



FOSTER WHEELER ENERGY CORPORATION

110 SOUTH ORANGE AVENUE · LIVINGSTON, NEW JERSEY 07039 · PHONE 201-533-1100

Date: 1/13/78
Letter No.: 574
File No.: 44

Subject: Inspection Documents

Gentlemen:

In accordance with the coordination procedure for the subject contract, we are enclosing three (3) copies of the Manufacturer's Data Reports, Mill Test Certificates, Nameplate Rubbings and/or pertinent data concerning the following items:

F.W.P.O.#

PP3-115-1776
PP23-115-1776

ITEM

T-202 Recycle Gas CO 2 Absorber
R-205 A/B Second Stage
Rich Gas Reactor

Very truly yours
FOSTER WHEELER ENERGY CORPORATION

C. Lambert for
C. Lambert A. L.
Project Manager

MEM/al

Copied: 1-15-78

RAL
NJP
ALL
1-15-78

FORM U-1A MANUFACTURERS' DATA REPORT FOR PRESSURE VESSELS
 (Alternate Form for Single Chamber, Completely Shop-Fabricated Vessels Only)
 As Required by the Provisions of the ASME Code Rules, Section VIII, Division 1

1. Manufactured by GENERAL WELDING WORKS, IN C. HOUSTON, TEXAS
 2. Manufactured for FOSTER WHEELER ENERGY CORP. LIVINGSTON, NEW JERSEY
 3. Location of Installation _____
 4. Type Vert. 13377 -- 6701A 8399 (Year Built) 1977
 (Horiz. or vert. tank) (Mfg'r Serial No.) (CRN) (Drawing No.) (Nat'l Brd No.)
 5. The chemical and physical properties of all parts meet the requirements of material specifications of the ASME BOILER AND PRESSURE VESSEL CODE. The design, construction, and workmanship conform to ASME Rules, Section VIII, Division 1 1974 and Addenda to 12-76 and Code Case Nos. --
 (Year) (Date)
 Special Service per UG-120(d) --
 Manufacturers' Partial Data Reports properly identified and signed by Commissioned Inspectors have been furnished for the following items of the report: --

6. Shell: Matl. SA-516-70 Nom. Thk. ** in. Corr. Allow. .125 in. Diam. 36 x 96 in. Lgth. 110 ft 2 in.
 (Spec. No., Grade)
 7. Seams: Long. DB R.T. *** Efficiency *** % H.T. Temp. 1100 F Time 1 1/2 hr
 (Welded, Dbl, Sngl, Lap, Butt) (Spot or Full)
 Girth DB R.T. *** No. of Courses 14
 (Welded, Dbl, Sngl, Lap, Butt) (Spot, Partial, or Full)
 8. Heads: (a) Material SA-516-70 (b) Material SA-516-70
 (Spec. No., Grade) (Spec. No., Grade)

Location (Top, Bottom, Ends)	Min. Thk.	Corr. Allow.	Crown Radius	Knuckle Radius	Ellipse Ratio	Conical Apex Angle	Hemisp. Radius	Flat Diam.	Side to Pressure (Convex or Concave)
(a) Top	9/16"	.125"			2:1				concave
(b) Bottom	1-1/8"	.125"			2:1				concave

If removable, bolts used (describe other fastenings) _____

9. Constructed for max. allowable working pressure 341 psi at max. temp. 345 F. V. @345°F
 less than -20 F) -- F. Hydrostatic, pneumatic, or combination test pressure 573 psi.
 10. Safety Valve Outlets: Number -- Size -- Location Par. UG-125 note 1
 11. Nozzles and Inspection Openings:

Purpose (Inlet, Outlet, Drain)	No.	Diam. or Size	Type	Matl.	Nom. Thk.	Reinforcement Matl.	How Attached	Location
Manway	7	20"-300#	RFWNF	SA-106-B	.593"	(6) 1/2" (1) 1" P*	welded in shell	
Water In	1	1"-300#	RFWNF	SA-106-B	.358"	weld	welded in shell	
Carbon In	1	4"-300#	RFWNF	SA-106-B	.438"	3/4" P*	welded in conn. bld.	
Carbon & Gas In	2	6"-300#	RFWNF	SA-106-B	.432"	3/4" & 1" P*	welded in conn. bld.	
Carbon Out	1	8"-300#	RFWNF	SA-106-B	.500"	1" P*	welded in shell	
Drain	1	2"-300#	RFWNF	SA-106-B	.343"	weld	welded in bot. hd.	
Gas Out	1	3"-300#	RFWNF	SA-106-B	.438"	weld	welded in top hd.	
Sample Pt.	1	2"-300#	RFLWN	SA-105	.625"	weld	welded in shell	

