

#69831



Customer Order No. 5764  
**FORM U-1 MANUFACTURERS' DATA REPORT FOR UNFIRED  
 PRESSURE VESSELS**

As Required by the Provisions of the ASME Code Rules

1. Manufactured by GLASCOTE PRODUCTS, INC., CLEVELAND 17, OHIO  
 (Name and address of Manufacturer)  
 2. Manufactured for Monsanto Chemical Co., Plastics Div., Texas City, Texas  
 (Name and address of Purchaser)  
 3. Type vert Kind jktd Vessel No. 18589 (Mfrs. Serial) (State & State No.)  
 (Horiz. or Vert.) (Tank, Jacketed, Heat Exch.) Nat'l. Bd. No. 2542 Yr. Built 1959

Items 4-9 incl. to be completed for single wall vessels (such as air tanks), jackets of jacketed vessels, or shells of heat exchangers.

4. SHELL: Material SA 285 C T.S. flg 55000 Nominal Thickness 5/16 in. Corrosion Allowance 0.03-25 in. Diam. 6 ft. 0 in. Length 6 ft. 9-1/4 in.  
 (Kind and Spec. No.) (Fig. or F.B. & lowest T.S.)

5. SEAMS: Long Dbl butt S.R. no X.R. no Sectioned no Efficiency 64 %  
 (Welded, Dbl., Single, Lap, Butt) (Yes or No) (Spot or Complete) (Yes or No)  
 Girth Dbl butt S.R. no X.R. no Sectioned no No. of Courses 1

If riveted describe seams fully on reverse side of form.

6. HEADS: (a) Material SA 285 C T.S. flg 55000 (b) Material SA 285 B T.S. flg 50000  
 Location Thickness Crown Radius Knuckle Radius Elliptical Ratio Conical Apex angle Hemispherical Radius Flat Diameter Side to Pressure  
 (a) bottom 1/2 (nom) 72 4-3/8 2:1 0 0 0 0 concave  
 (b) 0 0 0 0 0 0 0 0 0 0

If removable, bolts used (Material, Spec. No., T.S., Size, Number) Other fastening 1960 (Describe or Attach Sketch)

7. STAY BOLTS: If hollow Attachment Pitch (Material) (Size of Hole) (Threaded, Welded) (Horiz.) (Vert.) Diam. (Nominal)

8. JACKET CLOSURE: Ogee apron and weld  
 (Describe as ogee & weld, bar, etc. If bar give dimensions. If hollow describe or sketch.)

9. Constructed for (Int.) pressure of 75 psi Max. Temp. 650 °F. Subzero 0 °F. Hydrostatic Test 112-1/2 psi.

Items 10 and 11 to be completed for tube sections.

10. TUBE SHEETS: Stationary. Material (Kind & Spec. No.) Diam. in. Thickness in. Attachment (Welded, Bolted)  
 Floating. Material Diam. in. Thickness in. Attachment

11. TUBES Material O.D. in. Thickness inches or page. Number Type (Straight or U)

Items 12-15 incl. to be completed for inner chambers of jacketed vessels, or channels of heat exchangers.

12. SHELL: Material SA 285 B T.S. flg 50000 Nominal Thickness 3/4 in. Corrosion Allowance 0.03-25 in. Diam. 5 ft. 7-1/2 in. Length 8 ft. 11-1/2 in.  
 (Kind and Spec. No.) (Fig. or F.B. & lowest T.S.)

13. SEAMS: Long Dbl butt S.R. yes X.R. no Sectioned no Efficiency 64 %  
 (Welded, Dbl., Single, Lap, Butt) (Yes or No) (Spot or Complete) (Yes or No)  
 Girth Dbl butt S.R. yes X.R. no Sectioned no No. of Courses 1

If riveted describe seams fully on reverse side of form.

14. HEADS: (a) Material SA 285 B T.S. flg 50000 (b) Material SA 285 B T.S. flg 50000 (c) Material SA 285 B T.S. flg 50000

- Location Thickness Crown Radius Knuckle Radius Elliptical Ratio Conical Apex angle Hemispherical Radius Flat Diameter Side to Pressure  
 (a) Top, bottom, ends 11/16 0 0 2:1 0 0 0 0 both  
 (b) Channel-top 11/16 0 0 2:1 0 0 0 0 concave  
 (c) Floating 0 0 0 0 0 0 0 0 0

If removable, bolts used (a) (Material, Spec. No., T.S., Size, Number) (b) (Material, Spec. No., T.S., Size, Number) (c) (Material, Spec. No., T.S., Size, Number)

15. Constructed for (Int.) pressure of int. 100 psi Max. Temp. 75 °F. Subzero 0 °F. Hydrostatic Test 112-1/2 psi.

Items below to be completed for all vessels where applicable.

