy Paramount
EQUIPMENT OWNER:	Air Products Manufacturing LLC
ITEM NO.:	18-XF-354
SERVICE:	STEAM COIL FOR OFF SPEC PRODUCT COOLER
LOCATION:	World Energy, Paramount, CA, USA
PO NO.:	4505606036 / A8KM-4-406-PO-1
FABSCO JOB NO.:	A22-13312-6SC

REV:	DATE	COMMENT	BY
0	03-16-2022	FOR APPROVAL	BH
1	7/1/22	CUST. COMM.	BH
2	10/25/23	CUST COMM.	BH
3	11/2/23	CUST COMM.	BH
4	2/12/2024	CUST COMM.	BH

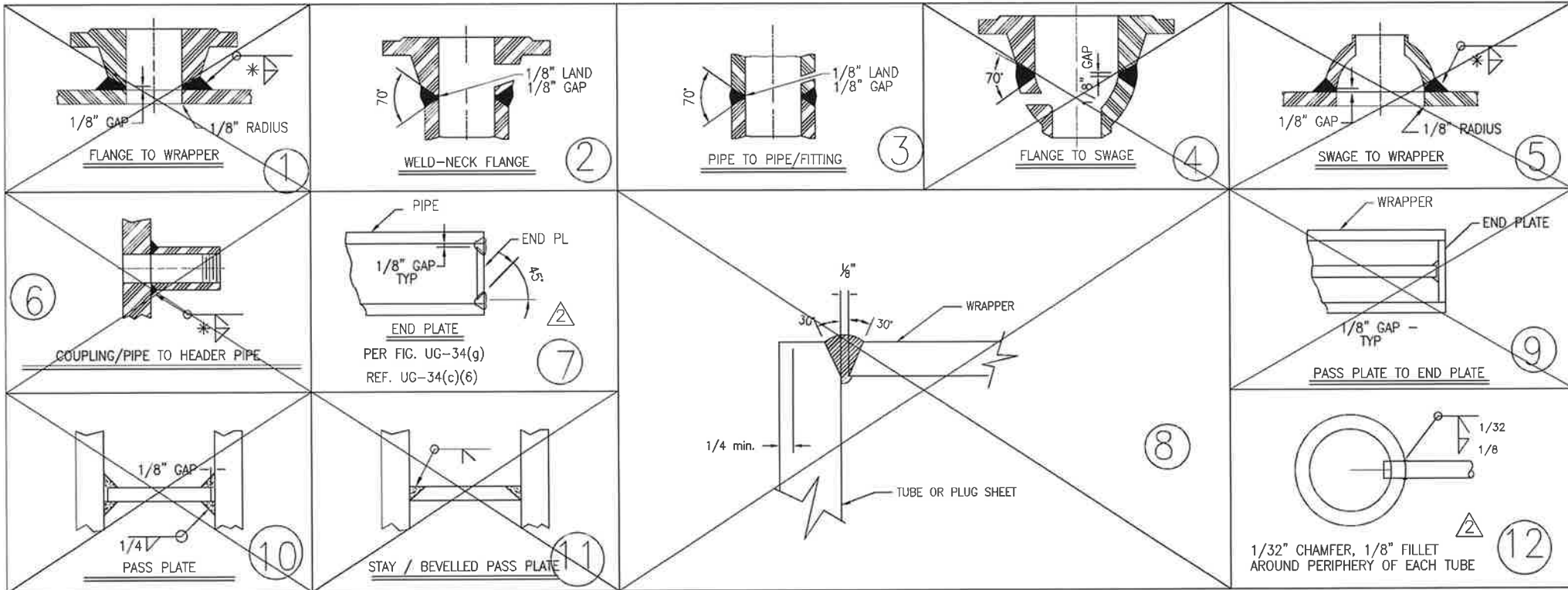
NOZZLE:	CONNECTIONS:	FRONT HEAD (PIPE)	BACK HEAD (PIPE)	FRONT END	BACK END
SC1 (INLET)	3" SCH XXH - SCH XXH - RFWN	3" SCH XXH PIPE - 51.1875" (1)	3" SCH XXH PIPE - 49.7600" (2)	0.6300	2.0900
SC2 (OUTLET)	3" TEE - SCH XXH 3" PIPE - SCH XXH - 325" LG - BBE 3" TEE - SCH XXH	3" SCH XXH PIPE - 51.1875" (1)	3" SCH XXH PIPE - 49.7500" (2)	0.6300	2.0900

BEVELS:	MATERIALS:	STRUCTURAL:	TUBE SPACERS:
PLATE: SA 516-70N	PIPE: SA 106B	SIDEFRAME: C 0.25" 16" 309.625	TUBE SPACERS RECD.: 52
FLANGE: SA 350-LF2	PIPE: SA 106B	SUPPORT: (5) - L 3 X 3 X 25	SCALLOPED CHANNELS:
SIDE FRAME: A36	FLANGE: SA 350-LF2	BINDER: (5) - L 2 X 2 X 25	1" X 1.5" PITCH
TUBE: SA-119	SIDE FRAME: A36	TP AIRSEAL: L SHAPE	ALUMINUM
FIN: ALUMINUM	TUBE: SA-119	BTM AIRSEAL: L SHAPE	
TEE: SA-350-LF2	FIN: ALUMINUM	LUG: A36 603 BOLTED	

HDR FINISH:	SFR FINISH:	DRY WEIGHT LBS:	HYDRO WEIGHT LBS:
SSPC SP 10	Hand Tool Clean	6366	6692
System 5 after hydro			
PER A8KM-PP-000-500520-A			
PER A8KM-PP-000-500540-A			

DRAWN BY:	BH	<b>FABSCO, LLC</b>	REV: 4
DATE:	03-16-2022		
CHECKED BY:		BUNDLE DETAIL - 18-XF-354 STEAM COIL	
		A22-13312-6SC-300	

**CERTIFIED**  
BY: \_\_\_\_\_ DATE: \_\_\_\_\_



JOINT DESIGNATION

APPLICABLE PROCEDURES:

1	2	3	4	5	6	7	8	9	10	11	12
<del>M-138 GTAW-SMAW</del> <del>M-125 GMAW-SMAW</del> <del>F-141-3 GMAW-FCAW</del>	M-101-1 GTAW	M-101-1 GTAW	<del>M-138 GTAW-SMAW</del> <del>M-125 GMAW-SMAW</del> <del>F-141-3 GMAW-FCAW</del>	<del>M-125 GMAW-SMAW</del> <del>F-141-3 GMAW-FCAW</del>	M-101-1 GTAW	M-101-1 GTAW	<del>A-352 SAW</del> <del>M-114 SMAW</del> <del>F-141-3 GMAW-FCAW</del>	M-138	M-138	M-138	M-101-1 GTAW
	F-148-2 FCAW	F-148-2 FCAW			F-148-2 FCAW	F-148-2 FCAW		M-125 GMAW-SMAW	M-125 GMAW-SMAW	M-125 GMAW-SMAW	

NOTES:

- ALL WELDING TO BE IN ACCORDANCE WITH ASME CODE ( SECTION IX )
- GRIND ALL INTERNAL NOZZLE WELDS SMOOTH.
- \* ALL FILLET WELDS 3/8"(MIN.) - UNLESS OTHERWISE SPECIFIED ON DETAILS

PROJECT NAME:	World Energy Renewables Project
PROJECT NO./UNIT:	EN-20-7119 / RFJU-B
CUSTOMER/CLIENT:	World Energy Paramount
EQUIPMENT OWNER:	Air Products Manufacturing LLC
ITEM NO.:	18-XF-354 Steam Coil
SERVICE:	World Energy, Paramount, CA, USA
LOCATION:	4505606039 / A8KM-4-406-PO-1
PO NO.:	
FABSCO JOB NO.:	A22-13312-6

