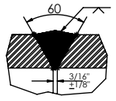
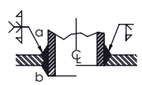
1 WPS NO.____001
ROOT ____ER70S6
FILLER ____E71T1/EM12K
CAP ____ EM12K



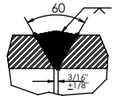
LONG SEAM

2 WPS NO.____BE-17 REV 01
ROOT ____ER70S6
FILLER ____E71T-1
CAP ____ E71T-1



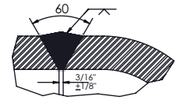
NOZZLE WELD DETAIL

3 WPS NO.____BE-17 REV 01
ROOT ____ER70S6
FILLER ____E71T1
CAP ____ E71T1



PIPE TO FLANGE WELD DETAIL

4 WPS NO.____BE-16 REV 01
ROOT ____ER70S6
FILLER ____E71T1/EM12K
CAP ____ EM12K

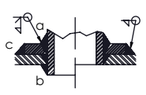


HEAD TO SHELL WELD DETAIL

5 WPS NO.____BE-17 REV 01
ROOT ____ER70S6
FILLER ____E71T1
CAP ____ E71T1

COUPLING WELD DETAIL

6 WPS NO.____BE-17 REV 01
ROOT ____ER70S6
FILLER ____E71T1
CAP ____ E71T1



REPAD WELD DETAIL

PALL FILTER HOUSING

PART NO. VV001SP4S08A
SERIAL NO. 100788
DESIGN PRESS. 100 PSIG; TEMP. 250°F
CRTG PART NO. CS604LGT2H13
FOR MAXIMUM ALLOWABLE DIFFERENTIAL PRESSURE SEE PRODUCT LITERATURE

WARNING DO NOT INSTALL OR SERVICE THIS EQUIPMENT WITHOUT READING THE INSTRUCTION SHEET
PALL TRINITY MICRO
CORTLAND, NY 13045

MATERIAL SPECIFICATIONS

SHELL #1: 0.5" THK; MATL: SA-106 Gr. B		SHELL #2: 0.5" THK; MATL: SA-106 Gr. B	
SHELL #3: -		SHELL #4: -	
HEAD #1: 0.5" THK; 0.4375" MIN THK; MATL: SA-234 WPB; TYPE: PIPE CAP			
HEAD #2: 8" NEVIS QUICK OPENING CLOSURE AF SWING BOLT			
HEAD #3: -			
INTERNALS: SA-304L			
FLANGE MATL: SA-105N	STUD BOLT MATL: SA-193-B7M		FLUOROCARBON BOLTS:
PIPE NOZZLE MATL: SA-106 Gr. B	NUT MATL: SA-194-4, CAD, PLT.		O YES X NO
WELD FITTING MATL: SA-234 WPB	MACH. BOLT MATL: SA-316L		MACH BOLTS & NUTS STAINLESS:
CPLG MATL: SA-105N	MACH. NUT MATL: SA-563 Hvy. Hex		X YES O NO

DESIGN SPECIFICATIONS

DESIGN PRESSURE: 100 PSIG/FV @ 250°F	MDMT: 32°F
FINAL HYDROSTATIC TEST PRESSURE: 130 PSIG	
FINAL HYDROSTATIC TEST PRESSURE BASED ON: 1.3 TIMES DESIGN PRESSURE	
POST WELD HEAT TREAT: YES; TIME: 1 Hrs. 0 Min. @ 1150°F ± 50°F	
CORROSION ALLOWANCE: 0.1875	

	RT1	RT2 X	RT3	RT4	NONE
LONG SEAM HEMI HD-SHELL:	FULL LTH.	N/A SMLS	SPOT		
HEAD TO SEAM:	FULL LTH.	SPOT	SPOT		
INTERMEDIATE GIRTH:	FULL LTH.		SPOT		
NOZZLE > 10" OR > 1.125":	FULL		SPOT		
NOZZLE <=10" AND <= 1.25":	N/A		N/A		
JOINT EFFICIENCIES (%)					
LONG SEAM:	100		85		70
SEAMLESS:	100		100		85
HEAD-SHELL (HEMI)	90/100		80/85		65/70

VESSEL TO BE CONSTRUCTED IN STRICT ACCORDANCE WITH 2019 EDITION OF ASME, PRESSURE VESSEL CODE: SECTION VIII, DIVISION 1. THE LOADING REQUIREMENTS OF UG 22 HAVE BEEN CONSIDERED IN THE DESIGNING OF THIS PRESSURE VESSEL.

