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

Manufactured and of Manufactured for Location of installation		company; 50	,		(Name and addre	ess of Ma	nufactu	er)	St. Lo	uis,	MO 631	10	
	Monsanto	Company; 50	0 Monsa	nto Av	e.: Saucet	BSS OF MA	nutactu 6220	rer) S					
Location of installati													
	on Sa	me		,	Name and address o	H Purcha	ser;						
Type: Hori:	zontal	Separator T	ank		(Name and addr CJ-6012	·ess)			18-L, v. 1		2666_	19	95
(Horiz., ve	rt., or sphere)	(Tank, separator, jkt. v			(Mfg's serial No.)			(Dra	(Drawing No.)		(Natl. Bd. No.)		(Year built
ASME Code, Section	n VIII, Div. 1	1992 Edition											
mag . 14 land talks a	ampleted for single		d Addenda (da	•		de Case i		المساحد المالة	•	ecial Sen	rice per UG-	120(d)	
	course(s):	e wall vessels, jackets o 3	-		ot neat exchangers, ill length (ft & in.);			WS,					
(-,				(2) 0				···········					
Course	```	Material	Thickness	<u> </u>	Long Joint (Cat. A)			-	it (Cat. A, B				
Diameter, in.	Length (ft & in.)		Nom. Corr	. 1	Full, Spot, None	Eff.	Туре	+	pot, None	Eff.	Temp.	 	ime
1 65-3/8"I.S 2 65-3/8"I.S		*5 *5	.313" 0" .313" 0"		Spot Spot	85% 85%	1		ot ot	85% 85%		 	<u></u>
3 65-3/8"I.S.		*5	.313" 0"		Spot	85%	1			85%		_	
	SA240 Gr.		1023 0		(b)) Gr	3041				L	
	*****	o., Grade or Type) H.T.	- Time & Tem	ρ) H.T. • '	lime & Temp)	
Location (Top,	Thickness	Radius	Elliptical	Conica	Hemispherical	Fla	ıc _	Side to	Pressure			gory A	
Bottom, Ends)		Crown Knuckle	Ratio	Apex And	le Radius	Diame	eter	Convex			Full, Spot, N	lone	Eff
Left Hd.	· · · · · · · · · · · · · · · · · · ·	60"I.S. 4"I.S.				 			Yes				
Right Hd.	[.313'' 0''	60"I.S. 4"I.S.				<u> </u>	-		Yes			1	
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(internal)	ns	psi at max.	(inter	mai)	Jacket closure	F Min.	, design	(Des	scribe as og	20	f boited, des		
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This form may be obtained from The National Board of Boiler and Pressure Vessel Inspectors, 1055 Crupper Ave., Columbus., OH 43229

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FORM U-4 MANUFACTURER'S DATA REPORT SUPPLEMENTARY SHEET As Required by the Provisions of the ASME Code Rules, Section VIII, Division 1

_	Мо	nsanto C	ompany;	500 Mo	nsanto A			manulacturer) L 62206					
		Same				(name and ad	idress of purc	haser)					
Location of installation				(name and address)									
		zontal	<u> </u>		arator 7		<u></u>		CJ-6012				
(hor ———	iz., vert.	., or sphere)		(tank, separator, heat exh., etc.)				(mtg's se 2666		1995			
(1	CRN)				(drawing no	5.)		(Na(l. 8d. no.))	(year	built)		
Data Report											 		
Item Number				<u> </u>			Remarks						
19. Nozzles,	ins	pection a	and safe	ty valv	e openir								
Purpose (inlet,		Diameter	Flange		terial	Nozzie Thickness		Reinforcement Material	How Att	ached Flange	Location (Insp. Ope		
Outet, Orain, etc.) Pump	No.	or Size 21.5" I.D.	Type	Nozzle ×6	Flange *7	.313"	Corr.	*5	5k (d)	None	Shell		
		11.5 1.50							& (a-1)				
·	 												
			<u> </u>		1								
*4) SA *5) SA *6) SB *7) SA	<u>-1</u> 82 -240 -463 -240	Tp. 304 -F304L S Gr. 304 Alloy 2 Gr. 304 /8" Thic	/S L S/S O L S/S B	acker M Overlay	aterial (Alloy	20) on	Full Fl	ange Face					
													
ificate of Authorization:		Туре	U	No.	27		Ex	pires Ap	ril 30		96		

NATIONAL BOARD No.

-7.5 PSI € 250°I

Continental Fabricators, Inc.

