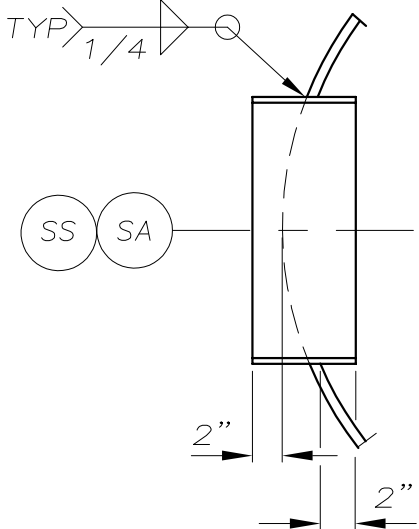


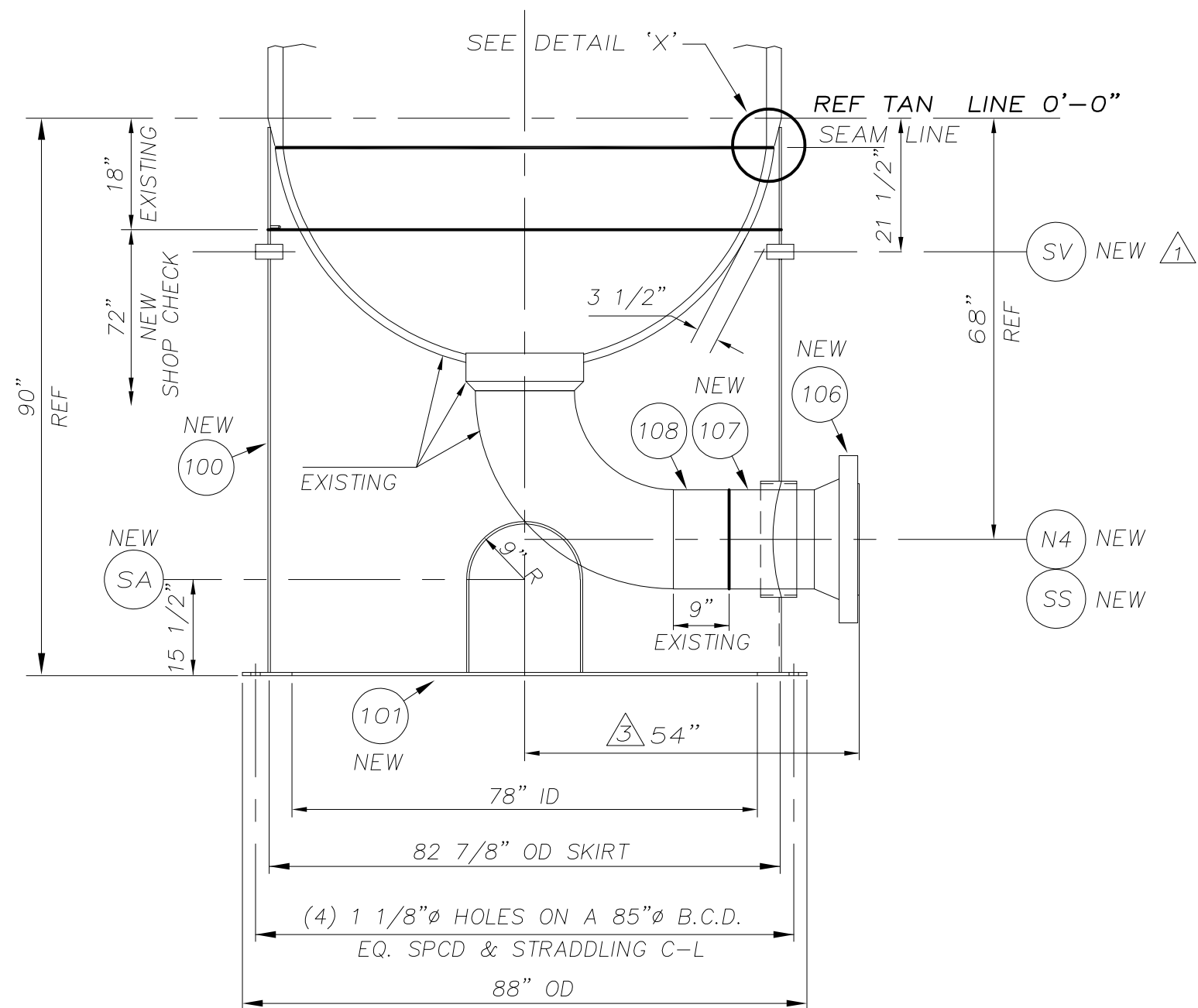
1. ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
2. ALL BOLT HOLES TO STRADDLE NATURAL VESSEL CENTER-LINES UNLESS OTHERWISE NOTED.
3. FULL PENETRATION WELDS TO BE CHIPPED OR GOUGED BEFORE BACKWELDING.
4. CORNER RADIUS 1/8" MINIMUM FOR NOZZLES AND 1/4" MINIMUM FOR MANWAYS.
5. NOZZLES AND MANWAYS ARE INSTALLED CONTOURED FLUSH WITH INSIDE OF VESSEL UNLESS OTHERWISE SPECIFIED ON THE VESSEL DRAWING.
6. PSV IS TO BE INSTALLED ON PIPING.
7. INSULATION THICKNESS 1 1/2" BY OTHERS.



