

69839

1. Seams: Longitudinal D.B.W. (Welded, Gal. Engr. Lap. Butt) R.T. SPOT (Spot or Full) Efficiency 85 %
 H.T. Temp. --- F Time --- Girth --- D.B.W. (Welded, Gal. Engr. Lap. Butt)
 R.T. SPOT No. of Courses 5
 2. Heads: (a) Material (Spec. No., Grade) (b) Material (Spec. No., Grade)
 Location (Spigot Bottom, Ends) Minimum Thickness Corrosion Allowance Crown Radius Knuckle Radius Elliptical Ratio

(a) SEE ITD #12

(b)

Conical Apex Angle Hemispherical Radius Flat Diameter Side to Pressure (Convex or Concave)

(a)

(b)

If removable, bolts used (describe other fastenings)

(Material, Spec. No., Gr., Size No.)

(1) CRS IN SHELL

3. Type of Jacket

BELLGWS EXP. JT.

Proof Test

MAT'L. SA-240-TP-304

(2) Jacket Closure VAPOR BELTS 59" I.D. X 5/8" THK X 38 1/2 LG. SA-285-C.W/END-FLGS.

Welded description sketch. 2" THK X 60 1/2" O.D. X 49" I.D. SA-515-70

11. Constructed for max. allowable working pressure 167 psi at max. temp 350 F Min. temp. (when less than -20 F) --- F. Hydrostatic, pneumatic, or combustion test pressure 290 psi.

Items 12 and 13 to be completed for tube sections

(1) 12. Tubeshells: Stationary-Material SA-240-304-L

Diam. 48

Subject to pressure

Nominal Thickness 4 in. Corrosion Allowance

STATIONARY

13. Flanges-Material SA-240-304-L

(Spec. No., Gr.)

Diam. 48

in.

in Attachment WELDED

Nominal Thickness 3/4 in. Corrosion Allowance

Attachment WELDED

13. Tubes: Material SA-240-TP-304

(Spec. No., Gr.)

O.D. 3/4

in

Nominal Thickness 16

Wt. Spillage

Number 1759

Type STRAIGHT

(Straight or U)

Items 14-17 incl. to be completed for vapor chambers of jacketed vessels or channels of heat exchangers

14. Shell: Material SA-240-304-L

(Spec. No., Gr.)

Nominal Thickness 2

in

Corrosion Allowance 0

Diam. 4

in.

Length 0

in

in

15. Seams: Longitudinal D.B.W. (Welded, Gal. Engr. Lap. Butt)

R.T. SPOT

(Spot or Full) Efficiency 85 %

H.T. Temp. ---

F

Time ---

Girth ---

D.B.W.

(Welded, Gal. Engr. Lap. Butt)

R.T. SPOT

(Spot or Full)

No. of courses 1 EACH

16. Heads: (a) Material SA-240-TP-304-L

(Spec. No., Grade)

(b) Material SA-515-70

(Spec. No., Grade)

Location (Spigot Bottom, Ends)

Minimum Thickness

Corrosion Allowance

Crown Radius

Knuckle Radius

Elliptical Ratio

(a) R. CHAN. COV.

NOM. 0

2.1

(b) F. CHAN. COV.

3/4" THK

W/ 3/8" THK

304-L

STN. LINER

Conical Apex Angle

Hemispherical Radius

Flat Diameter

Side to Pressure (Convex or Concave)

CONCAVE

(a) ---

(b) ---

If removable, bolts used (describe other fastenings)

ALLOY STL. SA-193-B7 (3/4) 72

(Material, Spec. No., Gr., Size No.)

17. Constructed for max. allowable working pressure 222 psi at max. temp 275 F Min. temp. (when less than -20 F) --- F. Hydrostatic, pneumatic, or combustion test pressure 344 psi.

