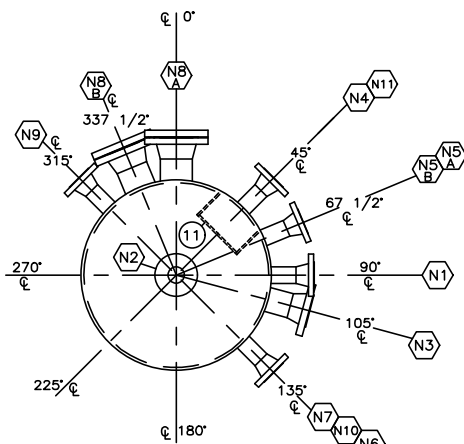
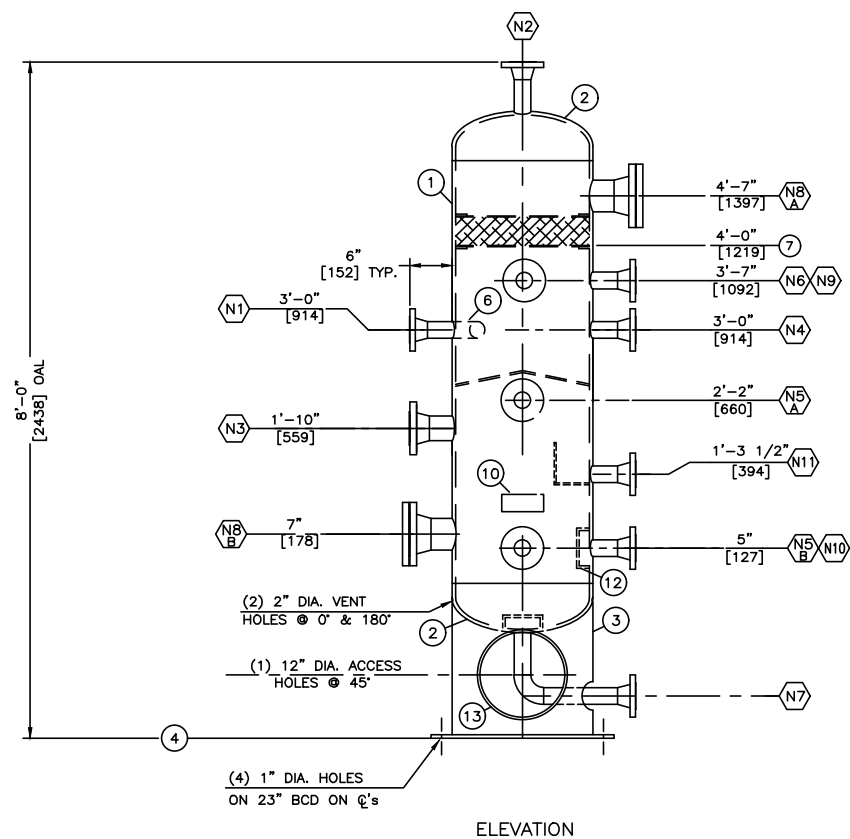


ITEM NO.	NO. REQ'D	SIZE	RATING	SERVICE	WELDING DETAIL	WELD SIZE			INT. PROJ. "D"
						"A"	"B"	"C"	
N1	1	2"	CL 150	INLET	N2, F1	3/8"			1 1/2"
N2	1	2"	CL 150	OUTLET	N1, F1	3/8"			
N3	1	3"	CL 150	LC GLYCOL	N1, F1	3/8"			TRIM FLUSH
N4	1	2"	CL 150	TI	N1, F1	3/8"			
N5	2	2"	CL 150	LG GLYCOL	N1, F1	3/8"			TRIM FLUSH
N6	1	2"	CL 150	BLANKET GAS	N1, F1	3/8"			
N7	1	2"	CL 150	DRAIN	N1, F1, S7	3/8"			GROUND FLUSH
N8	2	4"	CL 150	INSPECTION	N1, F1	3/8"			TRIM FLUSH
N9	1	2"	CL 150	PSV	N1, F1	3/8"			
N10	1	2"	CL 150	GLYCOL OUT	N1, F1	3/8"			TRIM FLUSH
N11	1	2"	CL 150	SKIMMER	N1, F1	3/8"			TRIM FLUSH

