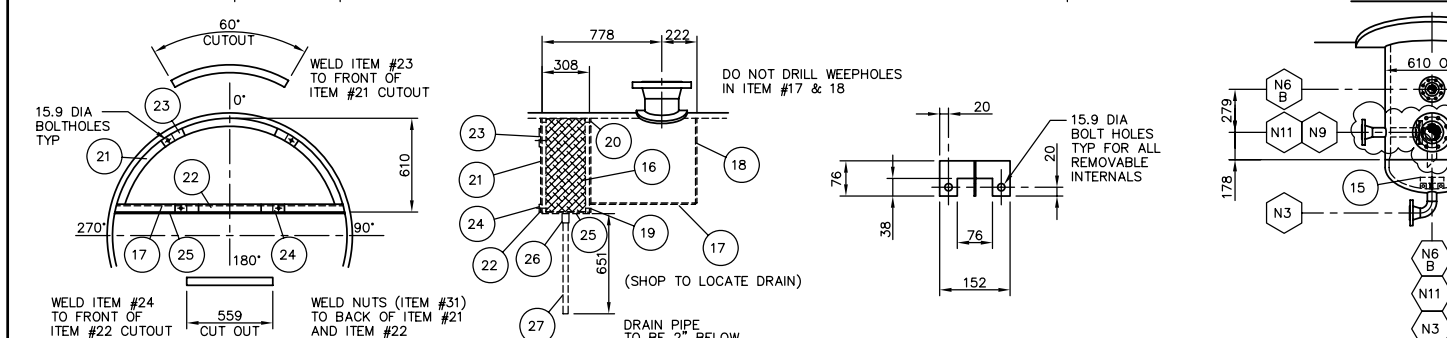
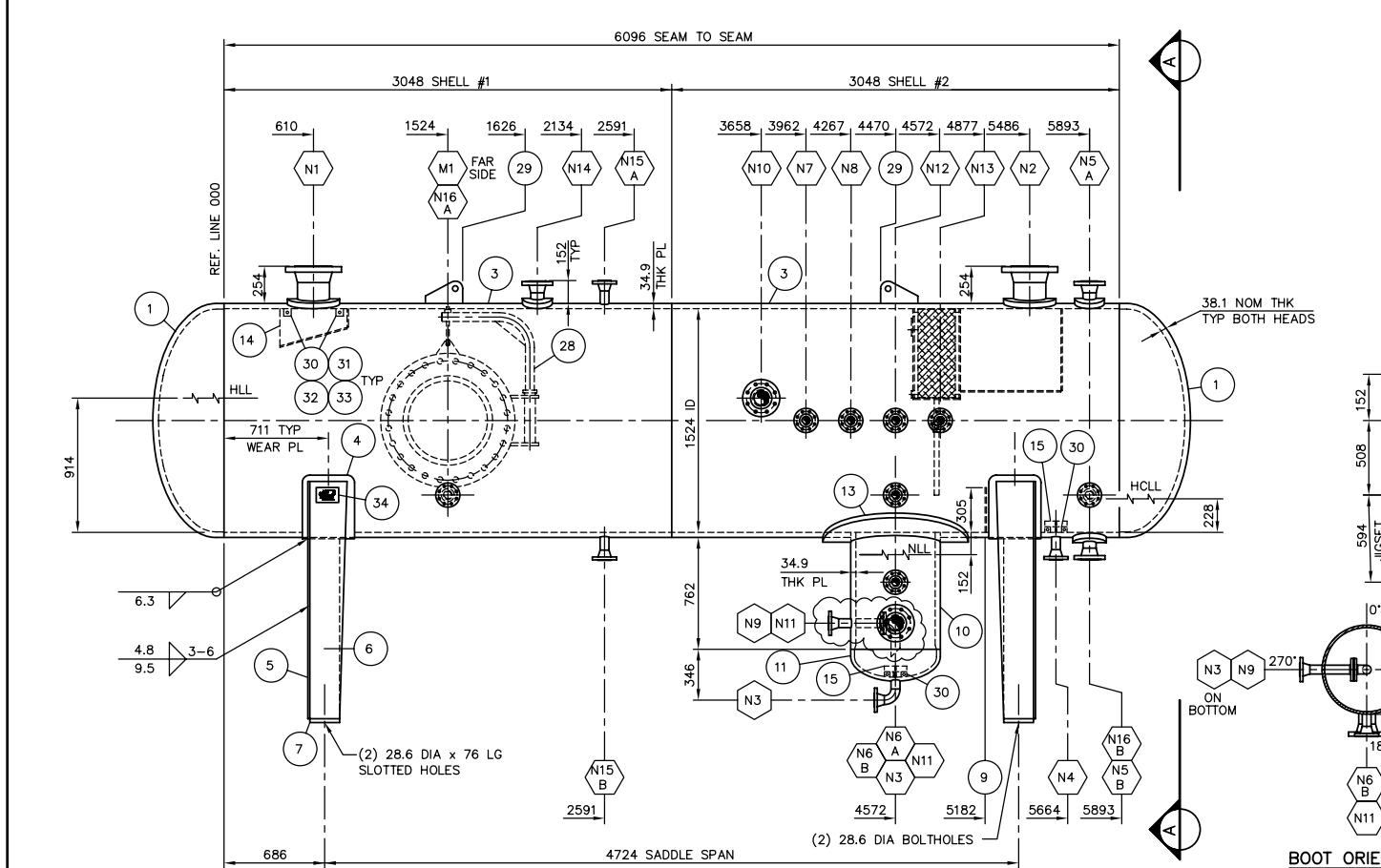
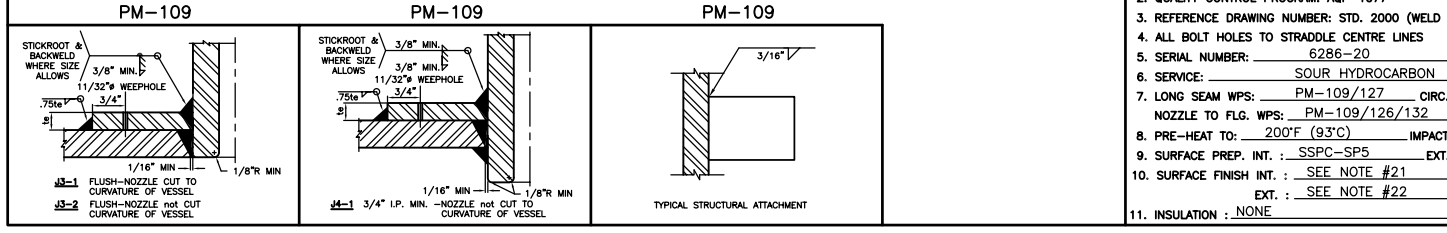