16. SAFETY VALVE OUTLETS: Number 2 Size 2" coups Location in top jkt. sh.

17. NOZZLES:  

Purpose (Inlet, Outlet, Drain)	Number	Diam. or Size	Type	Material	Thickness	Reinforcement Material	How Attached
<u>agit.</u>	<u>1</u>	<u>5-1/4</u>	<u>flgd.</u>				<u>fus. w.</u>
<u>drain</u>	<u>1</u>	<u>6</u>	<u>flgd.</u>				<u>fus. w.</u>
<u>inlets</u>	<u>1 each</u>	<u>2, 3, 5, 6</u>	<u>flgd.</u>				<u>fus. w.</u>
<u>outlets</u>	<u>2</u>	<u>4</u>	<u>flgd.</u>				<u>fus. w.</u>

18. INSPECTION Manholes, No. 1 each Size 30 & 12 x 16 Location in top hd. and in 30 MH cover  
 OPENINGS: PS Manholes, No. 1 Size 4 Location in 12 x 16 MH cover.  
 Threaded, No. 0 Size 0 Location 0

19. SUPPORTS: Skirt (Yes or No) Lugs (Number) Legs (Number) Other 4-3" coups Attached fus. w. jkt. (Where & How)

20. REMARKS: Vessel built to dwg. 6710-C for chemical service.  
Testing per HG-00-1 for enameled vessels.  
 (Brief description of purpose of the vessel, as Air Tank, After Cooler, Jacketed Cooler, etc. State contents of each part.)

(Over)

We certify that the statements made in this report are correct and that all details of material, construction, and workmanship of this unfired pressure vessel conform to the ASME Code for Unfired Pressure Vessels.

Date AUG 27 1959, 19..... Signed Glascote Products, Inc. By E. E. Mearns  
(Manufacturer)

#877 Certificate of Authorization Expires December 31, 1961

DIRECTOR OF PROD. ENG.

### CERTIFICATE OF SHOP INSPECTION

Insurance Company's Serial Number H.S.B. 2761

VESSEL MADE BY Glascote Products, Inc. at Cleveland 17, Ohio

I, the undersigned, holding a Certificate of Competency as an Inspector of Boilers and Unfired Pressure Vessels in Nat'l Bd. and employed by THE HARTFORD STEAM BOILER INSPECTION AND INSURANCE COMPANY of HARTFORD, CONN., inspected internally and externally, the vessel described in this report on 19..... and certify that the statements made in this report are correct, corresponding with mill test reports of materials furnished by the builders, and measurements made of the vessel; and that this vessel is constructed in accordance with the ASME Code for Unfired Pressure Vessels.

Date AUG 27 1959, 19.....

[Signature]  
Inspector's Signature

Commissions N.B. 3342  
State or Nat'l Bd. & Number

### CERTIFICATE OF FIELD ASSEMBLY INSPECTION

I, the undersigned, holding a Certificate of Competency as an Inspector of Boilers and Unfired Pressure Vessels in THE STATE OF..... and employed by..... of....., have compared the statements in this manufacturer's data report with the completed vessel, and certify that parts referred to as data items..... were completed in the field in accordance with the requirements of the ASME Code for Unfired Pressure Vessels. The completed vessel was inspected and subjected to a hydrostatic test of..... psi.

Date....., 19.....

[Signature]  
Inspector's Signature

Commissions.....  
State or Nat'l Bd. & Number



FORM R-1 REPORT OF WELDED ☒ REPAIR OR ☐ ALTERATION  
as required by the provisions of the National Board Inspection Code

RA-1000

1. Work performed by DeDietrich (USA), Inc. SO#44658A  
(name of repair or alteration organization) (P.O. no., job no., etc.)  
Highway 44 & McKinzie Road, Corpus Christi, TX 78460  
(address)

2. Owner Sterling Chemical, PO Box 1311  
(name)  
Texas City, Tx 77592  
(address)

3. Location of installation Sterling Chemical  
(name)  
201 Bay Street South, Texas City, TX 77590 Attn: F. DeZingotita PO#018691  
(address)

4. Unit identification: RV Name of original manufacturer Glascote Products, Inc.  
(boiler, pressure vessel)

5. Identifying nos.: 18589 2542 NA NA 1959  
(mfr's. serial no.) (original National Board no.) (jurisdiction no.) (other) (year built)

6. Description of work Removed jacket, replaced 3-2" jacket couplings, reglassed internal chamber, and  
(use back, separate sheet, or sketch if necessary)  
rewelded jacket to internal chamber. Replaced expansion diaphragm.

