

**GENERAL NOTES**

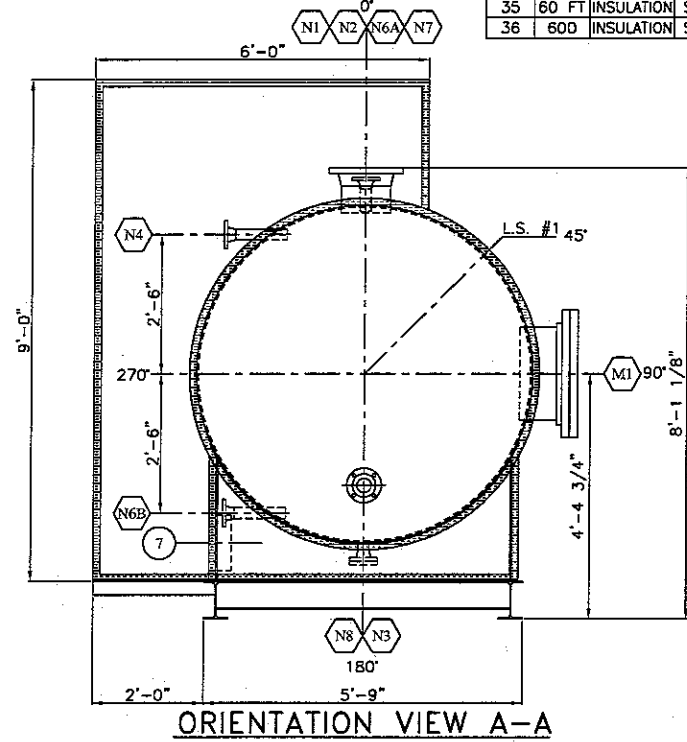
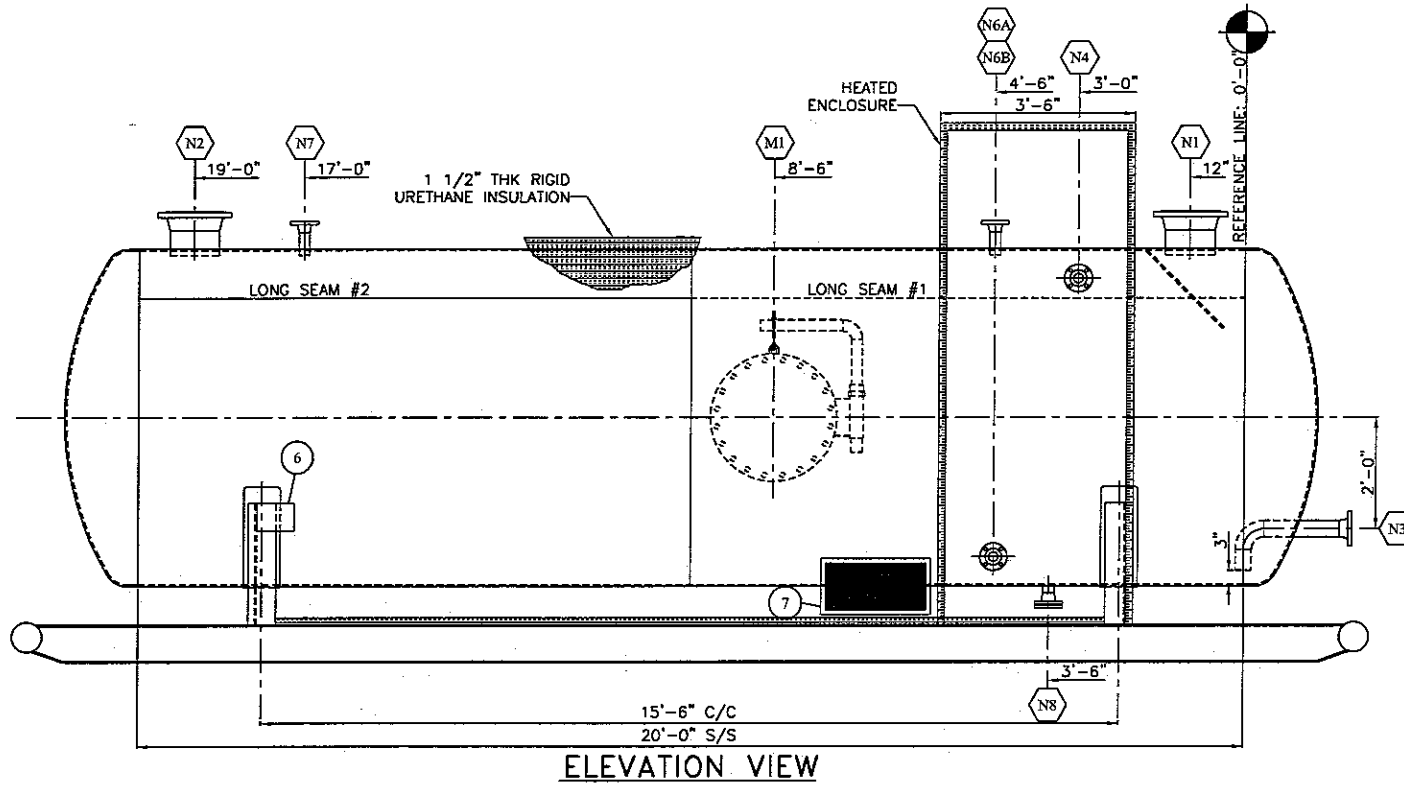
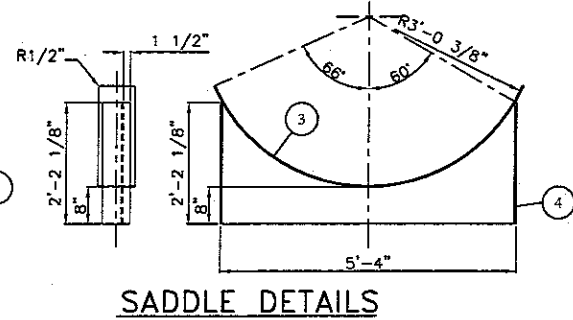
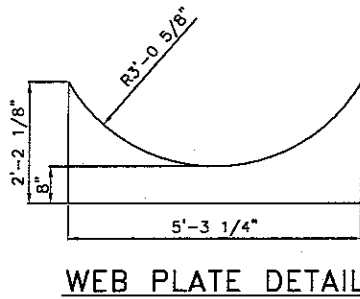
- QUALITY CONTROL PROGRAM NUMBER: AQP-1317(S)
- WELDING PROCEDURE REGISTRATION NUMBER: WP1970.2
- SHELL AND HEAD MATERIAL: SA-516-70N
- FLANGE MATERIAL: SA-105-N
- PIPE MATERIAL: SA-106-B
- PLATE MATERIAL: SA-516-70N/SA-36
- BOLTING MATERIAL: SA-193-B7M/SA-194-2HM
- INTERNAL SANDBLAST: SSPC-SP10 (NEAR WHITE)
- INTERNALLY COAT: DEVOE 253 AS PER MANUFACTURER'S SPECIFICATION
- EXTERNAL SANDBLAST: SSPC-SP3 (POWER TOOL)
- EXTERNAL COATING: ALL AREAS: ONE COAT OF PRIMER  
NON-INSULATED AREAS: ONE COAT OF INDUSTRIAL ENAMEL (WHITE)
- INSULATION: 1 1/2" THK RIGID URETHANE w/ ALUMINUM CLADDING
- ALL BOLT HOLES TO STRADDLE CENTERLINE
- ALL OPENINGS TO BE COVERED PRIOR TO SHIPPING
- ALL OUTSIDE PROJECTIONS ARE TO BE MEASURED ALONG THE CENTERLINE OF THE NOZZLE
- ALL INSIDE PROJECTIONS ARE TO BE MEASURED ALONG THE SHORTSIDE OF THE NOZZLE
- FABRICATION TOLERANCE AS PER BILTON WELDING DWG TOL2002
- VESSEL TO BE REGISTERED IN ALBERTA
- VESSEL TO BE SUPPLIED WITH U-STAMP
- SHIPPING DIMENSIONS: 8'-6" W x 10'-0" H x 24'-6" LG
- SHIPPING WEIGHT: 10,000 LBS
- SERIAL NUMBER: 13930