PM-109/126/127 PM-109/126/132 PM-126/127/132 PM-109 PM-109

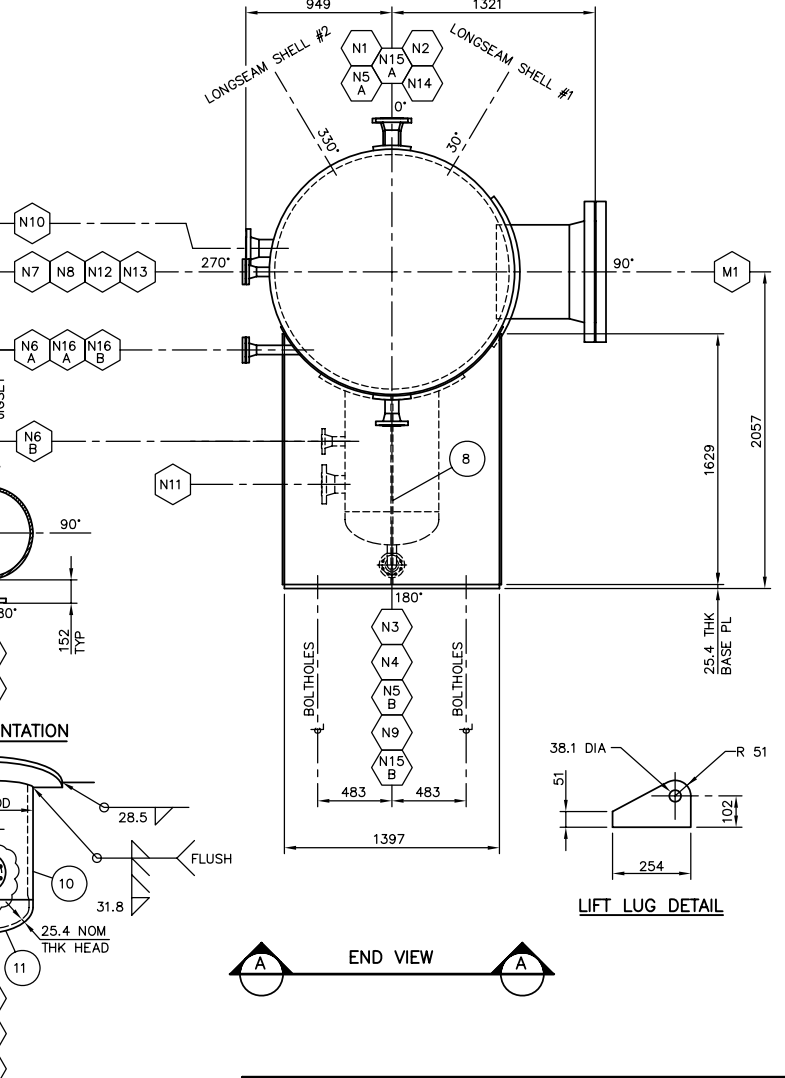


NOTES:
 12) ALL BOLTING TO BE OF SPEC SA-193-B7M & SA-194-2HM MATERIAL.
 13) ALL MATERIAL TO BE CHEM SELECT PER: CE ≤ 0.40 WHEN CE = C + Mn/6 + (Cr + Mo + V)/5 + (Ni + Cu)/15
 14) HEADS AND SHELLS TO BE U.T. EXAMINED ON A 9° GRID.
 15) SHELL, HEADS, REPADS AND BOOT SHELL TO BE IMPACT TESTED PER UG-84. OTHER COMPONENTS EXEMPT PER UCS-66 AND/OR UG-20(f).
 16) PRODUCTION HARDNESS TEST REQUIRED. (1) SET PER WPS/WELDER. (3) READINGS: (1) CENTER OF WELD, (1) ON EACH SIDE OF THE WELD IN HAZ. BHN 200 MAX.
 17) WET VISIBLE MAGNETIC PARTICLE EXAMINATION REQUIRED ON ALL CAT. 'D' WELDS BEFORE PHWT AND AFTER HYDROTEST.
 18) SADDLE WEAR PL AND NOZZLE REPADS TO RECEIVE 20 PSI AIR TEST.
 19) HYDROTEST REQUIRES A CHART RECORDER (1 hr).
 20) ALL INTERNAL SHARP EDGES AND CORNERS TO BE ROUNDED (MIN 3 mm RAD.) PRIOR TO INTERNAL COATING.
 21) VESSEL INTERIOR TO RECEIVE 12-15 MILS DFT OF DEVOE 253 ON TOP 2/3 OF VESSEL (4-5 MILS PER PASS). BOTTOM 1/3 OF VESSEL (INCLUDING BOOT) TO RECEIVE 3-5 MILS DFT OF DEVOE 253 AND 25-30 MILS DFT OF DEVOE DEVMAT III
 22) VESSEL EXTERIOR TO RECEIVE:
 - (1.0-2.0 MILS DFT) VALSPAR EPOXY ESTER PRIMER (YELLOW 13-Y-602)
 - (1.0-2.0 MILS DFT) VALSPAR 1 PART BLACK EPOXY ESTER TO 8 PARTS PRIMER.
 - (1.5-2.0 MILS DFT) VALSPAR M & F ENAMEL 20 SERIES (COLOR T.B.A.).
 23) SEAL WELD ALL NON-REMOVEABLE INTERNALS.
 24) MISTPAD TO BE 3 PIECE REMOVABLE WITH CS SUPPORT GRIDS; PIECES TO BE NO LARGER THAN 432 WIDE.
 25) CODE CASE 2236 APPLIED TO MANWAY M1 AND LIQUID BOOT IN LIEU OF PARA 1-7(b) RULES.
 26) FILL ALL WEEPHOLES IN REPAD WITH HEAVY GREASE OR SILICONE.