1.) ALL NOZZLES IN SHELL(S): FULL PENETRATION ATTACHMENT WELDS

2.) WELDING PROCEDURES: ASME VIII APPROVED

3.) CIRCUMFERENTIAL JOINTS HAVE BACKUP STRIPS: O YES X NO

4.) NO CHILL RINGS TO BE USED IN NOZZLES

5.) ALL FLANGES TO HAVE BOLT HOLES STRADDLING TRUE CENTERLINES

6.) REINFORCEMENT MATERIAL SHALL BE THE MATERIAL SPECIFIED

7.) ALL EXTERNAL REINFORCING PADS TO HAVE 1/4" NPT TAPPED HOLE

8.) MATERIAL OF ALL THICKNESS FOR PARTS NOT SUBJECT TO STRESS DUE TO PRESSURE SHALL COMPLY WITH UG-4(b)

9.) ALL ATTACHMENT WELDS SHALL BE DRY MT EXAMINED AFTER GRINDING

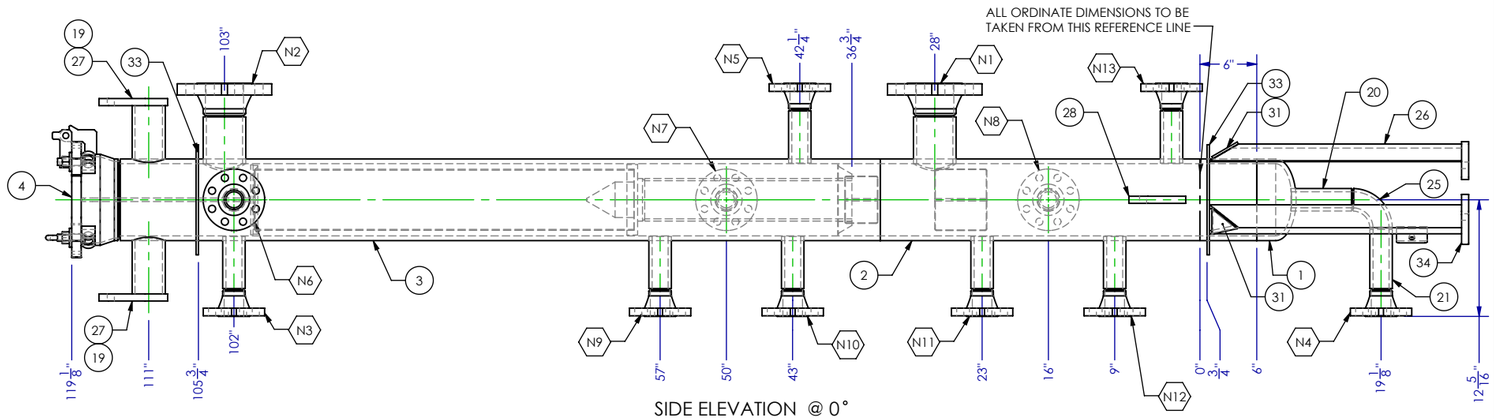
10.) WEIGHT EMPTY: 900 LBS
WEIGHT FULL: 1,112 LBS

PAINT NOTES:
COATING SYSTEM A
SURFACE PREP: SSPC-SP10
PRIME COAT: CARBOZINC 11
INTERMEDIATE COAT: N/A
TOP COAT: N/A

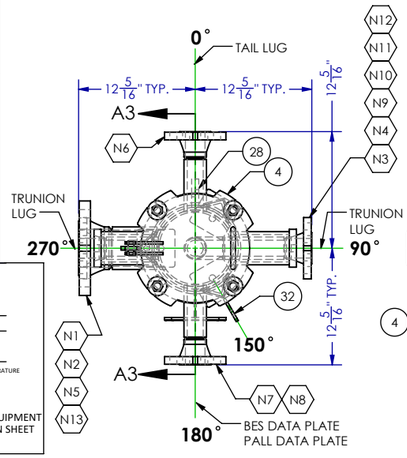
NOTE: REFERENCE PES-21-DF-2761-036 FOR INTERNAL FILTER DETAILS

BOM Table

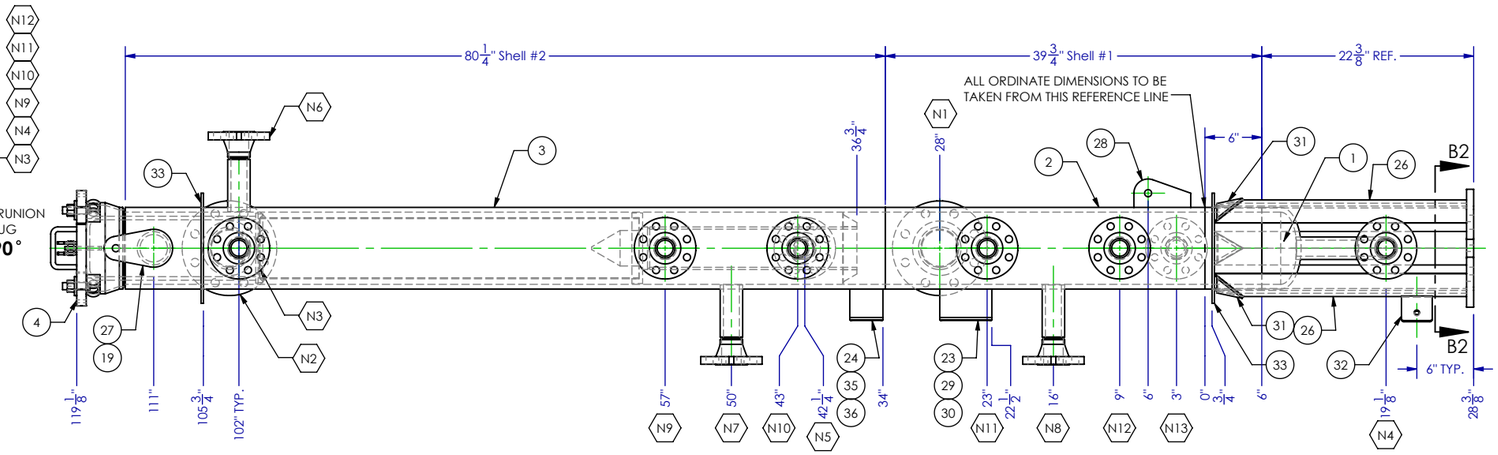
