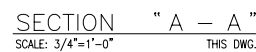


THIS DRAWING IS LOANED WITHOUT OTHER CONSIDERATION THAN THE AGREEMENT AND CONDITION THAT IT IS NOT TO BE REPRODUCED, COPIED OR OTHERWISE DISPOSED OF DIRECTLY OR INDIRECTLY, AND IS NOT TO BE USED IN WHOLE OR IN PART TO ASSIST IN MAKING OR TO FURNISH ANY INFORMATION FOR THE MAKING OF DRAWINGS, PRINTS, APPARATUS OR FOR THE PURPOSE THEREOF IN EXECUTION OF THE PARTICULAR WORK FOR WHICH IT WAS PREPARED.

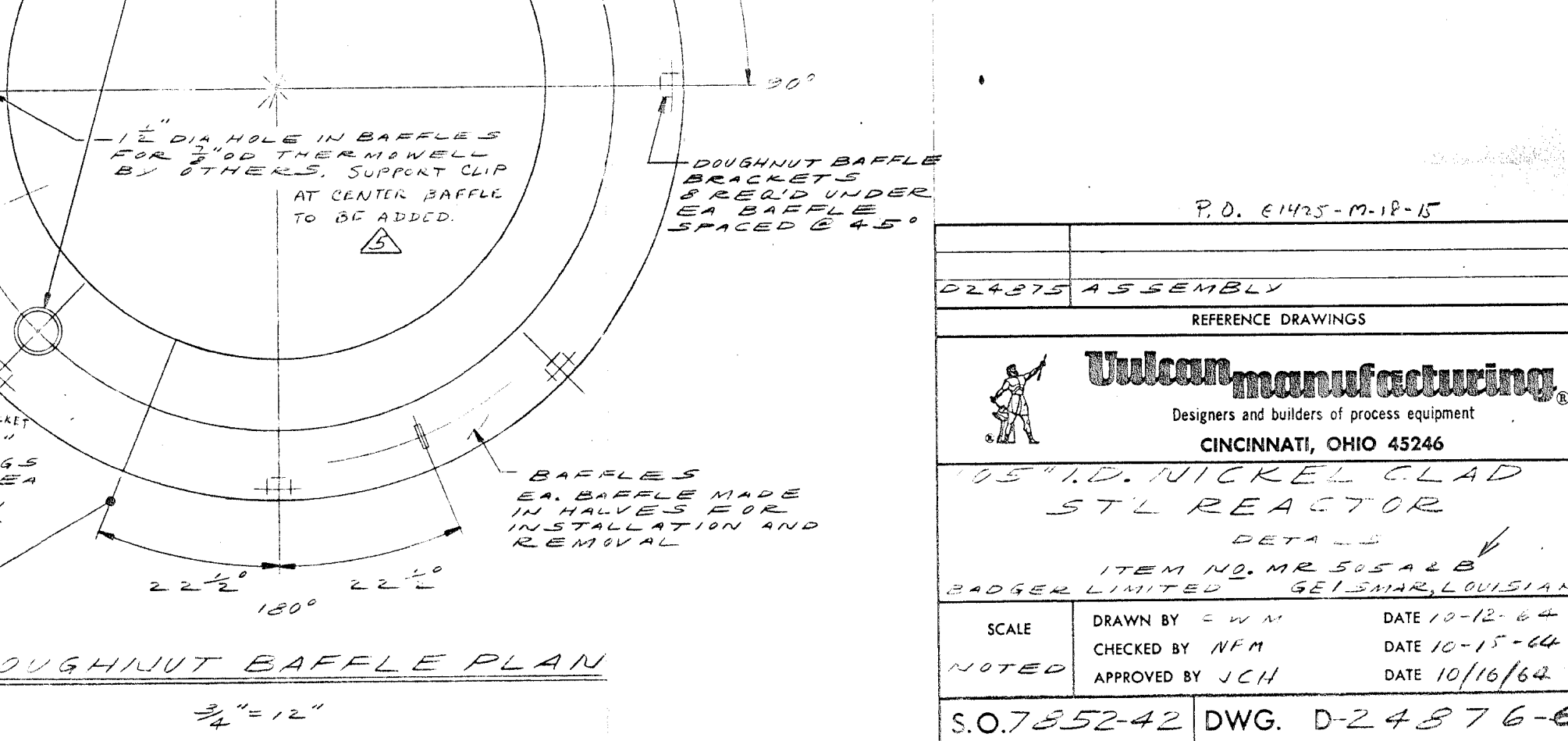
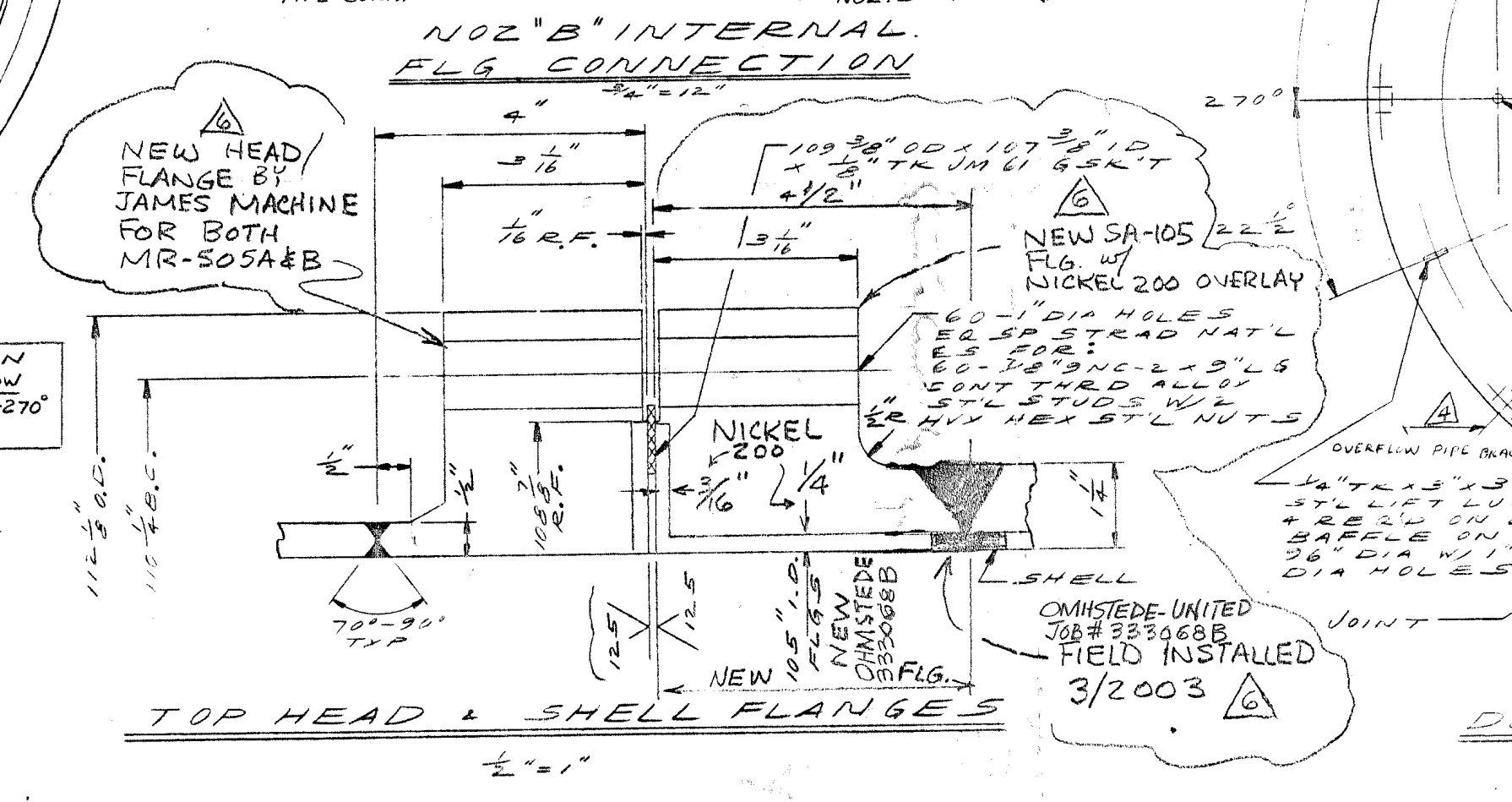
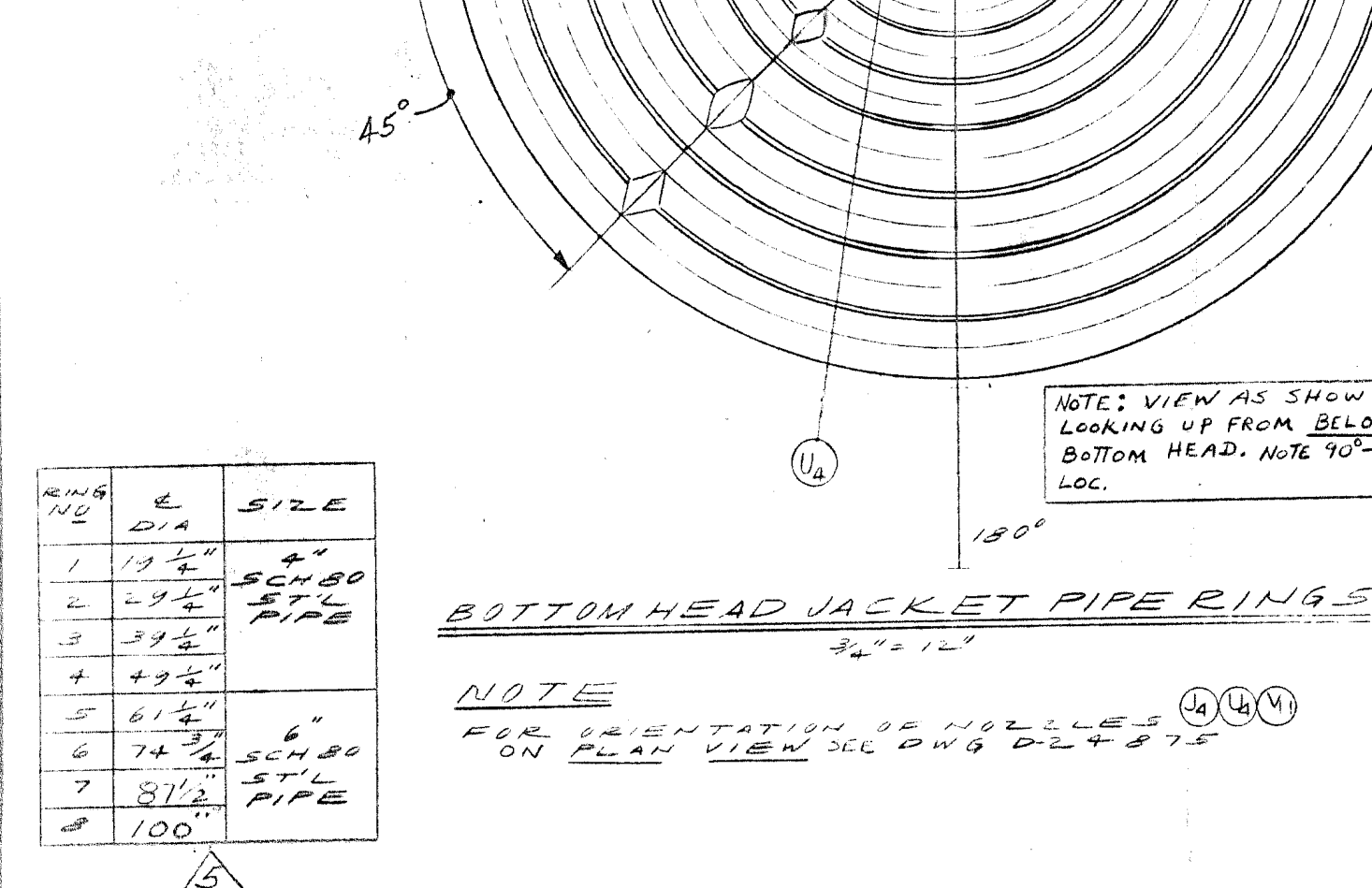