ITEM	DESCRIPTION	QTY	MATERIAL	WELD SYM
N12	PT-1002	2"	300# SCH XXH RFWN FLG	1 SA-105N L1-1
N13	TT-1003	2"	SCH XXH SMLS PIPE x 117 LG	1 SA-105N L1-1
N14	PSV-1000	3"	SCH XXH SMLS PIPE x 117 LG	1 SA-106B J1-1
	REPAD	203 OD x 34.9 PL x 92 ID (ROLL TO 1594 ID)		1 SA-105N L1-1
N15	FUTURE SLUG O/R	2"	SCH XXH SMLS PIPE x 117 LG	2 SA-106B J1-1
N16	COND. RECIRC.	2"	SCH XXH SMLS PIPE x 108 LG	2 SA-105N L1-1
		2"	SCH XXH SMLS PIPE x 346 LG	2 SA-106B J1-1
		2"	300# RF BLIND FLG	2 SA-105N
		2"	300# RF x 1/8" THK FLEX GASKET	2 316SS
		5/8" x 3 1/2" LG STUDS c/w (2) NUTS EACH		16 NOTE #12
M1	MANWAY	24"	300# SCH 40 RFWN FLG	1 SA350LF2 L2-1
		610 OD x 34.9 PL x 476 LG		1 SA51670N K2-1/J4-1
		24"	300# RF BLIND FLG	1 SA-105N
		24"	300# RF x 1/8" THK FLEX GASKET	1 316SS
		1 1/2" x 9 1/4" LG STUDS c/w (2) NUTS EACH		24 NOTE #12
	REPAD	991 OD x 34.9 PL x 613 ID (ROLL TO 1594 ID)		1 SA51670N J4-1

