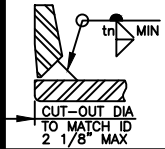
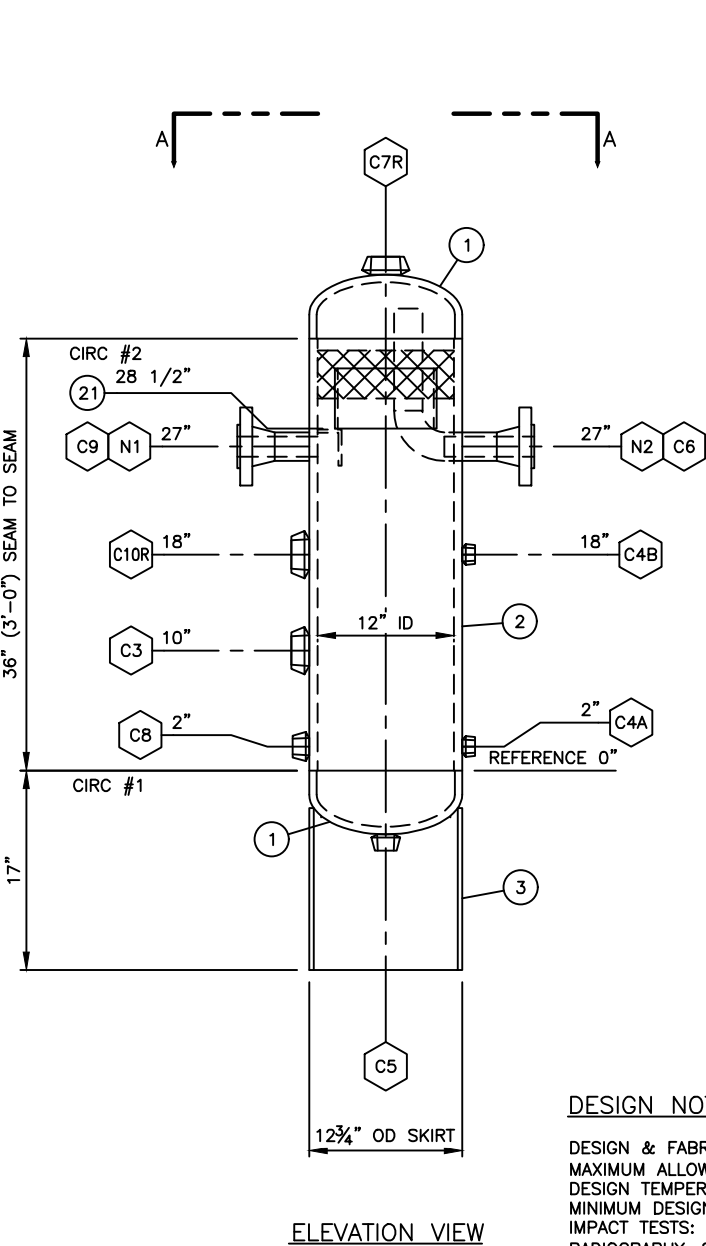


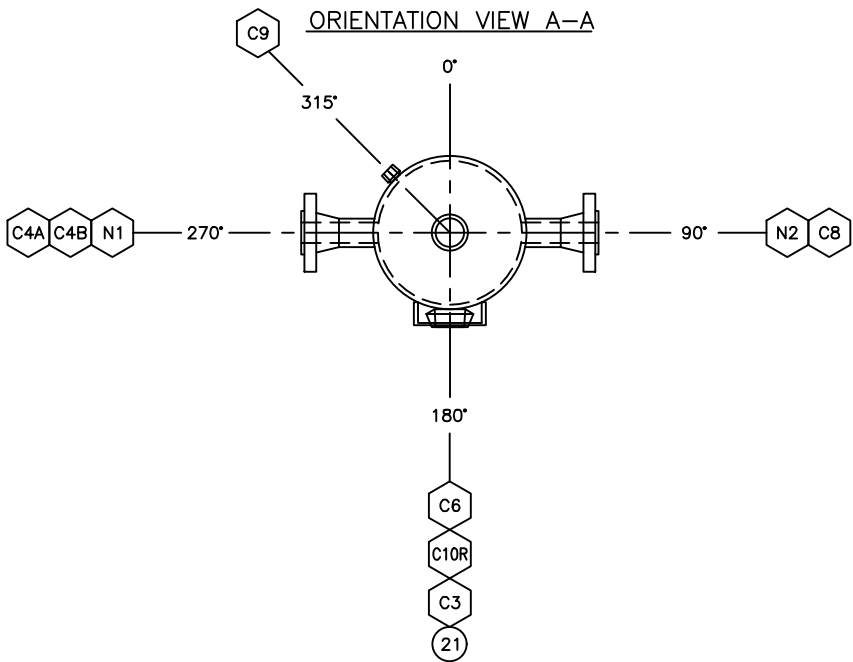
WD-5	STANDARD TOLERANCES
	FABRICATION: GENERAL DEVIATION: $\pm \frac{1}{8}$ " OVERALL LENGTH: $\pm \frac{1}{4}$ " ANGULAR: $\pm 1^\circ$
	WELD PREPARATION: LAND: $\frac{1}{6}$ " $\pm \frac{1}{32}$ " ROOT GAP: $\frac{1}{8}$ " $\pm \frac{1}{6}$ " ANGULAR: $\pm 15^\circ$
WPS: CAPE-4	
WPS: CAPE-12	