Welders: 4, 19, 21, 24 Pressure test, ~~if applied~~ 75 psi

7. Replacement Parts. Attached are Manufacturers' Partial Data Reports properly identified and signed by Inspectors for the following items of this report:

(name of part, item number, mfr's. name and identifying stamp)

8. Remarks: 3-2 jacket couplings, part #7649666, SA105  
1-12" expansion donut, part #7612661, SA286B  
1-12" expansion collar, part #7612679, SA106B  
1-3/4" half coupling, part #7649654, SA105

(reverse side of form)

### CERTIFICATE OF SHOP/FIELD COMPLIANCE

We verify that the statements made in this report are correct and that this \_\_\_\_\_ repair \_\_\_\_\_  
conforms to the National Board Inspection Code. (repair or alteration)

"R" Certificate of Authorization no. 2176 expires May 28, 19 96.  
Jurisdictional Authorization no. \_\_\_\_\_ expires \_\_\_\_\_, 19 \_\_\_\_\_.

Date 8/5, 19 93 DeDietrich (USA), Inc. Signed J. Sullivan  
(repair organization) (representative)

### CERTIFICATE OF SHOP/FIELD INSPECTION

I, the undersigned, holding a valid Commission issued by The National Board of Boiler and Pressure Vessel Inspectors and certificate of competency issued by the state or province of Texas and employed by C.U.I.C. of Boston, Mass. has inspected the work described in this report on 8/5, 19 93 and stated that to the best of my knowledge and belief, this work has been done in accordance with the National Board Inspection Code. By signing this certificate, neither the undersigned nor my employer makes any warranty, expressed or implied, concerning the work described in this report. Furthermore, neither the undersigned nor my employer shall be liable in any manner for any personal injury, property damage or loss of any kind arising from or connected with this inspection.

Date 08-06, 19 93 Signed L. Robbins Commissions NB#8826A-TX#985  
L. Robbins (Inspector) (National Board (incl. endorsements), state, prov., and no.)

Glascote  
1000 Gal.

**FORM R-1, REPORT OF WELDED ☒ REPAIR OR ☐ ALTERATION**  
**As Required by the Provisions of The National Board Inspection Code**

1. Work done by De Dietrich (USA), Inc. Union, New Jersey 7138  
(Name and address of repair or alteration organization) (Serial No.)

2. Owner \_\_\_\_\_  
(Name and address of owner)

3. Location of Installation Monsanto Company Texas City, Texas  
(Name and address)

4. Unit Identification Jkt. Pressure Vessel Name of Manufacturer Glascote Co.  
(Boiler, Pressure Vessel)

5. Identifying Nos. 18589 2542 N. J. - 1959  
(Mfr. Serial No.) (National Board No.) (Jurisdiction) (Other) (Year Built)

6. Description of Work: Removed jacket, glass lined inside inner vessel, and  
(Use back, separate sheet, or sketch if necessary)  
welded jacket back in place.

\_\_\_\_\_ Pressure Test, if Applied 112.5 psi

7. Remarks: Attached are Manufacturer's Partial Data Reports properly identified and signed by Commissioned Inspectors for the following items of this report: \_\_\_\_\_

(Name of part, item number, mfr's name, and identifying stamp)

**CERTIFICATE OF COMPLIANCE**

We certify that the statements made in this report are correct and that all \_\_\_\_\_ (design)  
material, construction, and workmanship on this repair \_\_\_\_\_ conform to  
The National Board Inspection Code. (repair, alteration)  
Date 7/24/80 Signed De Dietrich (USA), Inc. by Anthony A. Chiarella  
(Repair, Alteration Organization) (Authorized Representative)  
Our Certificate of Authorization No. 14722 to use the U Symbol expires July 25, 19 81

**CERTIFICATE OF INSPECTION**

I, the undersigned, holding a valid commission issued by The National Board of Boiler and Pressure Vessel Inspectors or the State or Province of New Jersey and employed by \_\_\_\_\_  
Royal Indemnity Co. of New York have inspected  
the work described in this Data Report on 7-24, 1980 and state that to the best of my knowledge and belief,  
this work has been done in accordance with The National Board Inspection Code.  
By signing this certificate, neither the Inspector nor his employer makes any warranty, expressed or implied, concerning the work described in this Report. Furthermore, neither the Inspector nor his employer shall be liable in any manner for any personal injury or property damage or a loss of any kind arising from or connected with this inspection, except such liability as may be provided in a policy of insurance which the Inspector's insurance company may issue upon said object and then only in accordance with the terms of said policy.  
Date 7-24-80 Robert N. Bunting Commissions NBS 361  
Inspector Nat'l Board, State, Province and No.