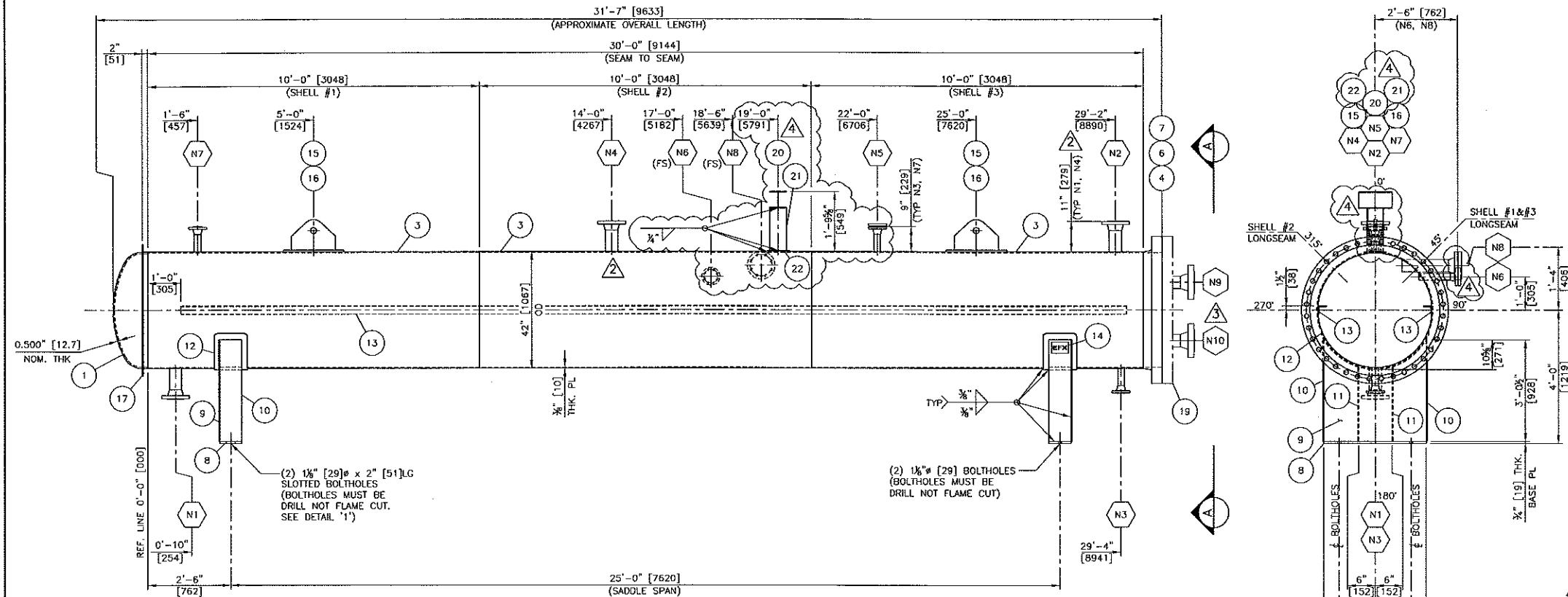
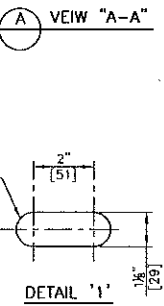
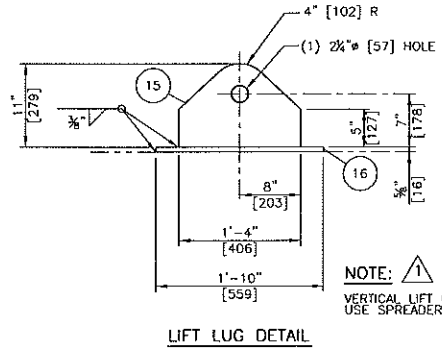
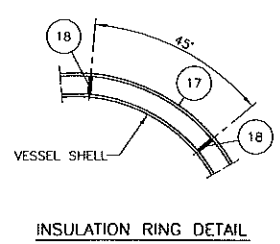


