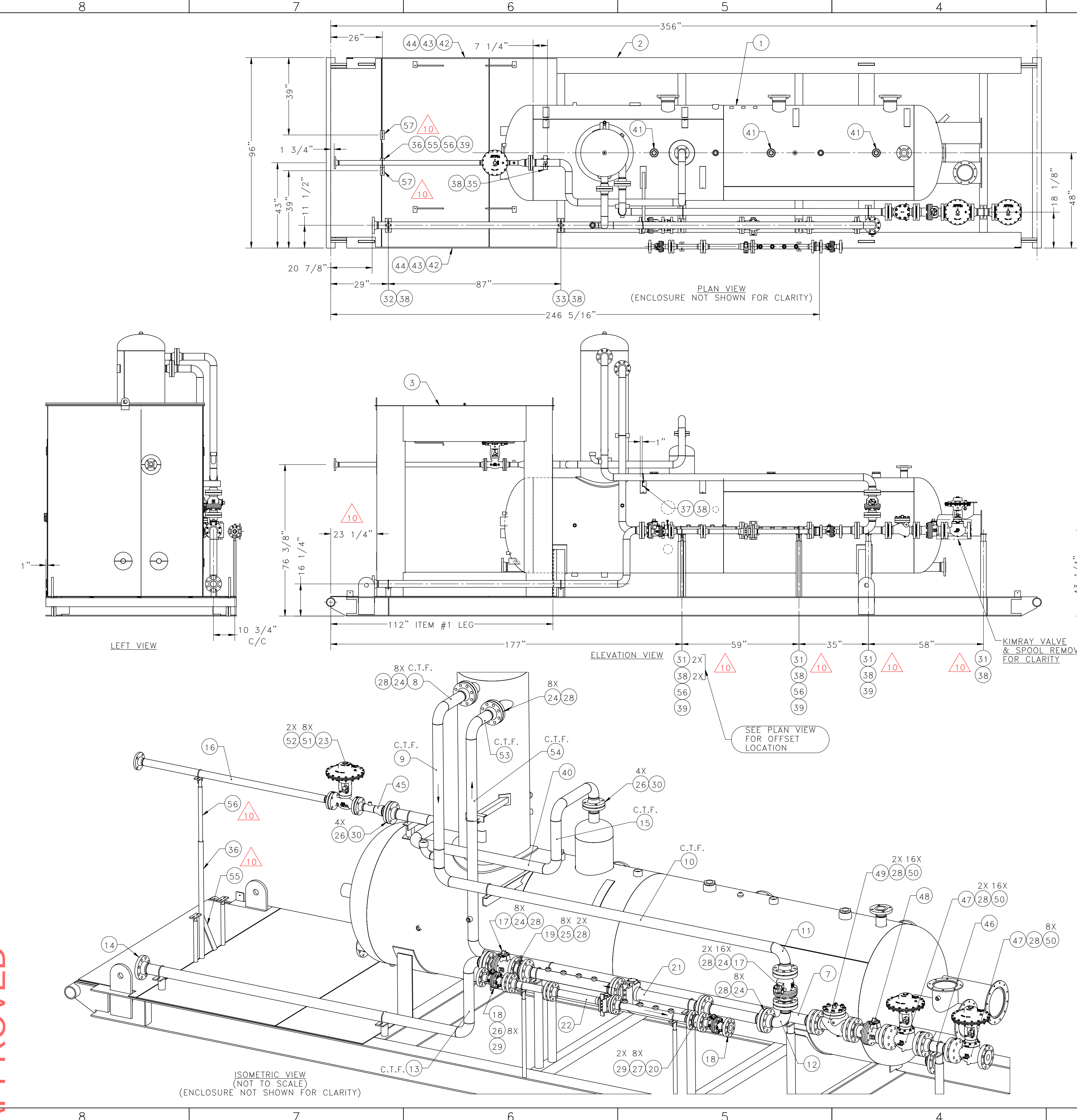




WELDING PROCEDURES	
LOCATION	WPS
ALL WELDS	CS-AW-1

BILL OF MATERIALS			
ITEM NO.	QTY.	DESCRIPTION	MATERIAL
1	1	HORIZONTAL SEPARATOR, 48" OD X 16'-0" S/S PER K512-01-1-*	
2	1	SKID ASSEMBLY, PER K512-60-1-*	
3	1	HOUSE ASSEMBLY, PER K512-55-1-*	
4		---DELETED---	
5		---DELETED---	
6		---DELETED---	
7	1	SPOOL 'A', 3" HP PIPING PER K512-75-2-*	
8	1	SPOOL 'B', 3" HP PIPING PER K512-75-2-*	
9	1	SPOOL 'C', 3" HP PIPING PER K512-75-2-*	
10	1	SPOOL 'D', 3" HP PIPING PER K512-75-2-*	
11	1	SPOOL 'E', 3" HP PIPING PER K512-75-2-*	
12	1	SPOOL 'F', 3" HP PIPING PER K512-75-2-*	
13	1	SPOOL 'G', 3" HP PIPING PER K512-75-2-*	
14	1	SPOOL 'H', 3" HP PIPING PER K512-75-2-*	
15	1	SPOOL 'L', 3" LP PIPING PER K512-75-2-*	
16	1	SPOOL 'K', 2" LP PIPING PER K512-75-2-*	
17	2	BALL VALVE, 3" ANSI RF 300#, FULL PORT BALON 3F-F33-RF	
18	2	BALL VALVE, 2" ANSI RF 600#, FULL PORT BALON 2F-F63-RF	
19	1	CHECK VALVE, 3" ANSI 300#, LONG WAFER, BALON 3L-300	
20	1	CHECK VALVE, 2" ANSI 600#, LONG WAFER, BALON 2L-600	
21	1	METER TUBE, 3" ANSI RFWN 300# X WELD PRECISION SOLO-FLOW SINGLE CHAMBER 3 PIECE METER TUBE ASSEMBLY, S.S. TRIM, FOUR (4) 3/4" DOWNSTREAM NPT CONN.; CPA 50E FLOW CONDITIONER, 300# ANSI RF FLANGE ENDS (94" F/F) RIGHT-TO-LEFT FLOW	
22	1	METER TUBE, 2" ANSI RFWN 600# X WELD PRECISION SOLO-FLOW SINGLE CHAMBER 3 PIECE METER TUBE ASSEMBLY, S.S. TRIM, FOUR (4) 3/4" DOWNSTREAM NPT CONNECTIONS; CPA 50E TYPE A FLOW CONDITIONER (72" F/F) LEFT-TO-RIGHT FLOW	
23	1	CONTROL VALVE, 2" ANSI RF 150#, KIMRAY FMT-150RF-PO-1IV (EHV)	
24	48	STUD BOLT, 3/4" X 4 1/2" LG	B-7
25	8	STUD BOLT, 3/4" X 7 1/2" LG	B-7
26	8	STUD BOLT, 5/8" X 4 1/2" LG	B-7
27	8	STUD BOLT, 5/8" X 7" LG	B-7
28	13	GASKET, 3" ANSI 600# FLEXITALLIC TYPE CG	304LSS
29	5	GASKET, 2" ANSI 600# FLEXITALLIC TYPE CG	304LSS
