

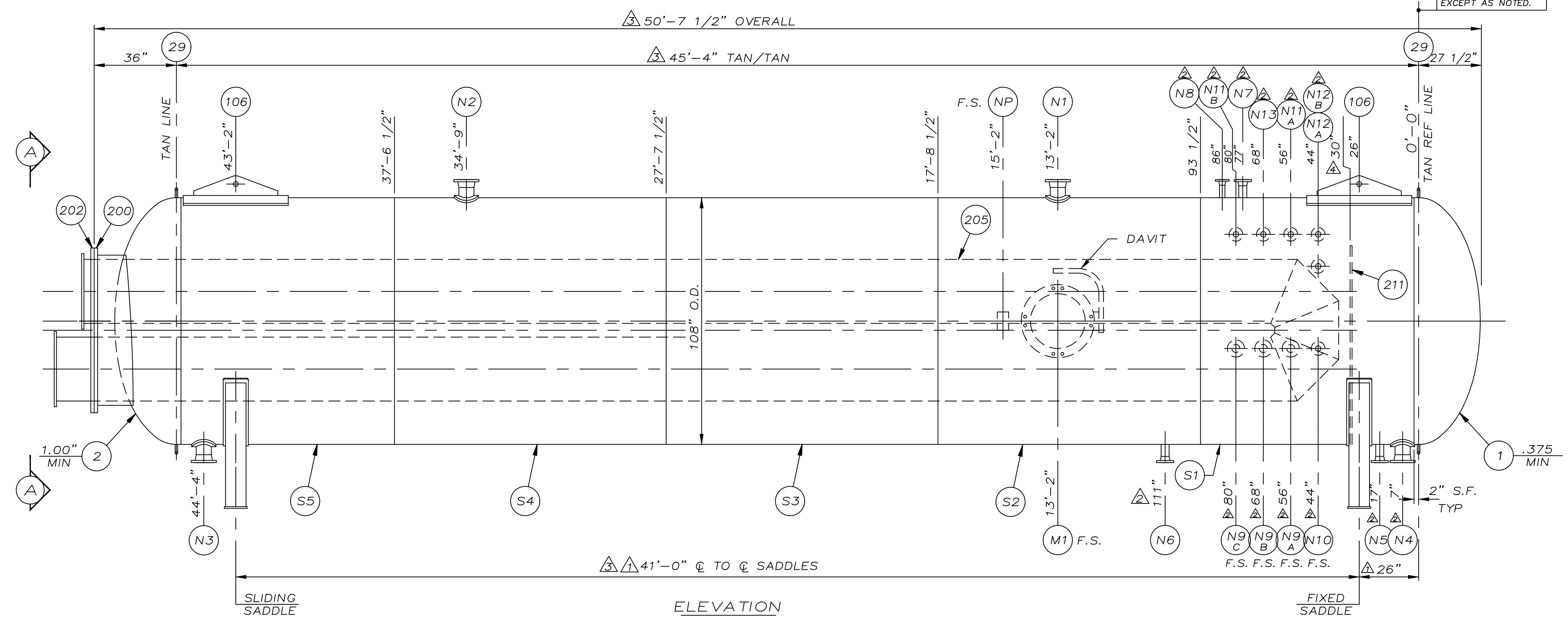
NOZZLE SCHEDULE AND WELDING DETAILS													
		I	II	III	IV	TYP. LONG & CIRC SEAM							
MARK NO.	NO. REQ'D	SIZE	RATING	TYPE	SCH	SERVICE	PROJECTION FROM CENTERLINE	WELDING DETAIL NO.	WELD SIZES			BILL OF MATERIAL ITEM NUMBER	REMARKS
N1	1	6"	150#	RFWN	XH	STRIPPING VAPOUR OUT	62 3/8"	1,III	3/8"	5/16"		12,13,14	
N2	1	6"		XH		STRIPPING VAPOUR OUT	62 3/8"	1,III	3/8"	5/16"		12,13,14	
N3	1	6"		XH		RICH AMINE INLET	62 1/2"	1,III	3/8"	5/16"		12,13,14	
N4	1	6"			160	LEAN AMINE OUTLET	62 1/2"	1,II	3/8"			12,13,14	
N5	1	3"			160	DRAIN	62 1/2"	1,II	3/8"			16,17	
N6	1	3"			160	DRAIN	62 1/2"	1,II	3/8"			16,17	
N7	1	3"			160	SPARE	62 1/2"	1,II	3/8"			16,17,19,20,21	c/w BLD FLG
N8	1	2"			160	EQUALIZER	62 1/2"	1,II	3/8"			23,24	
N9A to N9C	3	3"			160	TT/TSDH/(1)SPARE	SHOWN	1,II	3/8"			16,18	
N10	1	2"			160	TI	SHOWN	1,II	3/8"			23,24	
N11A to N11B	2	2"			160	PI/PT	SHOWN	1,II	3/8"			23,25	
N12A to N12B	2	2"			160	LG	SHOWN	1,II	3/8"			23,26,27	
N13	1	2"			160	PURGE GAS	SHOWN	1,II	3/8"			23,25	
M1	1	24"			STD	MANWAY	64 3/8"	1,III	3/8"	5/16"		4 to 10	c/w BLD FLG & DAVIT