SER. N.2 CJ-6012 YR. 1995

NAMEPLATE

BRACKET TO BE 304 S/S AND TO EXTEND 3" FROM OUTSIDE OF SHELL

Equip No 21-000943

FLANGES MUST CONFORM TO ANSI BIG.5 STANDARD

EXEMPT FROM IMPACT TESTING PER UHA-51(a) FOR S/S AND

GENERAL SPECIFICATIONS

DESIGN, CONSTRUCTION AND TEST IN ACCORDANCE WITH THE ASME CODE

INTERNAL DESIGN PRESS. 71 PSI ● 302 °F EXTERNAL DESIGN PRESS. 7.5 PSI ● 250 °F

IN HORIZONTAL POSITION

SAI82-F304L/SB462 ALLOY 20

NOZZLES: PIPE SA312-304L/SB464 ALY. 20 PLATE SA240-304L/

48,000 LBS.

1/8" THK. (GARLOCK 3510)

SB463 ALLOY 20

__NUTS___SAI94-8

EFFICIENCY: HEAD 85% SHELL 85%

MAWP 71 PSI . 302 .F LIMITED BY DESIGN

CURRENT CODE, ACCEPTED EDITION

PER UNF-65 FOR ALLOY 20

CORROSION ALLOWANCE NONE

MDMT<u>-20</u> °F • 71 PSI

RADIOGRAPH ___SPOT XRAY PER ASME CODE

SHOP TEST PRESSURE HYDROTEST AT 108 PSI

SA240-304L

SA240-304L

SA240-304

MATERIAL SPECIFICATIONS:

COUPLINGS_____

WEIGHT FULL OF WATER _____

TAG ITEM 304

NO.REQ'D ONE

SUPPORTS __

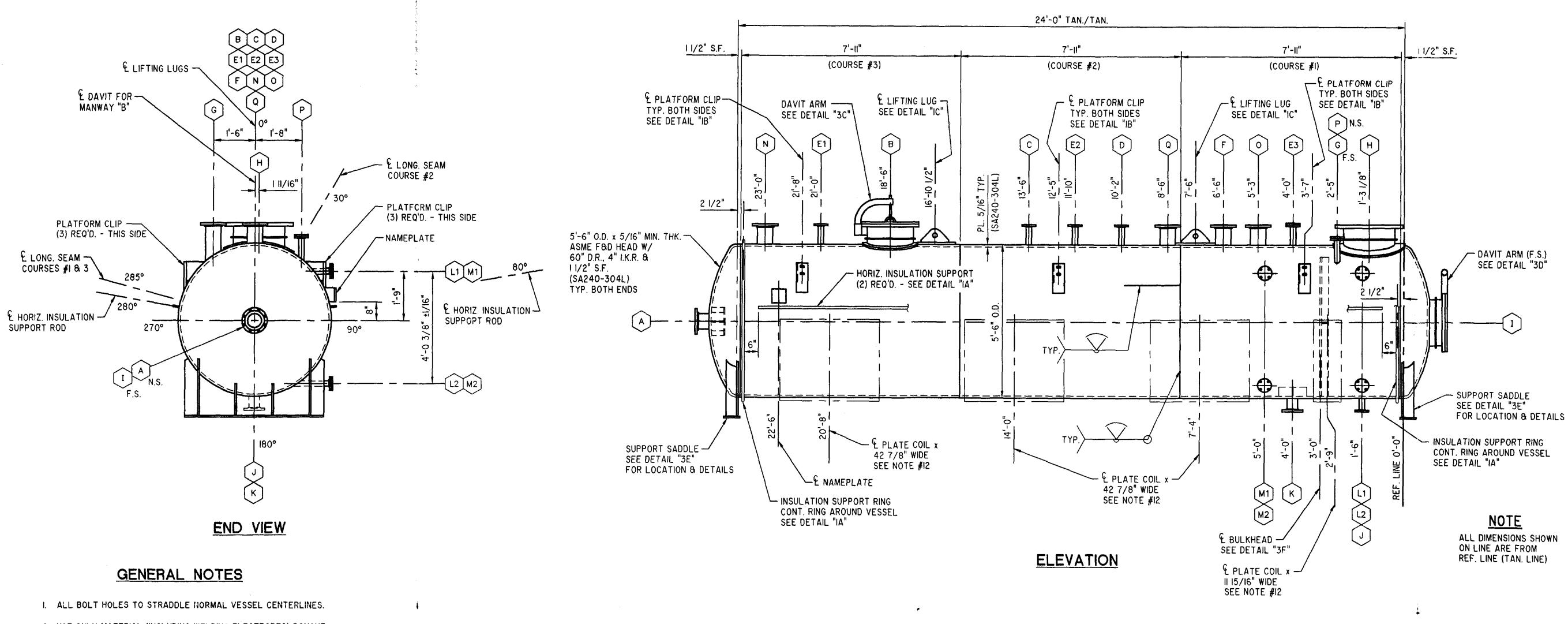
REINFORCEMENT_SA240-304L

INTERNALS SA240-304L

BOLTS/STUDS SAI93-B8

ESTIMATED SHIPPING WEIGHT 11,500 LBS.

