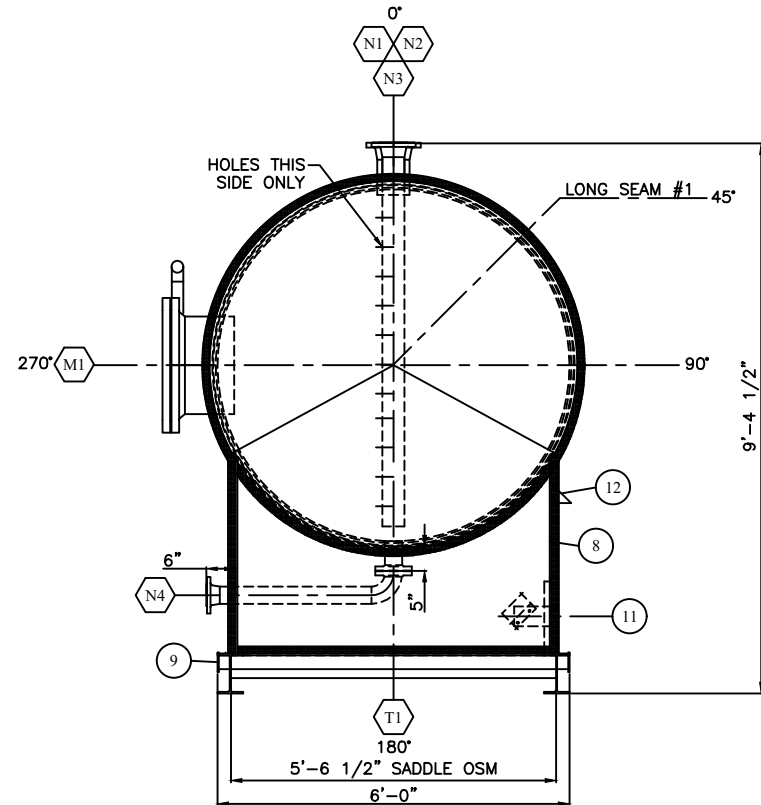
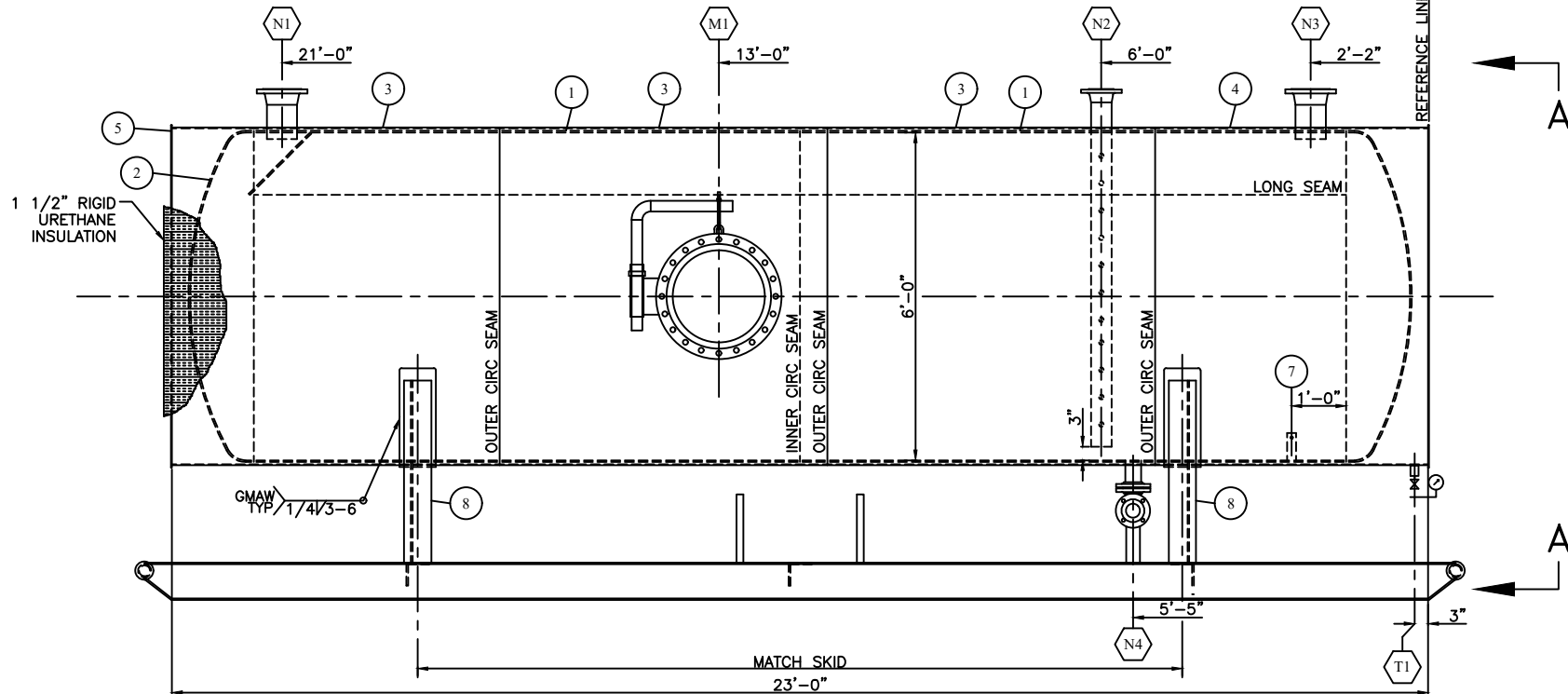


