



GENERAL NOTES:

1. ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE NOTED.
2. ALL BOLT HOLES TO STRADDLE NATURAL VESSEL CENTER LINES UNLESS OTHERWISE NOTED.
3. FULL PENETRATION WELDS TO BE GROUDED BEFORE FILING.
4. CORNER RADIUS 1/8" MINIMUM FOR NOZZLES AND 1/8" MINIMUM FOR MANWAYS.
5. ALL REPAIRS TO HAVE A 1/4" NPT WEEP HOLE ON DOWN-HILL SIDE OF NOZZLE OR MANWAY.
6. 1/4" NPT WEEP HOLES REQUIRED ON ALL REPAIRS, WEAR PADS AND POISON PADS. AIR/SOAP TEST @ 15 PSIG REQUIRED.
7. TWO WEEP HOLES REQUIRED WHEN REPAIR IS SPLIT (ONE EACH).
8. CHASE THREADS ON COUPLINGS BEFORE HYDRO.
9. IF PSV IS NOT SHOWN IN NOZZLE SCHEDULE, IT IS THE USER'S RESPONSIBILITY TO LOCATE THE PSV IN ADJACENT PIPING PER ASME UG-125.

INSPECTION NOTES:

1. SPOT ON CIRC., ALL NOZZLE GREATER THAN 10" OR 1 1/8" WT
2. CHART RECORDER FOR HYDRO.

FABRICATION NOTES:

1. FOR FABRICATION TOLERANCES REFER TO "STANDARD FABRICATION TOLERANCES FOR UNFIRED PRESSURE VESSELS, (REV. 0)"
2. PREHEAT TO 200° F PRIOR TO WELDING.
3. SURFACE PREP: SANDBLASTED TO SSPC-SP-6
4. PRIMED: ONE (1) COAT ZINC PHOSPHATE
5. PAINTED: ONE (1) COAT INDUSTRIAL ENAMEL (WARM GREY)
6. MATERIAL SUBSTITUTION FOR:
SA-105N USE SA-350-LF2 CL.1
SA-105B USE SA-333-GR.6
SA-234-WPB USE SA-420-WPL6
SA-36 USE SA-516-70N
7. RETURN DWG. TO QC AFTER FABRICATION
8. WELD BOTTOM HEAD ON BEFORE TOP HEAD

BILL OF MATERIAL												
ITEM	QTY.	SIZE	TYPE	RATING	SCH./W.T.	MAT'L SPEC	DESCRIPTION					WEIGHT (kgs)
100. VESSEL												
101	1	20" OD	PIPE		STD	SA-106-B	20" OD x 5'-0" S/S x 0.375" NOM. THK.					179
102	2	20" OD	WELD CAP		STD	SA-516-70N	2:1 S.E. HEAD (0.3125" FORMED MIN.) HOT FORMED 20" OD x 0.3125" THK.					48
200. CONNECTIONS												
201	11	2"	RFWN	CL150	160	SA-105N	ANSI FLANGE					33
202	1	3"	RFWN	CL150	80	SA-105N	ANSI FLANGE					5
203	3	4"	RFWN	CL150	80	SA-105N	ANSI FLANGE					12
204	AS REQ'D	2"	PIPE		160	SA-106B	SEAMLESS PIPE					11
205	AS REQ'D	3"	PIPE		80	SA-106B	SEAMLESS PIPE					1
206	AS REQ'D	4"	PIPE		80	SA-106B	SEAMLESS PIPE					2
207	1	2"	CS ELBOW		160	SA-234-WPB	ELBOW, BW, 90° LR					1
208	4	2" x 3/4"	REDUCING FLG	CL150		SA-105N	REDUCING FLANGE 2" 150 RF x 3/4" THRD					5
209	1	2" x 1"	REDUCING FLG	CL150		SA-105N	REDUCING FLANGE 2" 150 RF x 1" THRD					1
300. INTERNAL ASSEMBLIES												
301	2	1/4" THK	PLATE			SA-516-70N	INLET DIVERTER/SKIMMER BOTTOM PLATE (CUT TO SUIT) 78 x 154					
302	1	6"	PIPE		40	SA-106B	INLET DIVERTER PIPE (CUT INTO HALF) 100 LG.					1
303	1	1/4" THK	PLATE			SA-516-70N	VORTEX BREAKER PLATE 90 X 185					2
304	1	6"	PIPE		40	SA-106B	SKIMMER (PIPE CUT INTO HALF) 203 LG.					1
400. EXTERNAL ASSEMBLIES												
401	1	20" OD	PIPE		STD	SA-106-B	PIPE SKIRT 483 LG.					2
403	1	1/4" THK	PLATE			SA-516-70N	NAMEPLATE BRACKET 150 x 100					59
404	1	3/4" THK	PLATE			SA-36	SKIRT BASE PLATE 23" OD x 18" ID					1
405	1	2" x 1/4"	FLAT BAR			316LSS	GROUND LUG 50 LG.					24
406	7 SETS	5/8" x 3 1/4" LG. STUDS				SA-193-B7M SA-194-2HM	4 STUDS & 8 NUTS					1
407	7		RF GASKET	150		316SS	SPWD FLEX, 3 THK.					12
408	AS REQ'D	8"	PIPE		40	SA-106B	SEAMLESS PIPE					1
409	AS REQ'D	12"	PIPE		40	SA-106B	SEAMLESS PIPE					2
404												