ELEVATION VIEW

DESIGN NOTES

DESIGN & FABRICATE TO: ASME SECTION VIII, DIVISION 1, 2004 EDITION
MAXIMUM ALLOWABLE WORKING PRESSURE (MAWP): 1440 PSIG
DESIGN TEMPERATURE: 100°F
MINIMUM DESIGN METAL TEMPERATURE: -20°F AT 1440 PSIG
IMPACT TESTS: PER U1-A
RADIOGRAPHY: SPOT PER UW-11(a)5(b) (RT-2)
PREHEAT: 100°F
PWHT PER UCS-56: NO
HYDROSTATIC TEST PRESSURE: 2160 PSIG
CORROSION ALLOWANCE: 1/16"
WEIGHT EMPTY: 400 LBS
WEIGHT FULL OF WATER: 700 LBS



ORIENTATION VIEW A-A

ALTERATION NOTES

1. REPLACE 1" TOL ON TOP HEAD (C7) WITH 2" TOL (C7R).
2. ADDED 2" TOL (C10R) TO SHELL.
3. MPI C7R, N10R CUT-OUT AND WHERE NAMEPLATE BRACKET WILL BE WELDED TO SHELL BEFORE INSTALL.
4. ADD NEW TOLS AND NAMEPLATE BRACKET USING APPROVED WELDING PROCEDURES AND QUALIFIED WELDERS.
5. MPI TOLS AND NAMEPLATE BRACKET AFTER WELDING.
6. HYDRO TO 2160 PSIG.
7. INSTALL NAMEPLATE TO BRACKET, WITNESSED BY SCO.

GENERAL NOTE

1. QUALITY CONTROLPROGRAM NUMBER: AQP-1529
2. WELDING PROCEDURE REGISTRATION NUMBER: WP-3326.2
3. CAPACITY: 2.42 FT³
4. SERVICE: HYDROCARBONS
5. EXPOSED INSIDE OR OUTSIDE EDGES OF NOZZLES OR OPENINGS SHALL HAVE AN 1/8" MINIMUM RADIUS.
6. ALL BOLT HOLES TO STRADDLE CENTERLINES.
7. CLEAN AND COVER ALL OPENINGS FOR SHIPMENT.
8. EXTERNAL SURFACE PREPARATION: SSPC-SP3
9. EXTERNAL COATING: ONE COAT CLOVERDALE PRIMER
10. USE WELD PROCEDURE (CAPE-12) FOR ALL TACK WELDS.
11. CRN: R9415.231
12. S/N: PV-1322
13. A#: 549641

CONNECTION SCHEDULE

MARK	QTY.	SIZE	SCH	CLASS & TYPE	SERVICE	MINIMUM PROJECTION		WELD SIZE			WELD DETAIL	BOM ITEM NO.
						INSIDE	OUTSIDE	A	B	C		
N1	1	2"	160	600 RFWN	INLET	-	6"	-	-	-	-	5, 7
N2	1	2"	160	600 RFWN	GAS OUTLET	-	-	-	-	-	-	5, 7
C3	1	2"	NPT	3000 TOL	LC	-	-	-	-	-	-	10
C4AB	2	3/4"	NPT	3000 TOL	LG	-	-	-	-	-	-	12
C5	1	1"	NPT	3000 TOL	DRAIN	-	-	-	-	-	-	11
C6	1	3/4"	NPT	3000 TOL	PI	-	-	-	-	-	-	12
C7R	1	2"	NPT	3000 TOL	VENT/INSPECTION	-	-	3/8"	-	-	-	9
C8	1	1"	NPT	3000 TOL	DUMP	-	-	-	-	-	-	11
C9	1	1"	NPT	3000 TOL	RELIEF	-	-	-	-	-	-	11
C10R	1	2"	NPT	3000 TOL	LSHH	-	-	3/8"	-	-	-	5 13

BILL OF MATERIALS

ITEM	QTY.	COMMENT	DESCRIPTION	MATERIAL
1	2	HEADS	PLATE - 12 3/4" OD x 3/4" THK (.625" min) 2:1 SE	SA-516-70N
2	1	SHELL	PIPE - 12" SCH 80 (.688") x 3'-0" LG	SA-106B
3	1	SKIRT	PIPE - 12" SCH STD (.375")	EXISTING
4				
5	2	N1-2	FLANGE - 2" CLASS 600 x SCH 160 BORE	EXISTING
6				
7	2	N1-2	PIPE - 2" SCH 160 (.344")	EXISTING
8				
9	2	C7R, C10R	THREADOLET - 2"-NPT CLASS 3000 ON 12"	SA-105N
10	1	C3	THREADOLET - 2"-NPT CLASS 3000 ON 12"	EXISTING
11	3	C5, C8-9	THREADOLET - 1"-NPT CLASS 3000 ON 12"	EXISTING
12	3	C4, C6	THREADOLET - 3/4"-NPT CLASS 3000 ON 12"	EXISTING
13				
14				
15				
16				
17				
18				
19				
20				
21	1	NAME PLATE	STANDARD NAME PLATE AND BRACKET	EXISTING
22				

CAPE MANUFACTURING LTD.

BOX 216, HALKIRK, AB TOC 1M0
TELEPHONE: (403) 884-2442 EMAIL: SALES@CAPEMFG.COM

CLIENT: STOCK

DATE: 24-08-21

JOB NO: CML-242338

DRAWN BY: KG

CHECKED BY:

APP BY:

VERTICAL SCRUBBER VESSEL

12 3/4" OD x 3'-0" s/s

1440 PSIG AT -20°F / 100°F

DWG NO:

CML-242338V-4

REV

1