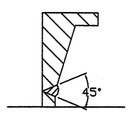
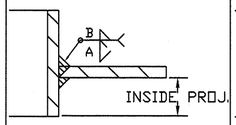
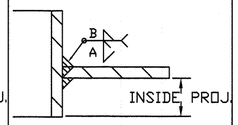
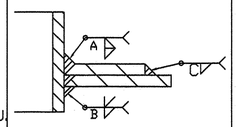
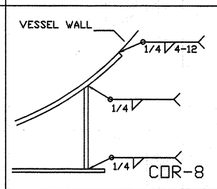
APPURTENANCE & ATTACHMENT WELD DETAILS (n.t.s.)

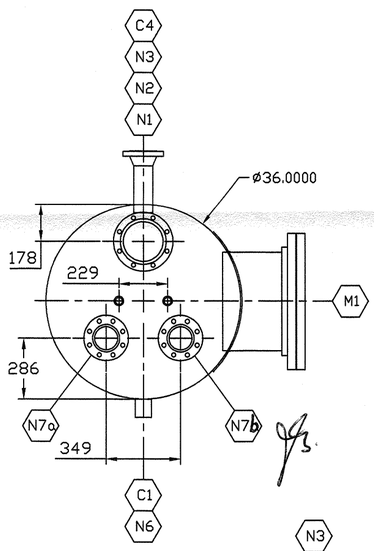
N1,N2,N3,N4,N5,N6,N7,N8	N1,N2,N3,N4,N5,N6,N7,N8	C1,C2,C3,C4	M1	WEAR PLATES
TYPE 1 MIG ROOT  COR-9	 COR-8	 COR-8	 COR-8	 COR-8
TRANSITION	**CIRC SEAMS**	**LONG SEAMS**	**WEIR DETAIL**	**LIFTING LUG**
TYPE '1' MIG ROOT COR-9 COR-10	TYPE '1' MIG ROOT COR-9 COR-10	TYPE '1' MIG ROOT COR-9 COR-10	 TANK WALL COR-8	 COR-8