BILL OF MATERIAL				
ITEM NO.	NO. REQ'D	DESCRIPTION	MATERIAL	MARK NO.
S1	2	SHELL 1/2" PL x 108" O.D. x 91 1/2" LG	SA-516-70N	
S2, S3, S4	3	SHELL 3/8" PL x 108" O.D. x 119" LG		
1	1	HEADS .375" MIN. x 108" O.D. x 2:1 S.E. w/ 2" S.F.		
2	1	HEADS 1.00" MIN. x 108" O.D. x 2:1 S.E. w/ 2" S.F.		
4	1	FLG 24"~150# ANSI RFWN SCH STD BORE	SA-105	
5	1	BLD FLG 24"~150# ANSI R.F.	SA-105	
6	1	NECK 24" SCH STD PIPE x 7 7/8" LG	SA-106-B	
7	1	REPAD 3/8" PL x 24 1/4" I.D. x 38" O.D.	SA-516-70	M1
8	20	STUD 1 1/4" x 6 3/4" LGc/w(2) HEX NUTS	SA-193-B7M SA-194-2HM	
9	1	GASKET FOR A 24"~150# FLG	JM-60	
10	1	DAVIT PER CESSCO STD ST-318-0-1	C.S.	
12	4	FLG 6"~150# ANSI RFWN SCH XH BORE	SA-105	
13	4	NECK 6" SCH XH PIPE x 6 5/8" LG	SA-106-B	N1,N2,N3,N4
14	4	REPAD 3/8" PL x 6 7/8" I.D. x 10 5/8" O.D.	SA-516-70N	
16	6	FLG 3"~150# ANSI RFWN SCH 160 BORE	SA-105	N5,N6,N7,N9A to N9C
17	3	NECK 3" SCH 160 PIPE x 7 1/8" LG	SA-106-B	N5,N6,N7
18	3	NECK 3" SCH 160 PIPE x 7 9/16" LG	SA-106-B	N9A to N9C
19	1	BLD FLG 3"~150# ANSI R.F.	SA-105	
20	4	STUD 5/8" x 3 3/4" LGc/w(2) HEX NUTS	SA-193-B7M SA-194-2HM	N7
21	1	GASKET FOR A 3"~150# FLG	JM-60	
23	7	FLG 2"~150# ANSI RFWN SCH 160 BORE	SA-105	N8,N10,N11A/B,N12A,B,N13
24	2	NECK 2" SCH 160 PIPE x 8" LG	SA-106-B	N8,N10
25	3	NECK 2" SCH 160 PIPE x 10 1/16" LG	SA-106-B	N11A/B,N13
26	1	NECK 2" SCH 160 PIPE x 8 3/8" LG	SA-106-B	N12A
27	1	NECK 2" SCH 160 PIPE x 19 1/16" LG	SA-106-B	N12B
29	2	INSULATION RING 3/8" R.B. x 112" O.D.	SA-36	
30	58	SUPPORT 3/8" R.B. x 1 5/8" LG	SA-36	
NP	1	CESSCO NAMEPLATE c/w BRACKET	SA-516-70 304 S.S.	

29 INSULATION RING

VIEW 'A-A'

ALL DIMENSIONS ARE TAKEN FROM THIS REF. TAN LINE EXCEPT AS NOTED.



