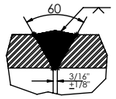
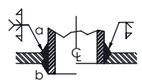
1 WPS NO.____001
ROOT ____ER70S6
FILLER ____E71T1/EM12K
CAP ____ EM12K



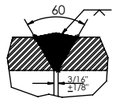
LONG SEAM

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



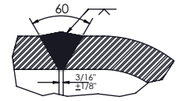
NOZZLE WELD DETAIL

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



PIPE TO FLANGE WELD DETAIL

4 WPS NO.____BE-16 REV 00
BE-17 REV 01
ROOT ____ER70S6
FILLER ____E71T1/EM12K
CAP ____ EM12K

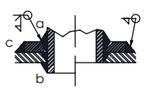


HEAD TO SHELL WELD DETAIL

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. VV001QT0N36A
SERIAL NO. 100789 / 100790
DESIGN PRESS. 500 PSIG; TEMP. 550°F
CRTG PART NO. VANE PACK
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: 0.75" THK; MAT'L: SA-516-70N		SHELL #2: 0.75" THK; MAT'L: SA-516-70N			
SHELL #3:		SHELL #4: -			
HEAD #1: 0.75" THK; 0.615" MIN THK; MAT'L: SA-516-70N; TYPE: 2:1 ELLIPTICAL HEAD					
HEAD #2: 36"NEVIS QOC Series AD Swing Bolt					
HEAD #3: -					
HEAD #4: -					
FLANGE MAT'L: SA-105N	STUD BOLT MAT'L:	SA-193-B7	FLUOROCARBON BOLTS:		
PIPE NOZZLE MAT'L: SA-106 Gr. B	NUT MAT'L:	SA-194-2H	O YES X NO		
WELD FITTING MAT'L: SA-234 WPB	MACH. BOLT MAT'L:	SA-316L	MACH BOLTS & NUTS STAINLESS:		
CPLG MAT'L: SA-105N	MACH. NUT MAT'L:	SA-316L	X YES O NO		

DESIGN SPECIFICATIONS

DESIGN PRESSURE: 500 PSIG/FV @ 550°F	MDMT: 32°F
FINAL HYDROSTATIC TEST PRESSURE: 650 PSIG	
FINAL HYDROSTATIC TEST PRESSURE BASED ON: 1.3 TIMES DESIGN PRESSURE	
POST WELD HEAT TREAT: NO	
CORROSION ALLOWANCE: 0.125"	

	RT1	RT2 X	RT3	RT4	NONE
LONG SEAM HEMI HD-SHELL:	FULL LTH.	FULL LTH.	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 AND CUT EDGE OPENINGS IN VESSEL WALL GREATER THAN 1/2" SHALL BE MT INSPECTED.

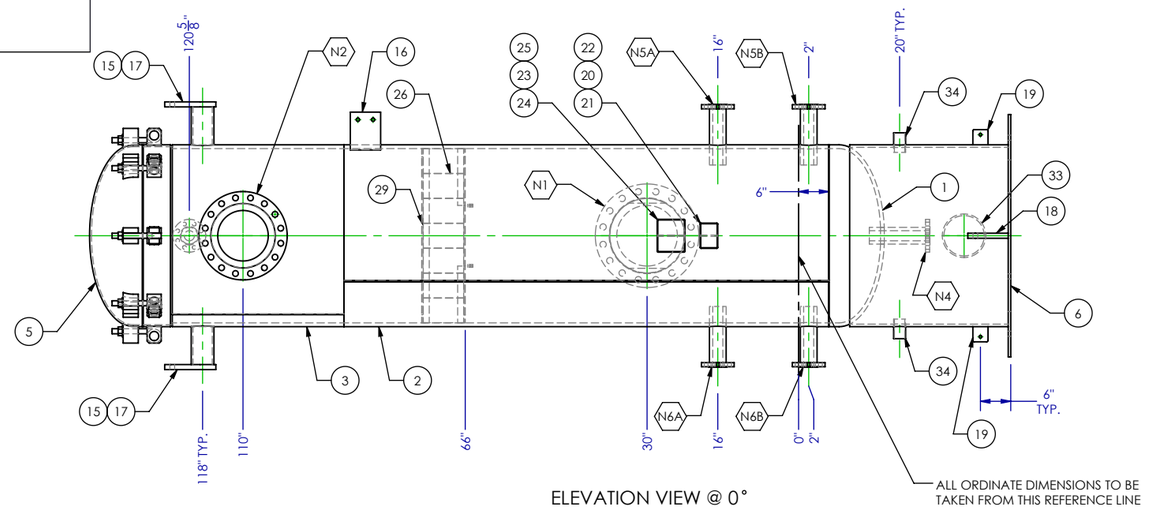
10.) WEIGHT EMPTY: 6,800 LBS
WEIGHT FULL: 11,600 LBS

