



VESSEL NOTES:

- 1.) Reinforcement Calculations for Nozzles "N2", "N8", "N9", "N10" and "M1" are based on Appendix, 1-10 in lieu of UG37 Area replacement calculations. The Appendix 1-10 calculations are based on the maximum local primary membrane stress and allowable stress. The nozzle attachments weld calculations are based on Division 2 Part 4.5.
- 2.) Nozzle "N1" and the Inlet Nozzle head calculations are based on Code Case 2695, which states Section VIII Division 2 rules are allowed to be used on Section VIII Division 1 Vessels. The nozzle calculations are based on Division 2, 4.5.11, maximum local primary membrane stress, nozzle neck minimum thickness, strength of nozzle attachment welds and Division 2 Table 4.2.10 minimum fillet weld sizes.
- 3.) Appendix 1-10 are alternative rules for nozzle calculations and are not based on UG-37 which is based on area replacement calculations.
- 4.) Vessel to be constructed of stress-relieved CS and Fabricated in compliance with NACE MR-0175/ISO 15156-1, 2 & 3.
- 5.) Vessel shall conform to NACE SP 0178.
- 6.) Internal welds shall meet weld condition D described in NACE SP 0178, Appendix C.
- 7.) Production impact required per UG-84.
- 8.) Carbon steel maximum hardness permitted on any of the weld, heat affected zone, or parent metal shall be Vickers HV₁₀ ≤ 240.

TESTING NOTES:

- HARDNESS TESTING IS VICKERS HV₁₀ (240)
- LONG SEAM = 1 SET PER 10 FT. (1 PER)
- LONG SEAM = 1 SET PER 10 FT. (2 PER)
- NOZZLE = 1 SET PER INTRUSION

FABRICATION TOLERANCES:

0 TO 10'-0" = ±1/8"
> 10'-0" = ±1/4"
ANGLE = ±1/2"
SHOP RECORDS REQ'D

- ☒ NAME PL. RUBBING
- ☒ STRESS RELIEVE CHART
- ☒ TEST PRESSURE CHART
- ☐ STENCIL OPENINGS

WELDING PROCEDURES:

CO-1 (GMAW)
CO-2 (GMAW)
SA-II

CERTIFIED BY:
CIMARRON ENERGY INC.
MARLOW, TEXAS

1390 PSI AT 130 °F
MAX. ALLOWABLE WORKING PRESS

-20 °F AT 1390 PSI
MIN. DESIGN METAL TEMP.

SEPXT00010 THRU 0014
MANUFACTURER'S SERIAL NUMBER

2018
YEAR BUILT

"NACE"

REVISED PRINT
DESTROY ALL OTHERS
4/3/18
Matt Underwood

JOB No:
SEPXT00010-0000
THRU
SEPXT00014-0000

CIMARRON
ENERGY

TITLE: 2PH HOZ. SEPARATOR DETAILS
48" OD x 180" S/S 1390#
XTO ENERGY

DESIGN BY: JJG CHK. BY: MHS APPD. BY: MU
DATE: NOVEMBER 2017

PART NO: SEPHZXT001001 JOB NO: Q14145
DRAWING NO. SHEETS REV.
Q14145-3-02-01 1 OF 5 1