1. REPAD FOR THE 8" NOZZLE IS 2 1/2" THICK, SA 516-70N
Δ SA 516-70N c/w LCVN 16/12 FT-LB @ 0°F.

1. 100% INCLUDING ALL NOZZLES BUTT WELDS.

SKIRT OPENING DETAIL



SKIRT & BASE DETAIL

			I		II		III		IV			
MARK NO.	NO. REQ'D	SIZE	RATING	TYPE	SCH	SERVICE	PROJECTION FROM VESSEL O.D.	WELDING DETAIL NO.	WELD SIZES			REMARKS
									A	B	C	
N1	1	8"	600#	RFWN	XH	INLET	10"	I, III	3/8"		1 7/8"	c/w INLET DIVERTER
N2	1	18"	600#	RFWN	--	GAS OUT	--	--	--			
N3	1	2"	600#	RFWN	160	SPARE	8"	I, II	3/8"			
N4	1	16"	600#	STUB FORGING PIPE + RFWN	80	LIQUID OUT	--	I	--			c/w VORT BREAKER, NEW NECK & RFWN FLANGE
N5A/B/C	3	2"	600#	RFWN	--	LG/BRIDLE	8"	I, II	3/8"			
MW	1	18"	600#	RF	--	MANWAY	--	--	--			
C2A/B	2	2"	6000#	CPLG	--	LSH	--	IV	3/8"			c/w FLOAT PROTECTOR
C3	1	2"	6000#	CPLG	--	PI	--	IV	3/8"			
C4	1	2"	6000#	CPLG	--	TI	--	IV	3/8"			
C5	1	2"	6000#	CPLG	--	SPARE	--	IV	3/8"			
C7	1	2"	6000#	CPLG	--	LSL	--	IV	3/8"			c/w FLOAT PROTECTOR
SA	1	18" ID	--	--		SKIRT ACCESS						
SS	1	18" ID	--	--		SKIRT SLEEVE						

* = EXISTING

ITEM NO.	REQ'D	DESCRIPTION	MATERIAL	MARK NO.	HEAT NO.
100	1	SKIRT 1/2" PL 82 7/8" OD x 74" LG (SHOP CHECK)	SA 516-70		
101	1	BASE 1/2" PL x 78" ID x 88" OD	SA 516-70		
102					
SA	1	SKIRT ACCESS 1/2" PL x 6" x 60" LG	SA 516-70		
SS	1	SLEEVE 1/2" PL x 18" ID x 6" LG	SA 516-70		
106	1	FLANGE 16"~600# ANSI RFWN x SCH 80	SA 105N	N4	
107	1	HOR PIPE 16" SCH 80 x 13 3/4" LG	SA 106-B		
108	1	HOR PIPE 16" SCH 80 x 9" LG (EXISTING)	--		
109	1	CUSTOM FORGING (EXISTING)	--		
110	1	ELBOW 16"~90° LR x SCH 80 (EXISTING)	--	↓	
112	1	FLANGE 8"~600# ANSI RFWN x SCH XH	SA 105N	N1	
113	1	NECK 8" SCH XH PIPE x SHOP CHECK LG	SA 106-B		
114	1	REPAD 2 1/2" PL x 9 1/8" ID x 17 5/8" OD	(SA 516-70N (SEE MAT'L NOTE))	↓	
116	4	FLANGE 2"~600# ANSI RFWN x SCH 160	SA 105N	N3,N5A/B/C	
117	4	NECK 2" SCH 160 PIPE x SHOP CHECK LG	SA 106-B	↓	
119	6	FULL COUPLING 2"~6000# THREADED x 5" LG	SA 350-LF2	C2A/B,C3 C4,C5,C7	

NOTE:

1. BILL OF MATERIALS IS FOR ONE VESSEL ONLY.
TWO REQUIRED.

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CESSCO

FABRICATION & ENGINEERING LIMITED
CANADIAN ERECTORS LTD.

