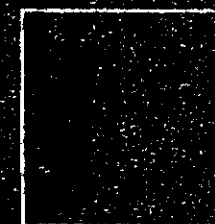


MANUFACTURED BY
WYATT INDUSTRIES, INC.
HOUSTON CORPUS CHRISTI DALLAS



W
X.R.
HT
YEAR BUILT

1964

MAX. WORKING
PRESSURE

800 P.S.I.*

MAX. TEMP.

290 °F

MANUFACTURER
SERIAL NO.

64-D-1841

H.S.B. NO.

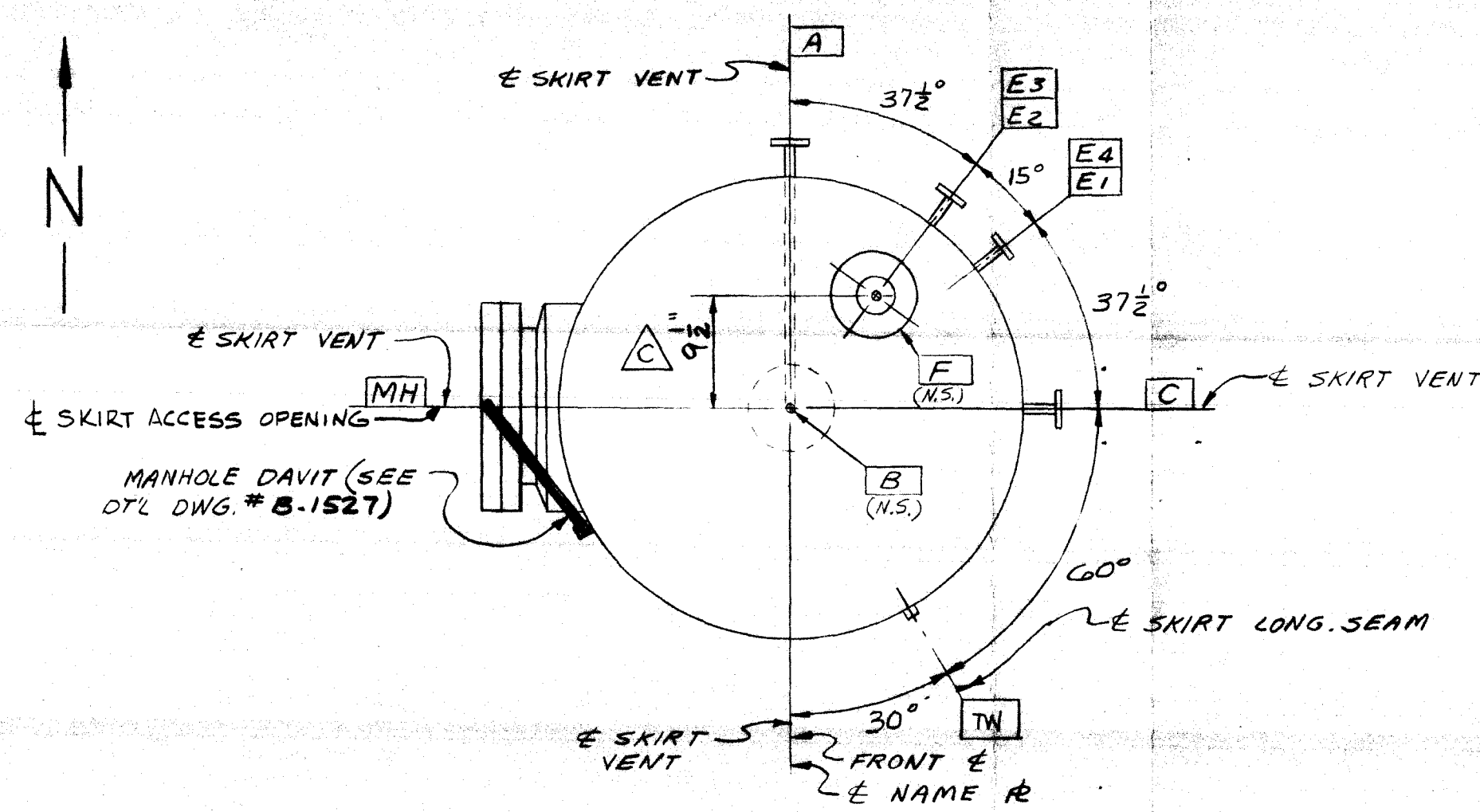
*3 FULL VAC. AT 200 °F