12. Supports: Skirt yes Lugs -- Legs -- Other -- Attached welded to head
 (Yes or no) (No.) (No.) (Describe) (Where and how)

13. Remarks: "RECYCLE GAS CO2 ABSORBER" Item # T-202(2-280-15) S/O 6701
Contract # 15-1779 PO. # PP3-115-1776

** RI = 1-1/8", Cone = 1-3/16", R2 & 3 = 5/8", R4 thru. 12 = 9/16"

*** RI, Cone & Bot. Hd. = Full, 100%; Remainder = Spot, 85%

* SA-516-70

CERTIFICATE OF COMPLIANCE

We certify that the statements made in this report are correct and that all details of design, material, construction, and workmanship of this vessel conform to the ASME Code for Pressure Vessels, Section VIII, Division 1.

Date 12-14-77 Signed General Welding Wks, Inc. by A. Malinowski
 (Manufacturer) (Representative)

"U" Certificate of Authorization No. 2106 expires Feb. 28, 1978

CERTIFICATE OF SHOP INSPECTION

Vessel made by GENERAL WELDING WORKS, INC. at HOUSTON, TEXAS

I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State or Province of TEXAS and employed by H.S.B.I. & I. CO. have inspected the pressure vessel described in this Manufacturers' Data Report on Dec. 14 1977, and state that, to the best of my knowledge and belief, the Manufacturer has constructed this pressure vessel in accordance with ASME Code, Section VIII, Division 1. By signing this certificate neither the Inspector nor his employer makes any warranty, expressed or implied, concerning the pressure vessel described in the Manufacturers' Data Report. Furthermore, neither the Inspector nor his employer shall be liable in any manner for any personal injury or property damage or a loss of any kind arising from or connected with this inspection.

Signed Jan C. Hollister Date 12-14-77 Commissions Natl. Bd. No. 6955
 (Inspector) (Nat'l Board, State, Province and No.)

Purpose	No.	Size	Type	Matl.	Nom.Thk.	How		Location
						Reinf.	Attached	
Pz.Pt, LG	1	3/4"-6000#	S.W.Cplg.	SA-105-II	--	weld	welded	in shell
T.I.	3	1 1/2"-300#	RFWNF	SA-105	.625"	weld	welded	in shell
Heating coil	2	2"-150#	RFWNF	SA-106-B	.343"	weld	welded	in coil bld.
Coil Location	1	12"-300#	RFWNF	SA-106-B	.562"	3/4"P*	welded	in shell
LS/HH & LL	4	1"-6000#	S.W.Cplg.	SA-105-II	--	weld	welded	in shell
Conn. #3,5	2	8"-300#	RFWNF	SA-106-B	.500"	3/8" & 1/2"P*	welded	in shell
Conn. #4	1	12"-300#	RFWNF	SA-106-B	.562"	1/2"P*	welded	in shell
Chimney Drain	1	3"-300#	RFWNF	SA-106-B	.438"	3/8"P*	welded	in shell
Drain Return	1	3"-300#	RFWNF	SA-106-B	.438"	1"P*	welded	in shell
Sample Pt.	1	1"-300#	RFWNF	SA-106-B	.358"	weld	welded	in samp. bld.

NAT'L. BD. 8399

GENERAL WELDING WORKS, INC. - HOUSTON, TEXAS



MAX ALLOW WORKING PRESS

34 PSIG @ 345°F

SER NO 13377

YEAR: REC'D 1977

SHOP ORDER 6701

MEMO NO T-202 *

W
RT-2
H.T.

