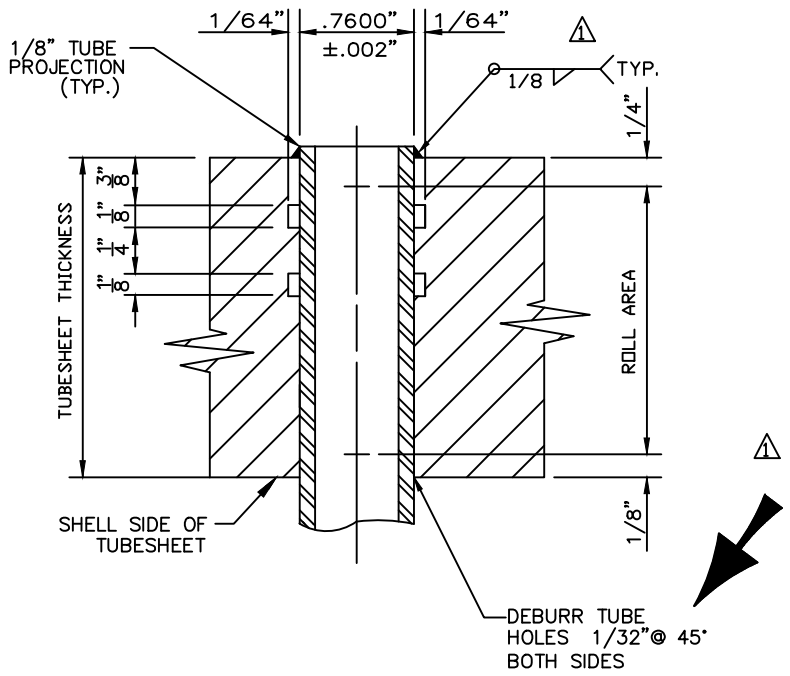

TUBE TO TUBESHEET SEAL WELD AND FABRICATION SEQUENCE

* *

1. DRILL, REAM AND RING GROOVE TUBE HOLES PER DETAIL ABOVE.
2. CLEAN AREAS TO BE WELDED AND ROLLED WITH DEGREASER.
3. INSTALL TUBES IN BUNDLE AND SET PROJECTIONS.
4. FUSION WELD USING GTAW PROCESS USING WPS: T-266.
5. LIQUID PENETRANT EXAMINE ALL WELDS AND THEN CLEAN THEM WITH DEGREASER. REPAIR ANY DEFECTIVE WELDS AND RECHECK.
6. TUBE-TO-T'SHT. WELDS SHALL BE AIR & SOAP TESTED PRIOR TO FINAL ROLLING W/ 15 PSI (MAX.) AIR PRESSURE.
7. ROLL TUBES INTO TUBESHEET PER DETAIL ABOVE.
8. REPEAT STEP 5.
9. TUBE WALL REDUCTION SHALL BE 8% (MAX.). 1

PROJECT NAME: WORLD ENERGY RENEWABLES PROJECT
EQUIPMENT OWNERAIR PRODUCTS MANUFACTURING LLC
SERVICE:STRIPPER FEED / DEBUTANIZER BOTTOMS EXCHANGER
LOCATION:WORLD ENERGY, PARAMOUNT, CA. USA
PRODUCT: STRIPPER FEED / DEBUTANIZER BOTTOMS EXCHANGER
ITEM NO.: 18-X-372A
AIR PRODUCTS P.O. NO.: 4505600057 / A8KM-4-402-PO-2
AP PROJECT NO: EN-20-7120
VDR CODE NO.: BE04
SERIAL NO.:S21-13258-9
ENGINEER: EG
CUSTOMER / CLIENT:WORLD ENERGY PARAMOUNT

NO.	DATE	REVISIONS
1	8/2/2022	REV./CUST. COMMENTS GO/DD

TUBE SEAL WELD
& TUBE HOLE GROOVING DETAIL

DWN. BY: B.W.
DATE: 5/24/22
CKD. BY: DiCarlo

Fabsco
SHELL & TUBE, LLC

DWG.NO.: S21-13258-9-4A
REV.: 1