**NOZZLE SCHEDULE**

MARK	NO. REQ'D	DESCRIPTION	NPS	CLASS	TYPE	PROJECTION		WELD DETAIL	WELD				REPAD	BILL OF MATERIALS ITEM NUMBER
						INSIDE	OUTSIDE		A	B	C	D		
N1	1	INLET	10	150	RFWN	1"	8"	1.3	1/4	-	-	-	-	9,10,11
N2	1	OUTLET	10	150	RFWN	1"	8"	1.3	1/4	-	-	-	-	9,10
N3	1	PUMPOUT	3	150	RFWN	6"	12"	1.3	1/4	-	-	-	-	12,13,14,15
N4	1	HLSD	2	150	RFWN	1"	10"	1.3	1/4	-	-	-	-	16,17
N6A	1	LIT	2	150	RFWN	1"	6"	1.3	1/4	-	-	-	-	16,18
N6B	1	LIT	2	150	RFWN	1"	10"	1.3	1/4	-	-	-	-	16,17
N7	1	DRAIN INLET	2	150	RFWN	1"	6"	1.3	1/4	-	-	-	-	16,18
N8	1	DRAIN	2	150	RFWN	FLUSH	4"	1.4	1/4	-	-	-	-	16,19,20,21,22,23
M1	1	MANWAY	20	150	RFSO	1"	8"	2.3	1/4	-	-	-	-	24,25,26,27,28,29,30