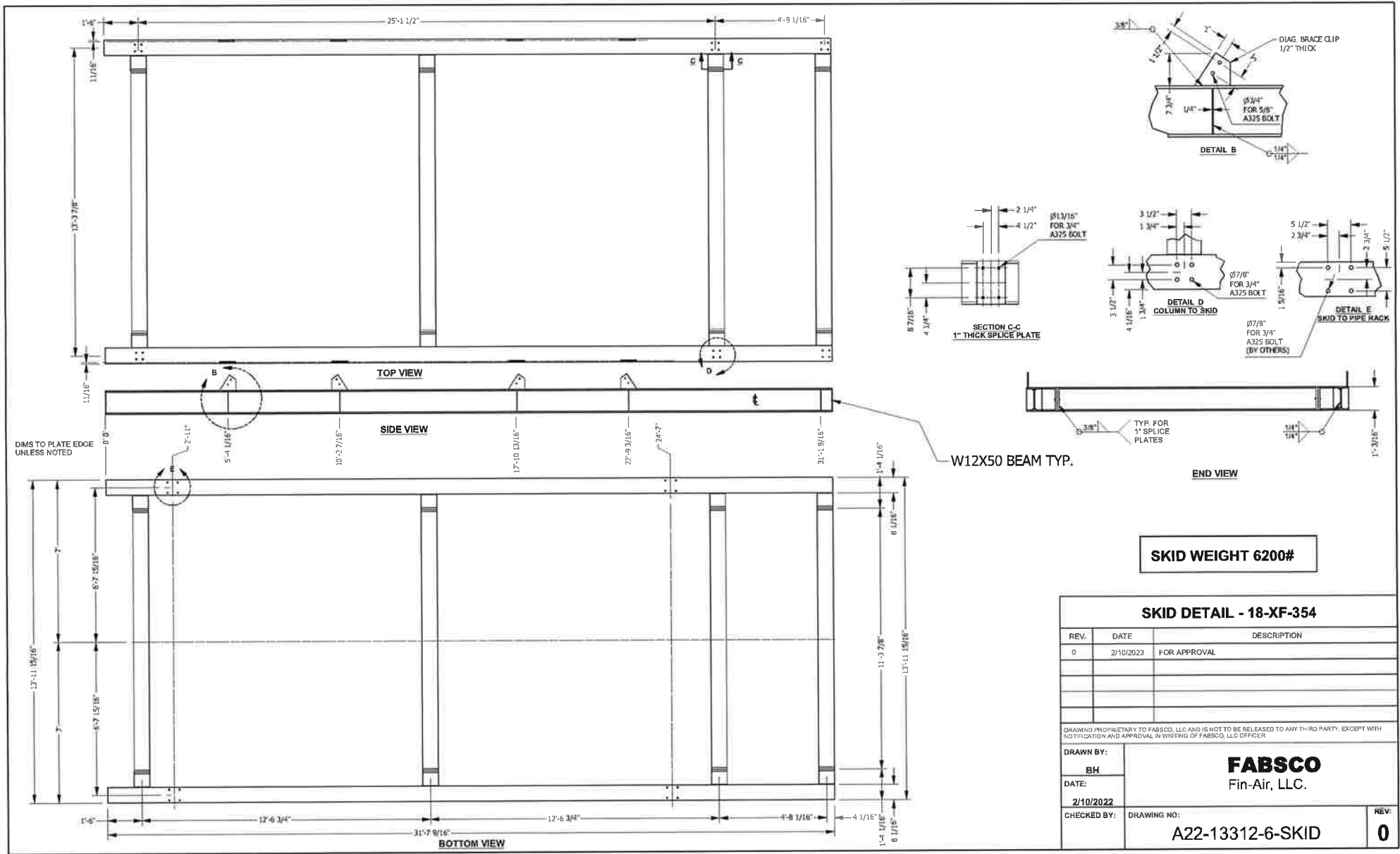
A.S.M.E. CODE WELD MAP - 18-XF-354  
CARBON - HEAT TREATED

REV.	DATE	DESCRIPTION
0	4/19/22	FOR APPROVAL
1	6/6/22	REVISED TAG BLOCK
2	9/8/22	ADD DESCRIPTION TO BLOCK 12, NOTE BLK 7

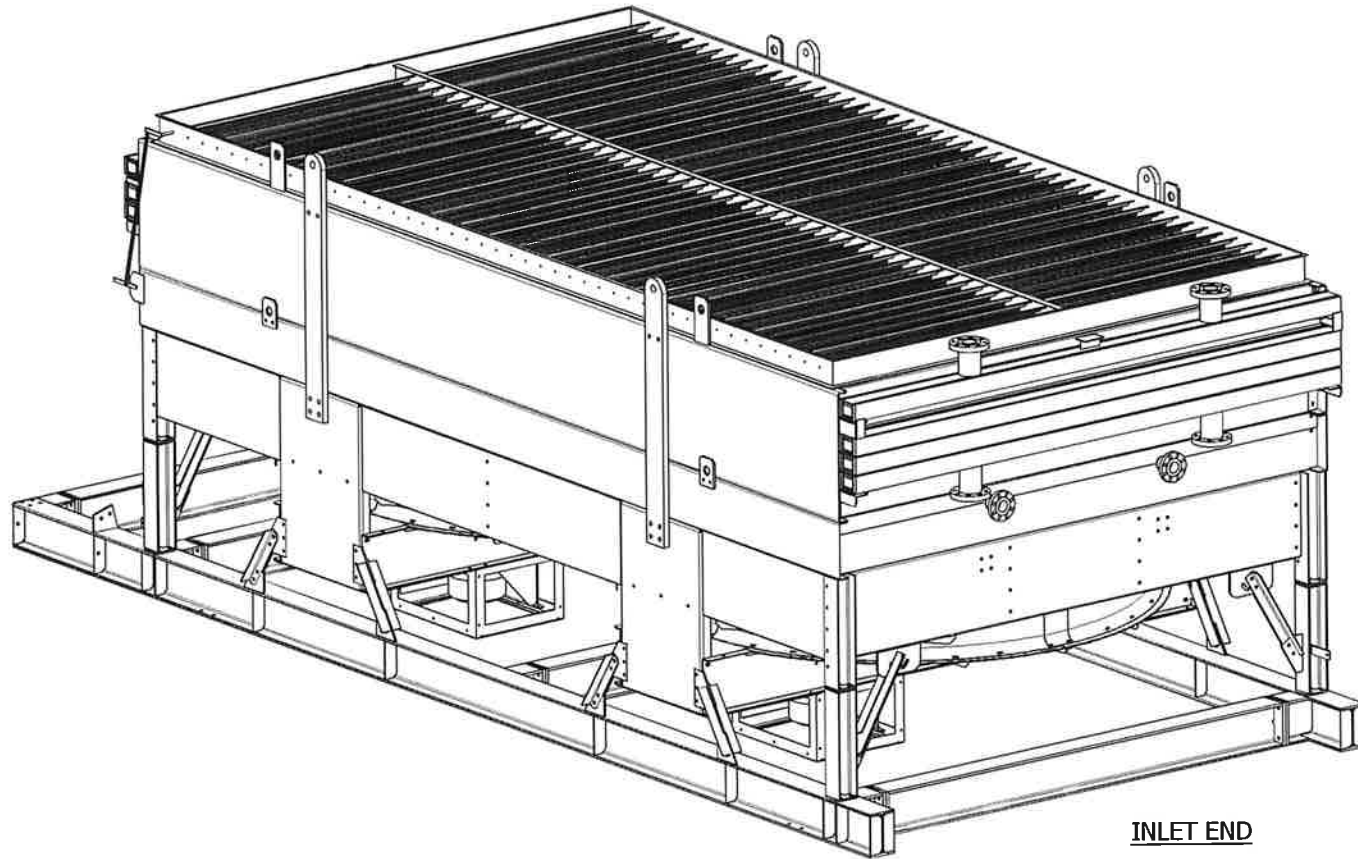
DWG. BY:  
CN  
DATE:  
8/16/12  
CHK'D BY:  
CN

**Fabsco**

DRAWING NO.: A22-13312-6-SC-W HT  
REV. 2



# FIELD ASSEMBLY 1



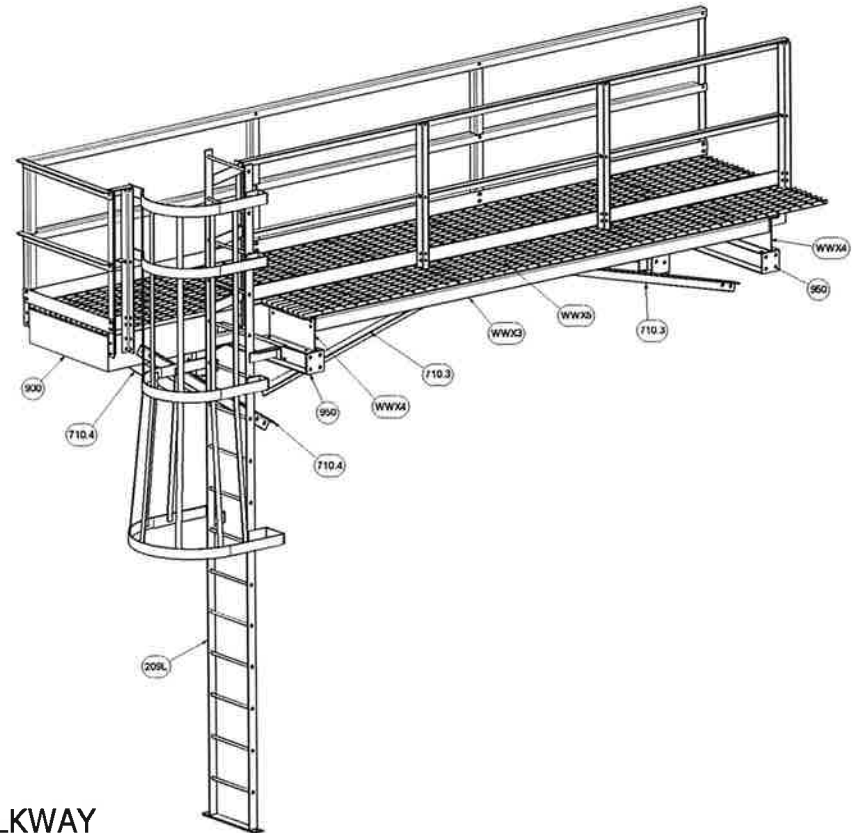
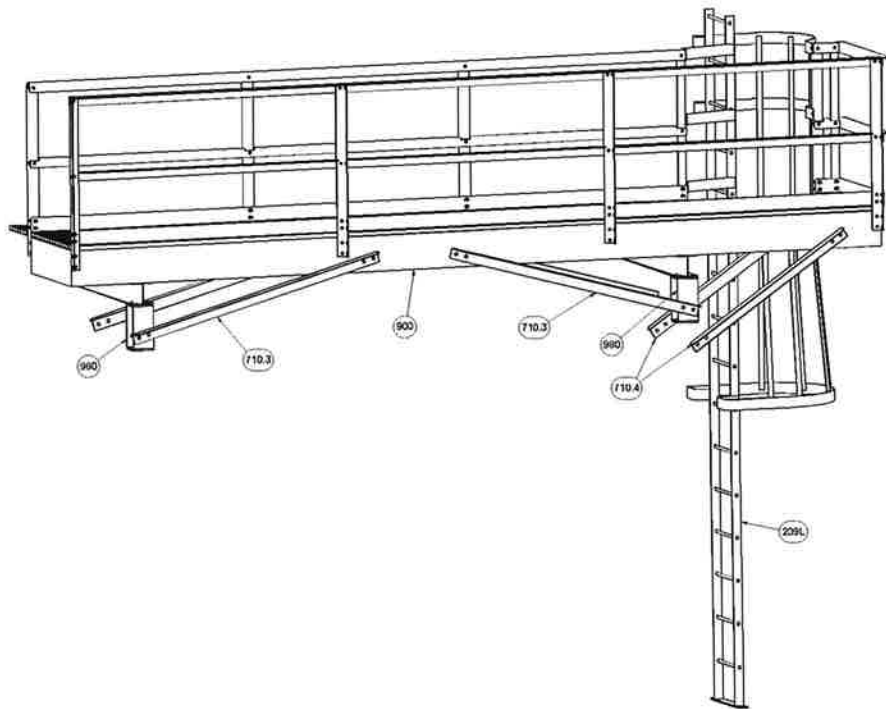
INLET END

**NOTE:**

1. USE 3/4" X 2-1/4" A-325 BOLT, LOCKNUT & (2) FLATWASHERS AT ALL COLUMN CONNECTIONS.
2. USE 5/8" X 1-3/4" A-325 BOLT, LOCKNUT & (2) FLATWASHERS AT ALL WALKWAY CONNECTIONS.

JOB NUMBER: <b>A22-13312-6</b>	
<small>DRAWING PROPRIETARY TO FABSCO, LLC AND IS NOT TO BE RELEASED TO ANY THIRD PARTY, EXCEPT WITH NO INDICATION AND APPROVAL BY WRITING OF FABSCO, LLC OR HCBH</small>	
DRAWN BY: JH	<b>FABSCO, LLC</b>
DATE: 4/19/24	DESCRIPTION: FEILD ASSEMBLY 1
CHECKED BY: JH	DRAWING NO: <b>FA1</b>
	REV: <b>0</b>

## FIELD ASSEMBLY 2



900 WALKWAY

**NOTE:**

1. USE 3/4" X 2-1/4" A-325 BOLT, LOCKNUT & (2) FLATWASHERS AT ALL SUPPORT CONNECTIONS.
2. USE 5/8" X 1-3/4" A-325 BOLT, LOCKNUT & (2) FLATWASHERS AT ALL WALKWAY CONNECTIONS.

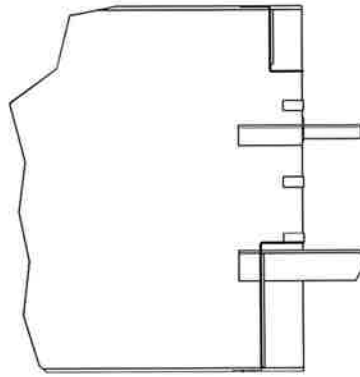
JOB NUMBER: <b>A22-13312-6</b>	
DRAWING PROPRIETARY TO FABSCO, LLC AND IS NOT TO BE RELEASED TO ANY THIRD PARTY, EXCEPT WITH NO ITI CALIFORNIA APPROVAL IN WRITING OF FABSCO, LLC OFFICER	
DRAWN BY: JH	<b>FABSCO, LLC</b>
DATE: 4/19/24	DESCRIPTION: FEILD ASSEMBLY 2
CHECKED BY: JH	DRAWING NO: <b>FA2</b>
	REV: <b>0</b>