30	2	GASKET, 3" ANSI 150# FLEXITALLIC TYPE CG	304LSS
31	5	PIPE SUPPORT, PER P-10001-4	
32	1	PIPE SUPPORT 'B', PER K512-75-3-*	
33	1	PIPE SUPPORT 'C', PER K512-75-3-*	
34	1	PIPE SUPPORT 'D', PER K512-75-3-*	
35	1	PIPE SUPPORT 'E', PER K512-75-3-*	
36	1	PIPE 1 1/4", PER K512-75-3-* ITEM #1	
37	1	PIPE SUPPORT 'G', PER K512-75-3-*	
38	11	U-BOLT FOR 3" PIPE	
39	3	U-BOLT FOR 2" PIPE	
40	1	SPOOL 'J', 3" LP PIPING PER K512-75-2-*	
41	3	DIP-TUBE SUB-ASSEMBLY, PER K512-75-2-*	
42	2	DOOR CHAIN, 18"	
43	2	S HOOK, 1 1/2" LG	
44	2	DOOR LATCH W/ SPRING, GRAINGER #4PE12	
45	1	SPOOL 'M', 3" LP PIPING PER K512-75-2-*	
46	1	SPOOL 'N', 3" HP PIPING PER K512-75-2-*	
47	2	HIGH PRESSURE CONTROL VALVE, 3" 600# W/3" TRIM AND SEAT, KIMRAY 3-FMT-600RF-PB-PO-3IV-EFU	
48	1	BALL VALVE, 3" ANSI RF 600#, FULL PORT BALON 3F-F63-RF	
49	1	CHECK VALVE, 3" ANSI RF 600#, WHEATLEY 30-510-035144-121	
50	40	STUD BOLT, 3/4" X 5 1/2" LG	B-7
51	8	STUD BOLT, 5/8" X 3 1/2" LG	B-7
52	2	GASKET, 2" ANSI 150# FLEXITALLIC TYPE CG	304LSS
53	1	SPOOL, 'P' 3" HP PIPING PER K512-75-2-*	
54	1	SPOOL, 'Q' 3" HP PIPING PER K512-75-2-*	
55	1	PLATE, 3/8" PER K12-75-3-* ITEM #2	
56	3	PIPE SUPPORT, PER P-10000-4	
57	2	PIPE SUPPORT, PER P-10000-2	

REVISIONS				
REV.	LOG#	DESCRIPTION	DATE	REVISED BY
7	6620	REMOVE #4-6	10-06-2021	TYZ
8	6645	UPDATE SKID AND LUG	10-27-2021	TYZ
9	6999	BOM #47: #18 FLOW DIRECTION	05-09-2022	JRM
10	7296	HOUSING SHIFT/PIPE SUPPORT UPDATE, ADD #55-57 BOM.	11-30-2022	HCM



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Process Equipment & Service Company, Inc.

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TITLE: WELD ASSEMBLY

NAME	DATE	CUSTOMER:
RAY	06-02-20	DJR OPERATING

DRAWN BY:	RAY	DATE	12-01-2022	SIZE	DWG. NO.	REV.
PROJ. MGR.	RYR	D	K512-75-1			10

SCALE: 1:24 WEIGHT: 17016 LBS. SHEET: 1 OF 1