

#78871

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

Alternate Form for Single Chamber Completely Shop-Fabricated Vessels Only

1. Manufactured by GENERAL WELDING WORKS, INC.
(Name and address of Manufacturer)

2. Manufactured for M.W. Kellogg Company
(Name and address of Purchaser)

3. Type Vert Vessel No. (7576) (Mfrs. Serial) (Louisiana Natl. Bd. No. 4286) Yr. Buil 1966
(Horiz. or Vert.) (State & State No.)

4. SHELL: Matl. * T.S. 70000 Thk. Nom. 1 3/4 Corr. 1/16 In. Allow. 9 Ft. 6 In. Length 9 Ft. 2 In.
(Kind and Spec. No.) (Fig. or F.B. & Spec. Min. T.S.)

5. SEAMS: Long DB-FW H.T. yes X.R. comp Sectioned no Efficiency 100 %
(Welded, Dbl., Single, Lap, Butt) (Yes or No) (Spot or Complete) (Yes or No)
Girth DB-FW H.T. yes X.R. comp Sectioned no No. of Courses 1
If riveted or brazed describe seams fully under remarks

6. HEADS: (a) Material * T.S. 70000 (b) Material * T.S. 70000
Location (Top, bottom, ends) Thickness Crown Radius Knuckle Radius Elliptical Ratio Conical Apex Angle Hemispherical Radius Flat Diameter Side to Pressure (Convex or Concave)
(a) top 1 11/16" 2:1 concave
(b) bottom 1 3/4" 2:1 concave
If removable, bolts used _____ Other fastening _____
(Material, Spec. No., T.S., Size, Number) (Describe or Attach Sketch)

7. Constructed for max. allowable working press. 425 psi. at max. temp. 850 °F. Min. temp. (when less than -20°) - °F. Hydrostatic Test Press. 774 psi.
Corrosion Allowance _____

8. SAFETY OR RELIEF VALVE OUTLETS: Number none Size _____ Location _____

9. NOZZLES:
Purpose (Inlet, Outlet, Drain) Number Diam. or Size Type Material Thickness Reinforcement Material How Attached
Inlet one 12"-400# RFWNF A-335-P1 .500 1 3/4"* Welded
Outlet one 12"-400# RFWNF A-335-P1 .500 1 3/4"* Welded

10. INSPECTION Manholes, No. one Size 18"-400# Location In top head
OPENINGS: Handholes, No. _____ Size _____ Location _____
Threaded, No. _____ Size _____ Location _____

11. SUPPORTS: Skirt no Lugs four Legs _____ Other _____ Attached welded
(Yes or No) (Number) (Number) (Describe) (Where & How)

12. REMARKS: Methanator P.O.#5376-106-D30-101 Item 106-D S/O 5934
two 12"-400# RFWNF A-335-P1 .500 1 3/4" Welded
one 8"-400# RFWNF A-335-P1 .500 1 3/4" Welded
one 18"-400# RF Lenape "H" A-182-F1 2 3/8" Weld Welded
one 3"-400# RFWNF A-335-P1 .600 1 3/4"* Welded

*A-204-B-FB

(Brief description of purpose of the vessel as Air Tank, Water Tank, L.P.G., Etc.—State Contents.)

† 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 material, construction, and workmanship of this vessel conform to the ASME Code for Unfired Pressure Vessels.

Date Aug., 15, 19 66 Signed GENERAL WELDING WORKS, INC. By Audrey Malinowski
(Manufacturer)

Certificate of Authorization Expires Dec. 31, 1967

CERTIFICATE OF SHOP INSPECTION

VESSEL MADE BY General Welding Works, Inc. at Houston, Texas

I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State of Texas and employed by H.S.B.I. & I. Co. of Hartford have inspected the pressure vessel described in this manufacturer's

data report on Aug., 15, 1966, 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 Aug., 15, 19 66

NG Bergman
Inspector's Signature

Commissioner Texas No. 450 Nat'l Bd No 5373
Nat'l Board or State and No.

