

Pfaudler

A Unit of Robbins & Myers, Inc.

[REDACTED] - 82802

[REDACTED]

REC

Pfaudler, S.A. de C.V.
Av. Encarnación Ortiz 1860
Col. Cosmopolita
02670 México, D. F.
Tel: 355-01-00
Fax: 355-08-09
355-13-98 (Ventas)

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[REDACTED]

Item # V971502

Description: RA-78-2000-100-90 JCW National Board No. 20618

[REDACTED] No.: P700848 Pfaudler Order No.: R164-0414

PSA Job Order: 7-2661E

R 813-2

- 1. Form R-1 Report of Welded Repair**
- 2. Manufacturer's Data Report U-1 Form**
- 3. Copy of Repair Nameplate**
- 4. Copy of Original Nameplate**
- 5. Final Inspection Report**

82802

REPAIRED BY

PAUDLER

PAUDLER S.A. DE C.V. MEXICO

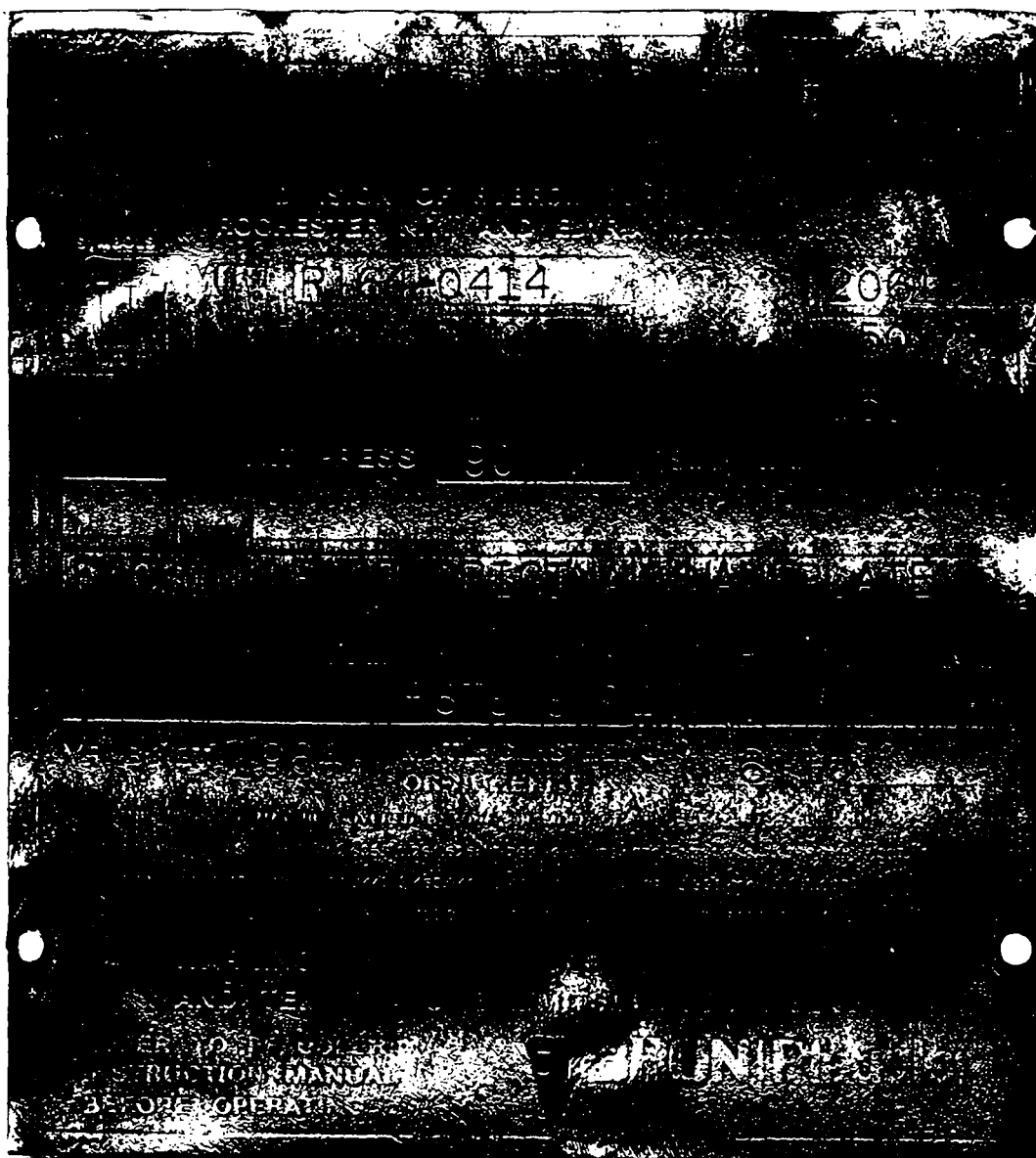
1643	INTERNAL MAWP	100	PSI AT	450
	JACKET MAWP	90	PSI AT	350
	JACKET MAWP	90	PSI W/INT. VAC. LOSS	
NAME	MER# 7-2661 E		DATE OF REPAIR	11/96
REPAIR SYMBOL	ORIG S/N	R 164-0414	YR. BUILT	1964
STAMP NO.	GLASSING & OR NUBERING CONST	9115		