BILL OF MATERIALS

ITEM NO.	QTY REQ'D	DESCRIPTIONS	MATL SPEC.
1	1	SHELL- 20" OD x 0.500" THK. PLATE	SA-516-70N
2	2	HEADS- 20" OD x 0.4375" MIN x 2:1 SE c/w 2" SF (0.500" NOM)	SA-516-70N
3	1	SKIRT- 20" OD SCH. STD. SML'S PIPE	SA-106-B
4	1	BASE PLATE- 26" OD x 16" ID x 1/2" PLATE	SA/CSA-640.21-44W
5	1	FLOAT SHIELD- 1/2" THK. PLATE	SA/CSA-640.21-44W
6	1	ELBOW - 2" SCH 160 90° LR	SA-234-WPB
7	1	MISTEX- 4" THK. x 9#/FT ³ x 19" OD	316L SS
8	2	RINGS- 18 7/8" OD x 15 7/8" ID x 1/2" THK. PLATE	SA/CSA-640.21-44W
9	2	XPM- x 18 7/8" OD (HEAVY)	SA/CSA-640.21-44W
10	1	NAME PLATE BRACKET- 3/16" THK. PLATE	SA/CSA-640.21-44W
11	4 pcs	SKIMMER BOX- 1/2" THK PLATE	SA/CSA-640.21-44W
12	2 pcs	VORTEX BREAKER-2" x 1/2" THK. x 6" LG	SA/CSA-640.21-44W
13	1	REINF. RING-12" SCH STD. ERW PIPE x 4" LG	SA-53-B
N1	1	FLG - 2" CL 150 RFWN SCH. XXH	SA-105N
	1 PC	NECK- 2" SCH. XXH SML'S PIPE	SA-106B
N2	1	FLG - 2" CL 150 RFWN SCH. XXH	SA-105N
	1 PC	NECK- 2" SCH. XXH SML'S PIPE	SA-106B
N3	1	FLG - 3" CL 150 RFWN SCH. XXH	SA-105N
	1 PC	NECK- 3" SCH. XXH SML'S PIPE	SA-106B
N4	1	FLG - 2" CL 150 RFWN SCH. XXH	SA-105N
	1 PC	NECK- 2" SCH. XXH SML'S PIPE	SA-106B
N5	2	FLG - 2" CL 150 RFWN SCH. XXH	SA-105N
	2 PCS	NECK- 2" SCH. XXH SML'S PIPE	SA-106B
N6	1	FLG - 2" CL 150 RFWN SCH. XXH	SA-105N
	1 PC	NECK- 2" SCH. XXH SML'S PIPE	SA-106B
N7	1	FLG - 2" CL 150 RFWN SCH. XXH	SA-105N
	2 PC	NECK- 2" SCH. XXH SML'S PIPE	SA-106B
	1	ELBOW- 2" LR 90° BW SCH XXH	SA-234-WPB
N8	2	FLG - 4" CL 150 RFWN SCH. 160	SA-105N
	2 PCS	NECK- 4" SCH. 160 SML'S PIPE	SA-106B
	2	BLIND FLG- 4" CL 150 RF	SA-105N
	16	STUDS- 5/8" x 3 1/2" LG c/w NUTS	SA-181-87M
	2	GASKET- 4" CL 150 RF FLEX x 1/8" THK	316SS
N9	1	FLG - 2" CL 150 RFWN SCH. XXH	SA-105N
	1 PC	NECK- 2" SCH. XXH SML'S PIPE	SA-106B
N10	1	FLG - 2" CL 150 RFWN SCH. XXH	SA-105N
	1 PC	NECK- 2" SCH. XXH SML'S PIPE	SA-106B
N11	1	FLG - 2" CL 150 RFWN SCH. XXH	SA-105N
	1 PC	NECK- 2" SCH. XXH SML'S PIPE	SA-106B



ORIENTATION

GENERAL NOTES :