106 ✓ # 98871

10-0957

SO 5934

GENERAL WELDING WKS

HOUSTON TEXAS

NATL BD NO 4286

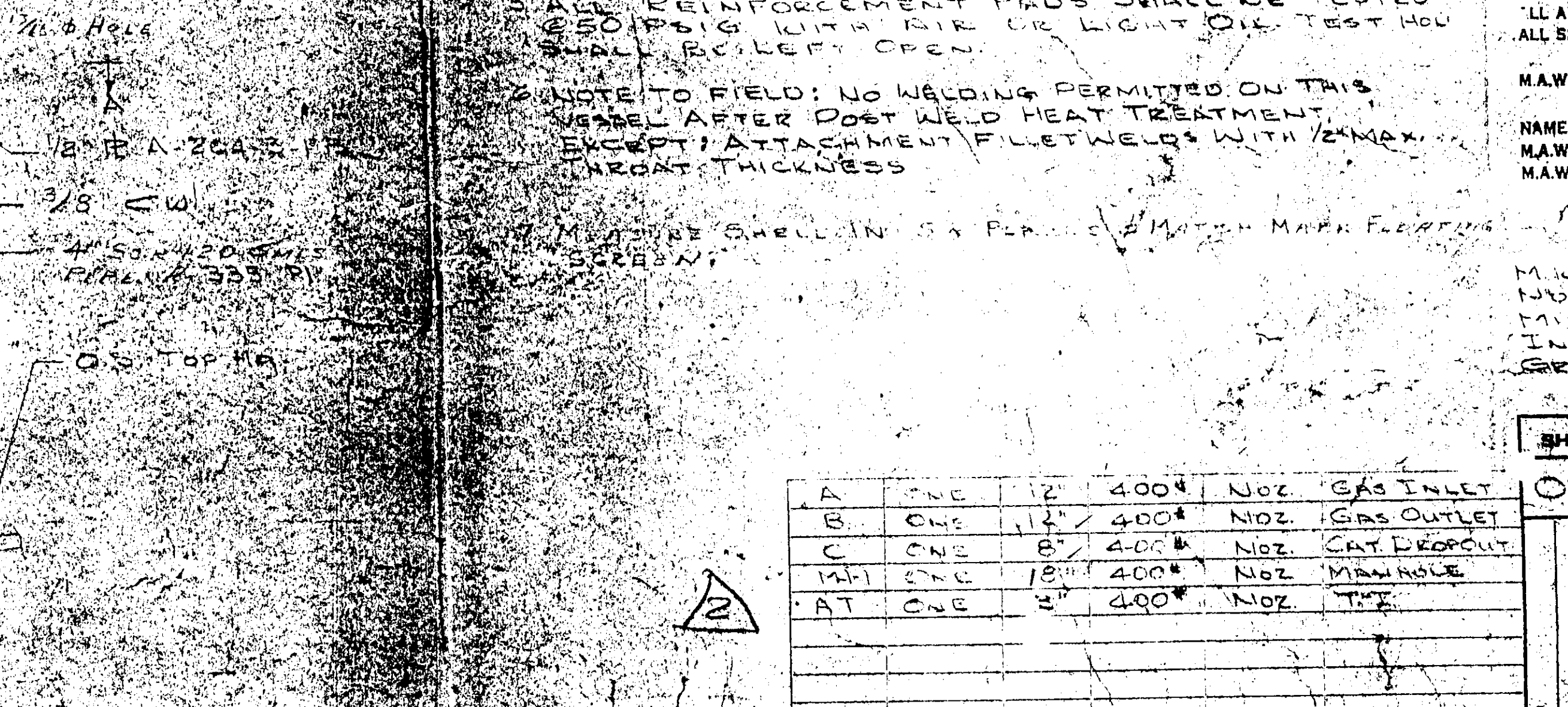
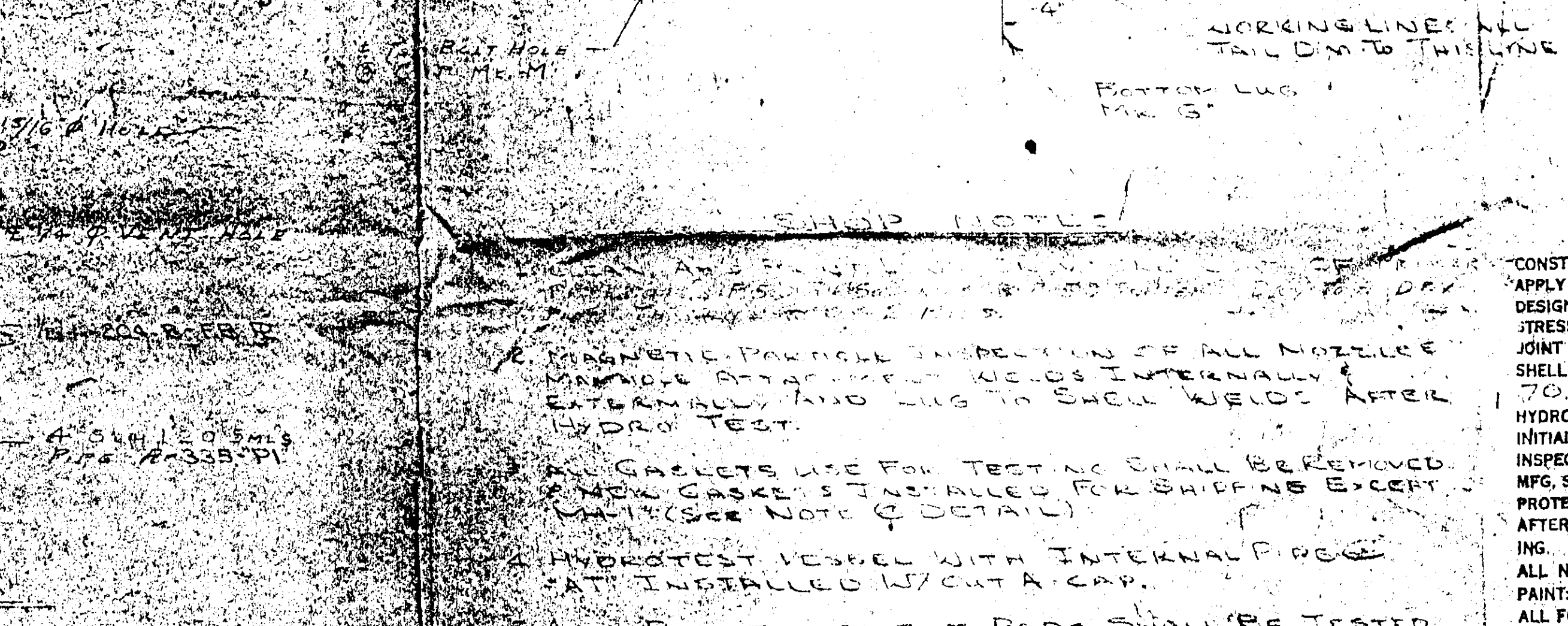