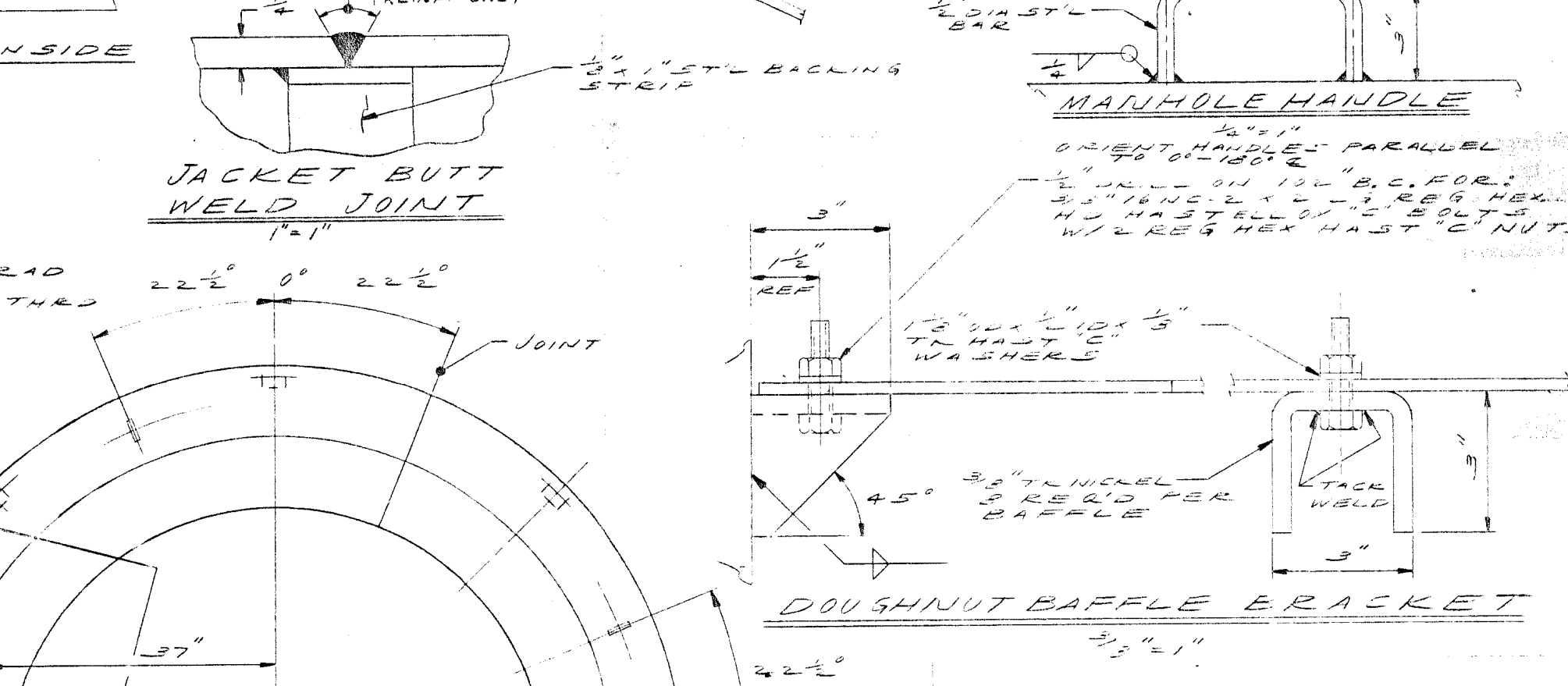
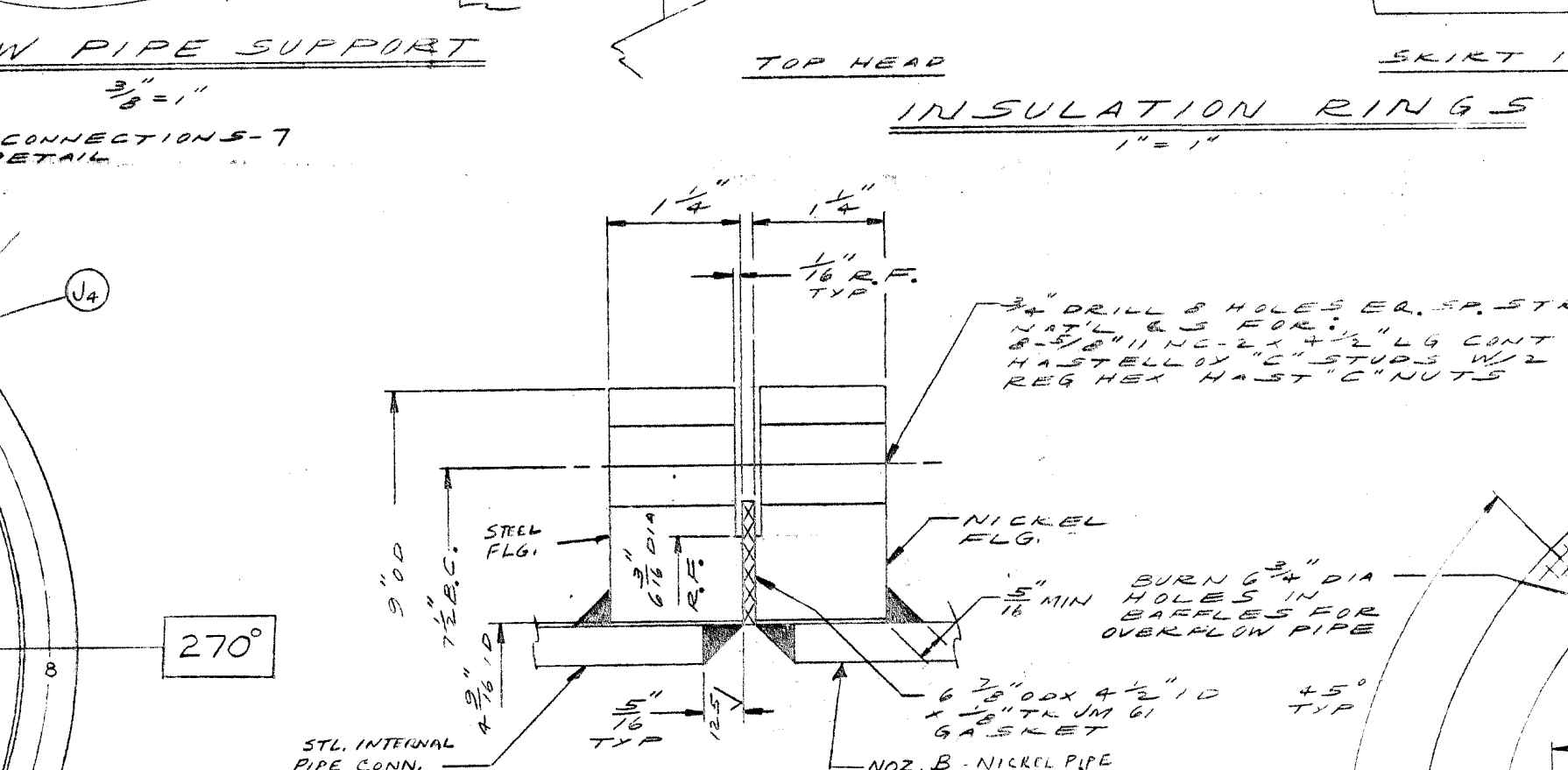
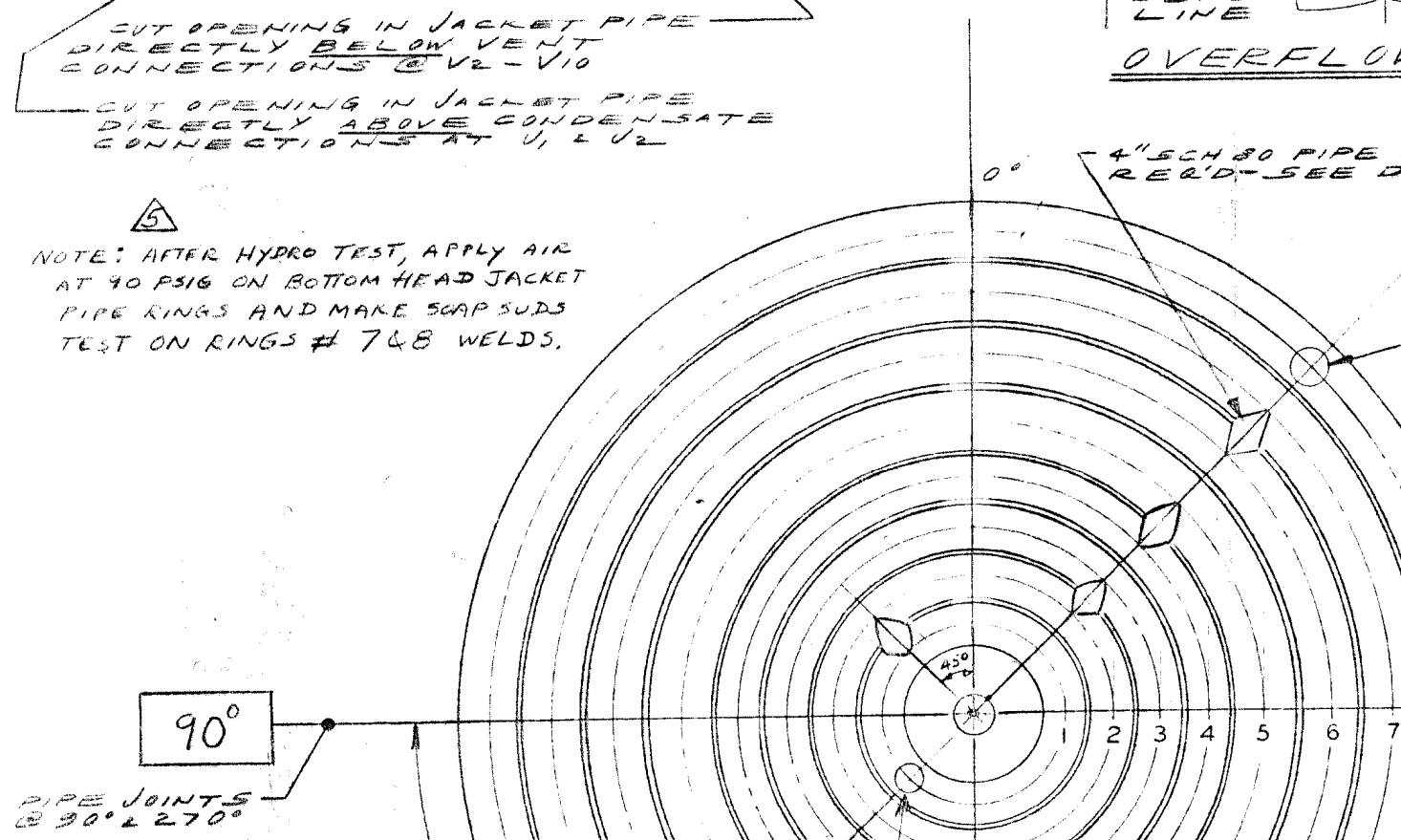
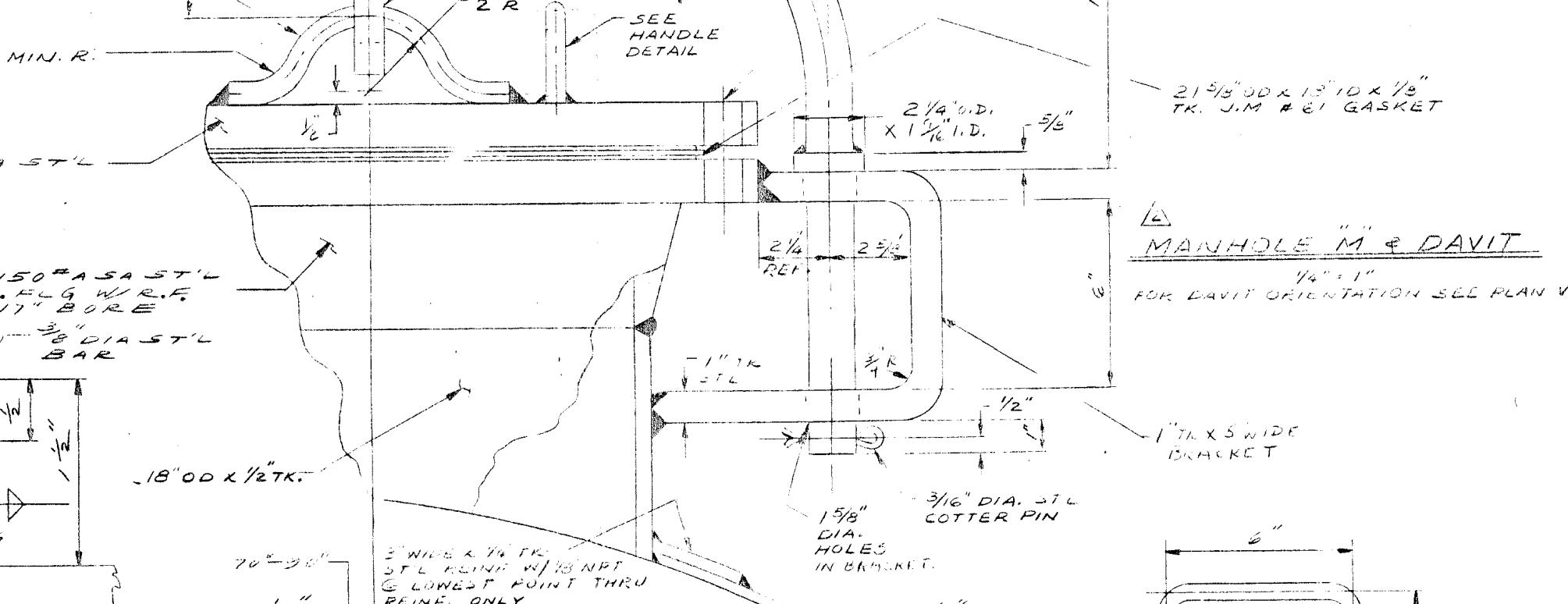