PM-126/127/147 PM-109/126/132 PM-109 PM-109 PM-109



- NOTES:**
- 1) ALL BOLTING TO BE SA-193-B7M AND SA-194-2HM CADMIUM PLATED MATERIAL.
 - 2) ALL GASKETS TO BE SPIRAL WOUND 316 SS WITH FLEXIBLE GRAPHITE FILLER AND 316 SS INNER AND CENTERING RINGS (GREY STRIPE).
 - 3) SHELLS AND HEAD ARE EXEMPT FROM IMPACT TESTED PER UCS-66(g). GMAW ROOT PASSES ARE IMPACT TESTED PER UG-84. TEST TEMP: -40°F. TEST RESULTS: 12 ft-lbs MIN, 15 ft-lbs AVG. PRODUCTION IMPACT TEST COUPONS REQUIRED. COIL IS EXEMPT PER UG-20(f). ALL OTHER COMPONENTS EXEMPT PER UCS-66(g).
 - 4) ALL WELDED JOINTS OF GOOD QUALITY AND HAVING UNIFORM APPEARANCE SHOULD NOT BE GROUND.
 - 5) SEAL WELD INTERNAL ATTACHMENTS WHERE ACCESSIBLE.
 - 6) VESSEL EXTERIOR TO BE COMMERCIALY SANDBLASTED PER SSPC-SP6.
 - 7) SANDBLASTING SHALL NOT BE CONDUCTED ON SURFACES THAT ARE LESS THAN 3" ABOVE DEWPOINT, OR WHEN THE RELATIVE HUMIDITY OF THE AIR IS GREATER THAN 80%.
 - 8) VESSEL EXTERIOR TO RECEIVE (1) COAT INTERTHERM 228.
 - 9) VESSEL TO BE INSULATED WITH 3" THK MINERAL WOOL INSULATION c/w SMOOTH ALUMINUM JACKET. INSULATION TO BE DONE BY OTHERS.
 - 10) ALL DIMENSIONS IN [] ARE IN mm.
 - 11) SHOP NOTE: "FS" DENOTES FAR SIDE.
 - 12) REFER TO DWG #B7563-00-DR-21-001-002 FOR COIL DETAILS.



WELDING NOTES

WELDING PROCEDURES: WP-719.2
 REF. DRAWING NUMBER: S10-2008 (FABRICATION TOLERANCES FOR PRESSURE VESSELS)
 LONG SEAM WPS: PM-126/127/147
 CIRC. SEAM WPS: PM-126/127/147
 NOZZLE TO FLG WPS: PM-109/126/132
 OTHER WELD WPS: PM-109
 PRE-HEAT TO: 70°F (21°C) MIN.

TESTING NOTES

QUALITY CONTROL PROGRAM: AQP-1077
 HYDROSTATIC TEST PRESSURE: 24.7 PSIG (1.703 kPag)
 RADIOGRAPHY: 100% PER RT-1
 IMPACT TESTS: SEE NOTE #3

DESIGN DATA

CODE: ASME SECTION VIII, DIV. 1, 2007 EDITION A-08 ADDENDA
 DESIGN PRESS: 190 PSIG (1.310 kPag), DESIGN TEMP: 400 °F (204 °C)
 EXTERNAL PRESS: - PSIG (- kPag), DESIGN TEMP: - °F (- °C)
 MIN. DESIGN METAL TEMP: -40 °F (-190 PSIG (-40 °C @ 1.310 kPag))
 M.A.W.P.: 190 PSIG @ 400 °F (1.310 kPag @ 204 °C), (LTO BY: DESIGN)
 M.A.P. NEW & COLD: - PSIG @ - °F (- kPag @ - °C)
 CORROSION ALLOW: 0.125" (3.175 mm)
 P.W.H.L. 60 min @ 1150°F (±25°F) PER UCS-56 & UW-40
 HEAD # TYP THK NOM: 0.5" (12.7 mm), MIN: 0.4375" (11.11 mm)
 HEAD # N/A THK NOM: N/A" (N/A mm), MIN: N/A" (N/A mm)
 SHELL # TYP THK NOM: 0.375" (9.525 mm), MIN: 0.375" (9.525 mm)
 SHELL # N/A THK NOM: N/A" (N/A mm), MIN: N/A" (N/A mm)
 MASS (EMPTY): 10600 lbs (4808 kg), MASS (HYDRO): 29850 lbs (13449 kg)
 VOLUME: 305 cu. ft. (8.65 cu. m) (DOES NOT INCLUDE COIL ASSEMBLY)

