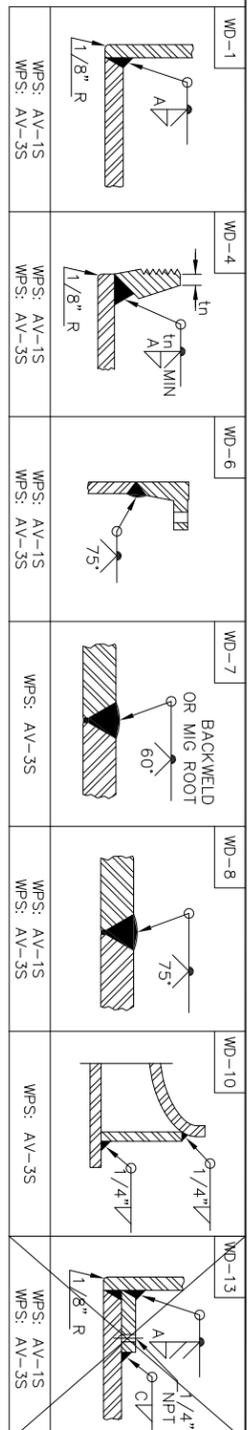


**STANDARD TOLERANCES**

FABRICATION: ± 1/8"  
 GENERAL DEVIATION: ± 1/4"  
 OVERALL LENGTH: ± 1"  
 ANGLAR: ± 1°

WELD PREPARATION:  
 LAND: 1/16" ± 1/32"  
 ROOT GAP: 1/8" ± 1/16"  
 ANGLAR: ± 15°

ELEVATION VIEW



CRN DRAWING NUMBER - 4088 SHTS 1&2 Rev1

CRN: W0647.213

JOB#: V-14055

GENERAL NOTES

DESIGN DATA

- QUALITY CONTROL PROGRAM NO.: AQP-1531
- WELDING PROCEDURE REGISTRATION NO.: WP 3328.2
- SERVICE: M.O.G. SOUR
- CAPACITY: 2012 CUBIC FT. (0.57 CUBIC METER)
- SURFACE PREPARATION: AS PER CLIENT SPECIFICATIONS
- PRIME: AS PER CLIENT SPECIFICATIONS
- PAINT: AS PER CLIENT SPECIFICATIONS
- ALL BOLT HOLES TO STRADDLE CENTERLINES.
- CLEAN AND COVER ALL OPENINGS FOR SHIPMENT.
- USE WPS AV-15 OR AV-35 FOR ALL TACK AND ATTACHMENT WELDS OR REPAIR.
- REFERENCE CALCS: 24-2-1440-4088-1 R1  
 24-2-1440-4088-2 R1  
 24-2-1440-4088-3 R1

DESIGN & FABRICATE TO: ASME SECTION VIII, DIV 1, 2013 EDITION

DESIGN PRESSURE & TEMPERATURE: 1440 PSIG AT 130° F

MINIMUM DESIGN METAL TEMPERATURE: -20° F AT 1440 PSIG

IMPACT TESTS: EXEMPT PER UG-20(f) 1-5 & UCS-66C

RADIOGRAPHY - LONG SEAMS: FULL PER UW-11g

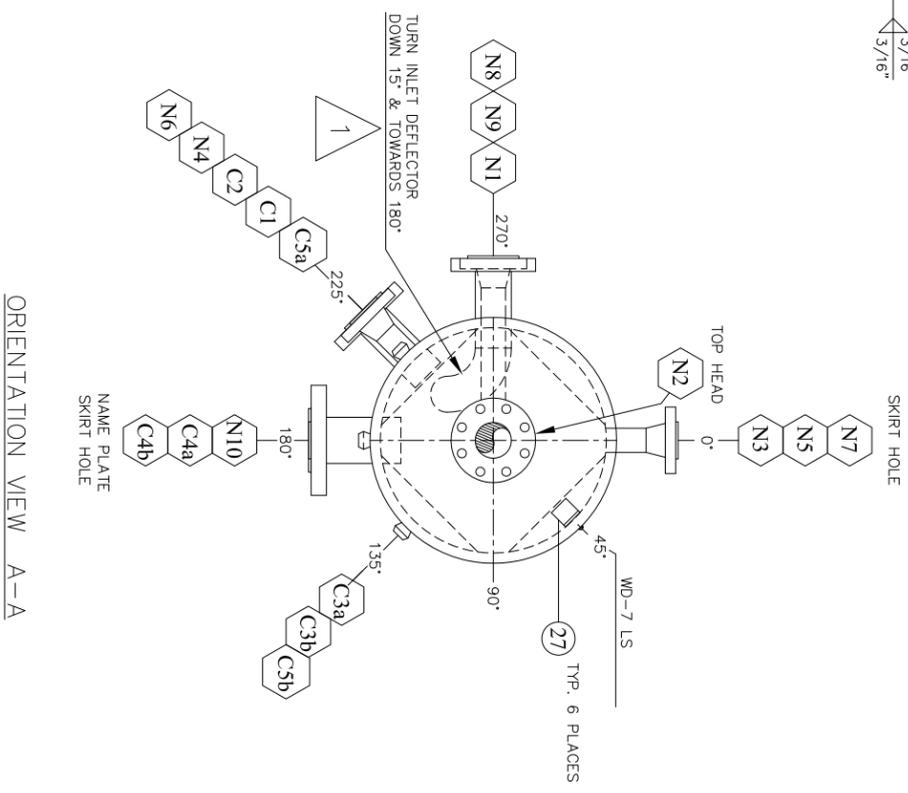
RADIOGRAPHY - CIRC SEAMS: FULL PER UW-11g

PWHT: 1125F ± 25F FOR 60 MINUTES(MIN.)