*DETAIL PRINT SET FOR:*

**A22-13312-6**

**NDE**

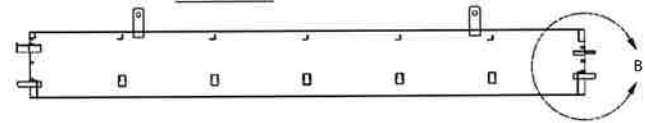
8 | 7 | 6 | 5 | 4 | 3 | 2 | 1



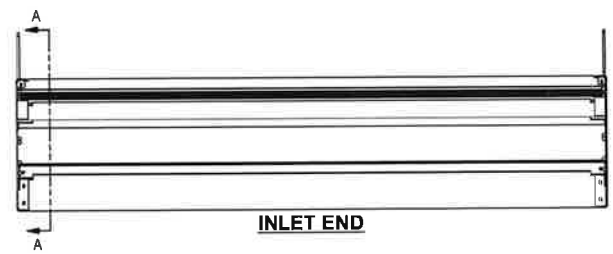
**NOTE: ALL AIR SEALS MOUNT BEHIND CLIPS**

5% MT OF ALL CLIP WELDS

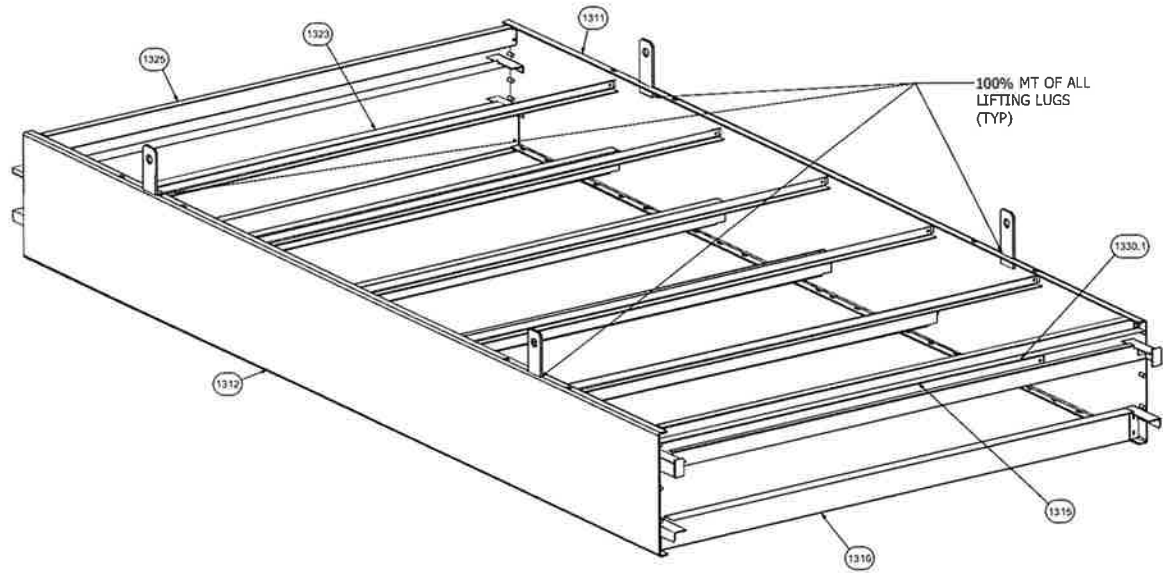
**DETAIL B**



**SECTION A-A**

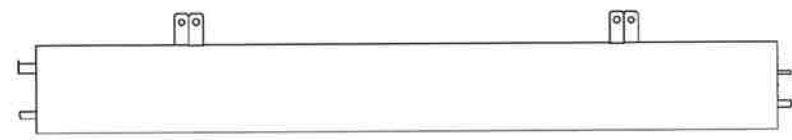


**INLET END**



100% MT OF ALL LIFTING LUGS (TYP)

**INLET END**



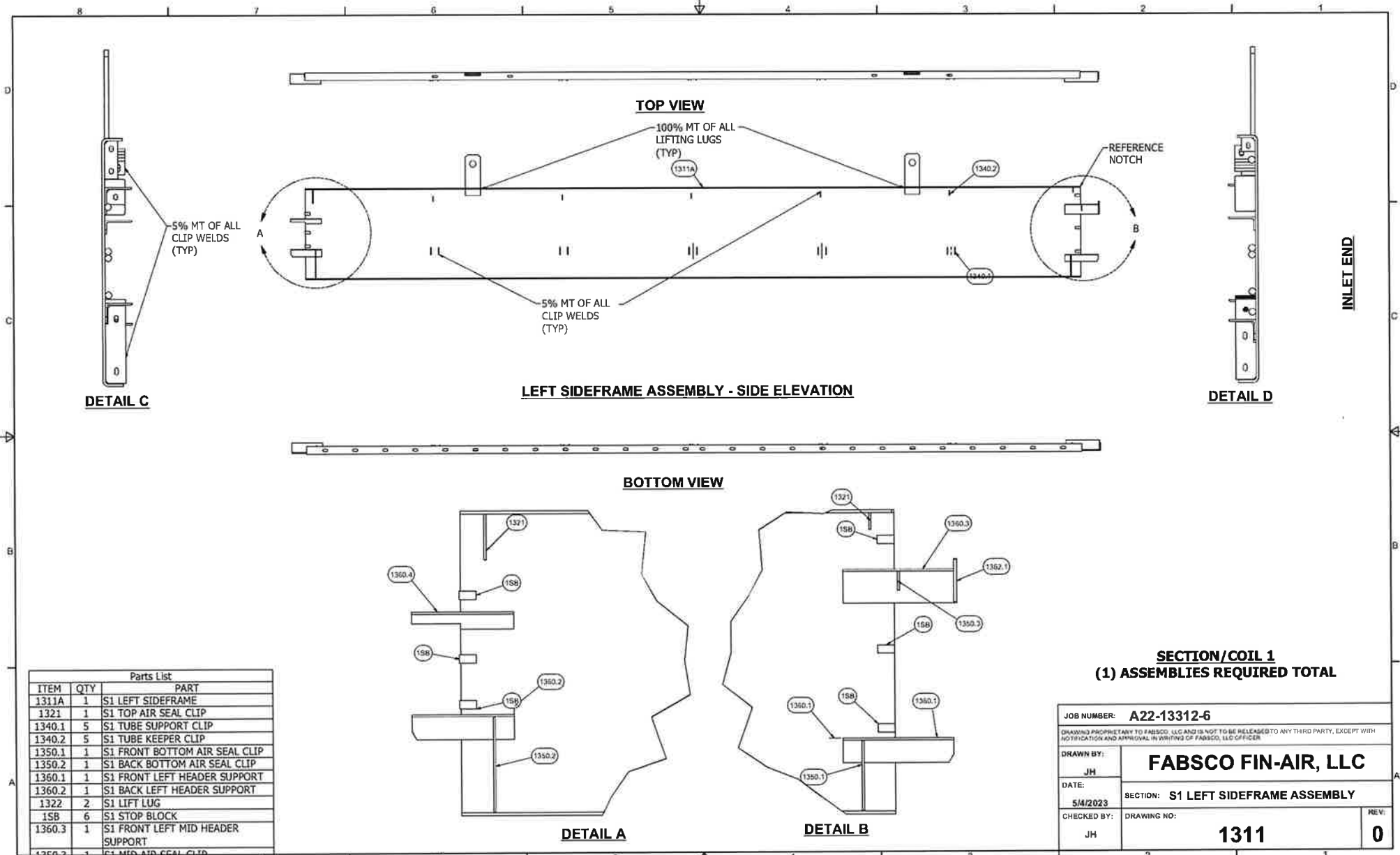
**SIDE VIEW**

Parts List		
ITEM	QTY	PART NUMBER
1315	1	S1 Top Air Seal
1316	1	S1 FRONT BOTTOM AIR SEAL
1323	1	S1 BACK BOTTOM AIR SEAL
1325	1	S1 Top Air Seal v2
1330.1	5	S1 TUBE SUPPORT
1311	1	S1 LEFT SIDEFRAME ASSEMBLY
1312	1	S1 RIGHT SIDEFRAME ASSEMBLY
1318	1	S1 Front Mid Air Seal
BTSA3	1	TUBESPACER 3
FTS5	1	TUBESPACER 5
1330.2	5	S1 SM Keeper

**SECTION/COIL 1  
(1) ASSEMBLIES REQUIRED TOTAL**

JOB NUMBER: <b>A22-13312-6</b>	
<small>DRAWING PROPRIETARY TO FABSCO, LLC AND IS NOT TO BE RELEASED TO ANY THIRD PARTY, EXCEPT WITH NOTIFICATION AND APPROVAL IN WRITING OF FABSCO, LLC OR DER.</small>	
DRAWN BY: JH	<b>FABSCO FIN-AIR, LLC</b>
DATE: 5/4/2023	SECTION: <b>S1 SIDEFRAME ASSEMBLY</b>
CHECKED BY: JH	DRAWING NO: <b>1310</b>
	REV: <b>0</b>

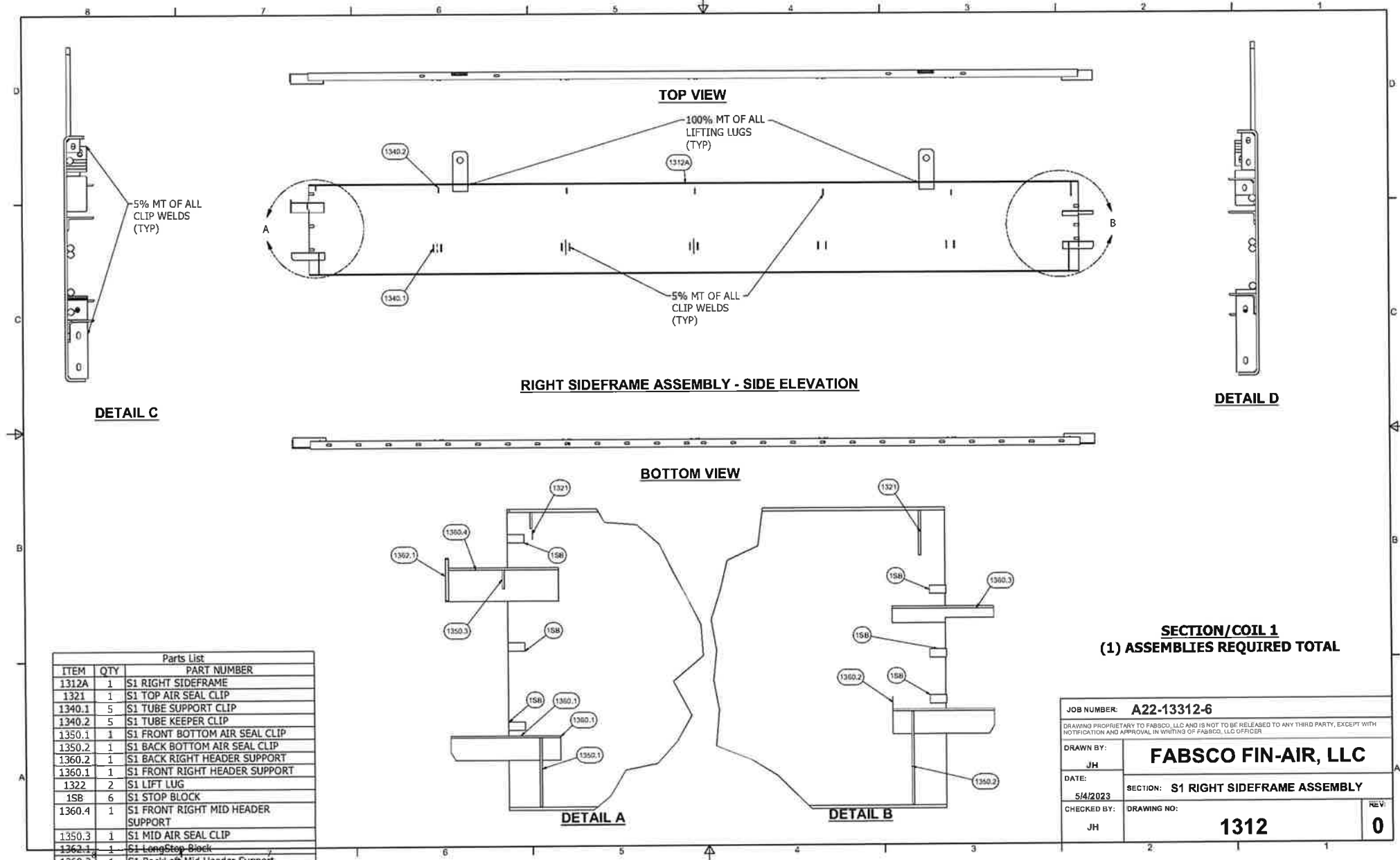
8 | 7 | 6 | 5 | 4 | 3 | 2 | 1



Parts List		
ITEM	QTY	PART
1311A	1	S1 LEFT SIDEFRAE
1321	1	S1 TOP AIR SEAL CLIP
1340.1	5	S1 TUBE SUPPORT CLIP
1340.2	5	S1 TUBE KEEPER CLIP
1350.1	1	S1 FRONT BOTTOM AIR SEAL CLIP
1350.2	1	S1 BACK BOTTOM AIR SEAL CLIP
1360.1	1	S1 FRONT LEFT HEADER SUPPORT
1360.2	1	S1 BACK LEFT HEADER SUPPORT
1322	2	S1 LIFT LUG
15B	6	S1 STOP BLOCK
1360.3	1	S1 FRONT LEFT MID HEADER SUPPORT
1360.4	1	S1 BACK RIGHT MID HEADER SUPPORT
1321	1	Front Upper Air Seal Clip

