

**BSCo. CD7276 (T-52) For Phillips Petroleum Co.**  
**FORM U-1 MANUFACTURERS' DATA REPORT FOR UNFIRED PRESSURE VESSELS**  
 As Required by the Provisions of the A.S.M.E. Code Rules

ALS 3436

1. Manufactured by BETHLEHEM STEEL COMPANY, BETHLEHEM, PA. T-98-52-181  
 (Name and address of the manufacturer)
2. Manufactured for Phil. Petro. Co., consigned To Chain Belt Co., Milwaukee, Wisconsin  
 (Name and address of the purchaser)
3. Type Horizontal Unfired Pressure Vessel No. (BSCo. 2150) (N.B. 1654) Year built 1952  
 (Horizontal or Vertical) (Mfr's serial, or A.S.M.E. No.) (State and State No.)
4. Have mill test reports been checked on all the plates entering this unfired pressure vessel. Yes  
 Do the chemical and physical properties of all plates meet the requirements of the Code. Yes
5. SHELL OR DRUMS: No. 1 Diameter 8 ft. 10 in. Length over-all 67 ft. 0-1/2 in. Height 7 ft. 7 in.  
 (or width) Gr. B Fbx. Nuts -A194 Cl. 2
6. STAMPS on shell plates A212 70,000 Rivets, stays, and braces Bolts - A193 Gr. B7  
 (Brand and Lowest Tensile Strength) Double welded butt (Iron or steel) Double welded butt
7. SHELL PLATES 0.96 in. Butt straps 7/8 in. Style of seams: Longitudinal Fusion welded U69 Girth Fusion welded U69  
 (Plate Thickness) (Thickness) (Riveted, Forge Welded, Brazed, or Fusion Welded—Par. No.)
8. Diameter of rivet holes 7/8 in. Pitch of rivets 1 1/2 in. Efficiency of joint 80 %
9. GIRTH JOINTS 7 Diameter rivet holes 7/8 in. Pitch of rivets 1 1/2 in. No. of courses 7  
 (Single or double riveted)
10. INNER SHELL 7/8 in. Style of seams: Longitudinal 7/8 Girth 7/8 Length of section or course 8 ft. 10-7/16 in.  
 (Thickness) (Riveted, Forge Welded, Brazed, or Fusion Welded—Par. No.)
11. HEADS: Flat or dished 0.77 in. Radius of dish Nil in. Side to pressure Concave  
 (Thickness) (Concave or convex)
- If removable, bolts used Nil or method of fastening Nil  
 (Number and size) (Describe or sketch)

STAYS	No.	Size	Net Area	Welded or Weldless	Area to be Stayed	Maximum Allowable Working Pressure
(a) F. H.	-	-	-	-	-	-
(b) R. H.	-	-	-	-	-	-
(c) Through	-	-	-	-	-	-
(d) Diagonal and Gusset Stays	-	-	-	-	-	-

13. STAY BOLTS: If hollow Nil Maximum pitch 1 1/2 in. Diameter 1/2 in.  
 (Iron or Steel) (Size of hole) (Horizontal) (Vertical) (Over the threads)
15. SAFETY VALVE outlets: No. 3 Size 1 1/2 in.
16. FUSIBLE PLUG (if used): No. Nil Diameter and material of filling Nil Location Nil
17. OUTLETS: No. 3 Size 1 1/2 in. Material of nozzle or reinforcement Steel How attached Welded  
 (Riveted, Welded, etc.)
18. DRAIN connection Nil in. HAND HOLES OR SIGHT HOLES Nil  
 (Size) (Number, size, and location)
19. MANHOLES: 1 18" 3' - 11-1/2" from head seam Reinforcement 0.96" pad welded to shell  
 (Number) (Size and location of each) (Riveted, Welded, etc.)
20. NONPRESSURE PARTS: (a) Supporting lugs 6 Supporting skirts Nil (b) Other nonpressure parts 15 ladder & plat clips  
 (c) Where and how attached 4 clips welded to head 4 shipping lugs  
7 clips welded to head 3 weather cover clips
21. Bursting pressure 1002 psi Hydrostatic test 400 lb 22. Constructed for pressure of 250 psi Factor of safety 4

REMARKS: 30,000 gal. propane storage tank. Hammer tested at 313#. Constructed to meet ASME 1950 code, section UW for 250# w.p., also complies with ASME 1947 code, para. U69 for 200# w.p. and para. U601 for 250# w.p.

Certificate of authorization expires 12/31/52

We certify the above data to be correct and that all details of material, construction, and workmanship on this unfired pressure vessel conform to the A.S.M.E. Code for Unfired Pressure Vessels.

1/19/52

Signed BETHLEHEM STEEL COMPANY  
 (Manufacturer)

*M. J. Smith*  
 M. J. Smith

BSCo. 2150

## CERTIFICATE OF SHOP INSPECTION

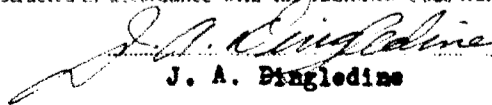
N.B. 1654

Insurance Company's Serial Number ..... **T-98-52-181**VESSEL MADE BY BETHLEHEM STEEL CO. at BETHLEHEM PA.

I, the undersigned, holding a certificate of competency as an inspector of steam boilers in THE STATE OF

..... Pennsylvania....., and employed by the TRAVELERS INDEMNITY CO.HARTFORD, CONN.

of....., inspected internally and externally, the vessel specified in this report, on.....

..... 8/19/52....., and certify that the statements made on this report are correct, corresponding with the mill test reports of material as furnished by the builders, and measurements made of the vessel when completed; and that this vessel is constructed in accordance with the A.S.M.E. Code Rules for the Construction of Unfired Pressure Vessels.


**J. A. Dingledine**

**N.B. 3352 Pa. 1627 Ohio 1349**  
 Inspector for State of Boiler Insurance Company.