

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

70723

194

- 1 Manufactured by Delta Southern Co., Inc., P.O. Box 3034, Baton Rouge, Louisiana 70821
(Name and address of manufacturer)
- 2 Manufactured for Pullman Kellogg Co., 1300 Three Greenway Plaza East, Houston, Texas 77046
(Name and address of purchaser)
- 3 Location of installation Plaquemine, Louisiana
(Name and address)
- 4 Type Heat Exch. Vessel No. 51853-77-1 - C-51853 Rev. 1 4384 Year Built 1977
(Type of vessel) (Mfg's Serial No.) (CRN) (Drawing) (Nat'l Bld 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 Winter 75 and Code Case no. *1177-7
(Date) (Year)

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: *Expansion Joint, U.S. Bellows Division, SN-2757U2-2259
(Name of part, item number, mfg'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 SA516GR.70 Nom Thickness 7/8 in Corrosion Allowance 1/4 in. Diam 2 ft 7 in. Length 10 ft. in Sm.
(Spec. No. Grade)
- 7 Seams: WDB R.T. Full Efficiency 100 % H.T. Temp - F Time - Girth WDB R.T. Full No. of Courses 3
(Dist. Sngl.) (Spot or Full) (Dist. Sngl.) (Spot, Partial, or Full)

8. Heads: (a) Material SA516GR.70 (b) Material -
(Spec. No. Grade) (Spec. No. Grade)

	Location (Top, Bottom, Ends)	Minimum Thickness	Corrosion Allowance	Crown Radius	Knuckle Radius	Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure (Convex or Concave)
Top	End	7/8"	1/4"	-	-	2:1	-	-	-	Concave
Bot	-	-	-	-	-	-	-	-	-	-

If removable, bolts used (describe other fastenings) (a) SA193B7, 1", 48
(Material Spec. No. Gr. Size, No.)

9. Type of Jacket - Proof Test -
10. Jacket Closure - If bar, give dimensions - If bolted, describe or sketch.
(Describe as open & weld bar etc.)
- 11 Constructed for max. allowable working pressure 660 psi at max. temp. 380 F Min. temp. (when less than -20 F) - F. Hydrostatic, ~~pneumatic~~ test pressure 990 psi.

Items 12 and 13 to be completed for tube sections

12. Tubesheets: Stationary Material SA240T316 Diam. 38-1/4 in. Nominal Thick. 3-5/8 in. Corrosion Allow. - in. Attachment Bolted
(Spec. No. Gr.) (Subject to pressure) (Welded, Bolted)
- Floating Material SA240T304 Diam. 30-5/8 in. Nominal Thick. 3-5/8 in. Corrosion Allow. - in. Attachment Bolted
(Spec. No. Gr.)

- 13 Tubes: Material SA249T316 O.D. 3/4 in. Nominal Thickness 16 gauge Number 680 Type Straight
(Spec. No. Gr.) (Straight or)

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

14. Shell: Material SA240T304 Nominal Thickness 3/8 in. Corrosion Allowance None in. Diam. 31" ID X 18" ID 3 0-11/16 4 in. Nozz. to F.F.
(Spec. No. Gr.)
15. Seams: WDB R.T. ** Efficiency ** % H.T. Temp - F Time - Girth WDB R.T. ** No. of courses 6
(Dist. Sngl.) (Spot or Full) (Dist. Sngl.) (Spot, Partial or Full)

16. Heads: (a) Material SA240T304 (b) Material -
(Spec. No. Grade) (Spec. No. Grade)

	Location (Top, Bottom, Ends)	Minimum Thickness	Corrosion Allowance	Crown Radius	Knuckle Radius	Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure (Convex or Concave)
Top	Flt. Hd.	2"	None	22"	-	-	-	-	-	Concave
Bot	-	-	-	-	-	-	-	-	-	-

If removable, bolts used (describe other fastenings) (a) SA193B7, 5/8, 36
(Material Spec. No. Gr. Size, No.)

- 17 Max. allowable working pressure 75 psi at max temp. 270 F. Min temp - F Hydro test pressure 113 psi.
- Items below to be completed for all vessels where applicable
18. Safety Valve Outlets: Number - Size - Location In Line Installed by Others

19. Nozzles:

Purpose (Inlet, Outlet, Drain)	Number	Size	Type	Material	Nominal Thickness	Reinforcement Material	Notes
Shell Inlet	1	10"	RFWN	SA106GR.B	Sch. 100	SA516GR.70	Welded
Shell Outlet	1	10"	"	"	"	"	"
Shell Outlet	1	3"	"	SA105	1"	Inherent	"
Tube Inlet	1	8"	L.J.	SA312TP304	Sch. 80S	"	"
Tube Outlet	1	18"	RFSO	SA240T304	3/8"	"	"
Nozzle	2	3/4"	RFWN	SA312TP304	Sch. 40S	"	"
Nozzle	1	1"	"	"	"	"	"
Press. & Temp. Conn.	4	3/4"	Cplg.	SA105	6000#	"	"

20. Inspection Openings:

Manholes No. - Size - Location -

Handholes No. - Size - Location -

Threaded No. - Size - Location -

21. Supports: Skirt ☒ Lugs ☒ Legs ☐ Other ☐ Attached ☒ Welded to Shell

22. Remarks: **Channel Cone - Full; Remainder of Channel - Spot

31" X 144" CO₂ Stripper Reboiler:

P.O. 5172-01-C21-104 - Item 105c

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 Sept. 30, 1977 Signed Delta Southern Co., Inc. by B. A. Collier

"U" Certificate of Authorization No. 3252 expires December 31, 1977

CERTIFICATE OF SHOP INSPECTION

Vessel made by Delta Southern Co., Inc. at Baton Rouge, Louisiana

I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and the State of Louisiana and employed by The Hartford Steam Boiler Inspection & Insurance Co. of Hartford, Connecticut of Hartford, Connecticut have inspected the pressure vessel described in this Manufacturers' Data Report on Sept. 30, 1977 and state that, to the best of my knowledge and belief, the Manufacturer has constructed the 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 Sept. 30, 1977

Signed Collier Commissions NAT'L BOARD COMM. NO. 1849

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 _____

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

CERTIFICATE OF FIELD ASSEMBLY INSPECTION

I, the undersigned, holding a valid commission issued by the National Board and Pressure Vessel Inspectors and the State 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 _____