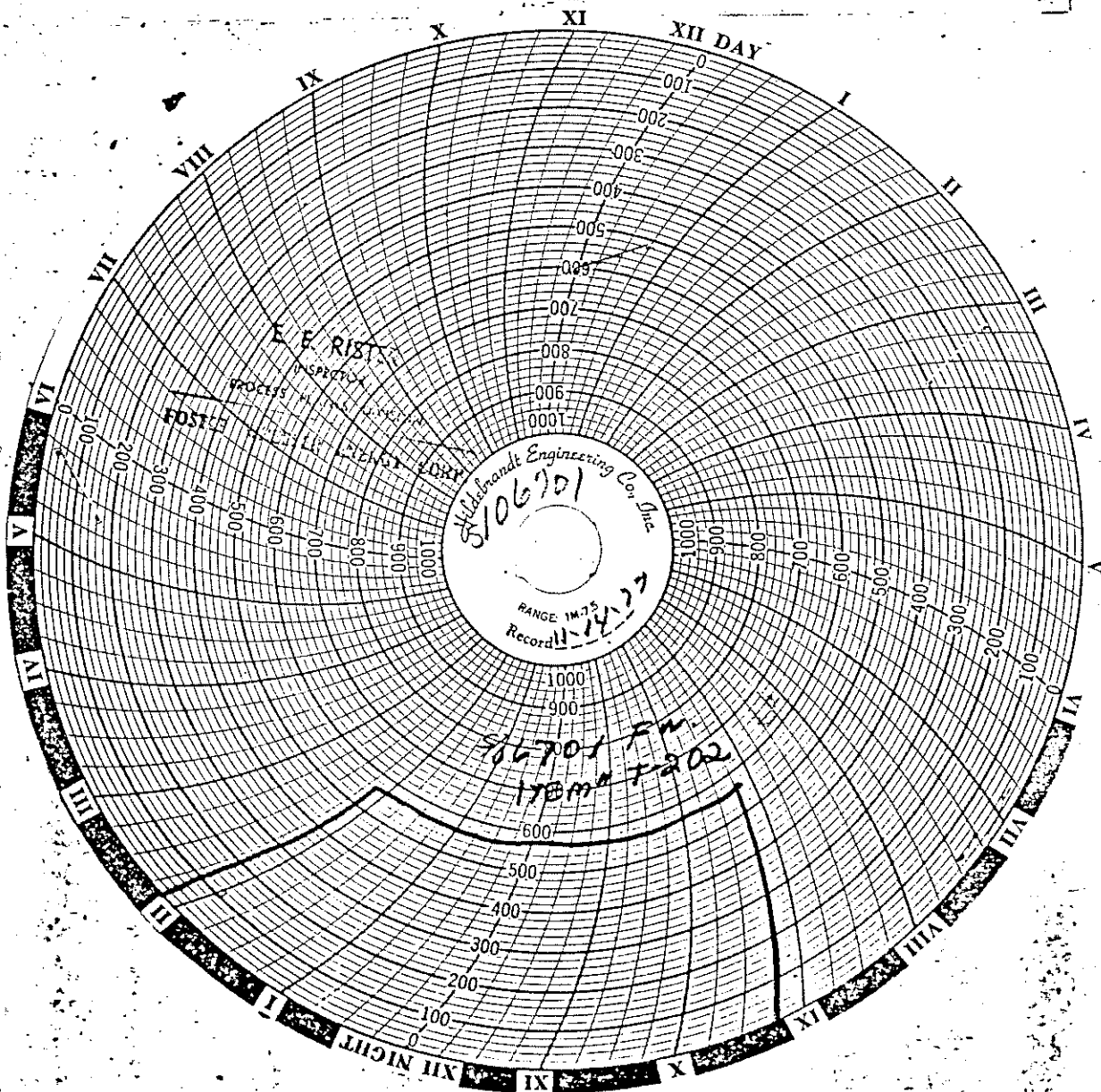
MAX EXPT PRESS

F.V. PSI @ 343 °F