- VESSEL TO BE THOROUGHLY DRAINED & CLEANED WITH ALL OPENINGS PLUGGED BEFORE SHIPMENT.
- ALL BOLT HOLE TO STRADDLE NATURAL Q'S UNLESS NOTED.
- EXPOSED INSIDE EDGES OF NOZZLES TO BE ROUNDED OR CHAMFERED
- ALL DIMENSIONS ARE TO REFERENCE LINE UNLESS NOTED.
- LONG & CIRC. SMS. USE WELD DETAIL "S7"
- IMPACT TEST NOT REQ'D AS PER UG-20-(f) 1-5 & UCS-66(c)
- MINIMUM DESIGN METAL TEMPERATURE, -20° F @ 275 PSIG.
- RUSHTON REF. WELD PROC. R-2, R-6, R-8, & R-13
- VESSEL CALC'S HAVE CONSIDERED ALL APPLICABLE LOADINGS IN ACCORDANCE WITH UG-22
- ALTERNATE DESIGN TO USE SA-350-LF2 FOR FORGINGS: SA-333-GR6 FOR PIPES & SA-420-WPL6 FOR WELD FITTINGS
- ROOT BEAD TO BE GMAW USING ER70S2 WIRE ONLY.
- ALL ATTACHMENT WELDS OF INTERNALS TO SHELL SHALL BE FULL PEN.
- RUN ON/OFF TABS MUST BE OF THE SAME "P" NO. AS MATERIALS BEING WELDED.
- FUSED SAW FLUX SHALL NOT BE GROUND & REUSED
- NICKEL CONTENT OF WELDING CONSUMABLES SHALL NOT EXCEED 0.80%
- FULL MT OR PT OF (2) CAT. "D" NOZZLE WELDS < NPS 4 AFTER PWHT

MATERIAL NOTES :

- ALL VESSEL SHELLS/HEADS PLATES HEAT & PRODUCT ANALYSES TO MEET SA-20 REQUIREMENTS
- SULPHUR CONTENT OF PLATES TO BE 0.010% - 0.020%.
- HEADS/SHELL PLATE SHALL HAVE THE FF. MAX. VALUES:
C: 0.22%
Mn: 1.20%
P: 0.015%
S: 0.003%
Ni + Cu + Cr + Mo + V: 0.50%
CE: 0.40%, WHERE:
 $CE = \%C + \frac{\%Mn}{6} + \frac{\%Cr}{5} + \frac{\%Mo}{5} + \%V + \frac{\%Ni}{15} + \frac{\%Cu}{15}$
BHN ≤ 200
FOR PIPE, FITTINGS & FLGS.
C: 0.23%
Cu + Ni + Cr + Mo + V : 0.60%
- ALL MATERIALS TO MEET NACE MR0175 REQUIREMENTS

SPECIFICATIONS

VESSEL TO BE DESIGNED AND CONSTRUCTED IN ACCORDANCE WITH THE ASME CODE SECTION VIII, DIVISION 1, PARA UW-11(a), 2007 EDITION
CODE STAMP REQ'D. _____ C.R.N. _____ C.A.-SHELL 0.2467" HEAD 0.2467"
DESIGN PRESSURE 275 PSIG @ -20/140 °F WEIGHT EMPTY 1350 LBS.
WORKING PRESSURE _____ @ _____ WEIGHT FLOODED 2040 LBS.
RADIOGRAPHY (RT-1) NOZZLE BW JT. EFF. 100% CIRC. JT. EFF. 100% VOLUME 11 FT³
STRESS RELIEVE 60 MIN. @ 1150°F HYDRO TEST 413 PSIG (NEW & COLD)
HEAD SPEC. SA-516-70N 0.4375" MIN. (0.500" NOM.)
SHELL SPEC. SA-516-70N (0.500" NOM.)
PAINT SEE PIPING PLAN NOTES

(1) REQ'D
TIME CARD
C-3026-FD

DWG. NO.	REFERENCE DRAWINGS	REV	DESCRIPTION	DATE	BY



CUSTOMER: NEXEN INC.		LOCATION: b-16-1/94-0-8	
c/o TRI-OCEAN ENGINEERING LTD.		P.O.# 4500105121	
GLYCOL FLASH DRUM			
20" OD x 5'-0" s/s x 275 PSIG x -20/140°F, 0.2467" C.A.			
DATE: 11/07/08	DRN BY: O.L.	SCALE: 1":1'-0"	CHKD BY: _____
APPRD BY: _____	DWG NO: C-3026-F	REV: Δ	