ST. LOUIS, MO.



- 2. USE ONLY MATERIAL (INCLUDING WELDING ELECTRODES) BOUGHT FOR THIS JOB DUE TO SPECIAL CHEMISTRY REQUIREMENTS FOR ALL ALLOY 20 MATERIALS.
- 3. SHOP SHALL USE ONLY S/S (P8 MAT'L.) FOR TEMPORARY SUPPORTS AND CLIPS.
- 4. ALL NOZZLES TO BE TRIMMED FLUSH INSIDE VESSEL AND GROUND TO A 1/16" MIN. RADIUS UNLESS NOTED OTHERWISE.
- 5. ALL REINFORCING PADS, OR SEGMENTS THEREOF, TO HAVE ONE I/8" NPT TELL-TALE HOLE LOCATED AT THE LOWEST POINT. TEST WITH AIR AND SOAP SUDS AT 10 PSIG AND PACK WITH GREASE PRIOR TO SHIPPING.
- 6. 100% LIQUID PENETRANT TESTING SHALL BE PERFORMED ON ALL ALLOY 20 WELDS WHICH SHALL INCLUDE THE FINISHED BEVELED SURFACE PRIOR TO ADDING THE FILLET WELD AS WELL AS THE INSIDE AND OUTSIDE SURFACES OF THE COMPLETED WELD.
- 7. PRIOR TO HYDROTESTING, VESSEL SHALL BE THOROUGHLY CLEANED OF ALL DIRT, WELD SPATTER, LOOSE SCALE, OIL AND ALL OTHER FOREIGN MATTER.
- 8. TEST VESSEL WITH I/8" THK. GASKETS (GARLOCK 3510) AND SERVICE BOLTING. DO NOT USE SERVICE GASKETS. TESTING MEDIUM SHALL BE AT OR ABOVE 60°F WHERE PRACTICABLE BUT IN NO CASE BELOW 45°F. TEST WATER MUST BE STERILE (CHLORINATED TO NOT LESS THAN 0.2 PPM BUT NOT MORE THAN I PPM OF DISSOLVED CHLORINE GAS) AND CONTAIN LESS THAN 25 PPM CHLORIDE ION. HYDROTEST CHARTS ARE REQUIRED.

2'-6" TO VESSEL CENTERLINE

(SA240-304)

⊕

DETAIL 1B

PLATFORM CLIP

(6) REQ'D.

TYP. (2) PLC'S.

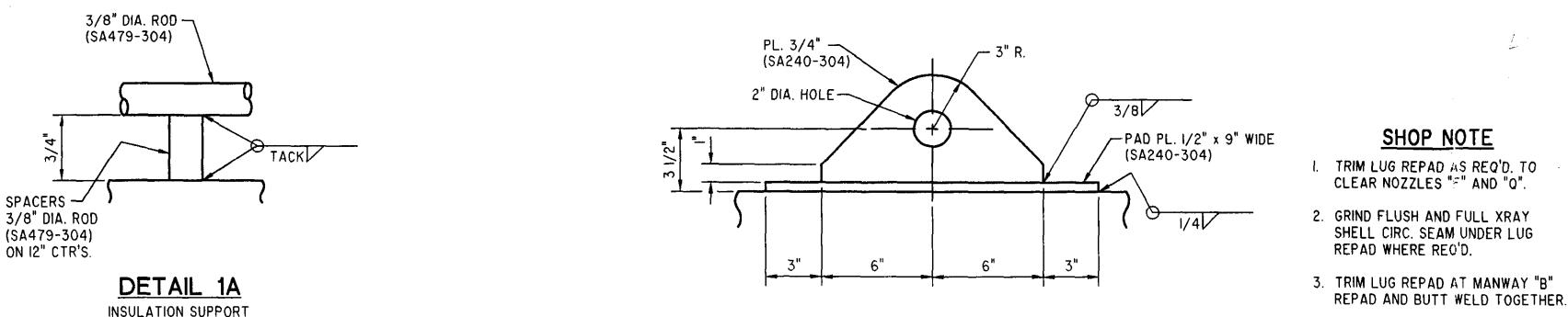
1/4/

2 1/2"