- GENERAL NOTES
- ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
 - ALL BOLT HOLES TO STRADDLE NATURAL VESSEL CENTER-LINES UNLESS OTHERWISE NOTED.
 - FULL PENETRATION WELDS TO BE CHIPPED OR GOUGED BEFORE BACKWELDING.
 - CORNER RADIUS 1/8" MINIMUM FOR NOZZLES AND 1/4" MINIMUM FOR MANWAYS.
 - ALL PADS TO HAVE A 1/4" NPT WEEPHOLE ON DOWN-HILL SIDE OF NOZZLE OR MANWAY.
 - TWO WEEPHOLES REQUIRED WHEN PAD IS SPLIT (ONE EACH).
 - NOZZLES AND MANWAYS ARE INSTALLED SET FLUSH WITH INSIDE OF VESSEL UNLESS OTHERWISE SPECIFIED ON THE VESSEL DRAWING.
 - CHASE THREADS ON COUPLINGS AFTER WELDING.
 - IMPACT TEST EXEMPT PER UG-20(f).
 - REQUIRE 100% RADIOGRAPHY.
 - IF PSV IS NOT SHOWN IN NOZZLE SCHEDULE IT IS THE USERS RESPONSIBILITY TO LOCATE THE PSV IN ADJACENT PIPING PER ASME UG-125.
 - VESSEL TO BE COVERED WITH 2" HOT INSULATION c/w SMOOTH ALUMINUM JACKET/VAPOUR BARRIER (BY OTHERS)

THE INFORMATION ON THIS DRAWING IS THE PROPERTY OF CESSCO FABRICATION AND ENGINEERING LTD. AND MUST NOT BE RE-USED IN ANY WAY WITHOUT WRITTEN PERMISSION.

CESSCO
FABRICATION & ENGINEERING LIMITED

A SUBSIDIARY OF CANADIAN ERECTORS LTD. EDMONTON, ALBERTA

CUSTOMER	PRESSION MANUFACTURING LTD.	FINAL OWNER	RENAISSANCE ENERGY LTD. CADOTTE LAKE
CUSTOMER P.O.	112230-B6133-60	TAG NO.	H-820

AMINE REBOILER
108" O.D. x 45'-4" T/T x 75 PSIG @ 300F x .125" C.A.
PRESSION DRAWING NO. B6133-660

DESIGN DATA			
DESIGN & FABRICATE TO	ASME UW 12(g) DIV. 1 SECT. VIII 1995 ED., 1996 ADDENDA		
DESIGN PRESS(NT)	75 PSIG	DESIGN TEMP(NT)	300° F
M.A.W.P.	75 PSIG	DESIGN PRESS(EXT)	---
SHELL EFFICIENCY(CIRC)	100%	SHELL EFFICIENCY(LONG)	100%
G.R. No.	N-8952.2	RADIOGRAPHY	RT-1~SEE NOTE 10
P.W.H.T.	68 MIN. @ 1150° F	HYDROTEST	113 PSIG @ 60° F(MIN)
SHELL THK.(NEW)	.375"/.5"	HEAD THK.(NEW)	.375"MIN/1.00"MIN
BOOT SHELL THK.(NEW)	---	BOOT HEAD THK.(NEW)	---
VOLUME	3031 FT ³	WT. (EMPTY)	72400 LBS
		WT. (FULL OF WATER)	216357 LBS

MATERIAL SPECIFICATIONS	
SHELL	SA-516-70N
HEADS	SA-516-70N
CONC	---
SADDLE	SA-36
WEAR PLATE	SA-516-70N
BOLT CHAIR	---
STIFFENING RINGS	---
INTERNAL PLATE	SA-36
INTERNAL PIPING	SA-53-B ERW
PAINT	COMMERCIAL BLAST PER SSPC-SP6 & PRIME
WITH CLOVERDALE RUSTEX 71029 PRIMER.	

REV	DESCRIPTION	DATE	BY	CHKD	APPR.
5	AS BUILT	12/18/97	GM		
4	RELOCATED ITEM 211	10/16/97	GM	GEM/AK	GC
3	VESSEL WAS 50'-4" TAN/TAN	10/6/97	GM	GEM/AK	GC
2	REVISED AS NOTED	9/23/97	GM	GEM/GC	GC
1	RELOCATED SADDLES & NOZZLES N4,N5	8/26/97	GM	GEM/AK	GC

DATE	8/14/97	DRAWN BY	GMacMILLAN	CHECKED	GEM/YH	APPROVED	G.CHABOT	JOB NO.	3626	DWG NO.	3626-0	REV	5
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