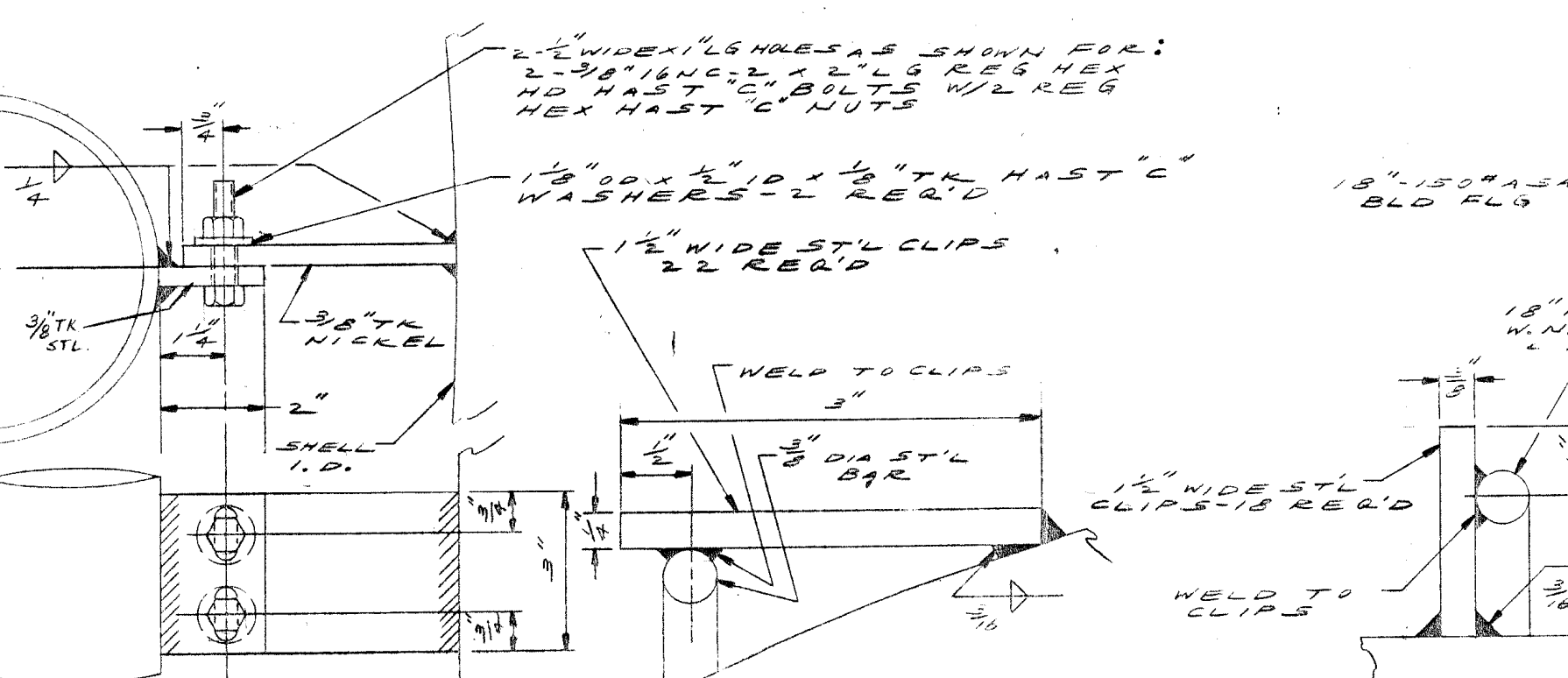
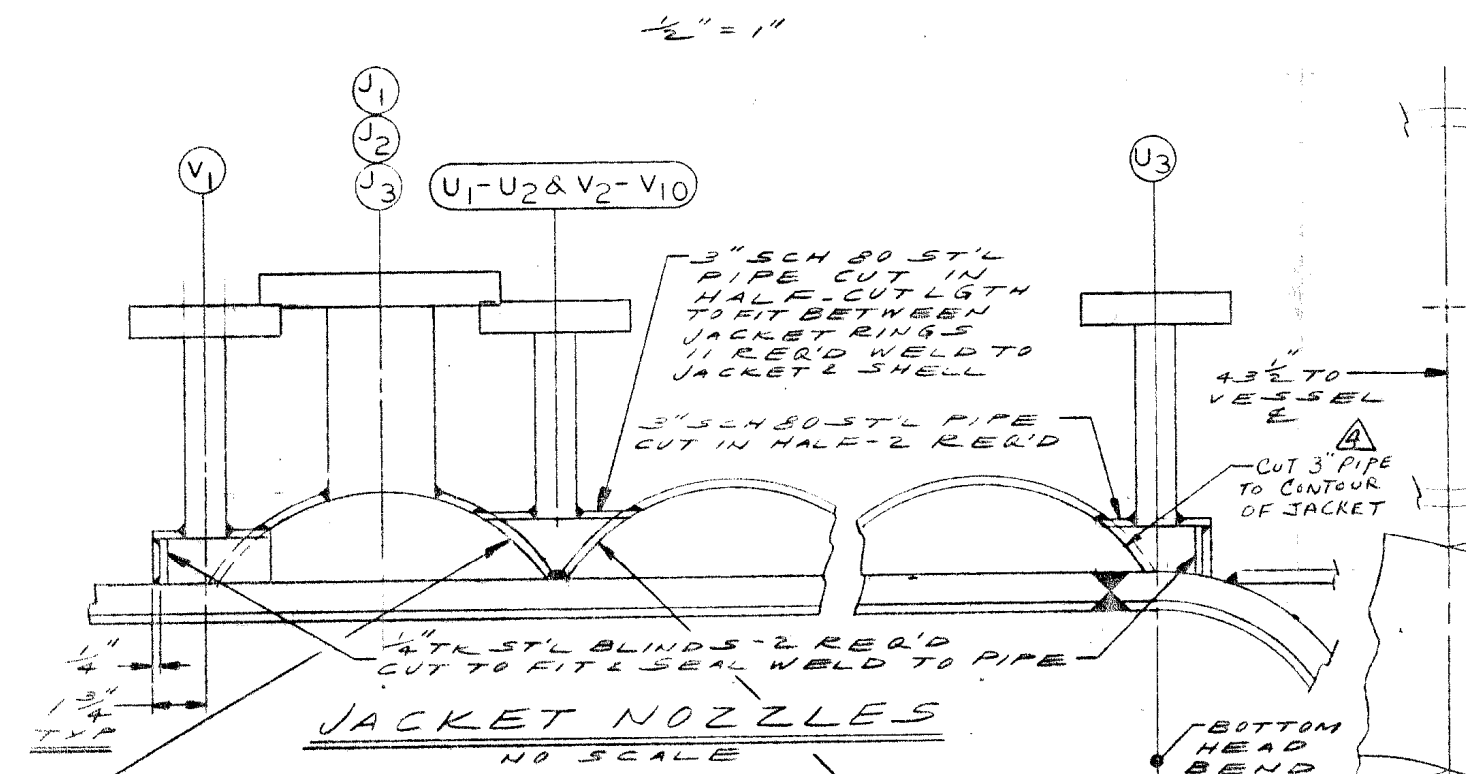
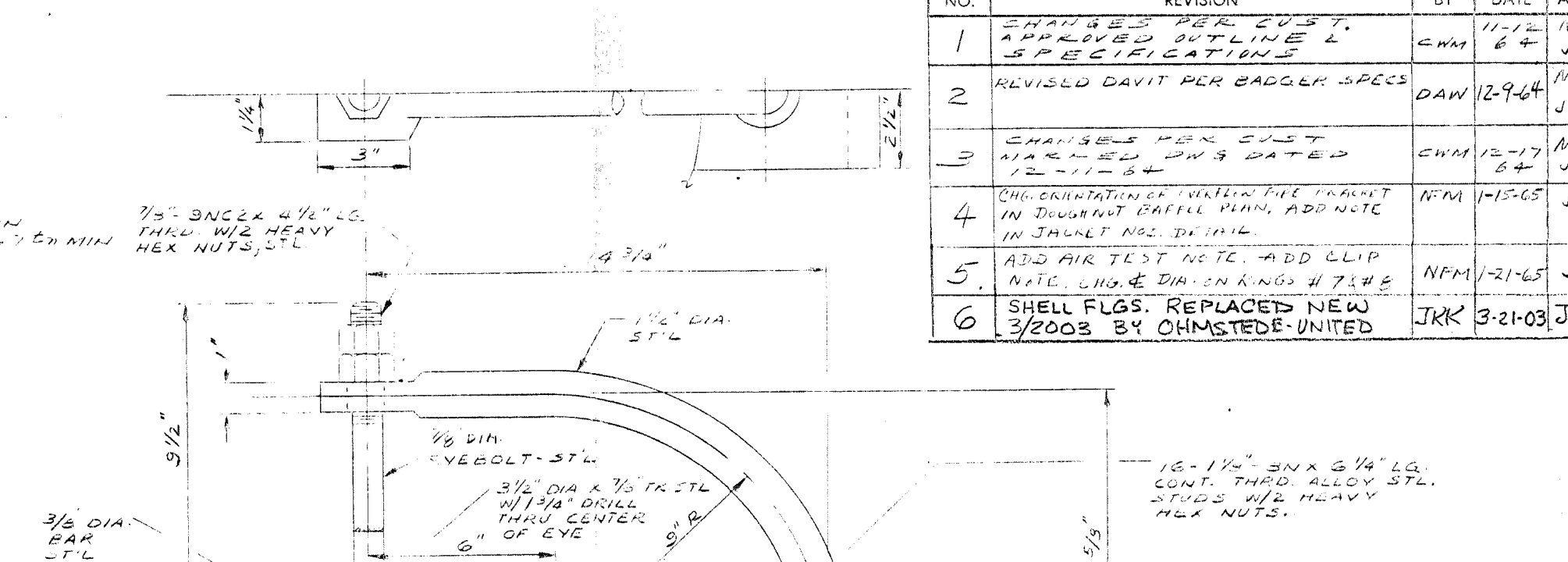
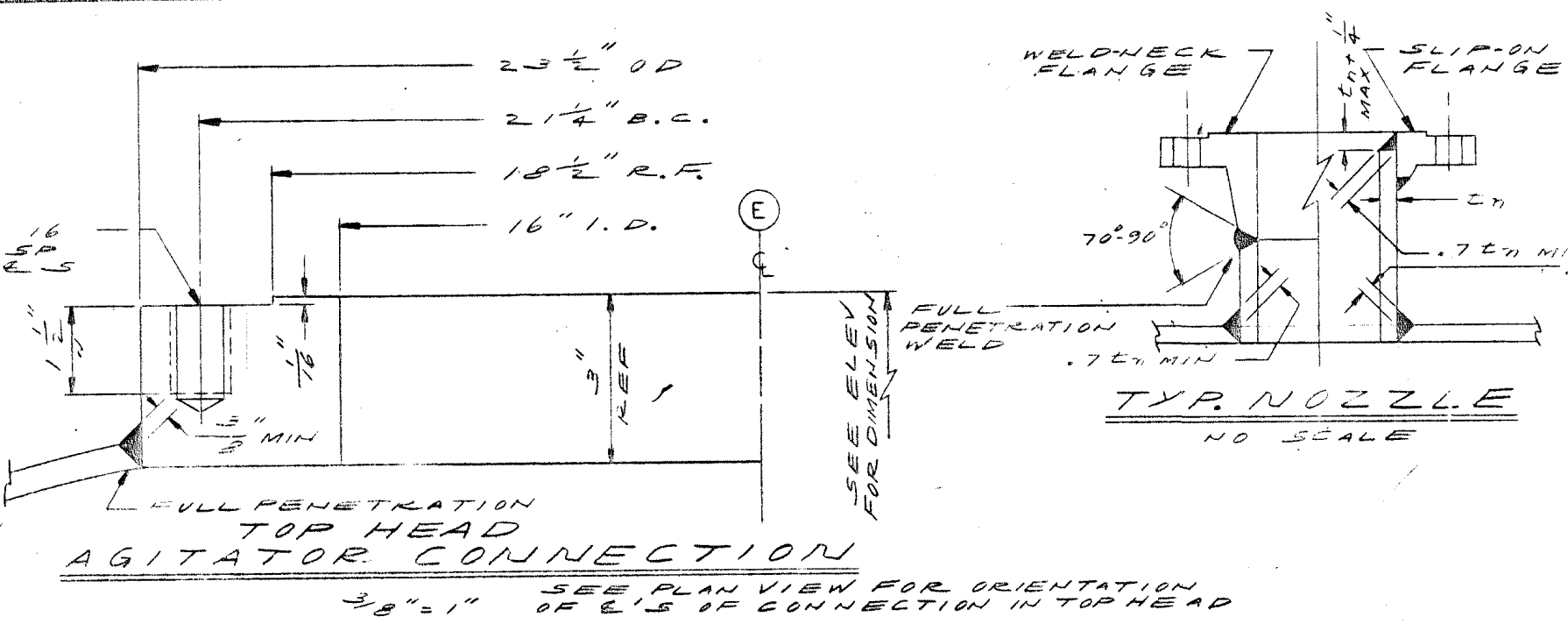
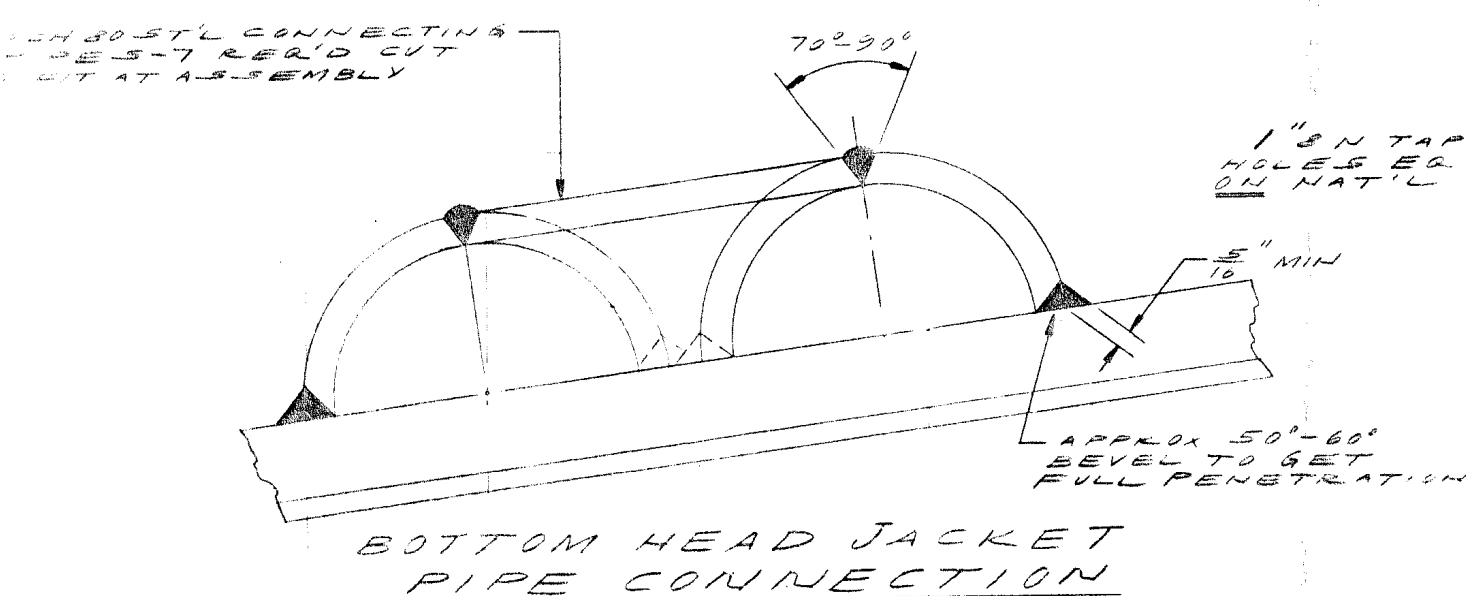
THE ACCEPTANCE OF THIS DRAWING WILL BE CONSTRUED AS AN ACCEPTANCE OF THE FOREGOING CONDITIONS, AND AS AN ADMISION OF THE EXCLUSIVE OWNERSHIP OF RUMFORD AND SONS, LTD. OF THE DRAWING.