- REF. LINE

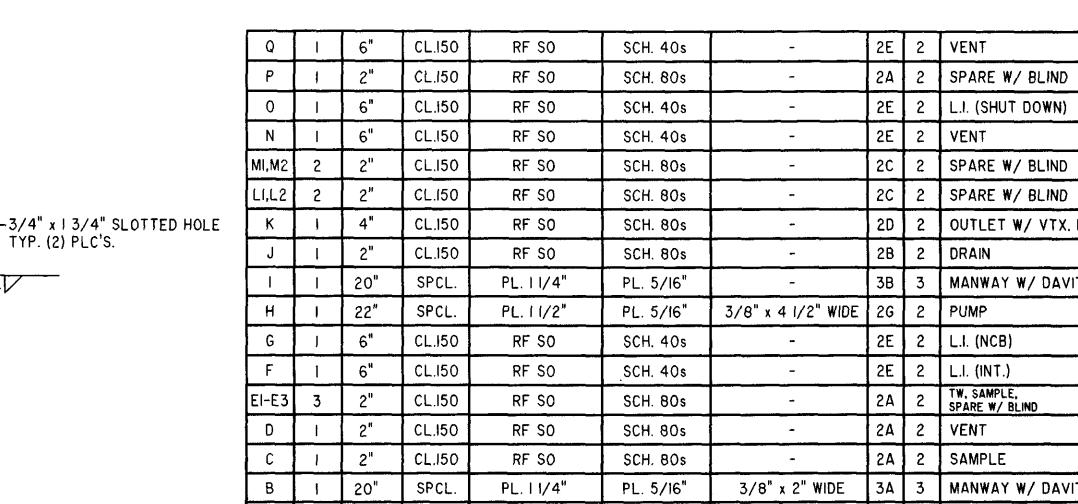
PL. I/2" —

- 9. PRIOR TO SHIPPING, INSTALL SERVICE GASKETS AND BOLTING, COVER ALL REMAINING FLANGE FACES WITH TEST GASKETS AND WOOD OR STEEL COVERS. SHIP LOOSE WITH VESSEL, ONE SPARE GASKET EACH MANWAY "B" AND "I" ONLY.
- 10. THE MONSANTO P.O. NUMBER (BX31783) SHALL BE DYE STENCILED OR PAINTED IN A CONSPICUOUS LOCATION ON THE VESSEL. PAINT OR INK USED FOR MARKING SHALL BE NON-METALLIC PIGMENT TYPE.
- JL SOLVENT CLEAN ALL EXTERIOR SURFACES OF VESSEL, INCLUDING SADDLES, PER SSPC-SPI THEN APPLY ONE COAT OF INTERNATIONAL INTERTUF #132 HS (FORMERLY PORTER #1332) II - 12 MILS WET FILM THICKNESS.
- 12. PLATE COILS SUPPLIED BY CUSTOMER AND INSTALLED BY C.F.I. PLATE COILS ARE TO BE TRIAL FIT AND LUGS INSTALLED PRIOR TO HYDROTESTING. PLATE COILS ARE TO BE INSTALLED AFTER HYDROTESTING AND PAINTING.



Mark Ouan. | Size | Rating |

DETAIL 1C LIFTING LUG (2) REQ'D. SEE "SHOP NOTE"



Neck

NOZZLE SCHEDULE

Type-Face

By mark Muller WELD PROCEDURES SMAW P8-P8 SAW P8-P8 GTAW P8-P8 #1225 SMAW P45-P45

CHRITICAL

下分为智力工程和人类的合理。

Carried and the second

建的排放或的方法。例如

119to 3-20-85

51. (0.00), 200.

#1210 SMAW P8-P45 #2023-A SMAW P8-ALLOY 20 OVERLAY

DESCRIPTION

REVISIONS

REFERENCE SUPERIOR WELDING CO. DWG. NO. 7L-9110-A REV. 2

Continental Fabricators, Inc. 5601 West Park Avenue Saint Louis, Missouri 63110 THIS BRAWNO IS CONFIDENTIAL AND THE PROPERTY OF CONTINENTAL FABRICATORS INC. AND SMALL NOT BE DISCLOSED OR REPROF. ED IN ANY PART OR USED FOR ANY PURPOSE WATSOEVER EXCEPT BY WRITTEN PERMISSION AS PROVIDED IN A SIMILED AGREEMENT WITH CONTINENTS. FABRICATORS INC. CRUDE NCB/ACID SEPARATOR TANK

ITEM: 304 MONSANTO, CO. TS-D-24915 SCALE NONE DR. JSG APPD. JSA

CUSTOMER NO. BX31783 DATE 12-1-94 H. MM PAINT NONE ORDER NO. SHEET NO. TOTAL DRAWING NO. 1118-L CJ-6012

2C 2 SPARE W/ BLIND #1228 GTAW P45-P45 2C 2 SPARE W/ BLIND 2D 2 OUTLET W/ VTX. BKF 3 MANWAY W/ DAVIT 7L-9110-B 2A 2 TW. SAMPLE, SPARE W/ BLIND MANWAY W/ DAVIT CL.150 RF SO | 2F | INLET W/ BAFFLE SCH. 40s I JG A 12-21-94 GEN'L. CHG'S, PER CUST, MARK-UP

Pad

Det Sht.

Service

NO. DR. CH. DATE