BILL OF MATERIALS					
MARK	PART	DESCRIPTION	QTY	MATERIAL	WELD SYM
		1524 ID x 38.1 NOM THK x 2:1 SE HEAD c/w 51" SF (HOT FORMED)	2	SA51670N	K2-2
1	HEAD	1524 ID x 38.1 NOM THK x 2:1 SE HEAD c/w 51" SF (HOT FORMED)	2	SA51670N	K2-2
3	SHELL #1 & #2	1524 ID x 34.9 PL x 3048 LG	2	SA51670N	K2-1
4	WEAR PLATE	356 x 9.5 PL x 1720 LG (ROLL TO 1594 ID)	2	SA51670	
5	FACE PLATE	1397 x 12.7 PL x 1629 LG	2	SA-G40.21	
6	SIDE PLATE	203/254 x 12.7 PL x 1629 LG	4	SA-G40.21	
7	BASE PLATE	203 x 25.4 PL x 1397 LG	2	SA-G40.21	
8	STIFFENER	203 x 12.7 PL x 1235 LG	2	SA-G40.21	
9	WEIR PLATE	1521 OD x 9.5 PL x 305 HIGH	1	SA51670	
10	BOOT SHELL	610 OD x 34.9 PL x 864 LG	1	SA51670N	K2-1
11	BOOT HEAD	610 OD x 25.4 NOM THK x 2:1 SE HEAD c/w 51 SF (HOT FORMED)	1	SA51670N	K2-2
13	BOOT REPAD	991 OD x 34.9 PL x 613 ID (ROLL TO 1594 ID)	1	SA51670N	SEE DETAIL
14	INLET DEFLECTOR	305 x 305 x 457 x 127 x 9.5 PL (FAB BOX)	1	SA-G40.21	
15	VORTEX BREAKER	76 x 9.5 PL x 152 LG (NOTCH & FORM CROSS)	2	SA-G40.21	SEE DETAIL
16	MISTPAD	1518 OD x 254 THK x 610 HIGH x 9# MISTEX	1	316SS	NOTE #24
17	MP SUPPORT	680 x 9.5 PL x 1473 WIDE	1	SA51670	
18	MP SUPPORT	1521 OD x 9.5 PL x 549 HIGH	1	SA51670	
19	MP SUPPORT	51 x 9.5 PL x 1499 LG	1	SA51670	
20	MP SUPPORT	1521 OD x 9.5 PL x 1419 ID x 559 HIGH	1	SA51670	
21	MP SUPPORT	1521 OD x 9.5 PL x 1419 ID x 559 HIGH	1	SA51670	SEE DETAIL
22	MP SUPPORT	51 x 9.5 PL x 1499 LG	1	SA51670	SEE DETAIL
23	MP SUPPORT	1521 OD x 9.5 PL x 1419 ID x 152 LG	2	SA51670	
24	MP SUPPORT	51 x 9.5 PL x 152 LG	2	SA51670	
25	MP SUPPORT	308 x 9.5 PL x 1499 LG	1	SA51670	
26	MP DRAIN	1" 3000# NPT S.S. CPLG	1	F304S.S.	
27	MP DRAIN	1" SCH STD SMLS PIPE x 651 (SHOP TO CUT)	1	304S.S.	
28	DAVIT	PRESSON STD DAVIT FOR 24" 300# BLIND FLG	1	SA-106B	
29	LIFT LUGS	152 x 38.1 PL x 254 LG	2	SA-G40.21	SEE DETAIL
30	SUPPORT CLIPS	51 SQ. x 9.5 THK PL c/w (1) 15.9 DIA HOLE	16	SA51670	
31	BOLTING	1/2" x [3/4"] LG CAPSCREWS c/w (1) HEX NUT EA	20	S.S.	