P.O. # 331-1402-4 TEM # V-348

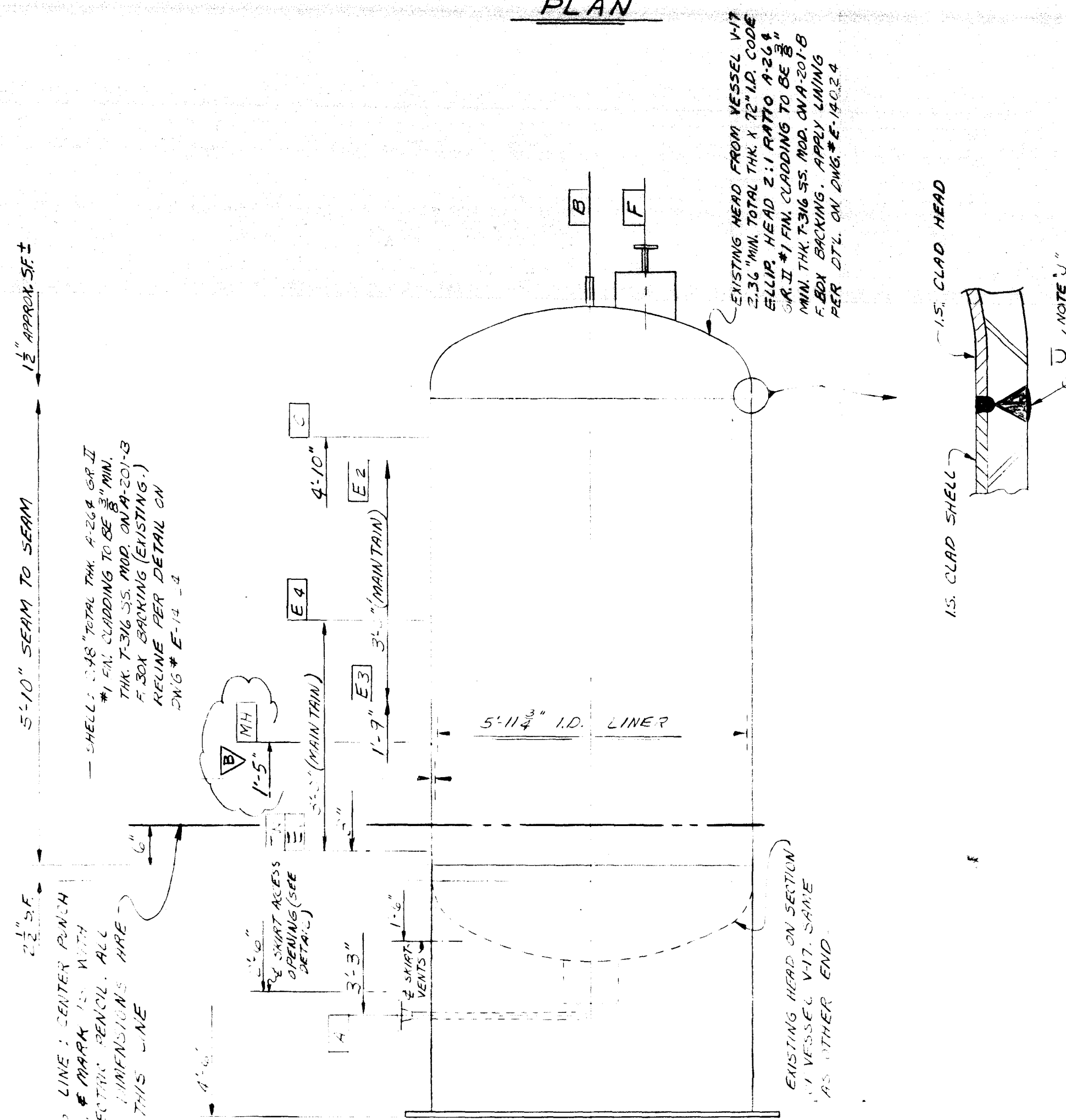
95728

SHOP NOTE

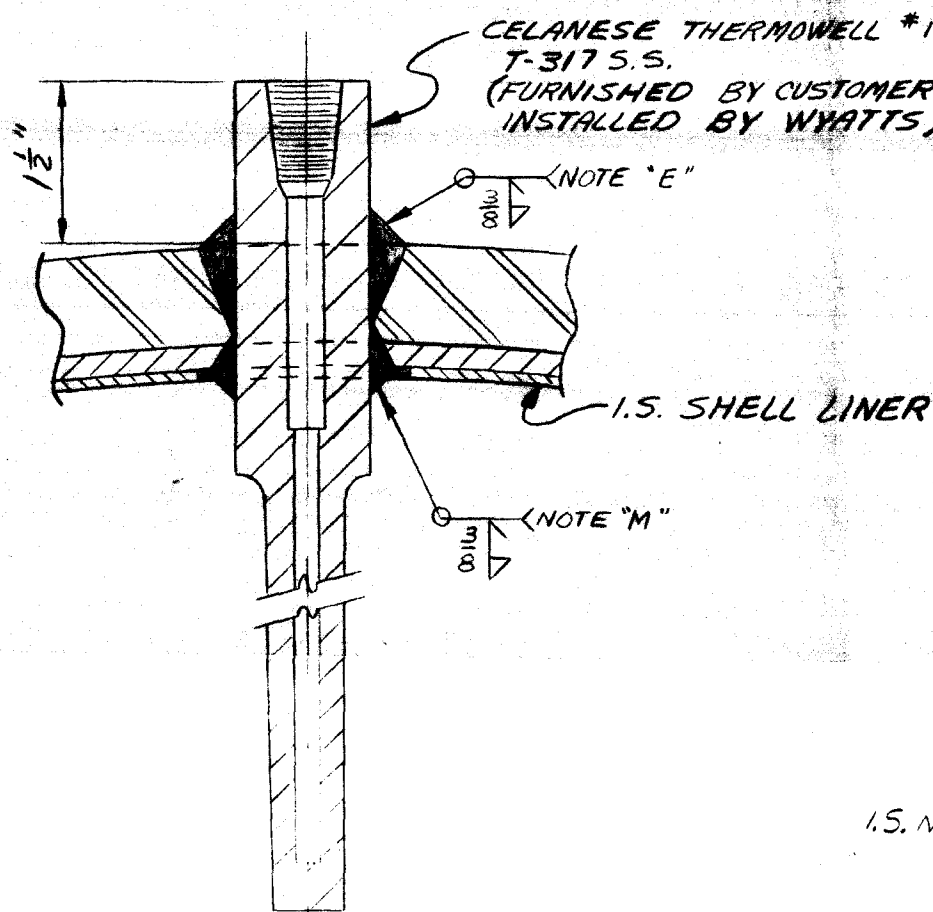
RIP OUT ALL EXISTING LINING IN REMAINING SECTION OF VESSEL V-17
HEAD FROM V-17. CUT OUT ALL EXISTING Baffles, EXTERNAL ATTACHMENTS,
NOZZLES EXCEPT NOZZLES MK "A" & "F" IN HEADS. ATTACH REMAINING
SECTION OF VESSEL V-17 # HEAD FROM V-17 AS SHOWN & INSTALL CARBON
STEEL MANHOLE NECK ONLY. PLUG HOLES LEFT BY REMOVED NOZZLES
PER DTL THIS DWG. ATTACH SKIRT & BASE AND THEN STRESS RELIEF
VESSEL. AFTER STRESS RELIEF, REINFORCE THE VESSEL TO WITH 316 L
STEEL. STRESS RELIEF. ADD # ADDRESS NOZZLES, NIPPLES, THERMOWELLS AND
MANHOLE LINER.



