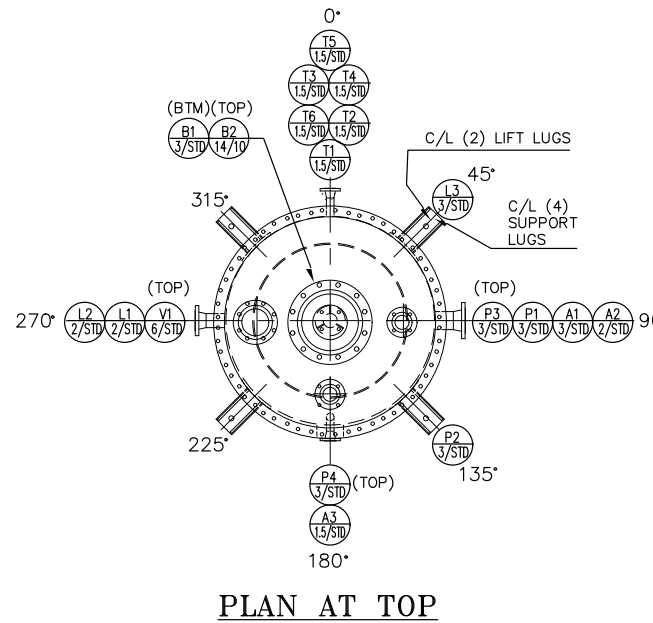


NOZZLE SCHEDULE												
MARK	NOZZLE		WELD HL.			FLANGE		REPAD		DETAIL	SERVICE	
	SIZE	SCH	THK	A	B	C	PRES	TYPE	FACE			WIDE
A1	3"	STD	.216	5/16"			150	WN	RF		2-A	PROCESS INLET
A2	2"	STD	.154	5/16"			150	WN	RF		2-A	PROCESS INLET
A3	1.5"	STD	.145	5/16"			150	WN	RF		2-A	RECIRC.
B1	3"	STD	.216	5/16"			150	WN	RF		2-A	PRODUCT OUTLET
B2	14"	10	.250	5/16"			150	WN	RF		2-A	VAPOR OUT
L1	2"	STD	.154	5/16"			150	WN	RF		2-A	LEVEL MEAS.
L2	2"	STD	.154	5/16"			150	WN	RF		2-A	LEVEL MEAS.
L3	3"	STD	.216	5/16"			150	WN	RF		2-A	LEVEL MEAS.
P1	3"	STD	.216	5/16"			150	WN	RF		2-A	PRESSURE MEAS.
P2	3"	STD	.216	5/16"			150	WN	RF		2-A	PRESSURE MEAS.
P3	3"	STD	.216	5/16"			150	WN	RF		2-A	PRESSURE MEAS.
P4	3"	STD	.216	5/16"			150	WN	RF		2-A	PRESSURE MEAS.
T1-6	1.5"	STD	.145	5/16"			150	WN	RF		2-A	THERMOWELL
V1	6"	STD	.280	5/16"			150	WN	RF		2-A	VENT

- NOTES**
- ALL BOLT HOLES SHALL STRADDLE VESSEL MAJOR C/L. UNLESS SPECIFIED OTHERWISE.
 - ALL S/S. WELDS PER AHE-800 & 807.
 - ALL DIMENSIONS ARE FROM GASKET FACES. UNLESS SPECIFIED OTHERWISE.
 - ALL REPADS TO HAVE (1) 1/4" WEEP HOLE AT LOWEST POINT. RADIUS ALL CORNERS 11 MIN. TEST ALL REPADS WITH AIR AT 15 PSIG.
 - ALL NOZZLE TO SHELL/HEAD WELDS SHALL BE PT TESTED AT 1st AND LAST PASS.
 - ORIENTATION PER PLAN/END VIEW (RESP.) UNLESS SPECIFIED OTHERWISE.
 - PROTECTIVE COVERS TO BE PROVIDED FOR ALL NOZZLE FLANGES PRIOR TO SHIPPING.
 - PAD EYES ON 3040 MUST BE DESIGNED SO THAT ONE PADEYE WILL BE ABLE TO TAKE LOAD FOR LIFTING 3040 & 3041 TO A VERTICAL POSITION.
 - CUSTOMER INSPECTION REQUIRED ON INTERNALS BEFORE CLOSING.



MATERIAL SPECIFICATIONS ASME	
DESCRIPTION	COLUMN
SHELL	SA240-316L
HEADS	SA240-316L
SUPPORTS	SA240-316L
FLANGES	SA182F-316L
PIPE	SA312-316L
TUBES	
TUBE SHEETS	
BOLTS/NUTS	SA193-B7/SA194-2H (HDG OR BBM)
GASKETS	GARLOCK 3500 1/8" T
BODY FLG.	SA182F-316L
INTERNALS	SA240-316L
FITTINGS	

DESIGN DATA		
DESCRIPTION	COLUMN	
DESIGN CODE	ASME SEC. VIII, DIV. 1 2004 ED. 2004 AD.	
DESIGN PRESSURE	INTERNAL - PSIG	50
	EXTERNAL - PSIG	-15
DESIGN TEMPERATURE	INTERNAL - °F	320
	EXTERNAL - °F	320
MAWP		320F / 50/FV
CORR. ALLOW.		0
HYDRO. PRESS. PSIG		65
WELD PROCEDURE		SEE NOTE 2
RADIOGRAPHY PER CODE		SEE DET'L 3-B
VESSEL WEIGHT - DRY		4,850 lbs.; FULL OF WATER: 19,750 lbs.
HEAT TREATMENT		NOT REQUIRED

DESIGN DATA

DESIGN CODE ASME SEC. VIII, DIV. 1 2004 ED. 2004 AD.

DESIGN PRESSURE INTERNAL - PSIG 50
EXTERNAL - PSIG -15

DESIGN TEMPERATURE INTERNAL - °F 320
EXTERNAL - °F 320

MAWP 320F / 50/FV

CORR. ALLOW. 0

HYDRO. PRESS. PSIG 65

WELD PROCEDURE SEE NOTE 2

RADIOGRAPHY PER CODE SEE DET'L 3-B

VESSEL WEIGHT - DRY: 4,850 lbs.; FULL OF WATER: 19,750 lbs.

HEAT TREATMENT NOT REQUIRED

U 620
W-L RT-1

CERTIFIED BY
ALABAMA HEAT EXCHANGERS, INC.
MAWP 50 PSIG @ 320 °F
MAEWP 15 PSIG @ 320 °F
MDMT -20 °F @ 50 PSIG
MFG. SERIAL NO. AHE- 968
YEAR BUILT 2006
ITEM NO. 3040
PROJ. NO. C0150.10002

REF: AHE JOB NO. 6449-A

REVISIONS

0. INITIAL ISSUE

1. REV & RESUBMIT PER CUST. DNG. DT. 3/24/06

2. REV & REL FOR FAB PER CUST. DNG. DT. 4/18/06

3. REV & REL FOR FAB PER WELDING W/UST DT. 4/20/06

4. AS-BUILT JCL 7/19/06

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ALABAMA HEAT EXCHANGERS, INC.
MOBILE, ALABAMA

DEGUSSA CORPORATION
ACH COLUMN NO. 3040
PROJ. NO. C0150.10002

CUST. ORDER NO.	JOB NO.	DRAWING NO.
4500154839	6493-A	E-493A-061
DRAWN BY J.C.LIGHTCAP	DATE 1-16-06	SHT 1 OF 3
APP'D BY	DATE	SCALE 3/8"=1'-0"