HYDROSTATIC TEST PRESSURE: 1878 PSIG

CORROSION ALLOWANCE: 1/8" WEIGHT EMPTY: 2,325 LBS

HEAD THK: .9375" MIN WEIGHT FULL OF WATER: 3,575 LBS



ORIENTATION VIEW A-A

BILL OF MATERIALS

ITEM QTY	DESCRIPTION	MATERIAL
1	HEAD - 24" OD x 1" THK (.9375" MIN) 2:1 SE, 2" SF (HOT FORMED)	SA-516-70N
2	SHELL PLATE - 24" OD x 1" THK x 7'-6" LG (COLD FORMED)	SA-516-70N
3	SKIRT PIPE - 24" SCH, STD x 15'-7/8" LG CUT TO SUIT	SA-53B, ERW
5	FLANGE - 4" CLASS 600 RFLWN x 9" LG - 1" THK	SA-105N
6	FLANGE - 3" CLASS 600 RFLWN x 9" LG - 0.81" THK	SA-105N
7	FLANGE - 2" CLASS 600 RFLWN SCH 160	SA-105N
8	TOL - 2" NPT CLASS 3000	SA-105N
9	TOL - 1/2" NPT CLASS 3000	SA-105N
10	TOL - 3/4" NPT CLASS 3000	SA-105N
11	PIPE - 2" SCH 160 (.344") x 3'-1/2" LG	SA-106-B
12	PIPE - 2" SCH 160 (.344") x 11'-3/4" LG	SA-106-B
13	PIPE - 2" SCH 160 (.344") x 4'-1/8" LG	SA-106-B
14	PIPE - 2" SCH XH (.218") x 18" LG (CTS)	SA-106-B
15	PIPE - 2" SCH 160 (.344") x 3'-7/8" LG	SA-106-B
20	ELBOW - 3" SCH XH LR 90° WELD	SA-234-WPB
21	ELBOW - 2" SCH 160 LR 90° WELD	SA-234-WPB
25	BASE PLATE - 3/8" THK x 30" OD x 22" ID CUT PER DETAIL	SA-36/44W
26	DIVERTOR - 1/4" THK x 11 5/16" x 21 7/8" WD BREAK @ 15° & TRIM	SA-36/44W
27	MIST SUPPORTS - 2" x 2" x 1/4" THK ANGLE IRON x 2" LG	SA-36/44W
28	MIST SUPPORTS - 3.0LBS STRUCTURAL GRATING CUT TO 20 1/8" DIA	CS
29	MISTEX - 9#/CUBIC FT x 6" THK ROLL TO 22" DIA	316L SS
31	ALLIED VESSEL FABRICATION NAMEPLATE & BRACKET ASSEMBLY	SA-1011

NOZZLE SCHEDULE

MARK	SIZE	SCH	CLASS	TYPE	SERVICE	WELD	A	B	C	I.P.	ITEM NO'S
N1	3"	0.81"	600	RFLWN	INLET	1, 8	3/8"	-	-	1"	6,20
N2	3"	0.81"	600	RFLWN	GAS OUT/INSP.	1	3/8"	-	-	1"	6
N3	2"	160	600	RFLWN	PSV	1, 6	3/8"	-	-	-	7,13
N4	3"	0.81"	600	RFLWN	HC LC	1	3/8"	-	-	1"	6
N5	2"	160	600	RFLWN	HC OUT	1, 6	3/8"	-	-	-	7,13
N6	3"	0.81"	600	RFLWN	H2O LC	1	3/8"	-	-	1"	6
N7	2"	160	600	RFLWN	H2O OUT	1, 6	3/8"	-	-	-	7,14,15
N8	2"	160	600	RFLWN	DRAIN	1, 6	3/8"	-	-	-	7,11,12,21
N9	3"	0.81"	600	RFLWN	CLEAN OUT/INSP.	1	3/8"	-	-	1"	6
N10	4"	1.00"	600	RFLWN	H2SD	1	3/8"	-	-	5/8"	5
C1	1/2"	NPT	3000	TOL	PI	4	3/8"	-	-	-	9
C2	3/4"	NPT	3000	TOL	TI	4	3/8"	-	-	-	10
C3a/b	3/4"	NPT	3000	TOL	HC LG	4	3/8"	-	-	-	10
C4a/b	3/4"	NPT	3000	TOL	H2O LG	4	3/8"	-	-	-	10
C5a/b	2"	NPT	3000	TOL	INSPECTION	4	3/8"	-	-	-	8

1 14-11-13 ROTATED INLET ELBOW

0 14-09-09 ISSUED FOR CONSTRUCTION

NO. DATE REVISION

ALLIED VESSEL FABRICATION

3 PHASE SEPARATOR

24" OD x 7'-6" SEAM TO SEAM

1440 PSIG AT 130° F

4088-4-14055