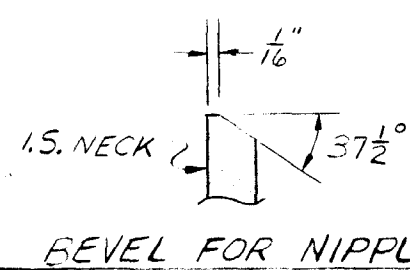
PLAN



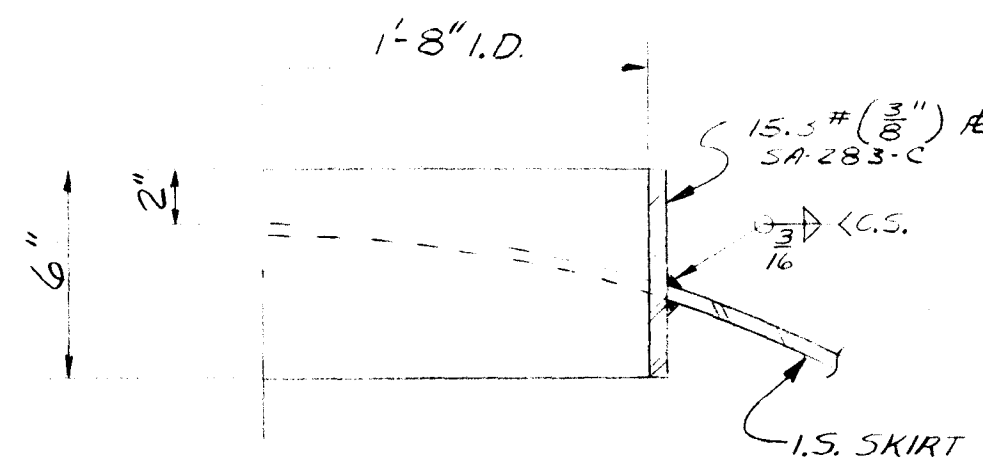
ELEVATION



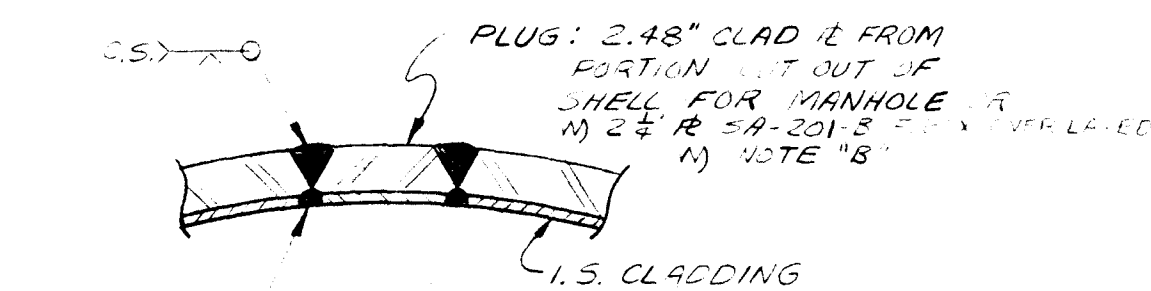
THERMOWELL MK "TW"