Items below to be completed for all vessels where applicable

18. Safety Valve Outlets: Number SEE REMARKS Size

Location

19. Nozzles:

Purpose (Inlet, Outlet, Drain)	Number	Diam. or Size	Type	Material	Nominal Thickness	Reinforcement Material	How Attached
CH. IN & OUT	(2)	10"-150	ANSI-LJF	SA-181-1	SA-312-304-L	.365	SA-240-304-L WELDED
SH. IN & OUT	(2)	18"-150	ANSI-RF	SA-181-1	SA-106-B	.500	INHERENT WELDED
SH. COIN	(2)	3/4	COUP	FORGED STEEL	---	---	INHERENT WELDED
CH. COIN	(2)	3/4	COUP	SA-182-F	304-L	---	---

FORM U-1 MANUFACTURERS' DATA REPORT FOR PRESSURE VESSELS
As Required by the Provisions of the ASME Code Rules, Section VIII, Division 1

1. Manufactured by STRUTHERS WELLS-GULFPORT, INC. GULFPORT, MISSISSIPPI JOB #3-74-04-38426
THE BADGER CO. AGENTS FOR THE (Name and address of manufacturer) P.O. E-4581-40 (REV. 1) ITEM TT-122
2. Manufactured for MONSANTO CO. ACRYLONITRILE PLANT #AN-5, TEXAS CITY, TEXAS MC#51E9
(Name and address of purchaser)
3. Location of Installation MONSANTO CO. ACRYLONITRILE PLANT, TEXAS CITY, TEXAS
(Name and address)
4. Type HORIZ. EXCH. Vessel No. 38426 3-74-04-38426-C1 REV. 2
(Work. or vert. tank) (Mfr's Serial No.) (ICRN) (Drawing)
2300 Year Built 1970
(Net Brd No)
5. The chemical and physical properties of all parts meet the requirements of material specifications of the ASME BOILER AND PRESSURE VESSEL CODE. The design, construction, and workmanship conform to ASME Rules, Section VIII, Division 1 1974 and Addenda to 1970 and Code Case no. _____
(Year) (Date)
Special service per UG-120(d) _____

Manufacturers' Partial Data Reports properly identified and signed by Commissioned Inspectors have been furnished for the following items of the report: LINE #9 COVERED BY PARTIAL DATA BY U.S. BELLows CORP. SANTEE, CALIF.

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

Items 6-11 incl. to be completed for single wall vessels, jackets of jacketed vessels, or shells of heat exchangers

6. Shell: Material SA-285-C Nominal Thickness 1/8 in. Corrosion Allowance 1/8 in.
(Spec. No., Grade)
Diam. 4 ft. Length 19 ft. 1/16 in.

CERTIFICATE OF COMPLIANCE

We certify that the statements made in this report are correct and that all details of design, material, construction, and workmanship of this vessel conform to the ASME Code for Pressure Vessels, Section VIII, Division 1.

Date 1-15-76 Signed STRUTHERS WELLS-GULFPORT, INC. by [Signature]
(Manufacturer) (Representative)

"U" Certificate of Authorization No. 7847 expires MARCH 30 1979

CERTIFICATE OF SHOP INSPECTION

Vessel made by STRUTHERS WELLS-GULFPORT, INC. at GULFPORT, MISSISSIPPI
I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State or Province of _____ and employed by THE HARTFORD STEAM BOILER I. & I. CO.
of HARTFORD, CONN. have inspected the pressure vessel described in this Manufacturers' Data Report on FEB. 6 1976 and state that, to the best of my knowledge and belief, the Manufacturer has constructed this pressure vessel in accordance with ASME Code, Section VIII, Division 1.

By signing this certificate neither the Inspector nor his employer makes any warranty, expressed or implied, concerning the pressure vessel described in the Manufacturers' Data 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.

Date FEB 6 1976
Signed Ralph J. Johnson Commissions NB # 7751
(Inspector) (Nat'l Board, State, Province and No.)

CERTIFICATE OF COMPLIANCE FOR FIELD WORK

We certify that the statements made in this report are correct and that all details of design, material, construction, and workmanship of this vessel conform to the ASME Code for Pressure Vessels, Section VIII, Division 1.