1. FABRICATOR TO HYDROTEST SPOOL MK-R24B-01 AT 450 PSIG & 30 PSIG HELIUM TEST.
2. THIS DIMENSION INCLUDES 3" OF EXTRA PIPE TO ALLOW ALIGNMENT OF THE PIPE IN THE FIELD.
3. FABRICATOR TO WELD CAP ON THE END OF SPOOL MK-R24B-01 FOR HYDROTEST PURPOSES ONLY. TO BE REMOVED BY THE FIELD PRIOR TO INSTALLATION.
4. GASKET SHALL BE PER ASME B16.21, 1/8" THK. FILLED PTFE, DURABARA DURLON 9000.
5. ALL MATERIALS IN FABRICATING THE SIDE CLIPS SHALL BE 3/4" THICK HASTELLOY C-276 (SB-575-C276). CLIPS SHOWN IN SECTION B-B & C-C FABRICATED FROM PLATE.
6. ALL MATERIALS IN FABRICATING THE BUTT CLIP SHALL BE 3/8" THICK NICKEL SB-162.
7. TACK WELD NUTS TO BOLT THREADS.
8. HAND TIGHTEN NUTS, TACK WELD NUT TO BOLT THREADS.
9. TACK WELD BOLT HEAD TO PLATE.
10. REFER TO RUBICON SPECIFICATION E03R FOR HASTELLOY C-276 MATERIAL.
11. ALL MATERIALS TO HAVE MTR's.