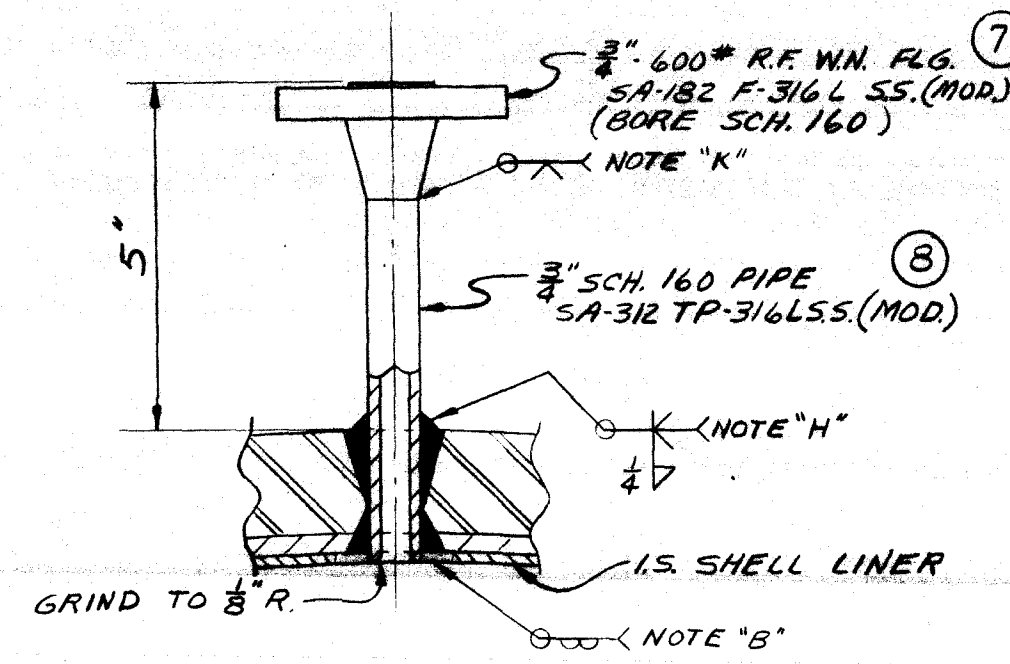
BEVEL FOR NIPPLE



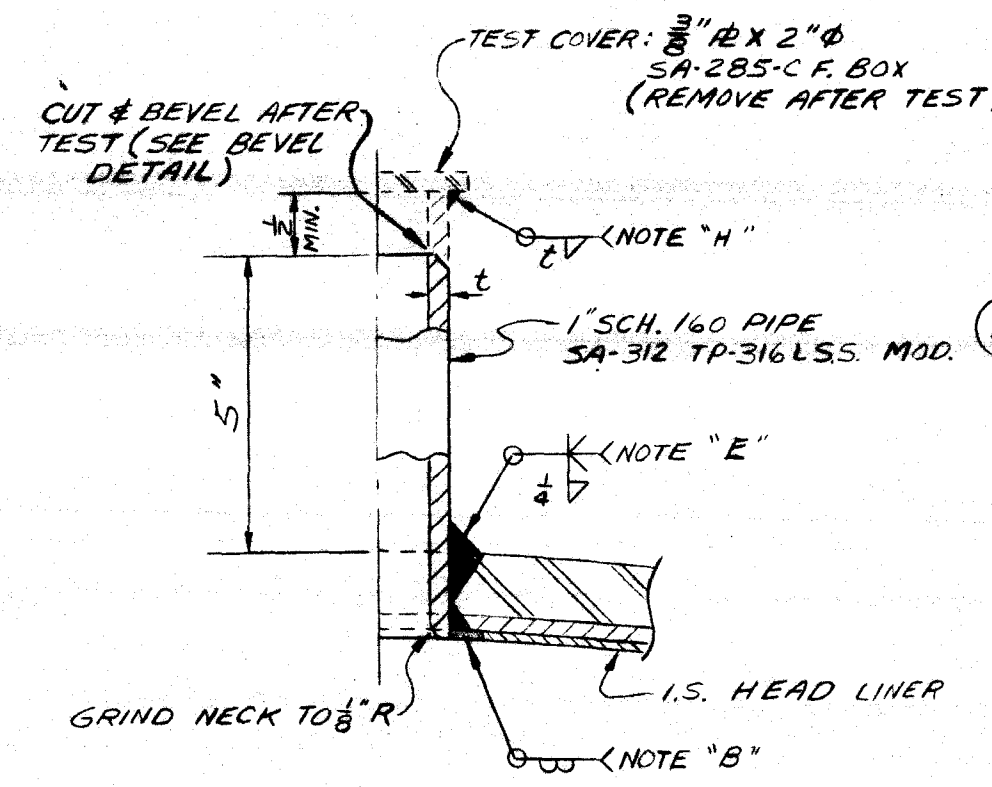
SKIRT ACCESS OPENING
(ONE REQ'D.)