MARK	QTY.	SERVICE	SIZE AND RATING	NOZZLE BORE	WELD DETAIL	OUTSIDE PROJECTION FACE TO SHELL	MINIMUM INSIDE PROJECTION	FILLET WELD SIZE: a (OUTSIDE)	FILLET WELD SIZE: b (INSIDE)	FILLET WELD SIZE: c (REPAD)
N1	1	Inlet	4" 300# RF WN	Sch. 80	2	8.00"	FLUSH	.250"	-	-
N2	1	Outlet	4" 300# RF WN	Sch. 80	2	8.00"	FLUSH	.250"	-	-
N3	1	Vent	2" 300# RF WN	Sch. 160	2	8.00"	FLUSH	.250"	-	-
N4	1	Drain	2" 300# RF WN	Sch. 160	2	SEE DWG	FLUSH	.250"	-	-
N5	1	Drain	2" 300# RF WN	Sch. 160	2	8.00"	FLUSH	.250"	-	-
N6	1	PSV	2" 300# RF WN	Sch. 160	2	8.00"	FLUSH	.250"	-	-
N7	1	Level Control	2" 300# RF WN	Sch. 160	2	8.00"	FLUSH	.250"	-	-
N8	1	Level Control	2" 300# RF WN	Sch. 160	2	8.00"	FLUSH	.250"	-	-
N9	1	Level Gauge	2" 300# RF WN	Sch. 160	2	8.00"	FLUSH	.250"	-	-
N10	1	Level Gauge	2" 300# RF WN	Sch. 160	2	8.00"	FLUSH	.250"	-	-
N11	1	Level Gauge	2" 300# RF WN	Sch. 160	2	8.00"	FLUSH	.250"	-	-
N12	1	Level Gauge	2" 300# RF WN	Sch. 160	2	8.00"	FLUSH	.250"	-	-
N13	1	Steam Out	2" 300# RF WN	Sch. 160	2	8.00"	FLUSH	.250"	-	-