Date _____ Signed _____ by _____
(Manufacturer) (Representative)

"U" Certificate of Authorization No. _____ expires _____ 19 _____

CERTIFICATE OF FIELD ASSEMBLY INSPECTION

I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State or Province of _____ and employed by _____
of _____ have compared the statements in this Manufacturers' Data Report with the described pressure vessel and state that parts referred to as data items _____ not included in the certificate of shop inspection, have been inspected by me and that, to the best of my knowledge and belief, the Manufacturer has constructed and assembled this pressure vessel in accordance with ASME Code, Section VIII, Division 1.

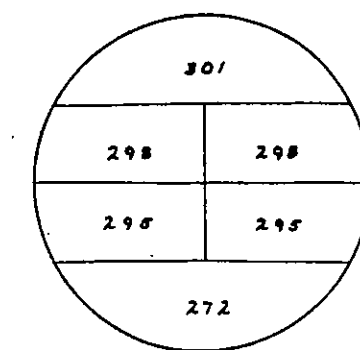
The described vessel was inspected and subjected to a hydrostatic test of _____ psi

By signing this certificate neither the Inspector nor his employer makes any warranty, expressed or implied, concerning the pressure vessel described in this Manufacturers' Data 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.

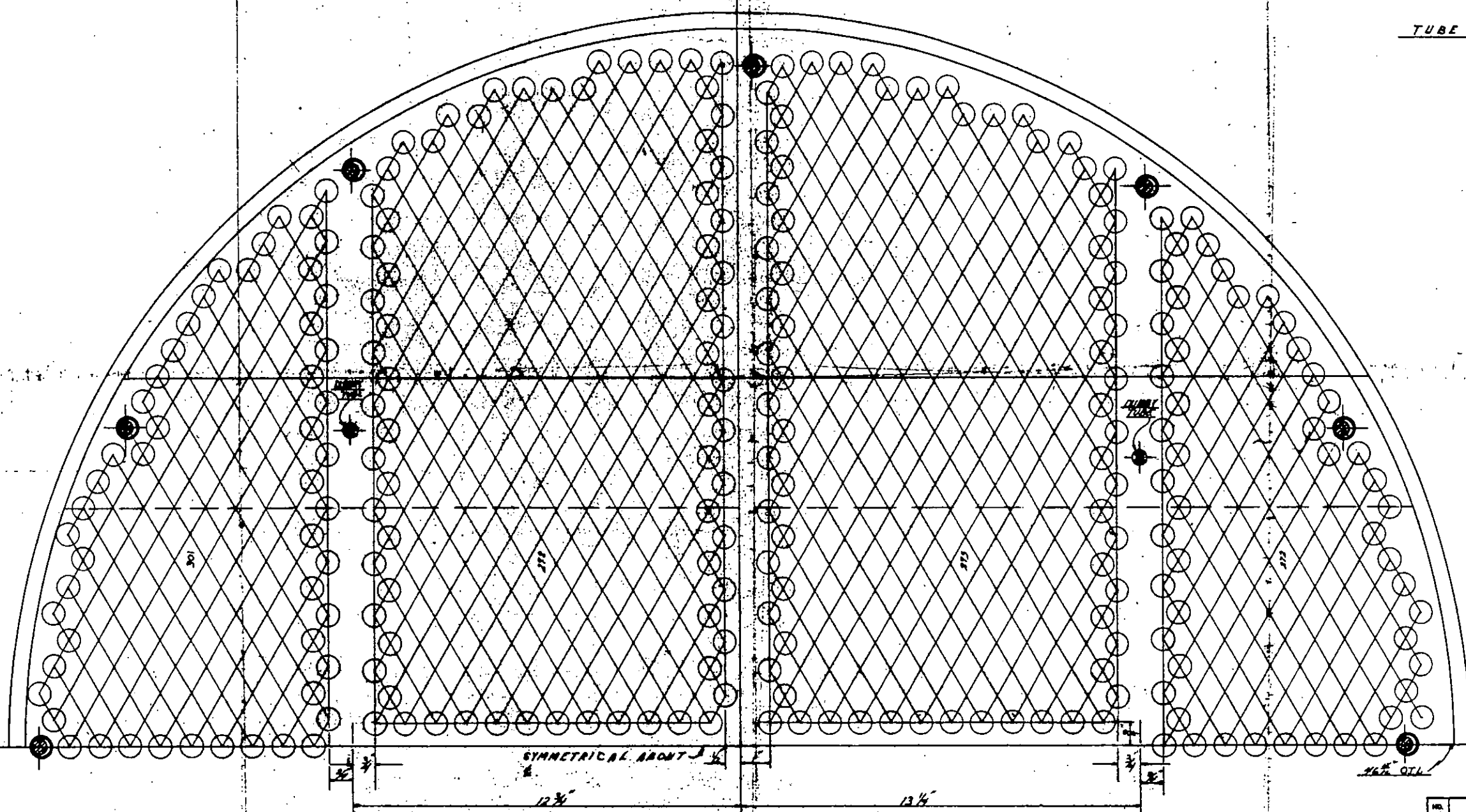
Date _____
Signed _____ Commissions _____
(Authorizing Inspector) (Nat'l Board, State, Province and No.)

