

FORM U-1 MANUFACTURERS' DATA REPORT FOR UNFILLED PRESSURE VESSELS

As required by the Provisions of the ASME Code Rules

1. Manufactured by Wyatt Industries, Inc. Dallas, Texas
(Name and address of manufacturer)
2. Manufactured for Celanese Chemical Company, Pampa, Texas
(Name and address of purchaser)
3. Type Horiz. Kind Ht. Exch. Vessel No. 65-D-2381 (Mfrs. Serial) (State & State No.)
(Horiz. or Vert.) (Tank, Jacketed, Heat Exch.) (Mfrs. Serial) (State & State No.) Natl. Bd. No. Yr. Built 1964

Items 4-9 incl. to be completed for single wall vessels (such as air tanks), jackets of jacketed vessels, or shells of heat exchangers.

4. SHELL: Material SA240 T304 T.S. 75,000 Nominal Thickness 1/4" Corrosion Allowance 1/16" In. Diam. 2 Ft. 4 In. Length 19 Ft. 11-1/2"
(Kind and Spec. No.) (Flg. or F.B. & Spec. Min. T.S.)
5. SEAMS: Long Dbl. Butt H.T. No X.R. Spot Sectioned No Efficiency 85 %
(Welded, Dbl., Single, Lap, Butt) (Yes or No) (Spot or Complete) (Yes or No)
Girth Dbl. Butt H.T. No X.R. Spot Sectioned No No. of Courses 4
If riveted describe seams fully on reverse side of form

6. HEADS: (a) Material T.S. (b) Material T.S.
Location Thickness Crown Radius Knuckle Radius Elliptical Ratio Conical Apex Angle Hemispherical Radius Flat Diameter Side to Pressure
(Top, bottom, ends) (Convex or Concave)
(a)
(b)
If removable, bolts used Other fastening
(Material, Spec. No., T.S., Size, Number) (Describe or Attach Sketch)

7. STAYBOLTS: If hollow Attachment Pitch X Diam.
(Material) (Size of Hole) (Threaded, Welded) (Horiz.) (Vert.) (Nominal)

8. JACKET CLOSURE:
(Describe as ogee & weld, bar, etc. If bar give dimensions, if bolted, describe or sketch)

9. Constructed for max. allowable working press.² 160 psi. at max. temp. 400 °F. Min. temp. (when less than -20°) -20 °F. Hydrostatic Test Press. 291 psi.
~~Working~~ ~~Pressure~~

Items 10 and 11 to be completed for tube sections.

10. TUBE SHEETS: Stationary. Material SA-240 T-304 SS Diam. 30-3/8" Thickness 1.8125 Attachment Welded
(Kind & Spec. No.) (Subject to Pressure) (Welded, Bolted)
Floating. Material Diam. In. Thickness In. Attachment
(Kind & Spec. No.)

11. TUBES: Material SA249 T304 O.D. 1" In. Thickness #14 BWG Inches or Gage Number 380 Type Straight
(Kind & Spec. No.) (Straight or U)

Items 12-15 incl. to be completed for inner chambers of jacketed vessels, or channels of heat exchangers.

12. SHELL: Material SA285-C Fbx T.S. 55,000 Nominal Thickness 5/16" Corrosion Allowance 1/16" In. Diam. Ft. In. Length Ft. In.
(Kind and Spec. No.) (Flg. or F.B. & Spec. Min. T.S.)
13. SEAMS: Long Dbl. Butt H.T. No X.R. Spot Sectioned No Efficiency 85 %
(Welded, Dbl., Single, Lap, Butt) (Yes or No) (Spot or Complete) (Yes or No)
Girth Dbl. Butt H.T. No X.R. Spot Sectioned No No. of courses 2
If riveted describe seams fully on reverse side of form