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ORIENTATION VIEW A-A



ELEVATION VIEW

NOZZLE SCHEDULE

MARK	NO. REQ'D	DESCRIPTION	SIZE	ANSI	TYPE	PROJECTION		WELD DETAIL	WELD		REPAD		BILL OF MATERIALS ITEM NUMBER
						INSIDE	OUTSIDE		A	B	C	D	
N1	1	INLET	6"	150#	RFWN	1"	8 1/2"	1,4	3/8	—	—	—	14,15,16,17
N2	1	GUAGE	4"	150#	RFWN	SHOWN	8 1/2"	1,4	3/8	—	—	—	18,19,20
N3	1	OUTLET	6"	150#	RFWN	1"	8 1/2"	1,4	3/8	—	—	—	14,15,16
N4	1	DRAIN	3"	150#	RFWN	FLUSH	SHOWN	1,2,5	3/8	—	—	—	21—30
M1	1	MANWAY	20"	150#	RFSO	2 1/2"	8 1/2"	2,4	3/8	—	—	—	31—37
T1	1	TEST	1"	3000#	CPLG	—	—	3	1/4	—	—	—	38, 39

GENERAL NOTES

- INTERNAL SHELL AND HEAD MATERIAL: SA-516-70N
- EXTERNAL SHELL AND HEAD MATERIAL: SA-36
- ALL FLANGE MATERIAL: SA-105-N
- ALL PIPE MATERIAL: SA-106-B
- ALL BOLTING MATERIAL: SA-193-B7M/SA-194-2HM
- INTERNAL SANDBLAST TO SSPC-SP-5 (WHITE)
- INTERNALLY COATED WITH 10-18 MILS OF DEVOE 253
- EXTERNAL SANDBLAST TO SSPC-SP-6 (COMMERCIAL)
- EXTERNALLY COATED WITH ONE COAT OF PRIMER AND ONE COAT OF INDUSTRIAL WARM GREY ALKALIDE
- CATADYNE HEATER IS c/w REGULATOR, TEMPERATURE CONTROLLER, HOSE AND CABLE FOR 120VOLT/12VOLT POWER
- ALL OPEN PIPE ENDS SHALL HAVE A 1/8" RADIUS INCLUDING INSIDE OF FLANGE EDGE
- 1 1/2" RIGID URETHANE INSULATION WITH ALUMINUM CLADDING
- DRAIN (N4) OPENING SHALL BE FLUSH WITH INSIDE OF VESSEL
- ALL SURFACES NOT COVERED BY INSULATION WILL BE PAINTED WITH INDUSTRIAL ENAMEL
- ALL OPENINGS SHALL BE COVERED PRIOR TO SHIPPING
- DESIGN PRESSURE: 50 PSI - MAWP: 14.9 PSI (NONREGISTERED)
- DESIGN TEMPERATURE: 300°F
- CORROSION ALLOWANCE: 1/8"
- HYDROTEST PRESSURE: 75 PSI
- ALL WELDING ON SKID AND SADDLES SHALL BE AS PER CSA W47.1-92 USING GAS METAL ARC WELDING WITH ER480S-6 FILLER METAL
- CONTAINMENT SHALL BE TESTED AS FOLLOWS:
  - PRESSURIZE WITH AIR TO 5 PSI
  - TEST EACH WELD WITH A SOAPY SOLUTION
  - VISUALLY INSPECT EACH WELD
  - DEPRESSURIZE AND REPAIR AND RETEST IF NEEDED
- WEIGHT: 15,500 LBS