**SECTION/COIL 1  
(1) ASSEMBLIES REQUIRED TOTAL**

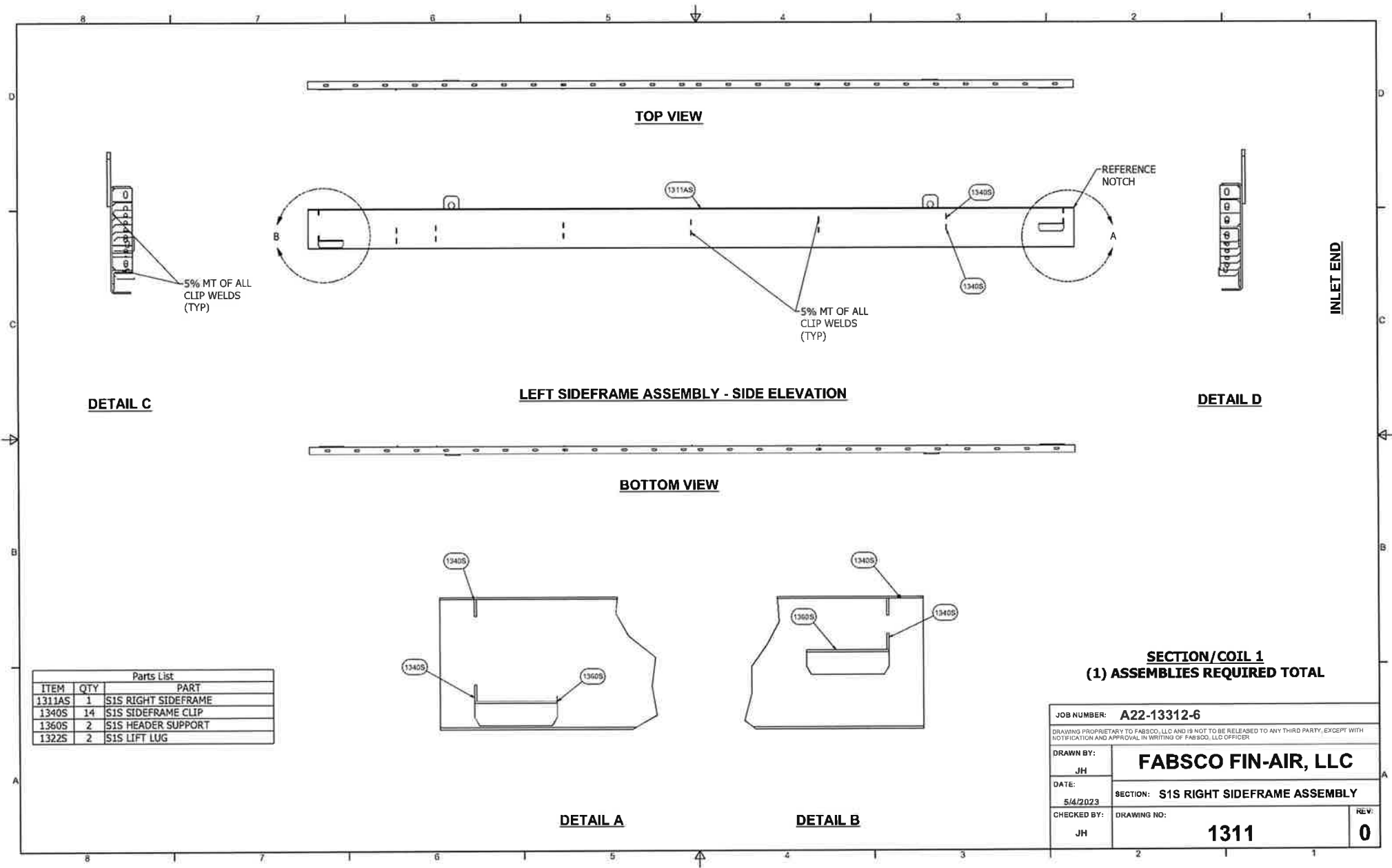
JOB NUMBER: <b>A22-13312-6</b>	
DRAWING PROPRIETARY TO FABSCO, LLC AND IS NOT TO BE RELEASED TO ANY THIRD PARTY, EXCEPT WITH NOTIFICATION AND APPROVAL IN WRITING OF FABSCO, LLC OFFICER	
DRAWN BY: JH	<b>FABSCO FIN-AIR, LLC</b>
DATE: 5/4/2023	SECTION: <b>S1 LEFT SIDEFRAE ASSEMBLY</b>
CHECKED BY: JH	DRAWING NO: <b>1311</b>
	REV: <b>0</b>



**SECTION/COIL 1  
(1) ASSEMBLIES REQUIRED TOTAL**

Parts List		
ITEM	QTY	PART NUMBER
1312A	1	S1 RIGHT SIDEFAME
1321	1	S1 TOP AIR SEAL CLIP
1340.1	5	S1 TUBE SUPPORT CLIP
1340.2	5	S1 TUBE KEEPER CLIP
1350.1	1	S1 FRONT BOTTOM AIR SEAL CLIP
1350.2	1	S1 BACK BOTTOM AIR SEAL CLIP
1360.2	1	S1 BACK RIGHT HEADER SUPPORT
1360.1	1	S1 FRONT RIGHT HEADER SUPPORT
1322	2	S1 LIFT LUG
15B	6	S1 STOP BLOCK
1360.4	1	S1 FRONT RIGHT MID HEADER SUPPORT
1350.3	1	S1 MID AIR SEAL CLIP
1362.1	1	S1 Long Stop Block
1360.3	1	S1 BackLeft Mid Header Support
1321	1	Front Upper Air Seal Clip

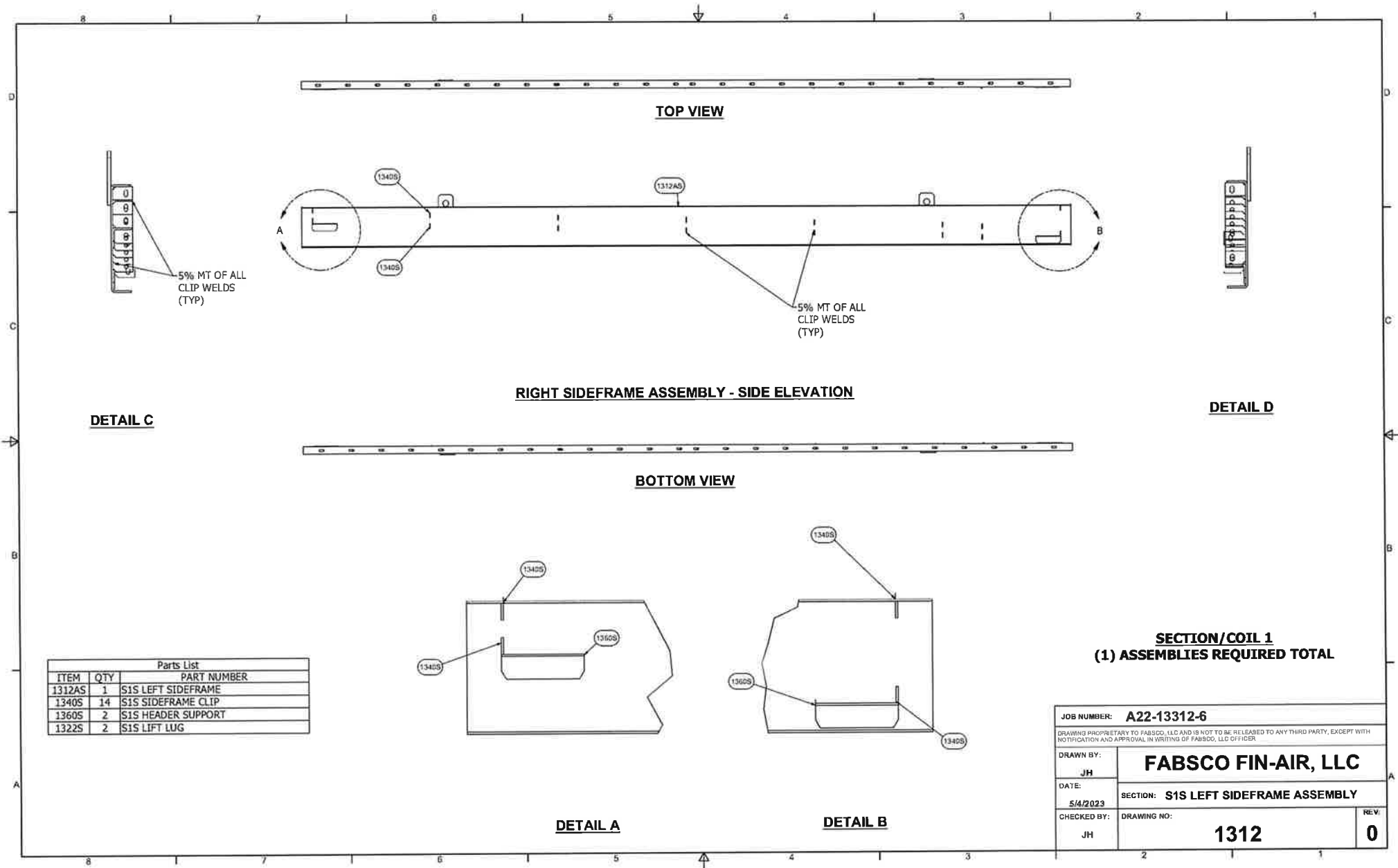
JOB NUMBER: <b>A22-13312-6</b>	
DRAWING PROPRIETARY TO FABSCO, LLC AND IS NOT TO BE RELEASED TO ANY THIRD PARTY, EXCEPT WITH NOTIFICATION AND APPROVAL IN WRITING OF FABSCO, LLC OFFICER	
DRAWN BY: JH	<b>FABSCO FIN-AIR, LLC</b>
DATE: 5/4/2023	SECTION: <b>S1 RIGHT SIDEFAME ASSEMBLY</b>
CHECKED BY: JH	DRAWING NO: <b>1312</b>
	REV: <b>0</b>



Parts List		
ITEM	QTY	PART
1311AS	1	S1S RIGHT SIDEFRAE
1340S	14	S1S SIDEFRAE CLIP
1360S	2	S1S HEADER SUPPORT
1322S	2	S1S LIFT LUG

**SECTION/COIL 1  
(1) ASSEMBLIES REQUIRED TOTAL**

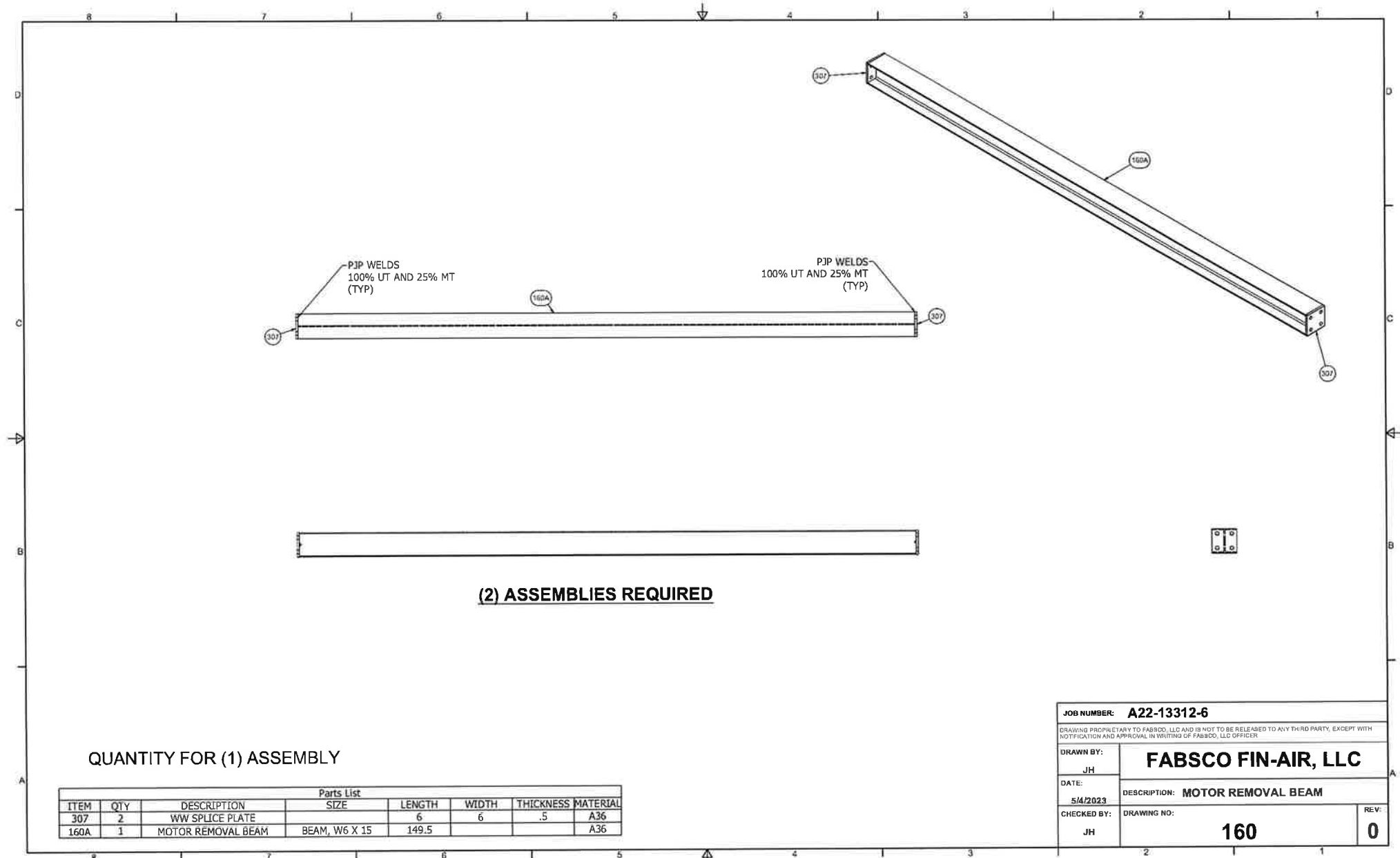
JOB NUMBER: <b>A22-13312-6</b>	
DRAWING PROPRIETARY TO FABSCO, LLC AND IS NOT TO BE RELEASED TO ANY THIRD PARTY, EXCEPT WITH NOTIFICATION AND APPROVAL IN WRITING OF FABSCO, LLC OFFICER	
DRAWN BY: JH	<b>FABSCO FIN-AIR, LLC</b>
DATE: 5/4/2023	SECTION: <b>S1S RIGHT SIDEFRAE ASSEMBLY</b>
CHECKED BY: JH	DRAWING NO: <b>1311</b>
	REV: <b>0</b>



