

94207

REVISED

MARCH 1966

IC-210

334.0000

## FORM U-1A MANUFACTURERS' DATA REPORT FOR UNFIRED PRESSURE VESSELS

Alternate Form for Single Chamber Completely Shop-Fabricated Vessels Only

Inspection Serial No. C-5628

1. Manufactured by NATIONAL TANK COMPANY TULSA, OKLAHOMA S.O. E-12769  
(Name and address of Manufacturer)

2. Manufactured for Bechtel Corporation - Blythville, Arkansas P.O. 4915-1C-7B  
(Name and address of Purchaser)

3. Type Vertical Vessel No. (SOE-12769) (Mfrs. Serial) (State & State No.) 5196 Yr. Built 1965  
(Horiz. or Vert.)

4. SHELL: Matl. SA-204 C Fbx T.S. 75,000 Nom. 1.6" Corr. 1.25" In. Allow. In. Diam. 10' 6" In. Length 7' 3" In.  
(Kind and Spec. No.) (Flg. or F.B. & Spec. Min. T.S.)

5. SEAMS: Long Fusion weld, double butt. H.T. Yes X.R. Complete Sectioned No Efficiency 100 %  
(Welded, Dbl., Single, Lap, Butt) (Yes or No) (Spot or Complete) (Yes or No)

6. HEADS: (a) Material SA-204 Gr. C Fbx T.S. 75,000 (b) Material T.S.  
(Top, bottom, ends) Thickness .875" Crown Radius 5'-3" I.R. Hemispherical Radius 5'-3" I.R. Flat Diameter Concave  
(a) Top & Bottom (b) Other fastening Fusion weld, double butt.  
(Material, Spec. No., T.S., Size, Number) (Describe or Attach Sketch)

7. Constructed for max. allowable working press. 430 psi. at max. temp. 700 °F. Min. temp. (when less than -20°) 774 \*  
Hydrostatic Test 774 \*  
Based on Shell New & Cold.

8. SAFETY OR RELIEF VALVE OUTLETS: Number 1 Size 2 1/2" Location Top

9. NOZZLES:

Purpose (Inlet, Outlet, Drain)	Number	Diam. or Size	Type	Material	Thickness	Reinforcement Material	How Attached
Inlet & Outlets	3	12" ASA 300#	Forging	SA-182 F1	1.375	SA-204 C Fbx	Fusion weld.
Inlet & Outlet	1	2" ASA 300#	Forging	SA-182 F1	.625"	Fusion weld.	Fusion weld.
Inlets & Outlets	3	3/4" & 1.5"	Cplg.	Forging	6000#	Fusion weld.	Fusion weld.

10. INSPECTION Manholes, No. 1 Size 24" Location In top head, SA-204 C Fbx. Fusion weld.

OPENINGS: Handholes, No. 1 Size 24" Location Top

Threaded, No. 1 Size 24" Location Top

11. SUPPORTS: Skirt No Lugs 8 Legs 8 Other Support Frame Attached Welded to bottom head.  
(Yes or No) (Number) (Number) (Describe) (Where & How)

12. REMARKS: 10'-6" I.D. x 7'-0" T/T x 430# W.P. Vertical Methanator per Dwg. A-24271

Item No. IC-210

Code Certificate - Supporting Document

CCSD-4915-1-C-7B-1-0

EQUIP. NO. IC-210

(Brief description of purpose of the vessel as Air Tank, Water Tank, etc., and working pressure, when applicable.  
\* If postweld heat-treated.  
\* List other internal or external pressures with coincident temperature, when applicable.)

We certify that the statements made in this report are correct and that all details of design, material, construction, and workmanship comply with the ASME Code for Unfired Pressure Vessels.

Date MAY 2-5-1965 19 1965 Signed National Tank Company  
(Manufacturer)

December 31, 1967

Certificate of Authorization Expires

## CERTIFICATE OF SHOP INSPECTION

VESSEL MADE BY National Tank Company at Tulsa, OklahomaI, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and employed by Commercial Union Insurance Company of New York have inspected the pressure vessel described in this manufacturer'sdata report on MAY 2-5-1965 19 1965, and state that to the best of my knowledge and belief, the manufacturer has constructed this pressure vessel in accordance with the applicable sections of the ASME Boiler and Pressure Vessel Code.

By signing this certificate neither the Inspector nor his employer makes any warranty, expressed or implied, concerning the pressure vessel described in this manufacturer's 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 MAY 2-5-1965 19 1965

G. W. Durnal

Inspectors Signature

Commissions

3194

Nat'l Board

REVI  
MARCH 1966



94207

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

1C-210

Work performed by Plant Maintenance Service Corp. AE-033  
(name of repair or alteration organization) (P.O. no., job no., etc.)

3000 Fite Rd., Memphis, TN 38127  
(address)

2. Owner Terra-Nitrogen  
(name)

PO Box 1049 Blytheville, Ark. 72316-1049  
(address)

3. Location of installation Same As Line 2  
(name)

(address)

4. Unit identification: Pressure Vessel Name of original manufacturer National Tank Company  
(boiler, pressure vessel)

5. Identifying nos.: SOE-12769 5196 1965  
(mlr's. serial no.) (original National Board no.) (jurisdiction no.) (other) (year built)

6. Description of work Repaired (3) cracks around manway weld and vessel top head.  
(use back, separate sheet, or sketch if necessary)

Gouged out cracks, Dye checked and Magna Flux checked cracks. Welded cracks,  
Stress relieved welds and Magna Flux tested after stress relieved.  
Found no defects.

A.I. to witness in operation

Pressure test, if applied 340# psi

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

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

8. Remarks: All work done in accordance with the National Board of Boiler and Pressure Vessel Handbook and all welding done by ASME Qualified Welder:

Allen Mathews

(reverse side of form)

CERTIFICATE OF SHOP/FIELD COMPLIANCE

We verify that the statements made in this report are correct and that this Repair conforms to the National Board Inspection Code. (repair or alteration)

"R" Certificate of Authorization no. 75 expires 3-5, 19 98

Jurisdictional Authorization no. \_\_\_\_\_ expires \_\_\_\_\_, 19 \_\_\_\_\_

Date 2/6, 19 96 Plant Maintenance  
Service Corp. Signed [Signature]  
(repair organization) (representative)

CERTIFICATE OF SHOP/FIELD INSPECTION

I, the undersigned, holding a valid Commission issued by The National Board of Boiler and Pressure Vessel Inspectors and certificate of competency issued by the state or province of Tennessee and employed by Commercial Union Insurance Company of Boston, MA has inspected the work described in this report on 1-25, 19 96 and stated that to the best of my knowledge and belief, this work has been done in accordance with 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 2-6, 19 96 Signed [Signature] Commissions NB#8909, TN#2378  
(Inspector) (National Board (incl. endorsements), state, prov., and no.)



PLANT MAINTENANCE  
SERVICE CORP.



75

SER. NO. AE-033

DATE: 1/96