**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	-
2	2	HEAD	3/8" THK (0.3130" MIN) x 72" ID F&D (KR=5" CR=66")	SA-516-70N	-
3	2	SADDLE	8" x 1/4" THK FLATBAR ROLL TO 72 3/4" ID x 84 3/8" LG	SA-36	-
4	4	SADDLE	6" x 3/8" FLATBAR x 2'-2 1/8" LG	SA-36	-
5	2	SADDLE	3/8" THK x 26 1/8" W x 63 1/4" LG (SEE DETAIL)	SA-36	-
6	1	NAMEPLATE	6" x 8" NAMEPLATE BRACKET	SA-36	-
7	1	HEATER	12" x 24" CATADYNE HEATER, 12 VOLT NATURAL GAS (12,000 BTU/HR)	-	-
8	1	SKID	SKID (SEE DWG B586-2 FOR DETAIL)	-	-
9	2	N1,N2	10" x CLASS 150 RFWN FLG SCH STD	SA-105-N	-
10	2	N1,N2	10" PIPE SCH STD x 5 3/4" LG (BOE,ROE)	SA-106-B	-
11	1	N1	3/8" THK DEFLECTOR PLATE	SA-36	-
12	1	N3	3" x CLASS 150 RFWN FLG SCH XH	SA-105-N	-
13	1	N3	3" x 90° LR BW ELBOW SCH XH	SA-234-WPB	-
14	1	N3	3" PIPE SCH XH x 1'-4 3/8" LG (BBE)	SA-106-B	-
15	1	N3	3" PIPE SCH XH x 4 1/2" LG (BOE,ROE)	SA-106-B	-
16	5	N4,N6,N7,N8	2" x CLASS 150 RFWN FLG SCH 160	SA-105-N	-
17	2	N4,N6B	2" PIPE SCH 160 x 11 1/8" LG (BOE,ROE)	SA-106-B	-
18	2	N6A,N7	2" PIPE SCH 160 x 4 7/8" LG (BOE,ROE)	SA-106-B	-
19	1	N8	2" x CLASS 150 RF BLIND FLG	SA-105-N	-
20	1	N8	2" x CLASS 150 RF FLEX GASKET	304SS	-
21	1	N8	2" PIPE SCH 160 x 1 7/8" LG (BOE,COE)	SA-106-B	-
22	4	N8	5/8" DIA x 3 1/2" LG STUD	SA-193-B7M	-
23	8	N8	5/8" DIA NUT	SA-194-2HM	-
24	1	M1	20" x CLASS 150 RFSO FLG	SA-105-N	-
25	1	M1	20" x CLASS 150 RF BLIND FLG	SA-105-N	-
26	1	M1	20" x CLASS 150 RF FLEX GASKET	304SS	-
27	1	M1	20" PIPE SCH STD x 10 1/4" LG (COE,ROE)	SA-106-B	-
28	1	M1	20" DAVIT ARM	-	-
29	20	M1	1 1/8" DIA x 6 1/4" LG STUD	SA-193-B7M	-
30	40	M1	1 1/8" DIA NUT	SA-194-2HM	-
31	5	INSULATION	1 1/2" x 45" x 23'-0" LG RIGID URETH, CORR & STUCCO EMBOSS ALUM ONE SIDE (CURFS)	-	-
32	2	INSULATION	1 1/2" x 45" x 12'-6" LG RIGID URETH, CORR & STUCCO EMBOSS ALUM ONE SIDE	-	-
33	3	INSULATION	1 1/2" x 45" x 16'-0" LG RIGID URETH, CORR & STUCCO EMBOSS ALUM BOTH SIDES	-	-
34	4	INSULATION	1 1/2" x 45" x 9'-0" LG RIGID URETH, CORR & STUCCO EMBOSS ALUM BOTH SIDES	-	-
35	60 FT	INSULATION	SEA "L" FLASHING	-	-
36	600	INSULATION	SCREWS - #8 - 1/2" STAINLESS STEEL	-	-



**DESIGN SPECIFICATIONS**

DESIGN & FABRICATE TO: 2004 EDITION ASME BOILER & PRESSURE VESSEL CODE SEC VIII, DIV 1

DESIGN PRESSURE & TEMPERATURE: 50 PSI @ 100°F

MINIMUM DESIGN METAL TEMP: -20°F @ 50 PSI

IMPACT TESTS: EXEMPT AS PER UG-20(f)(1)-(5)

RADIOGRAPHY: NONE AS PER UW-11(c)

POST WELD HEAT TREATMENT: EXEMPT AS PER UCS-56

HYDROSTATIC TEST PRESSURE: 75 PSIG PREHEAT: 50°F

CORROSION ALLOWANCE: 1/8" MAWP: 50 PSI @ 100°F

HEAD THK. MIN.: 0.3130" VOLUME: 614 CuFt, 17.4 Cum

WEIGHT EMPTY: 7,000 LBS WEIGHT FULL: 45,500 LBS

**EXALTA ENERGY**

110 BBL SINGLE WALL H.P. FLARE KNOCKOUT DRUM  
72" ID x 20'-0" S/S x 50 PSI MAWP

DATE: 10/27/05 SHEET: 1 OF 2

SCALE: N.T.S. JOB NO.: B586 SIZE D

DRAWN BY: DSG PURCHASE ORDER: EXA05-047-006

LOCATION: 10-33-85-11 W6M DRAWING NO.: B586-1

CRN DWG: BWM-106-D4 R2 APP'D: DJAM

CRN NUMBER: R6405.2

FILE PATH: \MAINDATA\CAD\TANKS\B500-B599\B586-1

WELD DETAIL NUMBER	REGISTERED WELDING PROCEDURE NUMBER	BACKWELD/GOUGE
ROOT	HOT PASS	FILL & CAP
1,2,3,4,5	BWM-19 (GMAW)	BWM-19 (GMAW)
6	BWM-19 (GMAW)	BWM-3 (SAW)