Parts List		
ITEM	QTY	PART NUMBER
1312AS	1	S1S LEFT SIDEFRAME
1340S	14	S1S SIDEFRAME CLIP
1360S	2	S1S HEADER SUPPORT
1322S	2	S1S LIFT LUG

**SECTION/COIL 1**  
**(1) ASSEMBLIES REQUIRED TOTAL**

JOB NUMBER: <b>A22-13312-6</b>		
DRAWING PROPRIETARY TO FABSCO, LLC AND IS NOT TO BE RELEASED TO ANY THIRD PARTY, EXCEPT WITH NOTIFICATION AND APPROVAL IN WRITING OF FABSCO, LLC OFFICER		
DRAWN BY: <b>JH</b>	<b>FABSCO FIN-AIR, LLC</b>	
DATE: <b>5/4/2023</b>	SECTION: <b>S1S LEFT SIDEFRAME ASSEMBLY</b>	
CHECKED BY: <b>JH</b>	DRAWING NO: <b>1312</b>	REV: <b>0</b>

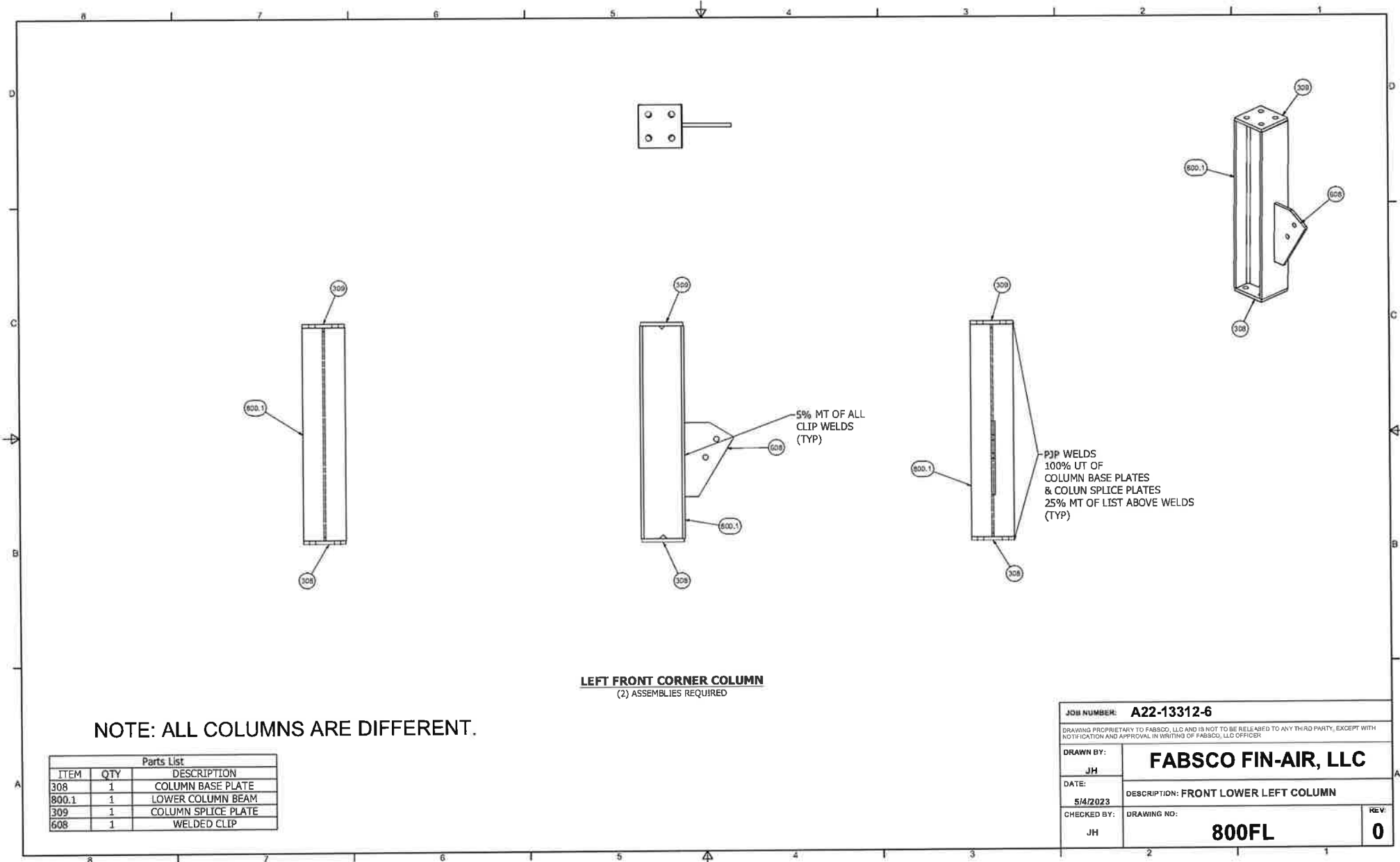


**(2) ASSEMBLIES REQUIRED**

**QUANTITY FOR (1) ASSEMBLY**

Parts List							
ITEM	QTY	DESCRIPTION	SIZE	LENGTH	WIDTH	THICKNESS	MATERIAL
307	2	WW SPLICE PLATE		6	6	.5	A36
160A	1	MOTOR REMOVAL BEAM	BEAM, W6 X 15	149.5			A36

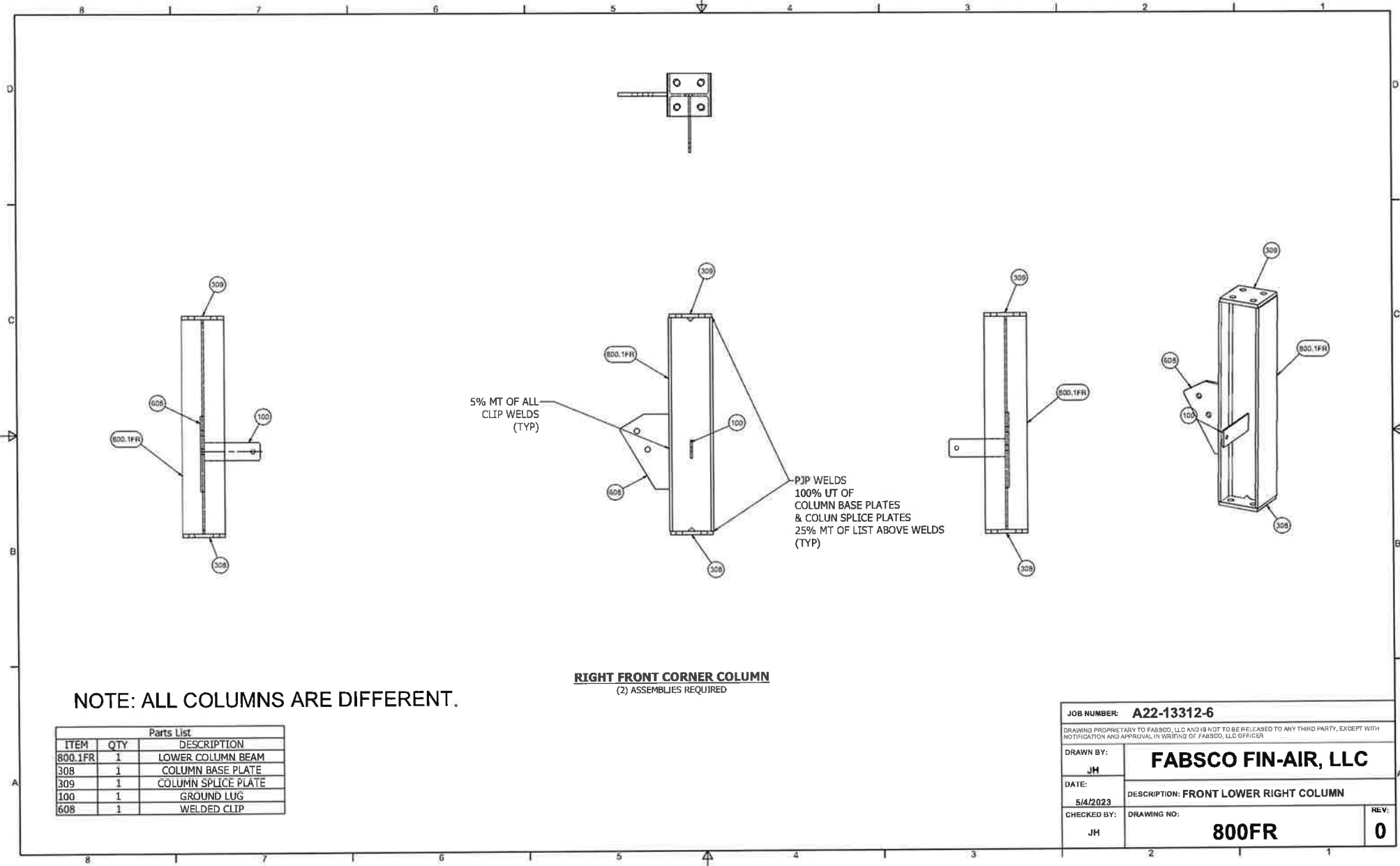
<b>JOB NUMBER: A22-13312-6</b>	
<small>DRAWING PROPRIETARY TO FABSCO, LLC AND IS NOT TO BE RELEASED TO ANY THIRD PARTY, EXCEPT WITH NOTIFICATION AND APPROVAL IN WRITING OF FABSCO, LLC OFFICER.</small>	
<b>DRAWN BY:</b> JH	<b>FABSCO FIN-AIR, LLC</b>
<b>DATE:</b> 5/4/2023	<b>DESCRIPTION: MOTOR REMOVAL BEAM</b>
<b>CHECKED BY:</b> JH	<b>DRAWING NO: 160</b>
	<b>REV: 0</b>



NOTE: ALL COLUMNS ARE DIFFERENT.

