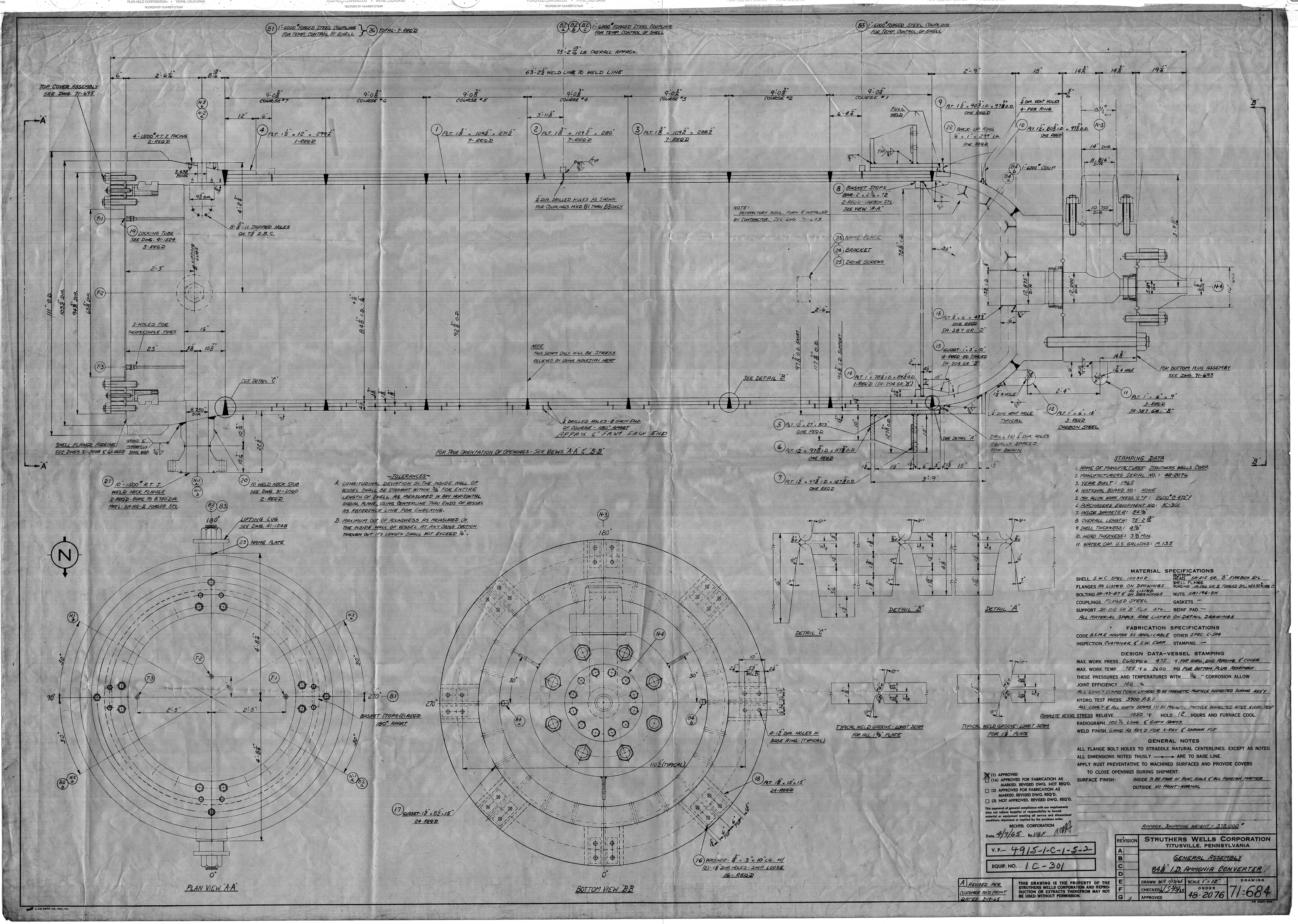

STAMPING DATA

1. NAME OF MANUFACTURER: STRUTHERS WELLS CORP.
2. MANUFACTURERS SERIAL NO.: 48-2076
3. YEAR BUILT: 1965
4. NATIONAL BOARD NO: NONE
5. MAX. ALLOW. WORK. PRESS. @ °F: 2600# @ 475°F
6. PURCHASERS EQUIPMENT NO: IC-301
7. INSIDE DIAMETER: 84 3/8"
8. OVERALL LENGTH: 75'-2 13/16"
9. SHELL THICKNESS: 4 7/8"
10. HEAD THICKNESS: 3 7/8" MIN.
11. WATER CAP. U.S. GALLONS: 19,135