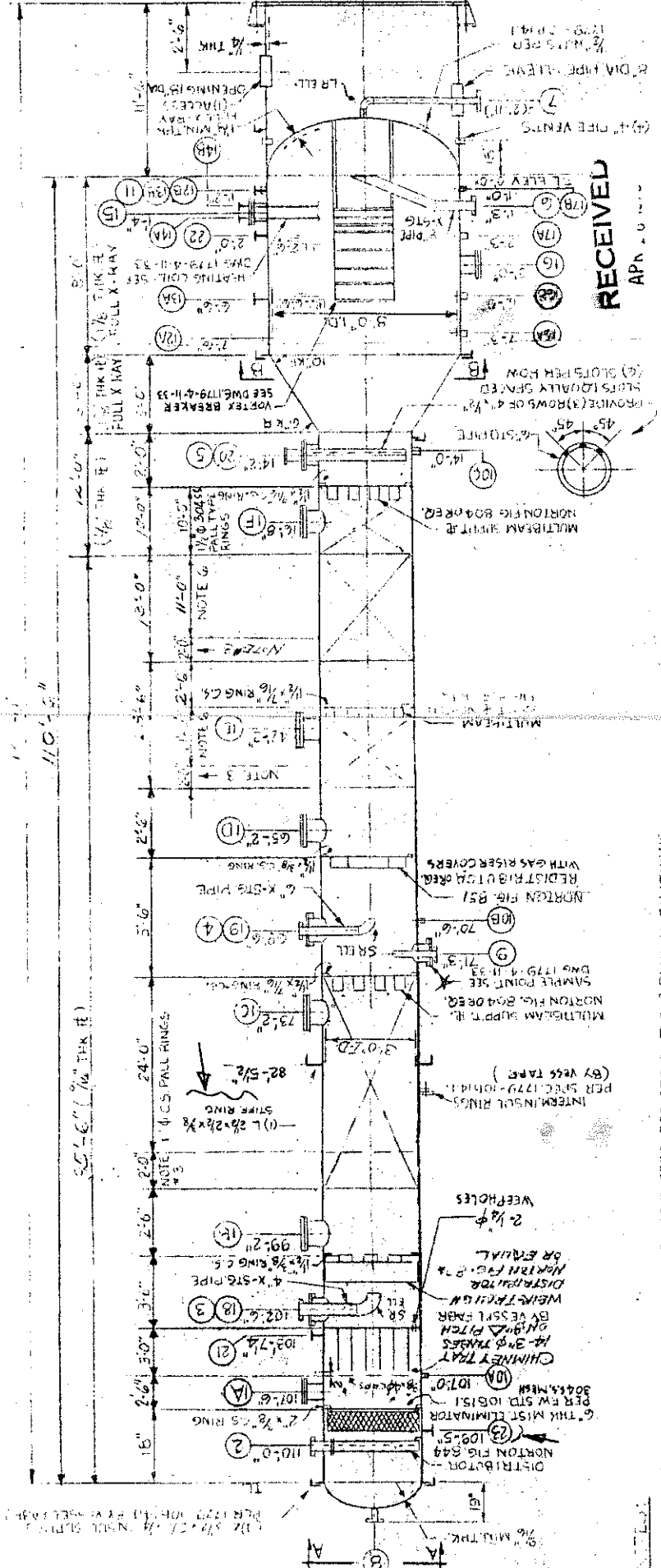
P.O. PP3-115-177

FOSTER WHEELER ENERGY CORP.