UPPER TEMPERATURES LIMIT IS REDUCED
DUE TO CERAMIC LIMITATIONS.

DO NOT EXCEED DESIGN LIMITS SHOWN ABOVE. EQUIPMENT MAY BE
AND SEVERE PERSONAL INJURY OR DEATH CAN RESULT

DANGER OPERATE THIS EQUIPMENT WITHIN TEMPERATURE AND
PRESSURE LIMITS STATED IN PAUDLER INSTRUCTION MANUAL.
DO NOT EXCEED DESIGN LIMITS SHOWN ABOVE. EQUIPMENT MAY BE
AND SEVERE PERSONAL INJURY OR DEATH CAN RESULT

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November 28, 1996.

QUALITY CONTROL DEPARTMENT

FINAL INSPECTION REPORT

The Quality Control Department Certify the equipment identified with the job order number 7-2661E (Pfaudler item number V971-502) has been reglassed conform to the Quality's Pfaudler specifications and We obtained the following results:

Visual inspection:	Satisfactory
Plugs:	None
Spark test: (15,000 V)	Satisfactory
Glass thickness:	minimum: 41.9 mils. maximum: 87.0 mils.
Hydro test:	vessel: 100 psi jacket: 90 psi

Certified by:

EVA ZEPEDA
QUALITY CONTROL DEPT.

FORM R-1 REPORT OF WELDED REPAIR in accordance with provisions of the National Board Inspection Code

1. Work performed by Pfaudler, S.A. de C.V. 7-2661E
(name of repair organization) (Form R No.)
Encarnación Ortiz 1860, México, D.F. 02670, México
(address)

2. Owner Universal Process Equipment
(name)
1180 RT. 130 South, Robbinsville, N.J., 08691-0338
(address)

3. Location of installation Not Kown
(name)
(address)

4. Unit identification Pressure Vessel Name of original manufacturer The Pfaudler Co.
(boiler, pressure vessel)

5. Identifying nos.: R164-0414 20618 1964
(mfg serial no.) (National Board No.) (jurisdiction no.) (other) (year built)

6. NBIC Edition/Addenda: 1995 Original Construction Code: _____
(if known) (incl edition and addenda)

7. Description of work: _____
(use supplemental sheet, Form R-4, if necessary)
Remove jacket, sandblasting of vessel and jacket, check steel thickness of inner vessel
and jacket with ultrasonic equipment. Repair vessel with weld overlay. Replacement
of diaphragm collar and diaphragm ring. Examination by liquid penetrant. Sandblasting
vessel before apply glass. Weld on jacket and hydrostatic test.
*Vessel: 100 PSI *Jacket: 90 PSI Pressure Test, if applied * psi

8. Replacement Parts. Attached are Manufacturer's Partial Data Reports or Form R-3s properly
completed for the following items of this report:

Sealer Ring:	Mat'l.: SA-516-70	Thk.: 0.4375"
Diaphragm:	Mat'l.: SA-516-70	Thk.: 0.25"
Bottom Head Jacket:	Mat'l.: SA-516-70	Thk.: 0.625"
Jacket Shell:	Mat'l.: SA-285-C	Thk.: 0.5"

(name of part, item number, data report type, mfr's name and identifying stamp)

9. Remarks: _____
Include Manufacturer's Data Report.

CERTIFICATE OF COMPLIANCE

I, Eva Zepeda, certify that to the best of my knowledge and belief the statements in this report are correct
and that all material, construction, and workmanship on this Repair conforms to the National Board Inspection Code.
National Board "R" Certificate of Authorization No. 1643 expires on 4/04, 19 99
Date 12/18, 19 96 Pfaudler, S.A. de C.V. Signed [Signature]
(name of repair organization) (authorized representative)

CERTIFICATE OF INSPECTION

I, Luis Miramontes, holding a valid Commission issued by The National Board of Boiler and Pressure Vessel
Inspectors and certificate of competency issued by the jurisdiction of TEXAS and employed by
THE HARTFORD STEAM BOILER INSPECTION & INSURANCE CO. of HARTFORD, CT. have
inspected the work described in this report on 12-18, 19 96 and state that to the best of my knowledge and
belief this work complies with the applicable requirements of 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 12-18, 19 96 Signed [Signature] Commissions N.B. 10905 "A", TX-1405
(inspector) (National Board (incl endorsements),
and jurisdiction, and no.)