14. HEADS: (a) Material T.S. (b) Material SA285C Fbx T.S. 55,000 (c) Material T.S.
Location Thickness Crown Radius Knuckle Radius Elliptical Ratio Conical Apex Angle Hemispherical Radius Flat Diameter Side to Pressure
(Top, bottom, ends) (Convex or Concave)
(a) Top, bottom, ends 3/8"
(b) Channel (2) 2:1 Concave
(c) Floating
If removable, bolts used (a) (b)
(Material, Spec. No., T.S., Size, Number) (Describe or Attach Sketch)

15. Constructed for max. allowable working press.² 160 psi. at max. temp. 400 °F. Min. temp. (when less than -20°) -20 °F. Hydrostatic Test Press. 240 psi.
~~Working~~ ~~Pressure~~

Items below to be completed for all vessels where applicable.

16. SAFETY VALVE OUTLETS: Number Size Location In Line

17. NOZZLES: See Attached Schedule of Openings.

Purpose (Inlet, Outlet, Drain)	Number	Diam. or Size	Type	Material	Thickness	Reinforcement Material	How Attached

18. INSPECTION Manholes, No. Size Location
OPENINGS: Handholes, No. Size Location

19. SUPPORTS: Skirt No Lugs Legs Other 2 Saddles Attached By Others
(Yes or No) (Number) (Number) (Describe) (Where & How)

20. REMARKS: 2' 4" O.D. x 19' 11-1/2" Tube Sheet to Tube Sheet Horiz. Ht. Exch.
P. O. No. 331-3430-4; Item No. HE-618;

(Brief description of purpose of the vessel, as Air Tank, After Cooler, Jacketed Cooker, etc. State contents of each part.)

(Over)

¹ If postweld heat-treated.² List other internal or external pressures with coincident temperature when applicable.

96233

[illegible]

Date 1-18- 19 65 Signed Wyatt Industries, Inc.
(Manufacturer) By [Signature]
(Representative)

Inspectors Signature

Commissions

Nat'l Board or State and No.

96233

SCHEDULE OF OPENINGS									
MARK	QUANTITY	SIZE	TYPE	RATING	MAT.	NOZZLE	SCHEM.	SERVICE	REMARKS
A1, A2	ONE EA.	12"	L.J.	150#	C.S.	1" R	F-304SS	PROCESS MALT	
B	ONE	8"	L.J.	150#	C.S.	1" R	F-304SS	PROCESS MALT	
C	ONE	8"	N.F.R.	150#	C.S.	80	C.S.	C.W. IN	
D	ONE	8"	N.F.R.	150#	C.S.	80	C.S.	C.W. OUT	

MANUFACTURED BY
WYATT INDUSTRIES, INC.
 HOUSTON TEXAS
 CORPUS CHRISTI TEXAS

DESIGN PRESSURE P.S.I. 160
 DESIGN TEMP. °F. 400
 MANUFACTURER SERIAL NO. 64-D-2381
 YEAR BUILT 1964

DETAIL OF NAME PLATE

END ELEVATION

SIDE ELEVATION

1. Type HORIZONTAL SHELL & TUBES
2. Size 2'-4" O.D. X 20'-0" TUBE LENGTH
3. Net Surface Area 1988 SQ. FT.
4. ASME Code for Unfired Pressure Vessels, Section VIII, Edition 1962
5. TEMA Standards, Class C, Edition 1959
6. Code Symbol to be Applied: YES
7. Design Pressure: Shell Side 160 PSI, Tube Side 160 PSI
8. Design Temperature: Shell Side 400 °F, Tube Side 400 °F
9. Type Heads CODE ELLIPTICAL 2:1 RATIO
10. Tubes: Number 380 Size 1" OD BWG 14 Length 40 ft. Pitch 1 1/2 in. Δ
11. No. of Passes: Shell Side 1 Tube Side 1
12. Type of Expansion Joint: PACIFIC BELLWOS OR EQ.
13. Hydro-Static Test Pressure: (Based on Design Pressure)
 Pressure on Shell Side Only 240 PSI
 Pressure on Tube Side Only 240 PSI
14. Weight Empty 11,917 lbs.
15. Weight filled with Water 15,917 lbs.
16. Mfg. Serial No. 64-D-2381
17. Joint Eff. Shell 85% Heads 100% Channels 85%
18. Stress Relieve NO X-Ray SPOT PER CODE
19. Inspection by Hartford S.B.I. Co. & Celanese