BILL OF MATERIALS

ITEM	REQ'D	PART	DESCRIPTION	MATERIAL	WEIGHT
1	2	SHELL	3/8" THK x 120" W ROLL TO 72" ID x 228 1/2" LG	SA-516-70N	5800#
2	2	HEAD	3/8" THK x 72" ID FLANGED & DISHED	SA-516-70N	1191#
3	3	SHELL	3/16" THK x 72" W ROLL TO 73 3/4" x 19'-5 1/2" LG	SA-36	3685#
		SHELL	ORDER 3/16" THK x 72" W ROLL TO 74" x 19'-8" LG	SA-36	
4	1	SHELL	3/16" THK x 60" W ROLL TO 73 3/4" ID x 19'-5 1/2" LG	SA-36	1024#
		SHELL	ORDER 3/16" THK x 60" W ROLL TO 74" ID x 19'-8" LG	SA-36	
5	2	HEAD	3/16" THK x 75 1/4" OD	SA-36	662#
6	1	SPACER	3/8" HRR x 60'-0" LF	SA-36	60#
7	1	ANODE	2" x 1/4" FLATBAR x 6" LG w/ HOLE (SEE ANODE DWG)	SS	1#
8	2	SADDLE	100 BBL SADDLE (SEE DWG 843-2)	SA-36	600#
9	1	SKID	100 BBL STANDARD SKID (SEE DWG 843-2)	-	1200#
11	1	HEATER	12" x 24" CATADYNE HEATER (SEE CATADYNE HEATER DWG)	-	-
12	1	VENT	GALV VENT AIR OUTLET MOUNT SIDE OF HEATER NEAR TOP	-	-
13	1	DECAL	10" x 18" BILTON WELDING DECAL	-	-
14	2	N1,N3	6" x 150# RFWN FLG SCH XH	SA-105-N	48#
15	2	N1,N3	6" PIPE SCH XH x 7 3/16" LG	SA-106-B	36#
16	2	N1,N3	6" x 150# FLANGE PROTECTOR	POLY	-
17	1	N1	3/8" THK DEFLECTOR PLATE	SA-36	6#
18	1	N2	4" x 150# RFWN FLG SCH XH	SA-105-N	16#
19	1	N2	4" PIPE SCH XH x 75 1/2" LG w/ HOLES (SEE DOWNCOMER DWG)	SA-106-B	96#
20	1	N2	4" FLANGE PROTECTOR	POLY	-
21	4	N4	5/8" DIA x 3 1/2" LG STUD	SA-193-B7M	-
22	8	N4	5/8" DIA NUT	SA-194-2HM	-
23	1	N4	3" x 150# RFWN FLG SCH XH	SA-105-N	12#
24	2	N4	3" x 150# RFSO FLG	SA-105-N	8#
25	1	N4	3" x 150# RF FLEXITALLIC GASKET	304SS	-
26	1	N4	3" x 150# FLANGE PROTECTOR	POLY	-
27	1	N4	3" PIPE SCH XH x 5 9/16" LG	SA-106-B	5#
28	1	N4	3" PIPE SCH XH x 31 1/16" LG	SA-106-B	27#
29	1	N4	3" x 90" LR BW ELBOW SCH XH	SA-234-WPB	6#
30	1	N4	DRAIN SPOOL BRACE (SEE DWG DRAIN PIPE SPOOL BRACE)	A-36	4#
31	1	M1	20" x 150# RFSO FLG	SA-105-N	165#
32	1	M1	20" x 150# BLIND FLG	SA-105-N	285#
33	1	M1	20' x 150# RF FLEXITALLIC GASKET	304SS	-
34	20	M1	1 1/8" DIA x 6" LG STUD	SA-193-B7M	-
35	40	M1	1 1/8" DIA NUT	SA-194-2HM	-
36	1	M1	20" PIPE SCH STD x 12 1/2" LG	SA-106-B	79#
37	1	M1	20" STANDARD DAVIT ARM (SEE 20 DAVIT DWG)	-	37#
38	1	T1	1" x 3000# NPT FULL CPLG	SA-105-N	1#
39	1	T1	VACUUM GUAGE ASSEMBLY (ABOVE GROUND)	-	-
40	6	INSUL	1 1/2" x 16'-0" LG SHT RIGID URETH, CORR & STUCCO EMBOSS ALUM ONE SIDE (CURFS)	-	-
41	6	INSUL	1 1/2" x 8'-0" LG SHT RIGID URETH, CORR & STUCCO EMBOSS ALUM ONE SIDE (CURFS)	-	-
42	2	INSUL	1 1/2" x 45" COV x 12'-6" LG SHT RIGID URETH, CORR & STUCCO EMBOSS ONE SIDE	-	-
43	3	INSUL	1 1/2" x 45" COV x 14'-6" LG SHT RIGID URETH, CORR & STUCCO EMBOSS ALUM BOTH SIDES	-	-
44	60 FT	INSUL	SEA "L" FLASHING	-	-
45	8 FT	INSUL	SEA "Z" FLASHING	-	-
46	600	INSUL	SCREWS - #8 - 1/2" STAINLESS STEEL	-	-
47	3	INSUL	ALUMINUM SILICONE CAULK	-	-
48	8	DECAL	2" X 6" DECAL	-	-

1	WELD NECK FLANGE	2	SLIP ON FLANGE	3	COUPLING	4	NOZZLE NECK	5	NOZZLE NECK	6	INTERIOR SEAM	7	EXTERIOR SEAM

REV. NO.	DATE	REVISION	BY	APPD
0	10/18/00	STANDARD DRAWING	JMB	JLM
1	11/25/00	AS BUILT DRAWING	DSG	JLM
2				
3				
4				
5				
6				
7				

**BILTON**  
Welding & Manufacturing Ltd.

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CRESTAR ENERGY

110 BBL ABOVE GROUND DOUBLE WALL KNOCKOUT TANK  
72" ID x 240" S/S, 50 PSI DESIGN, 14.9 PSI MAWP (NON REGISTERED)

DATE: 10/18/00	SHEET: 1 OF 1	SIZE
SCALE: N.T.S.	JOB NO.: 843	D
DRAWN BY: DSG	DRAWING NO.: 843-1	REV.
PURCHASE ORDER:		
LOCATION:		
PART NO.:		