3-7404-38426 D1

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TUBE ARRANGEMENT



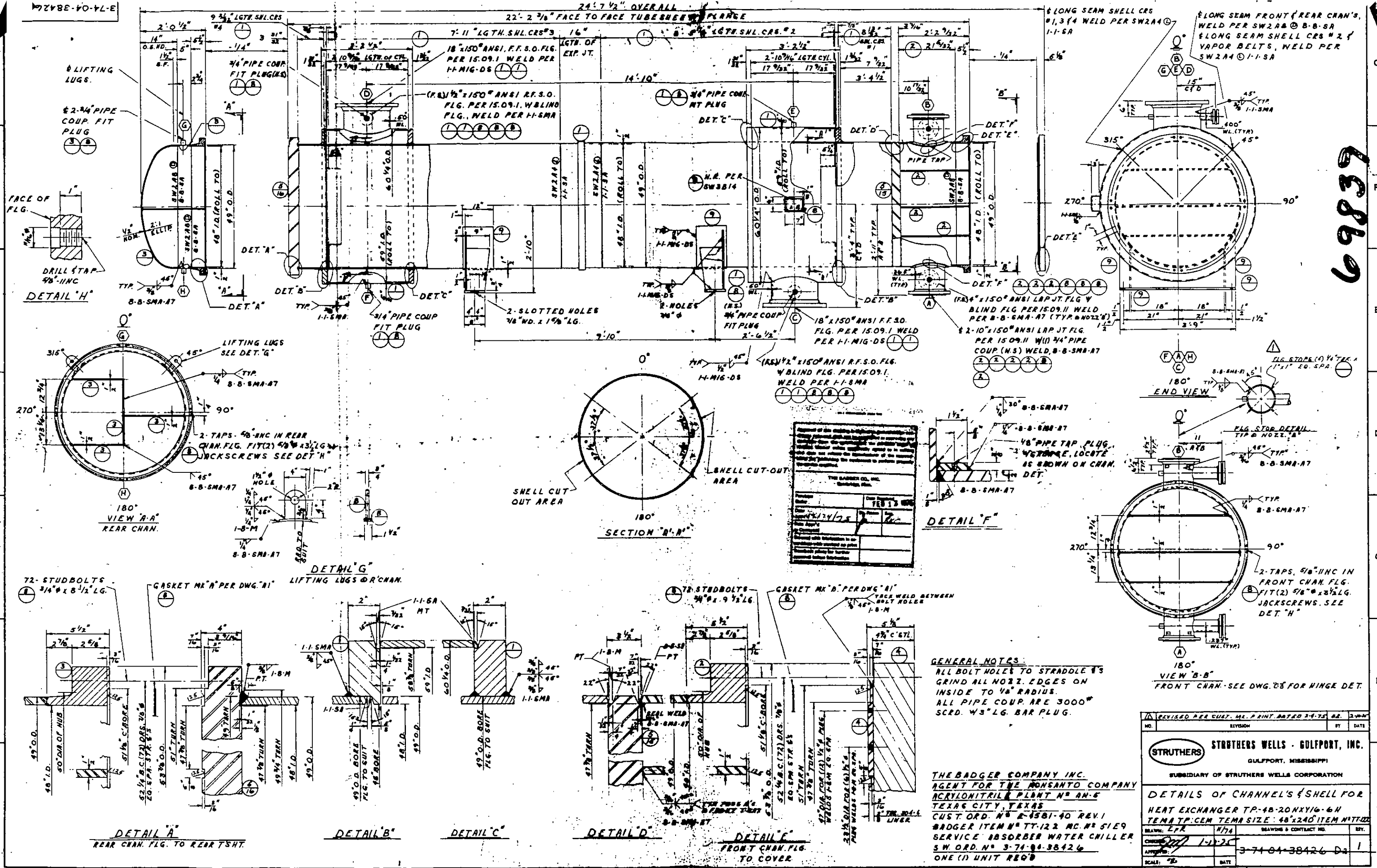
1759 TUBES—34" OD—1" TH PITCH—6 PASS
VIEW SHOWN LOOKING CHAN SIDE FRONT TUBE
SEE TUBE SHEET & RAFFLE DETAIL FOR DRILLING