EDMONTON, ALBERTA

CUSTOMER
DARSI ENGINEERING

CUSTOMER P.O. *DEL-265-105*

FINAL OWNER HCO ENERGY LTD.
ANSEL GAS PLANT

TAG NO. —

SKIRT, NOTES, NOZZLE SCHEDULE & WELDING DETAILS
REPAIRS & MODIFICATION FOR EXISTING VESSELS

		DESIGN DATA			
		DESIGN & FABRICATE TO <u>ASME UW 12(a) DIV. 1 SECT. VIII 1995 ED., 1996 ADD</u>			
		DESIGN PRESS(NT) <u>400PSIG</u>	DESIGN TEMP(NT) <u>650° F</u>	DESIGN PRESS(EXT) <u>—</u>	DESIGN TEMP(EXT) <u>—</u>
		M.A.W.P. <u>400 PSIG</u>	LIMITED BY <u>DESIGN</u>	M.A.W.P. (NEW&COLD) <u>—</u>	LIMITED BY <u>SHELL</u>
		SHELL EFFICIENCY(CIRC) <u>100%</u>	SHELL EFFICIENCY(LONG) <u>100%</u>	HEAD EFFICIENCY <u>100%</u>	
		C.R. No. <u>—</u>	RADIOGRAPH <u>FULL RT1 (SEE INS'N NOTE 1)</u>	M.D.M. <u>0° F @ 400 PSIG</u>	
		P.W.H.T. <u>150</u> MIN. @ <u>1150°F</u>	HYDROTEST <u>600 PSIG @ 60° F MIN</u>	CORR. ALLOW. <u>0.0625"</u>	
		SHELL THK.(NEW) <u>2.410"</u>	HEAD THK.(NEW) <u>1.210" MIN</u>	CONE THK.(NEW) <u>— — —</u>	
		BOOT SHELL THK.(NEW) <u>— — —</u>	BOOT HEAD THK.(NEW) <u>— — —</u>	SKIRT THK. <u>1/2"</u>	
<u>REPAIRS & MODIFICATIONS TO EXISTING VESSELS</u>		<u>3625-0</u>	VOLUME <u>940 FT³</u>	WT.(SHIPPING) <u>80,000 LBS</u>	WT. (FULL OF WATER) <u>138,656 LBS</u>
DESCRIPTION	DRAWING NO.	WT. (OPERATING) <u>81,000 LBS</u>			

SHELL	SA 212B FB		
HEADS	SA 212B FB		
FORGINGS	SA 105N	NOZZLE NECKS	SA 106-B
SKIRT	SA 516-70	BASE PLATE	SA 516-70
BOLT CHAIR	SA 516-70	STIFFENING RINGS	---
EXTERNAL ATTACHMENT		INSUL. RINGS	SA 516-70N
INTERNAL PLATE	SA 516-70	INTERNAL PIPING	SA 53-B
PAINT	SEE 3625-PAINT		

3	REVISED NOZZLE N4 PROJ'N & SKIRT DIA. AS NOTED	AUG 28/97	DL	.	.				
2	VESSEL DERATED FROM 1000 PSIG	8/21/97	G _M	GEM/GC	GC				
1	ADDED SKIRT VENTS & N4 DIM	8/19/97	G _M	GEM/YH	GC				
REV	DESCRIPTION	DATE	BY	CKD	APPR.				
MANUAL CHANGES MADE-- YES ☐ NO ☒						CAD DWG. FILE UPDATED--YES ☐ NO ☒		I.F. 24	

DATE	DRAWN BY	CHECKED	APPROVED	JOB NO.	DWG NO.	REV
AUG 14/97	DEL LUMAGUE	DL/GC	G.CHABOT	3625	3625-1	3