3/2/01

NO.	REVISION	BY	DATE	APPR.
1	CHANGES PER CUST. APPROVED OUTLINE & SPECIFICATIONS	CWM	11-12-64	JCH
2	REVISED DAVIT PER BADGER SPECS	DAW	12-9-64	JCH
3	CHANGES PER CUST. APPROVED DATED 12-11-64	CWM	12-17-64	NFM
4	CHLORINATION OF VENTURE PIPE IN JACKET IN DOWNOUT BAFFLE PLAIN, ADD NOTE IN JACKET NOZ. DETAIL	NFM	1-15-65	JCH
5	ADD AIR TEST NOTE, ADD CLIP NOTE, CHG. & DIA. ON RINGS #7 & 8	NFM	1-21-65	JCH
6	SHELL FLGS. REPLACED NEW 3/2003 BY OHMSTEDE-UNITED	JKK	3-21-03	JKK



P.O. 61435-M-12-15			
D-24876 ASSEMBLY			
REFERENCE DRAWINGS			
Vulcan Manufacturing Designers and builders of process equipment CINCINNATI, OHIO 45246			
15" I.D. NICKEL CLAD STL REACTOR			
ITEM NO. MR 505A & B			
BADGER LIMITED GEI-SMART, LOUISIANA			
SCALE	DRAWN BY CWM	DATE 10-12-64	
NOTED	CHECKED BY NFM	DATE 10-15-64	
	APPROVED BY JCH	DATE 10/16/64	
S.O. 7552-42		DWG. D-24876-6	

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

1. Work performed by OHMSTEDE MECHANICAL SERVICES, INC. 85145
(name of repair or alteration organization) (P.O. no., job no., etc.)
P.O. Box 537 Baytown, Texas 77520
(address)

2. Owner RUBICON CHEMICAL
(name)
P.O. Box 517 Geismar, Louisiana 70734
(address)

3. Location of Installation RUBICON CHEMICAL
(name)
Geismar, Louisiana
(address)

4. Unit Identification: Pressure Vessel Name of original manufacturer Vulcan Mfg.
(boiler, pressure vessel)

5. Identifying nos.: 9838 1787 LA 1964
(unit's serial no.) (original National Board no.) (jurisdiction no.) (year built)

6. Description of work: (see spec., separate sheet, or sketch if necessary)

Weld repaired nickel 200 cladding in area of vessel weld seams.
P.T. and visually inspected new welds.

Pressure test, if applied _____ psi

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

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

8. Remarks:

MR-505 B

FORM R-1 REPORT OF WELDED REPAIR

in accordance with provisions of the National Board Inspection Code

WO# 001329

1. Work performed by VIS, INC. (name of repair organization) (Form R. No.)
39423 Babin Road Gonzales, LA. 70737 (address)

2. Owner Rubicon, Inc. (name)
Highway 75 Geismar, LA. 70734 (address)

3. Location of installation Rubicon, Inc. (name)
Highway 75 Geismar, LA. 70734 (address)

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

5. Identifying nos.: 9839 1788 MR-505 B 1965
 (mfg serial no.) (National Board No.) (jurisdiction no.) (other) (year built)

6. NBIC Edition/Addenda: 1995/Ed. Add Original Construction Code: ASME VIII Div. 1
 (if known) (incl edition and addenda)

7. Description of work:

(use supplemental sheet, Form R-4, if necessary)

Replaced 3" 300# RFSO flange on nozzle "J4". Nozzle J4 is steam inlet nozzle to steam jacket
which is fabricated of SA-106 material. Replacement flange is of SA-105 material.
Welding procedure used was VIS 1. Welds were dye penetrant checked.

Pressure Test, if applied n/a psi

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

n/a

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

9. Remarks:

CERTIFICATE OF COMPLIANCE

I, Bobby Brooks 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. R 3847 expires on MAR 1, 2000
 Date 6-27, 1998 Signed Bobby Brooks
 (name of repair organization) (authorized representative)

CERTIFICATE OF INSPECTION

I, CHARLES A. EFFERSON holding a valid Commission issued by the National Board of Boiler and Pressure Vessel
 Inspectors and certificate of competency issued by the jurisdiction of LOUISIANA and employed by
H.S.B.I. & I. Co. of HARTFORD, CT. have

inspected the work described in this report on 7-26, 1998 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 7-26, 1998 Signed Charles A. Efferson Commissions NP9849A LA926
 (inspector) National Board (incl endorsements,
 and jurisdiction, and no.)

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

MR-505B

1. Work performed by VIS, INC. WO# 315934
(name of repair organization) (Form R No.)
39423 Babin Road, Gonzales, Louisiana 70737
(address)

2. Owner Rubicon Inc.
(name)
Highway 75, Geismar, LA 70734
(address)

3. Location of installation Rubicon Inc.
(name)
Highway 75, Geismar, LA 70734
(address)

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

5. Identifying nos.: 9839 N/A MR-505B 1965
(mfg serial no.) (National Board No.) (jurisdiction no.) (other) (year built)

6. NBIC Edition/Addenda: 1995/ED.ADD Original Construction Code: ASME VIII Div.1
(if known) (incl edition and addenda)

7. Description of work
(use supplemental sheet, Form R-4, if necessary)
Replace 1" 300# RFSO flange on nozzle "U2". Nozzle "U2" is condensate outlet on jacket
Replace 1" 300# RFSO flange on nozzle "V8". Nozzle "V8" is a jacket vent.
Replacement flange's is of SA-105 materail HT# TL196250.
Welding procedure used was VIS 1. Welds were dye penetrant checked.

Pressure Test, if applied N/A psi

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

N/A

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

9. Remarks:

CERTIFICATE OF COMPLIANCE

I, BILLY BROOKS, 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. R3847 expires on MAR. 1 2000

Date 2/18 1999 VIS, INC. Signed Billy Brooks
(name of repair organization) (authorized representative)

CERTIFICATE OF INSPECTION

I, Charlie R. Efferson, holding a valid Commission issued by The National Board of Boiler and Pressure Vessel
Inspectors and certificate of competency issued by the jurisdiction of LA. and employed by

H.S.B.I. & I. CO. of HARTFORD, CT have

inspected the work described in this report on 2-22- 1999 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 2-22- 1999 Signed Charlie R. Efferson Commissions NB9849A LA922
(inspector) (National Board (incl endorsements),
and jurisdiction, and no.)