EXTERNAL COATING - SYSTEM A

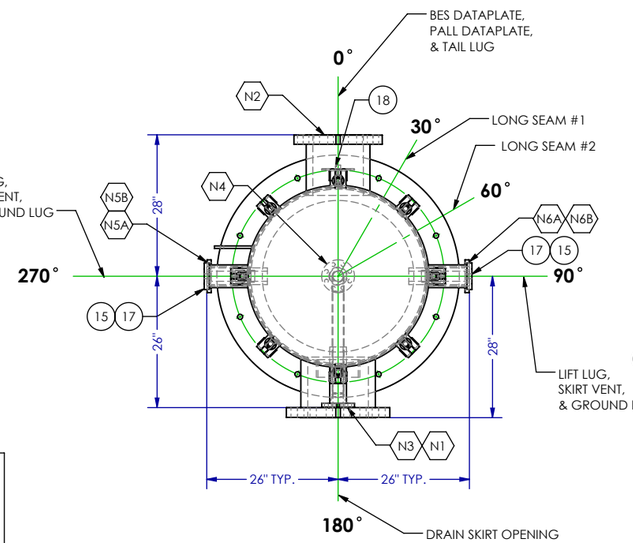
SURFACE PREP - SSPC-SP10
1ST COAT - CARBOZINC 11: 2.5-4.0 MILS DFT

BOM Table

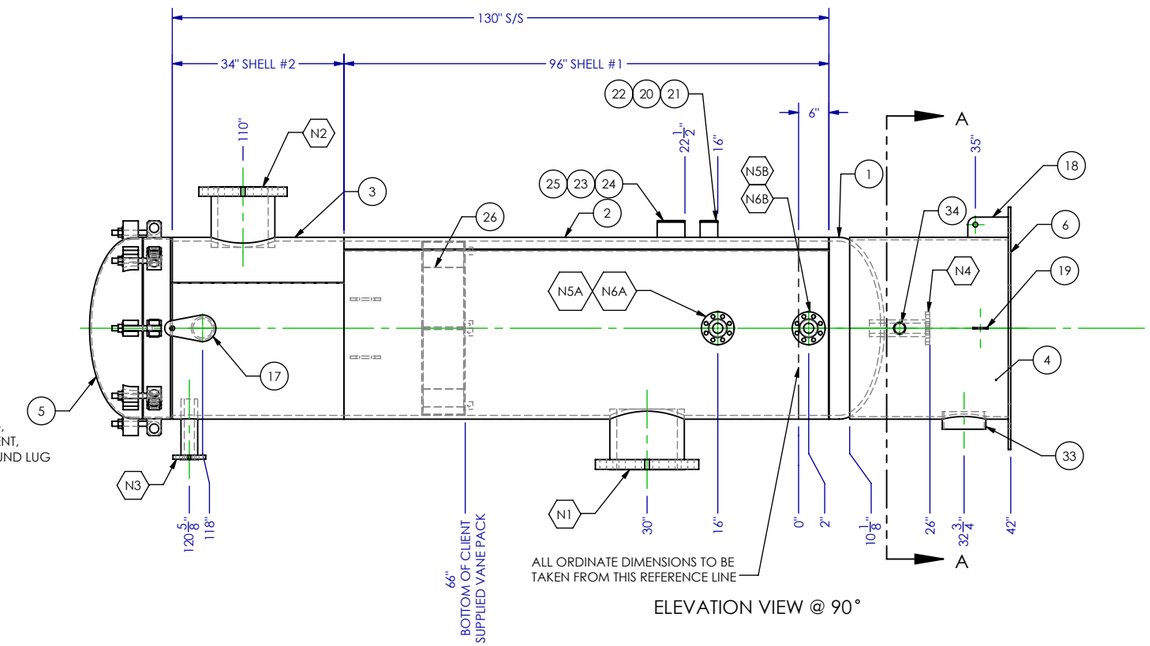
MARK	QTY.	SERVICE	SIZE AND RATING	NOZZLE BORE	WELD DETAIL	OUTSIDE PROJECTION FACE TO SHELL	MINIMUM INSIDE PROJECTION	FILLET WELD SIZE: a (OUTSIDE)	FILLET WELD SIZE: b (INSIDE)	FILLET WELD SIZE: c (REPAD)	REMARKS
N1	1	Inlet	12" 300# RF LWN	LWN	2	10.00"	Flush	0.500"	-	-	
N2	1	Outlet	10" 300# RF LWN	LWN	2	10.00"	Flush	0.500"	-	-	
N3	1	Vent	2" 300# RF LWN	LWN	2	8.00"	Flush	0.375"	-	-	
N4	1	Drain	2" 300# RF LWN	LWN	2	See Dwg.	Flush	0.375"	-	-	
N5A	1	LIT/LG	2" 300# RF LWN	LWN	2	8.00"	Flush	0.375"	-	-	
N5B	1	LIT/LG	2" 300# RF LWN	LWN	2	8.00"	Flush	0.375"	-	-	
N6A	1	LIT/LG	2" 300# RF LWN	LWN	2	8.00"	Flush	0.375"	-	-	
N6B	1	LIT/LG	2" 300# RF LWN	LWN	2	8.00"	Flush	0.375"	-	-	



ELEVATION VIEW @ 0°



PLAN VIEW
NOTE: INTERNALS HIDDEN FOR CLARITY



ELEVATION VIEW @ 90°

NATL BD: XX-XXX			
CERTIFIED BY Bagwell Energy Services	10404 Twin Port Rd. Delcambre, LA 70528 Phone: (337) 837-2244		
U			
W	MAWP 500 PSIG	AT	550°F
	MDMT 32°F	AT	500 PSIG
RT-2	OD: 36"	S/S: 130"	CA: 0.125"
	S/N: 21-446401-10/11		YR: BLT. 2021
SHELL MAT'L SA-516-70N	SHELL THK. 0.75"	HEAD MAT'L SA-516-70N	HEAD THK. 0.75"
TAG NO: 18-D-364 & 18-D-365			
EMPTY WEIGHT: 6,800 LBS		FULL WEIGHT: 11,600 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 ATTACHMENT WELDS SHALL BE IN ACCORDANCE WITH 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	WT	ISSUED FOR APPROVAL	11/19/2021
B	SF	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:
36" O.D. x 10'-10" S/S 500 PSIG/FV @ 550°F 18-D-364/365 MP Steam De-Entrainment

CLIENT DRAWING #:
446401-21217-08

PES DRAWING #:
PES-21-DF-2761-008

DRAWN BY:	APPROVED BY:	DATE:
WT	TC	11/19/2021
SCALE:	SHEET:	REV:
N/A	1 OF 5	B