Parts List		
ITEM	QTY	DESCRIPTION
308	1	COLUMN BASE PLATE
800.1	1	LOWER COLUMN BEAM
309	1	COLUMN SPLICE PLATE
608	1	WELDED CLIP

JOB NUMBER: <b>A22-13312-6</b>	
<small>DRAWING PROPRIETARY TO FABSCO, LLC AND IS NOT TO BE RELEAED TO ANY THIRD PARTY, EXCEPT WITH NOTIFICATION AND APPROVAL IN WRITING OF FABSCO, LLC OFFICER</small>	
DRAWN BY: JH	<b>FABSCO FIN-AIR, LLC</b>
DATE: 5/4/2023	DESCRIPTION: FRONT LOWER LEFT COLUMN
CHECKED BY: JH	DRAWING NO: <b>800FL</b>
	REV: <b>0</b>

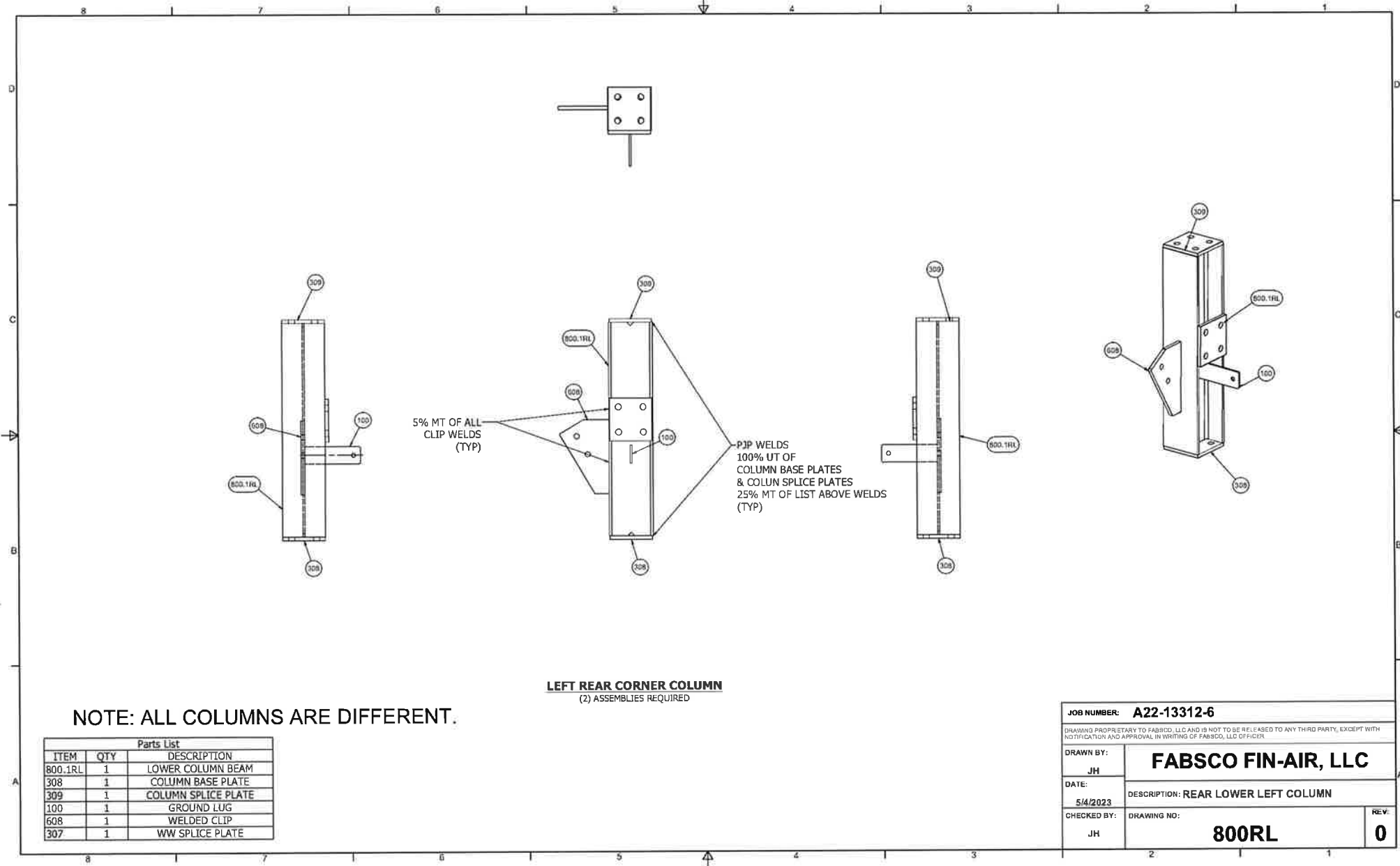


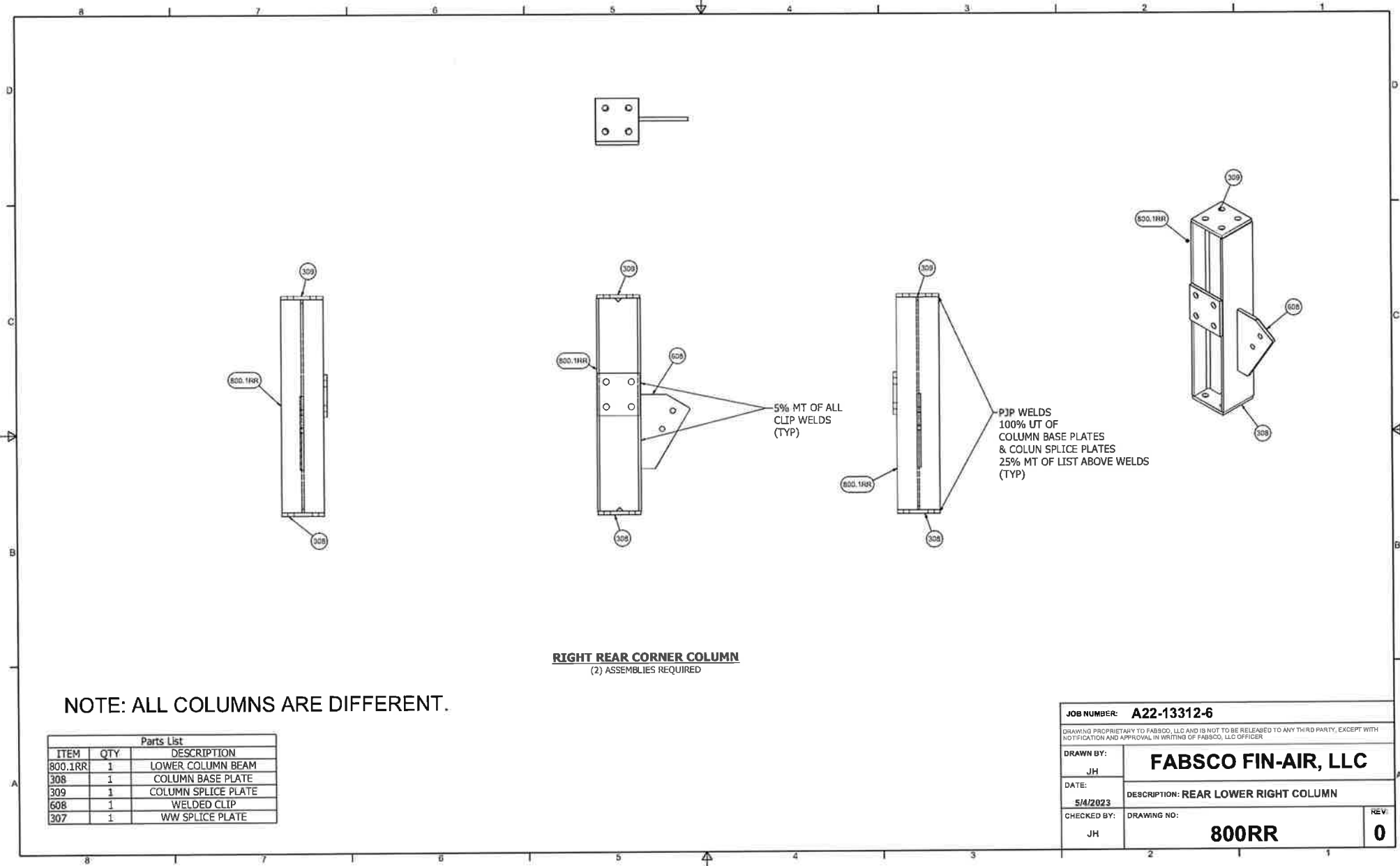
**RIGHT FRONT CORNER COLUMN**  
(2) ASSEMBLIES REQUIRED

NOTE: ALL COLUMNS ARE DIFFERENT.

Parts List		
ITEM	QTY	DESCRIPTION
800.1FR	1	LOWER COLUMN BEAM
308	1	COLUMN BASE PLATE
309	1	COLUMN SPLICE PLATE
100	1	GROUND LUG
608	1	WELDED CLIP

JOB NUMBER: <b>A22-13312-6</b>	
DRAWING PROPRIETARY TO FABSCO, LLC AND IS NOT TO BE RELEASED TO ANY THIRD PARTY, EXCEPT WITH NOTIFICATION AND APPROVAL IN WRITING OF FABSCO, LLC OFFICER	
DRAWN BY: <b>JH</b>	<b>FABSCO FIN-AIR, LLC</b>
DATE: <b>5/4/2023</b>	DESCRIPTION: <b>FRONT LOWER RIGHT COLUMN</b>
CHECKED BY: <b>JH</b>	DRAWING NO: <b>800FR</b>
	REV: <b>0</b>



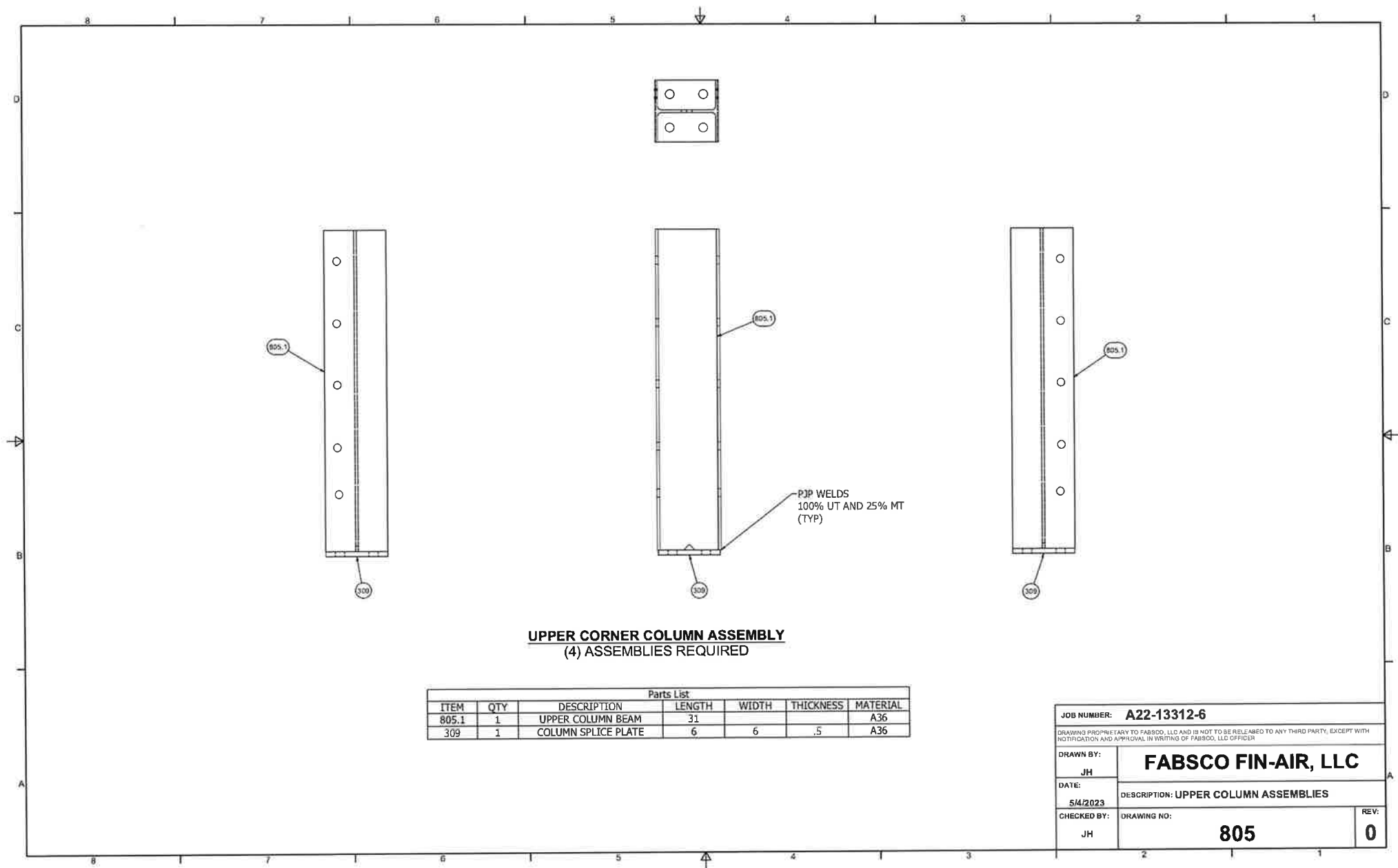


**RIGHT REAR CORNER COLUMN**  
(2) ASSEMBLIES REQUIRED

NOTE: ALL COLUMNS ARE DIFFERENT.