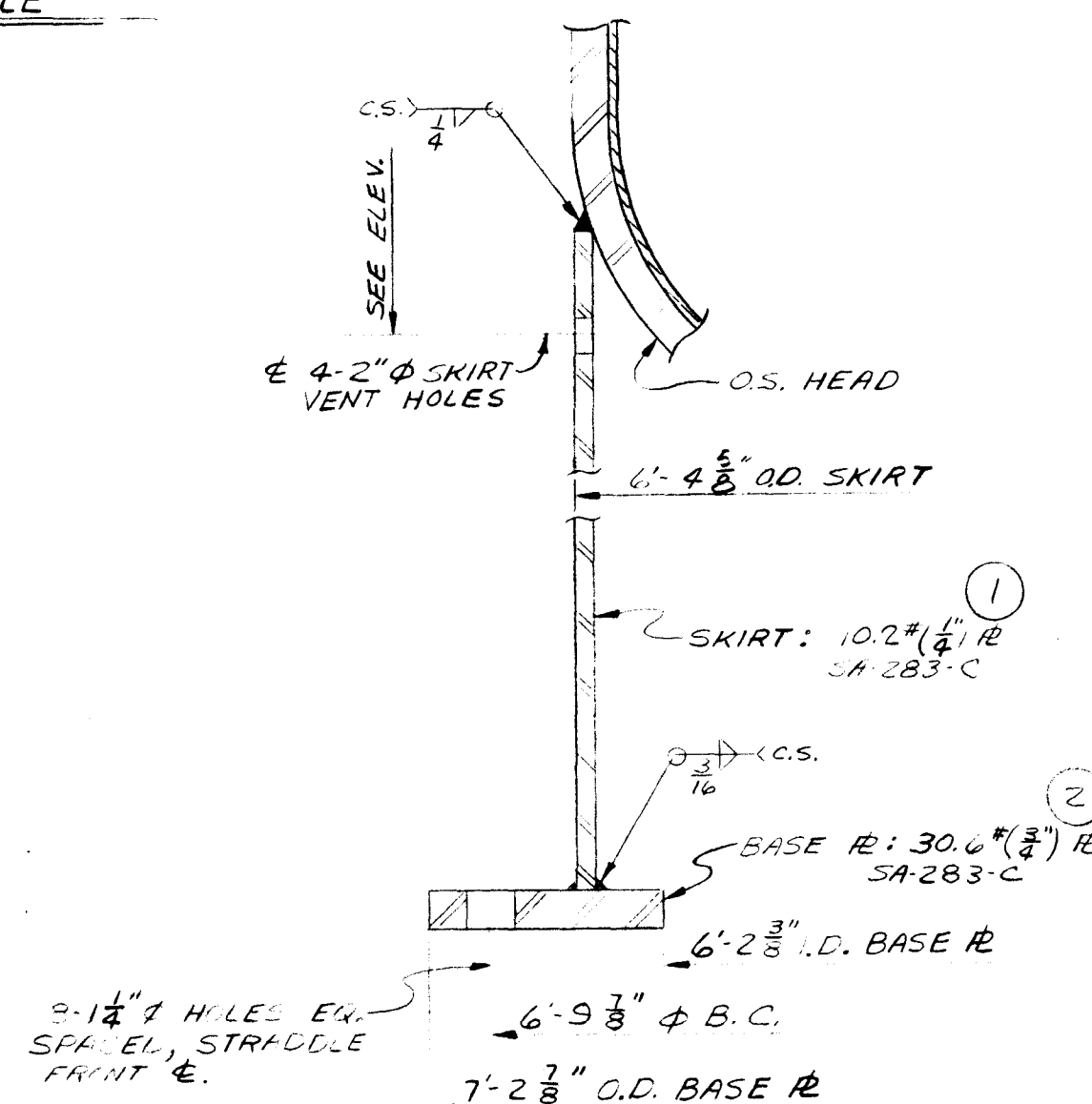
TYP. PLUG FOR NOZZLES REMOVED



NOZZLES MK "E1", "E2", "E3", "E4", & "C"



NIPPLE MK "B"



SECTION THRU SKIRT & BASE

SCHEDULE OF OPENINGS								
MARK	QUANTITY	SIZE	FLANGE			NOZZLE		REMARKS
			TYPR	RATING	MAT.	SCH.	WT.	
MH	1	20" LD	SPECIAL	SPECIAL	C.S.		C.S. W/ LINER	MANHOLE
A.	1	1"	RF WIN.	600 #	304 ST. 153 (MOD)	160	304 ST. MOD.	OUTLET
B	1	1"	WHPLE			160		PSY
C	1	3/4"	RF WIN.	600 #	304 ST. 153 (MOD)	160		INLET
E, E2, E3, E4	1 EA.	3/4"	RF WIN.	600 #	304 ST. 153 (MOD)	160		LG.
F	1	1"	RF WIN.	600 #	304 ST. 153 (MOD)	160	304 ST. MOD.	PRESS. TAP
TW	1		FURNISHED BY PURCHASER				T.304 ST. 153 (MOD)	THERMOWELL FURN. BY CUST.

DESIGN DATA

- a. ASME Code for Unfired Pressure Vessels, Section VIII. Edition 1962.
b. Additional Specifications: Celanese Purchasing Spec.
c. Code Symbol to be Applied: NO FURNISH CERTIFICATION OF ALL WORK & MATERIAL SUPERVISED BY CVAL
d. Design Pressure 800 PSIG plus necessary stiffening rings for full vacuum at 200 °F.
e. Design Temperature 390 °F.
f. Corrosion Allowance NONE inches.
g. Type of Heads ELLIPTICAL 2:1 RATIO
h. Stress Relief Required YES TIME BASED ON 3" THK. HEAD
i. Radiograph Required YES 100%
j. Joint Efficiency: Head 100 & Shell Longitudinal 95%
k. Maximum allowable Working Pressure (no corrosion allowance)
 Limited By SHELL 800 PSI @ 100°F.
 Limited By SHELL 800 PSI @ 390°F.
1. Hydrostatic Test Pressure 1200 P.S.I. (Based on
 Max. New and cold allowable pressure, no corrosion allowance.)
m. Weight Empty 100 lbs.
n. Weight Full of Water 53,678 lbs.
o. Design Wind Velocity 100 mph
p. Mfg. Serial No. 65-D-1841 ; H.S.B. No. _____
q. Inspection by _____ Celanese
r. TEST LINER w/ AIR & SOAP SUDS.