NO.	DESCRIPTION	WELD DETAIL
1	WELD NECK FLANGE	
2	SLIP ON FLANGE	
3	NOZZLE NECK	
4	NOZZLE NECK	
5	ATTACHMENTS	
6	SEAMS	

REV. NO.	DATE	REVISION	BY	APP'D
A	10/27/05	ISSUED FOR APPROVAL	DSG	JAM
0	10/31/05	ISSUED FOR FABRICATION	DSG	JAM
1	01/13/06	AS BUILT DRAWING	DSG	JAM

**BILTON**

Welding & Manufacturing Ltd.

BOX 6106  
5815 37 Street  
INNISFAIR, AB  
CANADA  
403-227-7799  
1-888-227-4923  
FAX 227-7796

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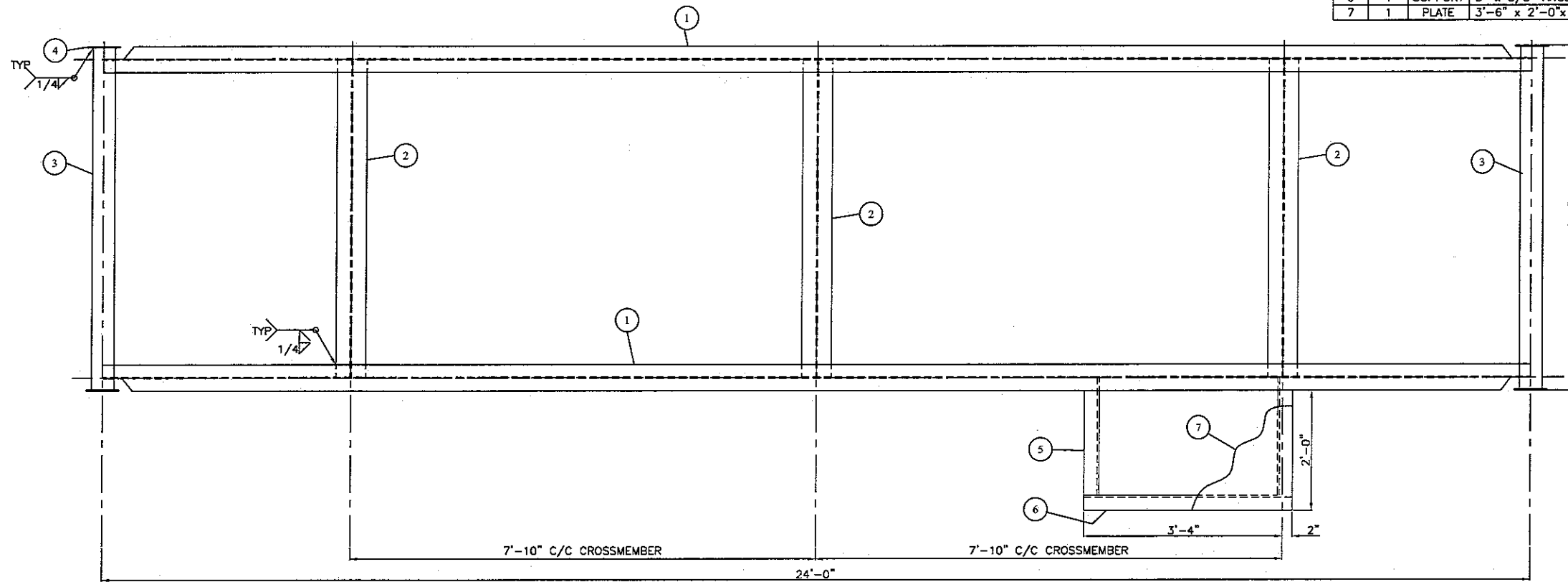
CERTIFIED AS BUILT