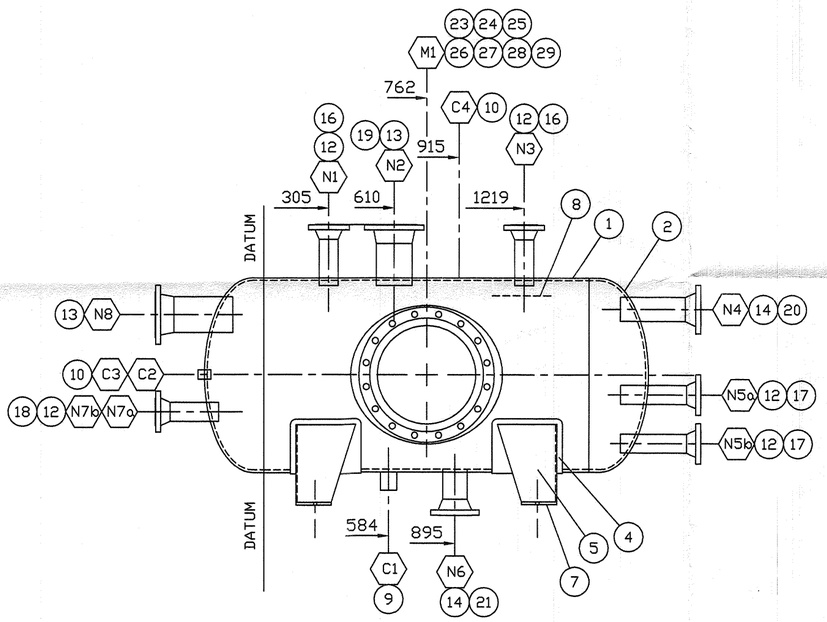
NOZZLE SCHEDULE

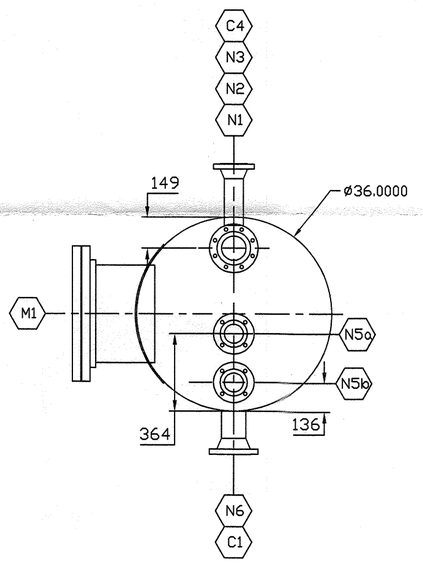
MK#	NO.	SIZE	SCH.	RATE	TYPE	PROJ. INT.	PROJ. EXT.	REPAD YES	REPAD NO	FILLET A	FILLET B	FILLET C	DETAIL	DESCRIPTION
M1	1	18"	STD	150#	RFSO	13mm	254mm	✓		3/8	3/8	1/4"		18" MANWAY
N1	1	3"	XH	150#	RFWN	25mm	254mm		✓	3/8	3/8			INLET
N2	1	6"	XH	150#	RFWN	25mm	254mm		✓	3/8	3/8			LEVEL CONTROLLER
N3	1	3"	XH	150#	RFWN	25mm	254mm		✓	3/8	3/8			OUTLET
N4	1	4"	XH	150#	RFWN	25mm	254mm		✓	3/8	3/8			LEVEL SWITCH HIGH HIGH
N5a	1	3"	XH	150#	RFWN	25mm	254mm		✓	3/8	3/8			FUTURE CONTROL
N5b	1	3"	XH	150#	RFWN	25mm	254mm		✓	3/8	3/8			FUTURE CONTROL
N6	1	4"	XH	150#	RFWN	25mm	254mm		✓	3/8	3/8			-
N7a	1	3"	XH	150#	RFWN	25mm	254mm		✓	3/8	3/8			HEAT COIL IN
N7b	1	3"	XH	150#	RFWN	25mm	254mm		✓	3/8	3/8			HEAT COIL OUT
N8	1	6"	XH	150#	RFWN	25mm	254mm		✓	3/8	3/8			SPARE
C1	1	2"	3000#	-	HALF	FLUSH	FULL		✓	3/8				DRAIN
C2	1	1"	-	3000#	CPLG	-	HALF		✓	3/8				TEMP. CONTROLLER
C3	1	1"	-	3000#	CPLG	-	FULL		✓	3/8				TEMP. INDICATOR
C4	1	1"	-	3000#	CPLG	-	FULL		✓	3/8				PSV

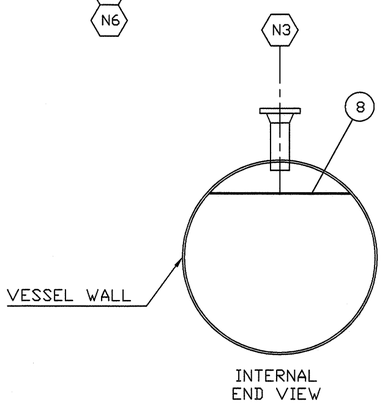
MATERIAL LIST

MK#	QTY.	DESCRIPTION	MATERIAL	WT.
1	1	SHELL; ø36" O.D. x 5'-0" LG x 3/8" NOM	SA 516 70N	
2	2	#36" O.D. x 2:1 S.E. HEADS x 1/2" NOM (0.4375" MIN)	SA 516 70N	
3				
4	2	WEAR PAD; 40 1/4" x 13" x 1/4" THICK	SA 516 70N	
5	4	SUPPORT PLATE; 14 3/8" x 11" x 1/4"	A 36	
6	2	SUPPORT PLATES; 14 3/8" x 31 5/8" x 1/4"	A 36	
7	2	BASE PLATE; 11" x 32 1/8" x ~~1/2"~~ 1/2.1"	A 36	
8	1	BAFFLE PLATE; 3/16" PLATE	A 36	
9	1	2" 3000# HALF COUPLING (C1)	SA 105 F.S.	
10	3	1" 3000# FULL COUPLING (C2,C3,C4)	SA 105 F.S.	
11				
12	6	3" 150# XH RFWN (N1,N3,N5a/b,N7a/b)	SA 105 N	
13	2	6" 150# XH RFWN (N2,N8)	SA 105 N	
14	2	4" 150# XH RFWN (N4,N6)	SA 105 N	
15				
16	2	3" XH SMLS PIPE x 8 3/4" LG (N1,N3)	SA-106 B	
17	2	3" XH SMLS PIPE x 12 1/4" LG (N5a/b)	SA-106 B	
18	2	3" XH SMLS PIPE x 9" LG (N7a/b)	SA-106 B	
19	1	6" XH SMLS PIPE x 8" LG (N2)	SA-106 B	
20	1	4" XH SMLS PIPE x 5 1/2" LG (N4)	SA-106 B	
21	1	4" XH SMLS PIPE x 10 7/8" LG (N6)	SA-106 B	
22				
23	1	18" 150# RFSO (M1)	SA 105 N	
24	1	18" 150# RF BLIND (M1)	SA 105 N	
25	1	18" STD SMLS PIPE x 13" LG (M1)	SA 105 N	
26	1	28" OD x 1/4" ROLLED REPAD	SA 516-70N	
27	1	18" 150# FLEX GASKET	304 C.C.	
28	16	1 1/8" x 5 3/4" STUDS	SA 193 B7	
29	32	1 1/8" NUTS	SA 194 2H	
30	1	18" 150# DAVIT ARM	STEEL	
31	1	DOOR PLATE 3/4" PLATE	A 36	