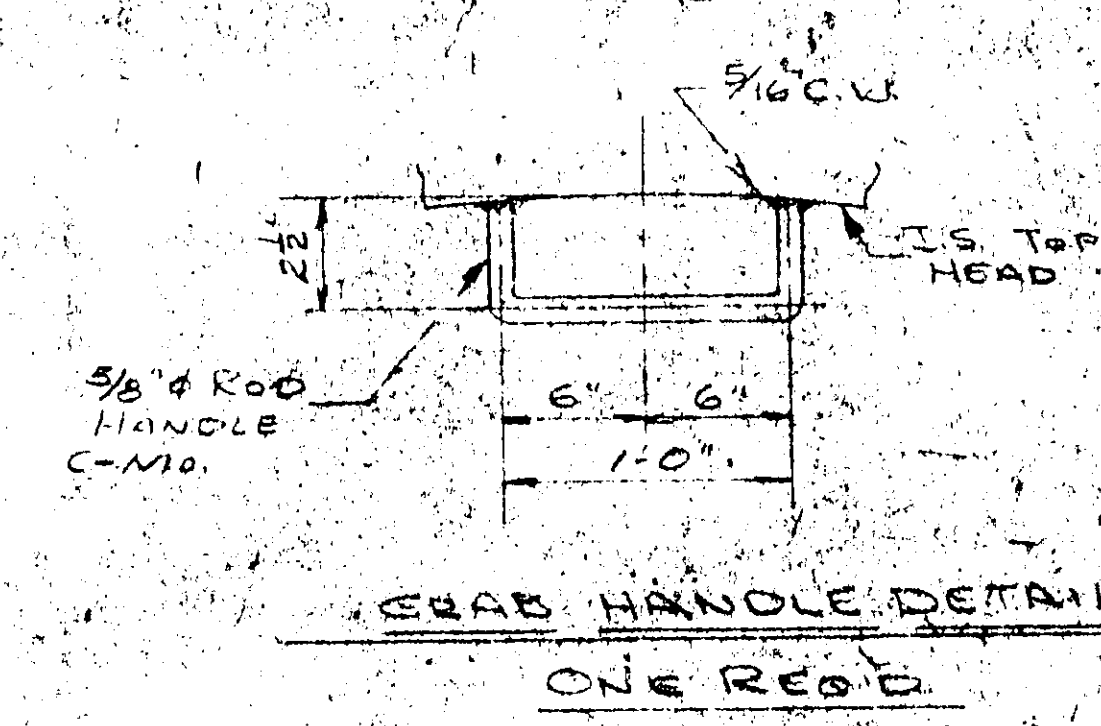
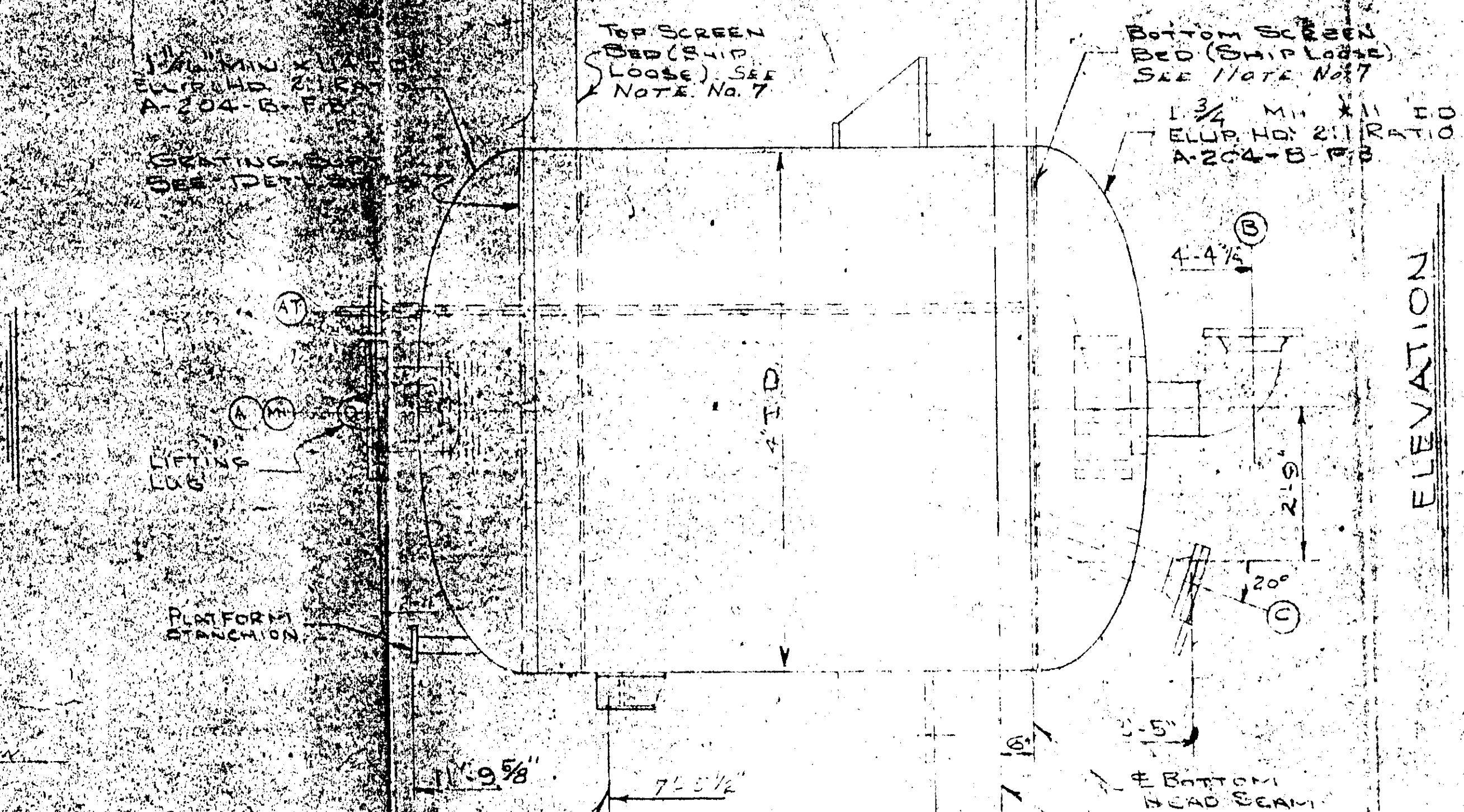
SER NO 7576