THE BRIDGER COMPANY, INC.
AGENTS FOR THE HUBBARD COMPANY
BENTONVILLE, ARK. 72715
TEXAS CITY, TEXAS
CITY, OKLA. 73101
HARPER, ILL. 61741
SCHOOL, KANSAS 66401
IN DEPT. OF AGRICULTURE
THE UNITED STATES

Approval of this drawing is limited to general design and details only and shall not be considered as approving any deviation from the specification, the purchase order or contract unless specifically agreed to in writing and does not release the manufacturer of the equipment from liability for furnishing the equipment to perform properly the work specified.

THE BRIDGER CO., INC. Cape Girardeau, Mo.	
Project	1759-405
Date	1/15
Appr'd	[Signature]
Rev Appr'd	[Signature]
As Checked	
Present with tolerances in accordance with contract or other	
Resubmit plans for further approval before fabrication	

NO.	REVISION	BY	DATE
STRUTHERS STRUTHERS WELLS - GULFPORT, INC. GULFPORT, MISSISSIPPI SUBSIDIARY OF STRUTHERS WELLS CORPORATION			
TUBE LAYOUT			
SCALE: 1/8" = 1'-0"	DATE: 1-17-71	DRAWING & CONTRACT NO.	NO.
3-7404-38426-D1		0	



THE BADGER COMPANY, INC. GULFPORT, MISSISSIPPI			
Part No.	Rev.	Date	By
374-01-38426	1	10/25/75	TEB
Description: Channel and Shell for Heat Exchanger			
Material: A304 Stainless Steel			
Welding: 1/8" A304 Electrode			
Finish: 320 Mesh			
Notes: See Detail A for Flange			

GENERAL NOTES:
ALL BOLT HOLES TO STRADDLE & S GRIND ALL NOZZ. EDGES ON INSIDE TO 1/4" RADIUS.
ALL PIPE COUP. ARE 3000" SCRD. 1/2" LG. BAR PLUG.

THE BADGER COMPANY, INC.
AGENT FOR THE MONSANTO COMPANY
ACRYLONITRILE PLANT # AN-6
TEXAS CITY, TEXAS
CUST. ORD. NO. 2-1581-40 REV. 1
BADGER ITEM NO. TT-122 AC. NO. 5129
SERVICE: ABSORBER WATER CHILLER
S.W. ORD. NO. 3-74-86-38426
ONE (1) UNIT REQ'D

REVISED PER CUST. WL. PRINT DATED 3-4-75		BY	DATE
STRUTHERS		STRUTHERS WELLS - GULFPORT, INC.	
GULFPORT, MISSISSIPPI		SUBSIDIARY OF STRUTHERS WELLS CORPORATION	
DETAILS OF CHANNEL & SHELL FOR			
HEAT EXCHANGER TP-4B-20XNY16-6N			
TENA TP-CEM TEMA SIZE: 48"X240" ITEM #11700			
SCALE: 1/4" = 1'-0"	DATE: 10/25/75	BY: TEB	CHK: JTB
374-01-38426		D3 1	

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