MATERIAL SPECIFICATIONS

SHELL S.W.C. SPEC. 100302 — BOTTOM HEAD SA-212 GR. "B" FIREBOX STL.
FLANGES AS LISTED ON DRAWINGS — SHELL FLANGE FORGING SA-266 GR. II FORGED STL. H.B. 302 MAX.
BOLTING SA-193-B7 & AS LISTED ON DRAWINGS — NUTS SA-194-2H
COUPLINGS FORGED STEEL — GASKETS —
SUPPORT SA-212 GR. "B" PLG. STL. — REINF. PAD —
ALL MATERIAL SPECS. ARE LISTED ON DETAIL DRAWINGS

FABRICATION SPECIFICATIONS

CODE A.S.M.E. NO STAMP AS APPLICABLE — OTHER SPEC. C-304
INSPECTION CUSTOMER & S.W. CORP. — STAMPING —

DESIGN DATA-VESSEL STAMPING

MAX. WORK PRESS. 2600 PSI @ 475 °F. FOR SHELL, END FORGING & COVER
MAX. WORK TEMP. 785 °F @ 2600 PSI FOR BOTTOM PLUG ASSEMBLY
THESE PRESSURES AND TEMPERATURES WITH 1/16" CORROSION ALLOW
JOINT EFFICIENCY 100 %
ALL LONGT SEAMS (EACH LAYER) TO BE MAGNETIC PARTICLE INSPECTED DURING ASS'Y
HYDRO. TEST PRESS. 3900 P.S.I.
ALL LONGT & ALL GIRTH SEAMS TO BE MAGNETIC PARTICLE INSPECTED AFTER HYDRO-TEST
COMPLETE VESSEL STRESS RELIEVE 1050 °F. HOLD 12 HOURS AND FURNACE COOL.
RADIOGRAPH 100% LONG. & GIRTH SEAMS
WELD FINISH GRIND AS REQ'D FOR X-RAY & SHRINK FIT

GENERAL NOTES

ALL FLANGE BOLT HOLES TO STRADDLE NATURAL CENTERLINES, EXCEPT AS NOTED.
ALL DIMENSIONS NOTED THUSLY ⟶ ARE TO BASE LINE.
APPLY RUST PREVENTATIVE TO MACHINED SURFACES AND PROVIDE COVERS TO CLOSE OPENINGS DURING SHIPMENT.
SURFACE FINISH: INSIDE TO BE FREE OF RUST, SCALE & ALL FOREIGN MATTER
OUTSIDE NO PAINT-NORMAL

APPROX. SHIPPING WEIGHT = 375,000#

☒ (1) APPROVED
☐ (1A) APPROVED FOR FABRICATION AS MARKED. REVISED DWG. NOT REQ'D.
☐ (2) APPROVED FOR FABRICATION AS MARKED. REVISED DWG. REQ'D.
☐ (3) NOT APPROVED. REVISED DWG. REQ'D.

This approval of general compliance with our requirements does not relieve Supplier of responsibility to furnish material or equipment meeting all service and dimensional conditions stipulated or implied by the purchase order.

BECHTEL CORPORATION
Date 4/9/65 By V.G.F.

V.P.— 4915-1-C-1-5-2
EQUIP. NO. 1C-301

REVISION	
A	
B	
C	
D	
E	
F	
G	

A REVISED PER CUSTOMER RED PRINT DATED 3-17-65

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STRUTHERS WELLS CORPORATION
TITUSVILLE, PENNSYLVANIA

GENERAL ASSEMBLY
84 3/8" I.D. AMMONIA CONVERTER

DRAWN W.R.P. 1/13/65 — SCALE 1" = 12" — ORDER 48-2076 — DRAWING 71-684
CHECKED W.S.S. 1/15/65
APPROVED