ITEM NO 106-1D

MAWP 425 PSI AT 850°F

MAWT 850°F AT 425 PSI

DATE 8-66



CONSTRUCTION: 365 ASME CODE
APPLY SYMBOL PER PAR. UG-116
DESIGN PRESSURE 42.5 P.S.I. DESIGN TEMPERATURE 350°F CORR. ALL V
STRESS RELIEVE YES RADIOGRAPH YES
JOINT EFF. SHELL 100% HEAD 100%
SHELL AND HEAD THICKNESSES HAVE BEEN DETERMINED USING A TENSILE STRENGTH OF 70,000 P.S.I.
HYDROSTATIC TEST BASED ON TOP HEAVY
INITIAL TEST _____ P.S.I. HAMMER TEST _____ P.S.I. FINAL TEST 774 P.S.I.
INSPECTION BY HEBERT T CO
MFG. SERIAL NO. 7576 NATURON No. 4286
PROTECT ALL MACHINE SURFACES & THREADED CONNECTIONS WITH RUST PREVENTIVE IMMEDIATELY AFTER MACHINING. INSTALL WOOD OR STEEL PROTECTORS OF FITTINGS IMMEDIATELY AFTER TESTING. VESSEL TO BE DRAINED AND CLEANED BEFORE SHIPPING
ALL NOZZLE AND MANHOLE BOLTS TO STRADDLE CENTER-LINE UNLESS NOTED.
PAINT: SEE NOTE 10-11
ALL FORGED STEEL FLANGES UP TO AND INCLUDING 300" TO BE ASTM A-181-CL 1
ALL ABOVE TO BE ASTM 105-CL 1 UNLESS NOTED
ALL SEAMLESS STEEL PIPE AS NOTED

M.A.W.P. 510 NEW AND COLD

NAME PLATE STAMPING

M.A.W.P. 425 P.S.I. AT 850 °F. PROC: GW-10P2 - GW-3224

M.A.W.T. 850 °F. AT 425 P.S.I.

REFERENCE DRAWINGS:

M.C. KELLOGG CO.	59342-204
NO2 DETAILS	59342-204
MISC DETAILS	59342-204
INCOL DETAILS	59342-204
GRATING DETAILS	59342-204

[illegible]

SHIPPING WEIGHT 76750		ONE VESSEL REQUIRED		S/O 5934	
Certified for Construction JUL 29 1958 GENERAL WELDING WORKS INC. BY: <i>[Signature]</i>				GENERAL WELDING WORKS HOUSTON, TEXAS 1-14" 16" x 9' 2" Beam T-3 METHUEN, N.H. ITEM NO. 106-5 COMMERCIAL SOUTHWEST CORP. 1600153 DAWSONIA PLANT SHERBOURNE, LOUISIANA CUSTOMER M. J. KEEFER, JR. P. O. BOX 106, 106-55-151	
REV SIZE NOT "AT"		7-11-58		7-11-58 CHECKED ☒ DATE ☒	
1 010-005 MAT. V. PART STN. 106-55-151		DATE REC'D		ORIGINAL 5934	
NO.	REVISION	DATE	BY		