**GENERAL NOTES**

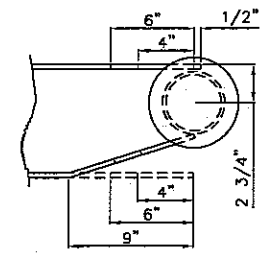
1. PRIME: ONE (1) COAT PRIMER
2. PAINT: ONE (1) COAT INDUSTRIAL ENAMEL (WHITE)
3. ALL WELDS FULL PENETRATION, 1/4" FILLETS
4. WELD PROCEDURE: GM-1
5. APPROXIMATE WEIGHT: 1200 LBS

**BILL OF MATERIALS**

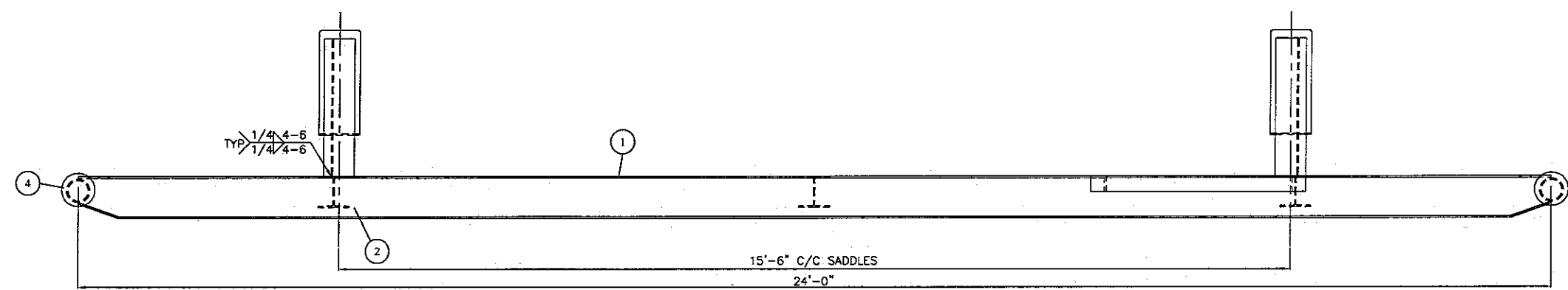
ITEM	REQ'D	PART	DESCRIPTION	MATERIAL	WEIGHT
1	2	RUNNER	W8@18# x 24'-0" LG (ROUGH CUT TO 289")	SA-36	870#
2	3	CROSSMEM	W6@15# x 5'-3 1/2" LG (COPE TO SUIT)	SA-36	225#
3	2	PULL	4" STD PIPE x 5'-8 1/2" LG	SA-106-B	90#
4	4	PULLCAP	1/4" THK x 6 1/2" OD	SA-36	5#
5	2	SUPPORT	3" x 3/8" ANGLE x 1'-11 1/2" LG	SA-36	12#
6	1	SUPPORT	3" x 3/8" ANGLE x 3'-6" LG	SA-36	10#
7	1	PLATE	3'-6" x 2'-0" x 1/4" PLATE	SA-36	70#



**PLAN VIEW**



**COPE DETAIL**



**ELEVATION VIEW**

REV. NO.	DATE	REVISION	BY	APP'D
A	10/27/05	ISSUED FOR APPROVAL	DSG	JAM
0	10/31/05	ISSUED FOR FABRICATION	DSG	JAM
1	01/13/06	AS BUILT DRAWING	DSG	JAM

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**EXALTA ENERGY**  
 110 BBL SINGLE WALL H.P. FLARE KNOCKOUT DRUM  
 SKID DETAILS

DATE: 10/27/05  
 SCALE: N.T.S.  
 DRAWN BY: DSG  
 PURCHASE ORDER: EXA05-047-006  
 LOCATION: 10-33-85-11 W6M  
 APP'D BY: JAM

SHEET: 2 OF 2  
 JOB NO.:  
 SIZE: D  
 B586  
 B586-2  
 REV. 1

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