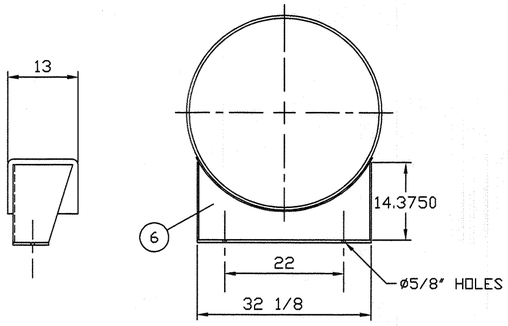




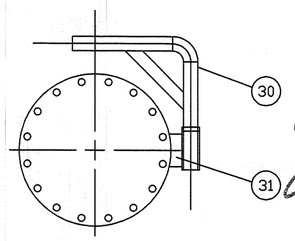




INTERNAL END VIEW



SADDLE DETIALS



DAVIT ARM

Saskatchewan Municipal Government Boiler & P.V. Safety Unit
CRN A3811.3
File 46342
REGISTERED
Date DEC. 9/98
Design Survey Office

GENERAL NOTES

1. QUALITY CONTROL PROGRAM NO: REGISTERED WITH ABSA
2. WELDING PROCEDURE NO: REGISTERED WITH ABSA
3. WELDING PROCEDURE NO: QUALIFIED TO 1 1/2"
4. SERVICE WATER, OIL, GAS
5. SURFACE PREPARATION: MINIMUM HAND TOOL CLEAN
6. CAPACITY: 44.8 CUBIC FEET
7. PRIME: AS PER CUSTOMER SPECIFICATIONS.
8. PAINT: AS PER CUSTOMER SPECIFICATIONS.
9. ALL BOLT HOLES TO STRADDLE CENTERLINES
10. ALL OPENINGS TO BE COVERED FOR SHIPPING
11. COMPONENT CLARIFICATIONS:
    A. FULL COUPLINGS MAY BE INTERCHANGED WITH O-LET TYPE CONNECTIONS
    B. FLANGE OR COUPLINGS MAY BE INCREASED TO HIGHER RATINGS
    C. PIPE MATERIAL MAY BE UPGRADED: SA-53-B TO SA-106-B TO SA-333-GR6
    D. WELD FITTINGS MAY BE UPGRADED: SA-234-WPB TO SA-420-WPL6
    E. PLATE MATERIAL MAY BE UPGRADED: SA-516-70 TO SA-516-70N
    F. FLANGE/COUPLING MATERIAL MAY BE UPGRADED: SA-105 TO SA-105-N TO SA-350-LF2
13. INSPECTION REQUIREMENTS:
    A. POST WELD HEAT TREATMENT MAY BE ADDED PROVIDED A PWHT WELD PROCEDURE IS USED. POSTWELD HEAT TREATMENT 1100°F +/- 25°F
14. DESIGN REGISTERED TO CORLAC INDUSTRIES LTD. CRN:

NO.	DATE	DESCRIPTION	BY	APP'D
A	98/12/02	ISSUED FOR APPROVAL	DK	

REVISIONS

ASME SECTION VIII DIV 1 1998 ED.

DESIGN PRESSURE & TEMPERATURE	150 psig @ 100°F
MINIMUM DESIGN METAL TEMPERATURE:	-20°F @ 150 psig
IMPACT TESTING NOT MANDITORY PER UG 20f (1-5)	
NDT X-RAY CIRC:	RT 1
LONG:	RT 1
PWHT:	NONE (SEE NOTE 13A)
SHELL THK NOM. 0.375	MIN CALC.: 0.33
HEAD THK NOM. 0.5	MIN CALC.: 0.4375
HYDROSTATIC TEST PRESSURE:	225 psig
PREHEAT TEMPERATURE:	50°F
CORROSION ALLOWANCE:	0.125
REGISTERED WELD PROCEDURE	COR-8, COR-9, COR 10
CAPACITY: 44.8 cu. ft.	APPROX. OVERALL HEIGHT: 4'-4"
VESSEL TYPE:	U - HORIZONTAL FLARE KNOCKOUT DRUM
MAWP	1034 kpa @ +38°C/-29°C

FILE NO.	981127
DRAWN	D.KIM
CHECKED	
APPROVED	
DATE APPROVED	

CORLAC INDUSTRIES LTD.
LLOYDMINSTER, ALBERTA

WASCANA ENERGY

FLARE KNOCKOUT
ø36" OD x 5'-0" S/S
150psi @ -20°F

CORLAC

SCALE	NTS
DATE	98/11/27
FILE	PRESSURE
DRAWING NO.	98-WAS-FLKO-36-01
REV	A

D005