32	WASHERS	1/2" S.S. WASHER (2 PER BOLT)	40	S.S.	
33	WASHERS	1/2" NYLON WASHER (2 PER BOLT)	40	NYLON	
34	NAME PLATE	PRESSON STANDARD NAME PLATE c/w BRACKET	1	SA-G40.21	
N1	INLET	8" 300# SCH XH RFWN FLG	1	SA-105N	L2-1
		8" SCH XXH SMLS PIPE x 181 LG	1	SA-106B	J3-1
	REPAD	356 OD x 34.9 PL x 222 ID (ROLL TO 1594 ID)	1	SA51670N	J3-1
N2	GAS OUTLET	8" 300# SCH XH RFWN FLG	1	SA-105N	L2-1
		8" SCH XXH SMLS PIPE x 181 LG	1	SA-106B	J3-1
	REPAD	356 OD x 34.9 PL x 222 ID (ROLL TO 1594 ID)	1	SA51670N	J3-1
N3	DRAIN	2" 300# SCH XXH RFWN FLG	1	SA-105N	L1-1
		2" SCH XXH 90° LRWB ELL	1	SA234WPB	L1-1
		2" SCH XXH SMLS PIPE x 83 LG	1	SA-106B	J1-1
N4	COND. OUTLET	2" 300# SCH XXH RFWN FLG	1	SA-105N	L1-1
		2" SCH XXH SMLS PIPE x 117 LG	1	SA-106B	J1-1
N5	BRIDLE	3" 300# SCH XXH RFWN FLG	2	SA-105N	L1-1
		3" SCH XXH SMLS PIPE x 108 LG	2	SA-106B	J3-1
	REPAD	203 OD x 34.9 PL x 92 ID (ROLL TO 1594 ID)	2	SA51670N	J3-1
N6	LT-1002	2" 300# SCH XXH RFWN FLG	2	SA-105N	L1-1
		2" SCH XXH SMLS PIPE x 346 LG	1	SA-106B	J1-1
		2" SCH XXH SMLS PIPE x 117 LG	1	SA-106B	J1-1
N7	TI-1002	2" 300# SCH XXH RFWN FLG	1	SA-105N	L1-1
		2" SCH XXH SMLS PIPE x 117 LG	1	SA-106B	J1-1
N8	PI-1003	2" 300# SCH XXH RFWN FLG	1	SA-105N	L1-1
		2" SCH XXH SMLS PIPE x 117 LG	1	SA-106B	J1-1
N9	WATER OUT	2" 800# SCH XXH RFWN FLG	1	SA-105N	L1-1
		2" SCH XXH SMLS PIPE x 279 LG	1	SA-106B	J2-1
		2" SCH XXH 90° LRWB ELL	1	SA234WPB	
		2" SCH XXH SMLS PIPE x 152 LG	1	SA-106B	
		2" 150# RFSO FLG	2	SA-105N	
		2" 150# RF x 1/8" THK FLEX GASKET	1	316SS	
		5/8" x 4" LG STUDS c/w (2) NUTS EACH	4	S.S.	
N10	LSHH-1001	4" 300# SCH XXH RFWN FLG	1	SA-105N	L1-1
		4" SCH XXH SMLS PIPE x 133 LG	1	SA-106B	J3-1
	REPAD	229 OD x 34.9 PL x 117 ID (ROLL TO 1594 ID)	1	SA51670N	J3-1
N11	LSLL-1007	4" 300# SCH XXH RFWN FLG	1	SA-105N	L1-1
		4" SCH XXH SMLS PIPE x 108 LG	1	SA-106B	J1-1
5	ADDED BREAK FLANGES TO N9		CM		98/08/20
4	MODIFIED MISTPAD DETAILS, ADDED NOTE 26 & REVISED NLL		CM		98/08/13