SIDE ELEVATION @ 0°



TOP VIEW
FILTER ASSEMBLY NOT SHOWN FOR CLARITY



SIDE ELEVATION @ 90°

	NATL BD: XX-XXX	
U	CERTIFIED BY Bagwell Energy Services	10404 Twin Port Rd. Delcambre, LA 70528 Phone: (337) 837-2244
W	MAWP 100 PSIG	AT 250°F
HT	MDMT 32°F	AT 100 PSIG
RT-2	OD: 8.625"	S/S: 10'-0" CA: 0.1875
	S/N: 21-446401-08	YR: BLT. 2021
SHELL MAT'L SA-106 Gr. B	SHELL THK. 0.5"	HEAD MAT'L SA-234 WPB / HEAD THK. 0.5"
TAG NO: 18-D-360		
EMPTY WEIGHT: 900 LBS		FULL WEIGHT: 1,112 LBS
P.O. #:		

DISCLAIMER:
THIS DRAWING IS AN INSTRUMENT OF SERVICE AND SHALL REMAIN THE PROPERTY OF PES. THIS DRAWING SHALL NOT BE REPRODUCED, PUBLISHED, OR USED IN ANY OTHER MANNER WITHOUT THE EXPRESSED WRITTEN PERMISSION OF PES.

GENERAL NOTES:

1. ALL WELDING SHALL BE IN ACCORDANCE WITH AWS D1.1 AND ASME VIII, DIV. 1.
2. ALL WELDS SHALL BE NDE TESTED IN ACCORDANCE WITH ASME VIII, DIV. 1.
3. ALL WELDS SHALL BE FULL PENETRATION WELDS UNLESS NOTED OTHERWISE.
4. ALL LIFT LUG HOLES SHALL BE DRILLED OR REAMED. FLAME CUTTING IS PROHIBITED.
5. ALL "-" TICK MARKS INDICATE NO INSIDE PROJECTION REQUIRED, BUT NOZZLES NOT REQUIRED TO BE CUT FLUSH.
6. NAMEPLATE TO BE STAINLESS STEEL.
7. ALL "REF." DIMENSIONS ARE FOR REFERENCE ONLY AND SHOULD NOT BE USED AS FINAL FIT-UP DIMENSIONS.
8. ALL INTERNAL ATTACHMENTS SHALL BE TO WPS BE-20 REV 0.
9. NO FOUNDATION ANALYSIS AND ANCHOR BOLT ANALYSIS PROVIDED IN PES' SCOPE OF SUPPLY.

REVISIONS

REV.	BY	DESCRIPTION	DATE
A	SL	ISSUED FOR APPROVAL	11/16/2021
B	SL	ISSUED FOR APPROVAL	11/24/2021

PALL Corporation
PALL.COM

PRACTICAL ENGINEERING SOLUTIONS LLC

P.O. BOX 51564
LAFAYETTE, LA 70505
PHONE: (337) 408-3242
EMAIL: info@eng-pes.com
www.eng-pes.com

DRAWING DESCRIPTION:
8.625" O.D. x 10'-0" S/S 100 PSIG/FV @ 250°F 18-D-360 FUEL GAS COALESCER

CLIENT DRAWING #: 446401-21217-06

PES DRAWING #: PES-21-DF-2761-006

DRAWN BY:	APPROVED BY:	DATE:
SL	TC	11/1/2021
SCALE:	SHEET:	REV:
N/A	1 OF 4	B