Parts List		
ITEM	QTY	DESCRIPTION
800.1RR	1	LOWER COLUMN BEAM
308	1	COLUMN BASE PLATE
309	1	COLUMN SPLICE PLATE
608	1	WELDED CLIP
307	1	WW SPLICE PLATE

JOB NUMBER: <b>A22-13312-6</b>	
DRAWING PROPRIETARY TO FABSCO, LLC AND IS NOT TO BE RELEASED TO ANY THIRD PARTY, EXCEPT WITH NOTIFICATION AND APPROVAL IN WRITING OF FABSCO, LLC OFFICER	
DRAWN BY: JH	<b>FABSCO FIN-AIR, LLC</b>
DATE: 5/11/2023	DESCRIPTION: REAR LOWER RIGHT COLUMN
CHECKED BY: JH	DRAWING NO: <b>800RR</b>
	REV: <b>0</b>

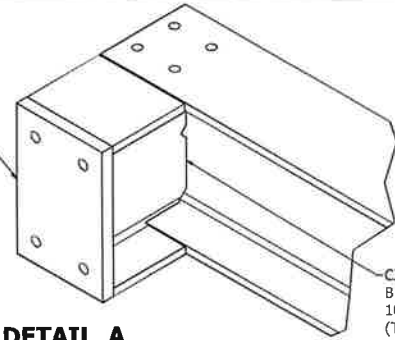


**UPPER CORNER COLUMN ASSEMBLY**  
(4) ASSEMBLIES REQUIRED

Parts List						
ITEM	QTY	DESCRIPTION	LENGTH	WIDTH	THICKNESS	MATERIAL
805.1	1	UPPER COLUMN BEAM	31			A36
309	1	COLUMN SPLICE PLATE	6	6	.5	A36

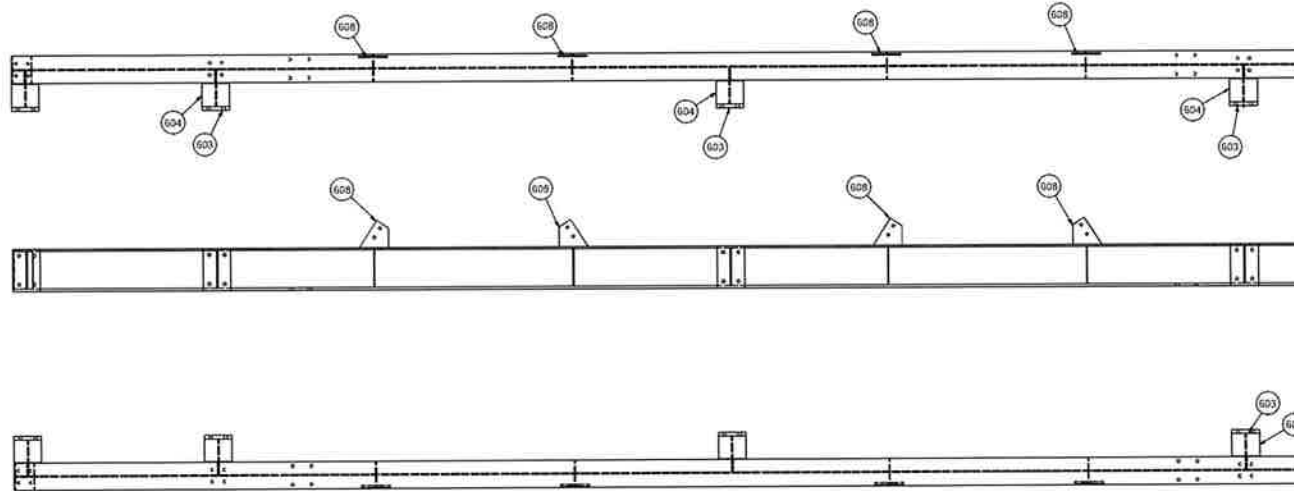
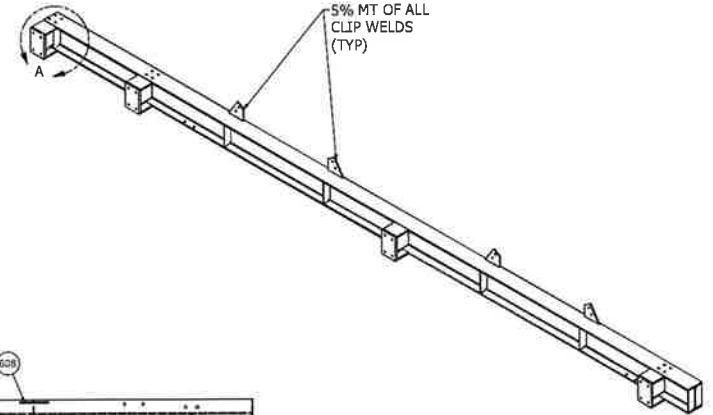
JOB NUMBER: <b>A22-13312-6</b>	
<small>DRAWING PROPRIETARY TO FABSCO, LLC AND IS NOT TO BE RELEASED TO ANY THIRD PARTY, EXCEPT WITH NOTIFICATION AND APPROVAL IN WRITING OF FABSCO, LLC OFFICER</small>	
DRAWN BY: JH	<b>FABSCO FIN-AIR, LLC</b>
DATE: 5/4/2023	DESCRIPTION: UPPER COLUMN ASSEMBLIES
CHECKED BY: JH	DRAWING NO: <b>805</b>
	REV: <b>0</b>

PJP WELD  
PLATE TO BEAM  
100% UT AND 25% MT  
(TYP)



**DETAIL A**

CJP WELD  
BEAM TO BEAM  
100% UT AND 25% MT  
(TYP)

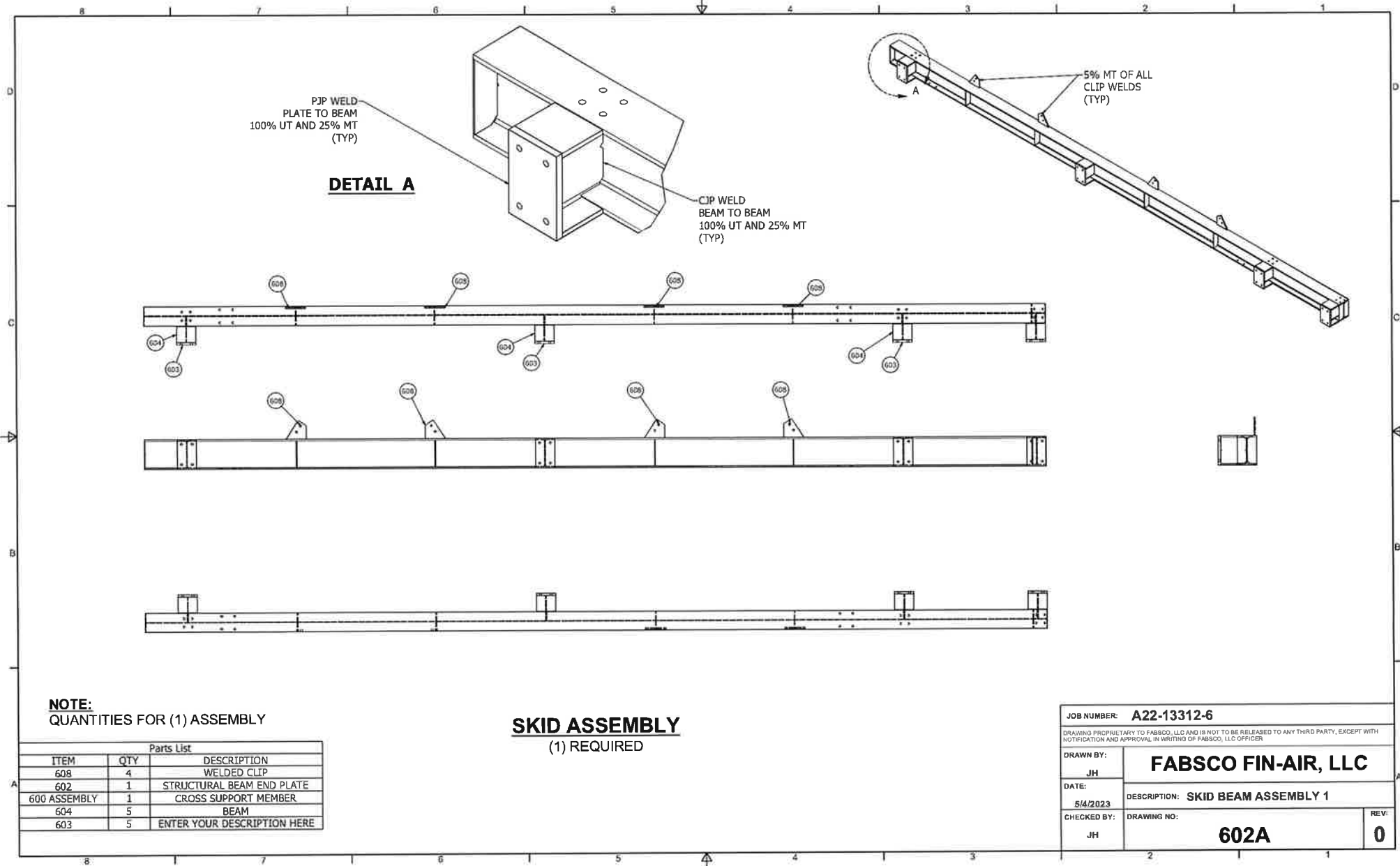


**SKID ASSEMBLY**  
(1) REQUIRED

**NOTE:**  
QUANTITIES FOR (1) ASSEMBLY

Parts List		
ITEM	QTY	DESCRIPTION
604	5	BEAM
603	5	ENTER YOUR DESCRIPTION HERE
608	4	WELDED CLIP
600 ASSEMBLY	1	CROSS SUPPORT MEMBER
602	1	STRUCTURAL BEAM END PLATE

JOB NUMBER: <b>A22-13312-6</b>		
<small>DRAWING PROPRIETARY TO FABSCO, LLC AND IS NOT TO BE RELEASED TO ANY THIRD PARTY, EXCEPT WITH NOTIFICATION AND APPROVAL IN WRITING OF FABSCO, LLC OFFICE.</small>		
DRAWN BY: JH	<b>FABSCO FIN-AIR, LLC</b>	
DATE: 5/4/2023	DESCRIPTION: <b>SKID BEAM ASSEMBLY 1</b>	
CHECKED BY: JH	DRAWING NO: <b>601A</b>	REV: <b>0</b>