* 2-280-15



ELEVATION



RECEIVED
APR 20 1977

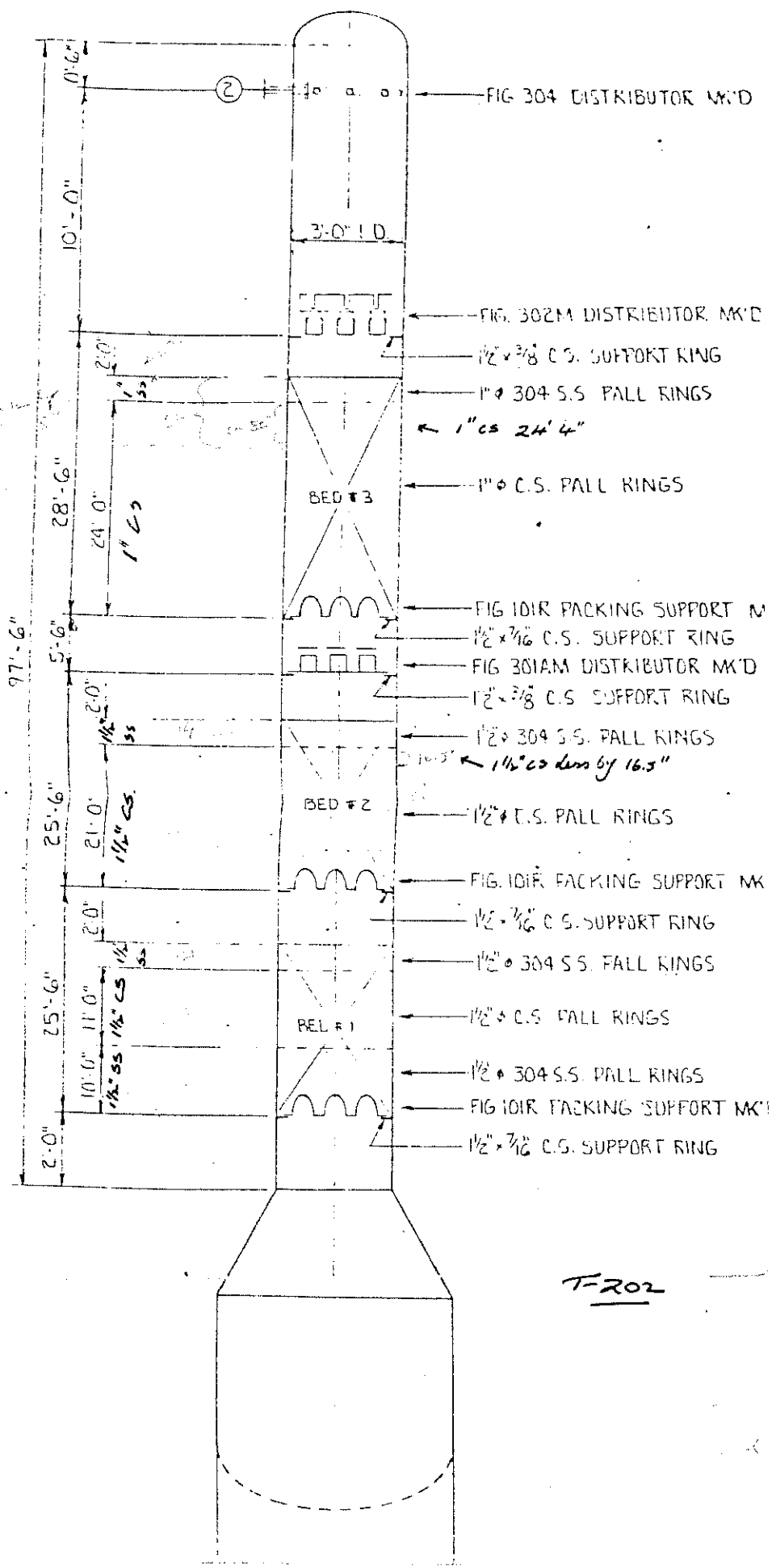
REV.	DATE	BY	DESCRIPTION
A	12-27-76
B	1-27-77
C	1-27-77
D	1-27-77

REVISIONS	CONTRACT NO.	REQUISITION NO.	DRAWING NO.
...	15-1779	1776-115-A-4B	1776-4-11-52

NOTE TO VEHSEL FABR.: SIZE OF DISTRIBUTOR & PACKING SUPPORTS TO BE CONFIRMED LATER BY PACKING VENDOR.

NOTE TO VEHSEL FABR.: PACKING SUPPORT RINGS TO BE CONFIRMED LATER BY PACKING VENDOR.

THIS DRAWING IS THE PROPERTY OF THE FOSTER WHEELER CORPORATION 110 SOUTH ORANGE AVENUE, LIVINGSTON, NEW JERSEY AND IS LENT WITHOUT CONSIDERATION OTHER THAN THE BORROWER'S AGREEMENT THAT IT SHALL NOT BE REPRODUCED, COPIED, LENT OR DISPOSED OF DIRECTLY OR INDIRECTLY FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT IS SPECIFICALLY FURNISHED. THE APPARATUS SHOWN IN THE DRAWING IS COVERED BY PATENTS.



T-202