DESIGN DATA TABLE		
PART	NOM THK	MIN THK
SHELL	1.375" (34.9 mm)	1.375" (34.9 mm)
HEAD	1.500" (38.1 mm)	1.347" (34.2 mm)
BOOT SHELL	1.375" (34.9 mm)	1.375" (34.9 mm)
BOOT HEAD	1.000" (25.4 mm)	0.9375" (23.8 mm)

GENERAL NOTES
 1. WELDING PROCEDURES: WP-719.2
 2. QUALITY CONTROL PROGRAM: AQP-1077
 3. REFERENCE DRAWING NUMBER: STD. 2000 (WELD STANDARDS)
 4. ALL BOLT HOLES TO STRADDLE CENTRE LINES
 5. SERIAL NUMBER: 6286-20
 6. SERVICE: SOUR HYDROCARBON
 7. LONG SEAM WPS: PM-109/127 CIRC. SEAM WPS: PM-126/127 NOZZLE TO FLG. WPS: PM-109/126/132 OTHER WELD WPS: PM-109/122
 8. PRE-HEAT TO: 200°F (93°C) IMPACT TESTS: SEE NOTE #15
 9. SURFACE PREP. INT.: SSPC-SP5 EXT.: SSPC-SP6
 10. SURFACE FINISH INT.: SEE NOTE #21 EXT.: SEE NOTE #22
 11. INSULATION: NONE

DESIGN DATA
 CODE: ASME SECTION VIII, DIV. 1, 1995 EDITION A-97 ADDENDA
 DESIGN PRESS. 4875 kPa (707 PSIG), DESIGN TEMP. 65 °C (150 °F)
 MIN. DESIGN METAL TEMP. -29 °C (-20 °F @ 707 PSIG)
 M.A.W.P. MAX. TEMP. °C (°F)
 M.A.W.P. NEW & COLD °C (°F)
 HYDROSTATIC TEST PRESSURE 7313 kPa (1061 PSIG) (SEE NOTE #19)
 CORROSION ALLOW. 3.2 mm (0.125 "), P.W.H.T. 90 MIN @ 1150°F ± 25°F
 RADIOGRAPHY 100% PER RT-1 PER UCS-56 & UW-40
 HEAD THK. NOM. SEE mm (TABLE), MIN. SEE mm (TABLE)
 SHELL THK. NOM. SEE mm (TABLE), MIN. SEE mm (TABLE)
 VOLUME 12 cu m (438 cu ft)
 WEIGHT EMPTY 13527 kg (29821 lbs)
 WEIGHT FULL OF WATER 25910 kg (57121 lbs)

PRESSON MANUFACTURING LTD.
 ENGINEERING — DESIGN — FABRICATION

CUSTOMER: UNION PACIFIC RESOURCES INC.
 CUSTOMER REF. NO: 235901014-0 JOB NO: B6286-20

PROJECT: TELFORDVILLE GAS PROJECT
 LSD 16-29-50-02 W5M

TITLE: HORIZONTAL INLET SEPARATOR (V-100)
 60" ID x 20'-0" S/S x 707 PSIG @ 150°F
 1524 mm ID x 6096 mm S/S x 4875 kPa @ 65°C

DRAWN: CM CHECKED: APPROVED: SCALE: 1/2"=1'-0" DATE: 98/07/17 DRAWING NUMBER: B6286-220