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1. Insulation - Insulation is a material that is used to reduce the transfer of heat between two objects. It is typically made of a material with a low thermal conductivity, such as fiberglass, mineral wool, or polystyrene. Insulation is used in a variety of applications, including building construction, industrial processes, and transportation. It is used to keep buildings warm in the winter and cool in the summer, to reduce energy costs, and to protect equipment from heat damage.

Grch DBFM SR NO XR NO Sectioned NO No. of Courses 1

If removable, take out.

1. Compressed by man _____ Psi. at max. temp. 350 _____ F. Test time - 75 _____ Sec. Total weight of _____ gms. 100 _____

11. TUBES: Material Steel & brass O.D. _____ In. Thickness _____ Inches or Gage Number _____ Type Standard or U

Class DEPT No. Mo Section No No. of courses 1

If removable, list use (a).

10. SAFETY VALVE OUTLETS: Number _____ Size _____ Location _____

12. SUPPORTS: Thread No. MO Size 4 Location None
 (In or On) Leg 0 Other None Attached To Jacket Shell Removable

(All packaging of purpose of the postal, as Air Mail, Air Parcel, Registered Parcel, etc. have contents of each part. All other items on each parcel must be marked with appropriate temperature when applicable.)

* 8A181
* 8A53

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NP 20618

Customer order #A-46019
Pfaudler order # R164-0114

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 May 20, 19 64 Signed THE PFAUDLER CO. by Michael DiBella
(Manufacturer)

Certificate of Authorization Expires #408 Expires 12/31/64

Nat. Bd. # 20618 CERTIFICATE OF SHOP INSPECTION

Inspection Agency's Serial No.

THE PFAUDLER CO.

VESSEL MADE BY a division of PFAUDLER PERMUTIT INC. at Rochester, New York

I, the undersigned, holding a Certificate of Competency as an Inspector of Boilers and Unfired Pressure Vessels in

THE STATE OF NEW YORK and employed by Fidelity & Casualty Co. of N.Y.

Inspected internally and externally, the vessel described in this report on June 3, 1964, 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 June 25, 19 64

M. R. Walker
Inspector's Signature

Commissions N. B. #1325

Date of 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 manufacturers' 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 _____

Inspector's Signature

Commissions'

Date of Nat'l Bd. # Number

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RECORD OF WELDED REPAIRS

Vessel Serial No.: R678-8092

Customer Order No.: A 36337-5885

This is to certify that the fusion-welded repair made by or under the direction of the undersigned on 4-5-79 and consisting of
(date of repair)

Furnished new diaphragm assembly, back-up ring, (2) 6" hand-
(Description of Repair)
hole assemblies, 30" collar, (1) 1/2", (4) 1-1/2", and (7)
2" couplings.

<u>Pfaudler Co.</u>	<u>U.P.V.</u>	<u>-</u>	<u>20618</u>	<u>1964</u>
(Name of original manufacturer)	(Type Vessel)	(Jurisdiction No)	(Nat'l Bd. No)	(Yr. Built)

Located in the plant of Ciba Geigy/J. M. Anderson Co.
(Name of Owner)

At Cranston, RI
(Address of Plant)

was made in accordance with the requirements of the National Board of Boiler and Pressure Vessel Inspectors Chapter III for Repairs by Welding to Boilers or Pressure Vessels and that the welding was done by ASME Qualified Welders
(Name of Qualified Welder)

who has met the test requirements of said rules.

(Note: Draw a sketch to show the repairs on back)

Name of Repair Firm Pfaudler Co.

Signed By George O. Terben Date 4/2/79

Address Rochester, New York

Russell B. Miller NB6658 Date 4/10/79
(Authorized Inspector's Signature)

H. S. B. I. & I. Co.
(Name of Inspection Agency Employed By)

(When alterations are used, follow the instructions of Paragraph RE-50 in the National Board Inspection Code.)