MATERIAL SPECIFICATIONS

- a. Shell ASME A-264 GR1 TO BE LINED W/SA-240T-316LSS (MOD.)
b. Head ASME A-264 GR1 TO BE LINED W/SA-240T-316LSS (MOD.)
c. Flanges ASME (N022L2) SA-192 C-316LSS MOD. (MANHOLE) SA-192 RT PRN SA-192 SA 105 GA 2
d. Nozzle Necks ASME SA-312 TP 316LSS (MOD.)
e. Nozzle Reinforcing ASME _____
f. Pressure Bolting ASME SA-193 B7 Studs Nuts SA-192 C 6.4
g. Internals ASME ASME A-283-C
h. Skirt and Base ASME ASME REQ'D
i. Stiffener Rings ASME ASME REQ'D
j. Gaskets J.M. # 60 HUNGROPHITED
k. Paint APPLY LAST ALL C.S. SURFACES & APPLY ONE COAT (2) (7)
RED METAL PRIMER J.B. # 983
l. Weld Rod ASME SEE WELDPROC NOTES
m. h. TYPE 316L S.S. TO BE MODIFIED AS FOLLOWS, CR. 110% MIN.,
MC. 2.55% MIN., + C. 0.03% MAX
GENERAL NOTES

WELDROD NOTES

- NOTE "H" $\frac{1}{2}$ # SA-298 CLE-317L-16 COATED MANUAL ELECTRODE (17)
NOTE "B" $\frac{1}{2}$ # SA-298 CLE-317L-16 COATED MANUAL ELECTRODE (18)
NOTE "C" $\frac{1}{2}$ # SA-298 CLE-317L-16 COATED MANUAL ELECTRODE (19)
NOTE "D" INITIAL PASSES NOTE "B" FINAL PASSES NOTE "C"
NOTE "E" $\frac{1}{2}$ # SA-298 CLE-310 MO-16 COATED MANUAL ELECTRODE (20)
NOTE "F" $\frac{1}{2}$ # SA-298 CLE-310 MO-16 COATED MANUAL ELECTRODE (21)
NOTE "G" INITIAL PASSES NOTE "E" FINAL PASSES NOTE "F"
NOTE "H" $\frac{1}{2}$ # SA-298 CLE-310 MO-16 COATED MANUAL ELECTRODE (22)
NOTE "J" INITIAL PASSES NOTE "F" FINAL PASSES NOTE "C"
NOTE "K" INITIAL PASSES NOTE "L" FINAL PASSES NOTE "A"
NOTE "L" $\frac{1}{2}$ # SA-371 CLE-317 L BARE WIRE (36" CUT LENGTHS) (23)
FOR HELIARC
NOTE "M" INITIAL PASSES NOTE "E" & FINAL PASSES NOTE "B"

MANUFACTURED BY
WYATT INDUSTRIES, INC.
HOUSTON TEXAS

MAX. WORKING PRESSURE 800 PSI *

MAX. TEMP. 390 °F

MANUFACTURER SERIAL NO. 64-D-1841

U.S.E. NO.

* FULL VAL. @ 200°F ITEM # V-358

PO # 331-1402-4

YEAR BUILT
1963

REFERENCE DRAWING MISC. DETAILS MANHOLE DAVIT				8 1/2" WT. 7563 B-1527			
				POLANESSE CHEMICAL COMPANY A DIVISION OF CELESTINE CORPORATION OF AMERICA DANDA ENGINEERING DEPT.			
				AREA II REACTION UNIT			
				VERTICAL VESSEL 5'-1 1/4" I.D. x 5'-10" SEAM TO SEAM			
C CHANGED LOCATION OF NOZZLE W/ F NOSE				TWL ✓ IN		8-18-64	
B REV. ELEV. OF MH				JDIK		7-21-64	
A REV. PER CUSTOMER APPROVAL				GEMI 3RD TWL		2-23-64	
W/ NO NO		DESCRIPTION		BY CK APPD DATE		APR BY DATE	
REVISIONS				DRAWING NO. WT. 7562			