BILL OF MATERIALS					
MARK	PART	DESCRIPTION	QTY	MATERIAL	WELD SYS
1	HEAD	42" OD x 1/2" NOM. THK 2:1 SE HEAD c/w 2" SF (HOT FORMED)	1	SA-51670N	K2-2
3	SHELLS #1, #2 & #3	42" OD x 3/8" PL x 10'-0" LG	3	SA-51670N	K2-1/K2-2
4	FLANGE	42" CL. 150 ASME B16.47 SERIES 'A' RFWN FLG (41 1/4" BORE)	1	SA350LF2CL1	L1-1
6	BOLTING	1 1/2" x 1'-0" LG STUDS c/w (2) HEX NUTS EA	36	NOTE #1	
7	GASKET	42" CL. 150 ASME B16.47 SERIES 'A' 1/8" GASKET	1	NOTE #2	
8	BASE PLATE	8" x 3/4" PL x 3'-1" LG	2	SAG40.2144W	
9	FACE PLATE	3'-0 1/2" x 3/8" PL x 3'-1" LG	2	SAG40.2144W	
10	SIDE PLATE	8" x 3/8" PL x 3'-0 1/2" LG	4	SAG40.2144W	
11	STIFFENER PLATE	8" x 3/8" PL x 2'-2 3/4" LG	4	SAG40.2144W	
12	WEAR PLATE	1'-0" x 3/8" PL x 4'-1" LG (ROLL TO 42" ID)	2	SA-51670N	
13	COIL SUPPORT	3" x 3" x 1/4" ANGLE x 28'-6" LG	2	SAG40.2144W	
14	NAME PLATE	STANDARD NAME PLATE c/w 'T' BRACKET	1	SAG40.2150W	
15	LIFT LUGS	11" x 1" PL x 1'-4" LG (SEE DETAIL)	2	SA-51670N	
16	LIFT LUG REPAD	4" x 5/8" PL x 1'-10" LG (ROLL TO 42" ID)	2	SA-51670N	
17	INSULATION RING	3/8" RB x 13'-0" LG (ROLL TO 47 1/2" OD)	1	SAG40.2144W	
18	INSULATION POSTS	3/8" x 3/8" PL x 2 3/8" LG	8	SA-51670N	
19	BLIND & COIL	REFER TO DWG #B7563-00-DR-21-001-002			
20	PIPE SUPPORT	W6 x 15# x 1'-0" LG	1	SAG40.2144W	
21	PIPE SUPPORT	W6 x 15# x 1'-3 1/2" LG	1	SAG40.2144W	
22	REPAD	8" x 3/8" PL x 8" LG (ROLL TO 42" ID)	1	SA-51670N	
N1	HM INLET	4" CL. 300 SCH XXH RFWN FLG	1	SA350LF2CL1	L1-1
N2	HM OUTLET	4" SCH XXH SMLS PIPE x 8 1/8" LG	1	SA350LF2CL1	L1-1
N3	DRAIN	2" CL. 300 SCH 160 RFWN FLG	1	SA-333GR6	J1-2
N4	PSV	4" CL. 300 SCH XXH RFWN FLG	1	SA350LF2CL1	L1-1
N5	PG	4" SCH XXH SMLS PIPE x 8 1/8" LG	1	SA-333GR6	J1-2
N6	TC	2" CL. 300 SCH 160 RFWN FLG	1	SA350LF2CL1	L1-1
N7	PT	2" CL. 300 SCH 160 RFWN FLG	1	SA-333GR6	J1-2
N8	LSLL	4" CL. 300 SCH XXH RFWN FLG	1	SA350LF2CL1	L1-1
N9	GAS INLET	4" CL. 300 RFWN FLG	1	SA-333GR6	J1-2
N10	GAS OUTLET	4" CL. 300 RFWN FLG	1	SA350LF2CL1	L1-1

NO.	REVISION	BY	CHECKED	DATE
4	ADDED PIPE SUPPORT; ADDED BLIND FLANGES ON N5, N6 & N8	YY		09/07/29
3	REVISED TITLEBLOCK; ADDED NOZZLE TAGS	SB		09/07/06
2	REVISED N4, WAS 3"	JC		09/06/16
1	REMOVED HOLD ON LIFT LUGS	YY		09/06/08
0	ISSUED FOR CONSTRUCTION	YY		09/06/05

ENERFLEX

PRODUCTION & PROCESSING

CUSTOMER	BG INTERNATIONAL LIMITED		
CUSTOMER REF. NO.	T.B.A.	JOB NO.	B7563-21
PROJECT	OJAY D SOUR GAS SATELLITE d-A21-C/93-1-16		
TITLE	RE-HEATER VESSEL (E-210)		
	42" OD x 30'-0" S/S x 190 PSIG @ 400°F 1067 mm OD x 9144 mm S/S x 1310 kPag @ 204°C		
DRAWN BY	SCALE	DATE	DWG NO.
YY	1/2"=1'-0"	09/05/29	B7563-00-DR-21-001-001

CERTIFIED AS BUILT