- MATERIALS**
21. Shell ASME SA-240 T-304 S.S. HRAP
 22. Heads ASME SA-240 T-304 S.S. HRAP
 23. Tubes ASME SA-240 T-304 S.S. HRAP
 24. Tube Sheets ASME SA-240 T-304 S.S. HRAP
 25. Flanges: Shell ASME SA-181 GR.1
 Head ASME SA-181 GR.1
 Nozzles (ss) ASME SA-181 GR.1
 26. Bolting ASME SA-193 B7 Studs, Nuts, ASME SA-193 CL. 2H
 27. Gaskets GARLOCK #8748
 28. Baffles ASME SA-240 T-304 S.S. HRAP
 29. Tie Rods ASME A-276 T-304 S.S. Spacers ASME
 30. Weld Metal: (ss) ASME SA-240 T-304 S.S. HRAP
 (cs) ASME SA-240 T-304 S.S. HRAP
 31. Nozzle Necks: (ss) ASME SA-240 T-304 S.S. HRAP
 (cs) ASME SA-240 T-304 S.S. HRAP
 32. Nozzle Reinforcing ASME SA-240 T-304 S.S. HRAP
 33. Structural Supports SA-240 T-304 S.S. HRAP
 34. Paint: SANDBLAST & APPLY ONE COAT RED METAL PRIMER

- GENERAL NOTES**
41. All bolt holes shall straddle center lines.
 42. Protect all machined surfaces and threaded connections with rust preventive.
 43. Vessel shall be drained and cleaned before shipping.
 44. All nozzle flanges shall be ASA standard except for manhole flanges.
 45. No metallic pigment paints, or center punch or tool scars shall be used for marking stainless steel, and no fit up lugs shall be used on inside of shell.
 46. Tolerances to be per page 22 of Celanese specifications, EN-71.
 47. All welding to be in accordance with Welding procedures (modified per Celanese Spec. EN-71, Section 10) DWI-4, DWI-1, DWI-2, DWI-3, DWI-4, DWI-5, DWI-6, DWI-7, DWI-8, DWI-9, DWI-10, DWI-11, DWI-12, DWI-13, DWI-14, DWI-15, DWI-16, DWI-17, DWI-18, DWI-19, DWI-20, DWI-21, DWI-22, DWI-23, DWI-24, DWI-25, DWI-26, DWI-27, DWI-28, DWI-29, DWI-30, DWI-31, DWI-32, DWI-33, DWI-34, DWI-35, DWI-36, DWI-37, DWI-38, DWI-39, DWI-40, DWI-41, DWI-42, DWI-43, DWI-44, DWI-45, DWI-46, DWI-47, DWI-48, DWI-49, DWI-50, DWI-51, DWI-52, DWI-53, DWI-54, DWI-55, DWI-56, DWI-57, DWI-58, DWI-59, DWI-60, DWI-61, DWI-62, DWI-63, DWI-64, DWI-65, DWI-66, DWI-67, DWI-68, DWI-69, DWI-70, DWI-71, DWI-72, DWI-73, DWI-74, DWI-75, DWI-76, DWI-77, DWI-78, DWI-79, DWI-80, DWI-81, DWI-82, DWI-83, DWI-84, DWI-85, DWI-86, DWI-87, DWI-88, DWI-89, DWI-90, DWI-91, DWI-92, DWI-93, DWI-94, DWI-95, DWI-96, DWI-97, DWI-98, DWI-99, DWI-100, DWI-101, DWI-102, DWI-103, DWI-104, DWI-105, DWI-106, DWI-107, DWI-108, DWI-109, DWI-110, DWI-111, DWI-112, DWI-113, DWI-114, DWI-115, DWI-116, DWI-117, DWI-118, DWI-119, DWI-120, 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