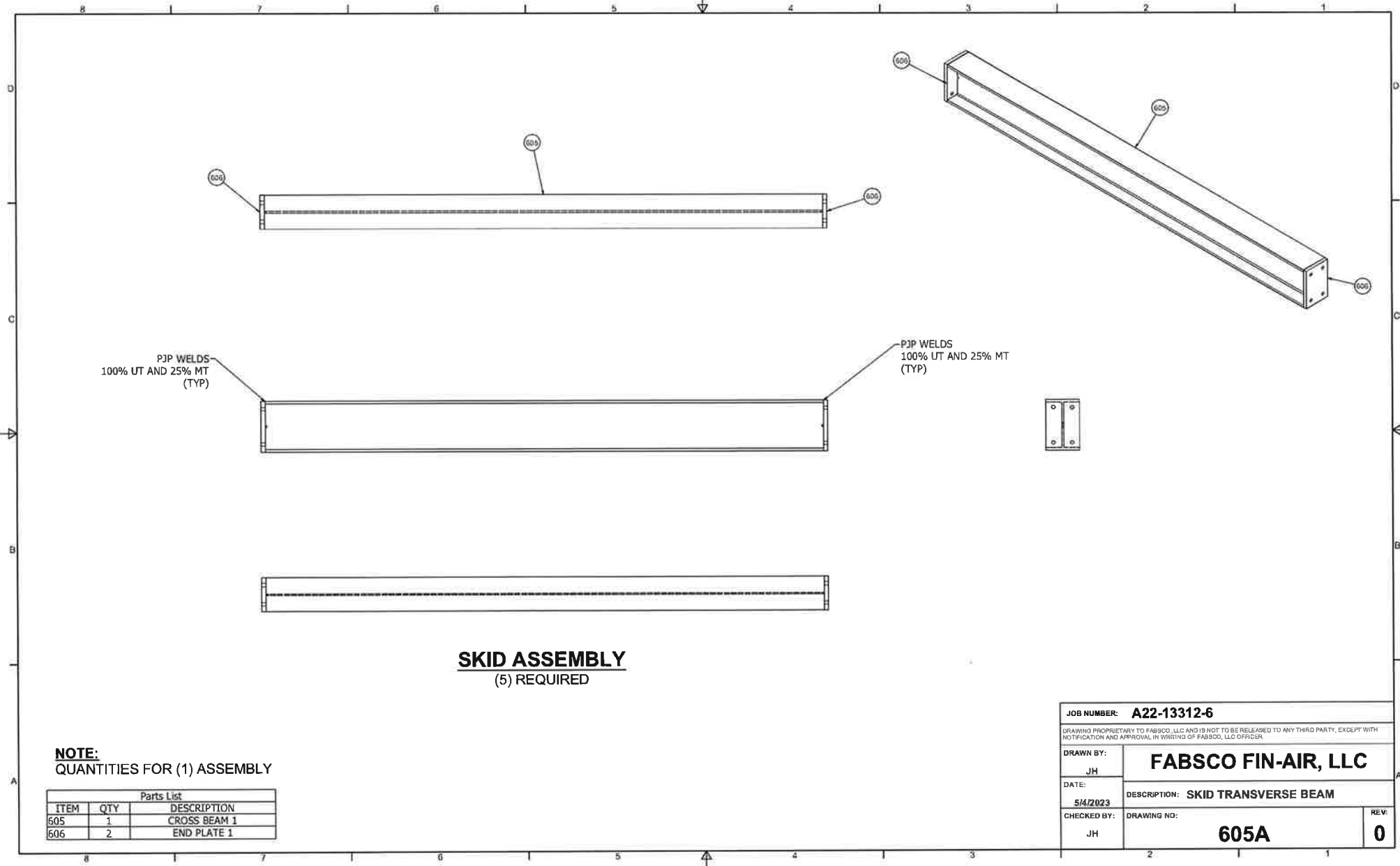


**NOTE:**  
 QUANTITIES FOR (1) ASSEMBLY

**SKID ASSEMBLY**  
 (1) REQUIRED

Parts List		
ITEM	QTY	DESCRIPTION
608	4	WELDED CLIP
602	1	STRUCTURAL BEAM END PLATE
600 ASSEMBLY	1	CROSS SUPPORT MEMBER
604	5	BEAM
603	5	ENTER YOUR DESCRIPTION HERE

JOB NUMBER: <b>A22-13312-6</b>	
<small>DRAWING PROPRIETARY TO FABSCO, LLC AND IS NOT TO BE RELEASED TO ANY THIRD PARTY, EXCEPT WITH NOTIFICATION AND APPROVAL IN WRITING OF FABSCO, LLC OFFICER.</small>	
DRAWN BY: JH	<b>FABSCO FIN-AIR, LLC</b>
DATE: 5/4/2023	DESCRIPTION: <b>SKID BEAM ASSEMBLY 1</b>
CHECKED BY: JH	DRAWING NO: <b>602A</b>
	REV: <b>0</b>

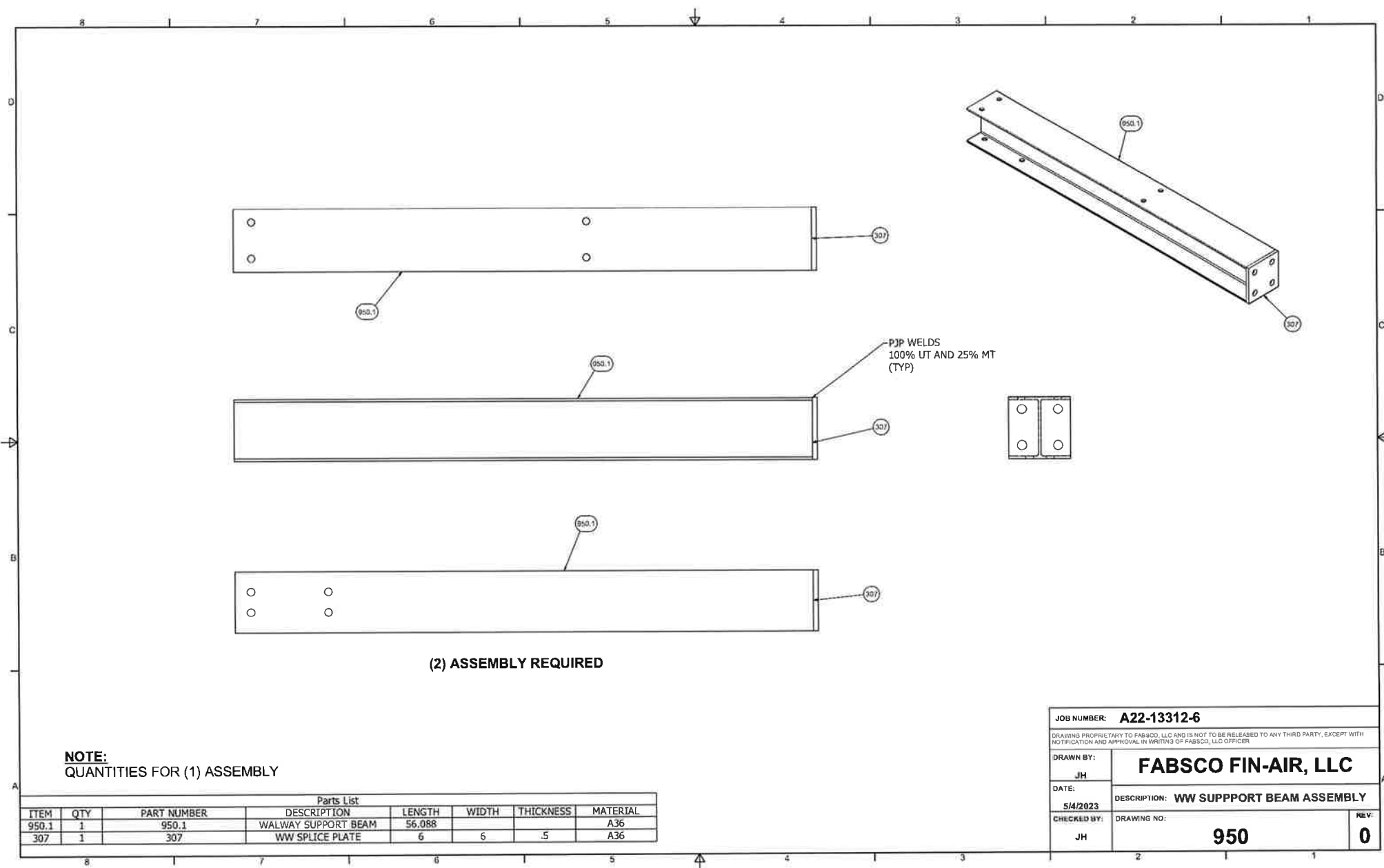


**SKID ASSEMBLY**  
(5) REQUIRED

**NOTE:**  
QUANTITIES FOR (1) ASSEMBLY

Parts List		
ITEM	QTY	DESCRIPTION
605	1	CROSS BEAM 1
606	2	END PLATE 1

JOB NUMBER: <b>A22-13312-6</b>	
<small>DRAWING PROPRIETARY TO FABSCO, LLC AND IS NOT TO BE RELEASED TO ANY THIRD PARTY, EXCEPT WITH NOTIFICATION AND APPROVAL IN WRITING OF FABSCO, LLC OFFICER.</small>	
DRAWN BY: JH	<b>FABSCO FIN-AIR, LLC</b>
DATE: 5/4/2023	DESCRIPTION: <b>SKID TRANSVERSE BEAM</b>
CHECKED BY: JH	DRAWING NO: <b>605A</b>
	REV: <b>0</b>



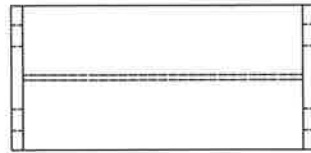
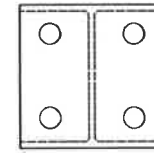
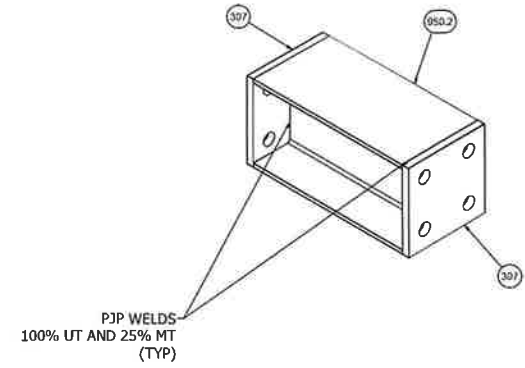
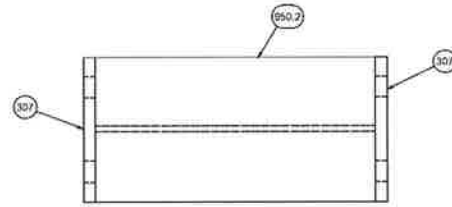
PJP WELDS  
100% UT AND 25% MT  
(TYP)

(2) ASSEMBLY REQUIRED

**NOTE:**  
QUANTITIES FOR (1) ASSEMBLY

JOB NUMBER: <b>A22-13312-6</b>	
DRAWING PROPRIETARY TO FABSCO, LLC AND IS NOT TO BE RELEASED TO ANY THIRD PARTY, EXCEPT WITH NOTIFICATION AND APPROVAL IN WRITING OF FABSCO, LLC OFFICER.	
DRAWN BY: JH	<b>FABSCO FIN-AIR, LLC</b>
DATE: 5/4/2023	DESCRIPTION: <b>WW SUPPORT BEAM ASSEMBLY</b>
CHECKED BY: JH	DRAWING NO: <b>950</b>
	REV: <b>0</b>

Parts List							
ITEM	QTY	PART NUMBER	DESCRIPTION	LENGTH	WIDTH	THICKNESS	MATERIAL
950.1	1	950.1	WALWAY SUPPORT BEAM	56.088			A36
307	1	307	WW SPLICE PLATE	6	6	.5	A36



**(4) ASSEMBLY REQUIRED**

**NOTE:**  
QUANTITIES FOR (1) ASSEMBLY

Parts List						
ITEM	QTY	DESCRIPTION	SIZE	LENGTH	WIDTH	THICKNESS MATERIAL
950.2	1	WALWAY VERTICAL SPT BEAM		11.698		
307	2	WW SPLICE PLATE		6	6	.5 A36

JOB NUMBER: <b>A22-13312-6</b>	
DRAWING PROPRIETARY TO FABSCO, LLC AND IS NOT TO BE RELEASED TO ANY THIRD PARTY, EXCEPT WITH NOTIFICATION AND APPROVAL IN WRITING OF FABSCO, LLC OFFICES	
DRAWN BY: JH	<b>FABSCO FIN-AIR, LLC</b>
DATE: 5/4/2023	DESCRIPTION: <b>WW VERT SUPPORT COLUMN</b>
CHECKED BY: JH	DRAWING NO: <b>980</b>
	REV: <b>0</b>