

B.S.Co. Contr. SA-1409 for Phillips Petroleum Co. Order 3457
FORM U-1 MANUFACTURERS' DATA REPORT FOR UNFIRED PRESSURE VESSELS
 A. Required by the Provisions of the A.S.M.E. Code Rules

1. Manufactured by Bethlehem Steel Company, Bethlehem, Pa.
(Name and address of the manufacturer)

2. Manufactured for Wisconsin Public Service, Oshkosh, Wis.
(Name and address of the purchaser)

3. Type Horizontal Unfired Pressure Vessel No. (B.S.Co. 362) (Pat'l. No. 177) Year built 1947
(Horizontal or Vertical) (Mfr.' serial, or A.S.M.E. No.) (Class 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. 0 in.

6. STAMPS on shell plates: SA-212, 70,000 Rivets, stays, and braces Double Butt (Iron or steel) Double Butt
(Brand and Lowest Tensile Strength)

7. SHELL PLATES: 3/16 in. Butt straps 3/16 in. Style of seams: Longitudinal Fusion Welded, U-69 Double Butt
(Outer Thickness) (Thickness) (Riveted, Forge Welded, Samed, or Fusion Welded—Pat. No.)

8. DIAMETER of rivet holes 1 1/8 in. Pitch of rivets X Efficiency of joint 85
(Single or double riveted)

9. GIRTH JOINTS: Diameter rivet holes 1 1/8 in. Pitch of rivets X No. of courses 7
(Single or double riveted)

10. INNER SHELL: 3/16 in. Style of seams: Longitudinal Double Butt Length of section or course 8 ft. 10 3/16 in.
(Thickness) (Riveted, Forge Welded, Samed, or Fusion Welded—Pat. No.)

11. HEADS: Flat or dished 7/16 in. Radius of dish Elliptical Side to pressure Concave
(Thickness of head) (Concave or convex)

If removable, bolts used XXXX or method of fastening XXXX
(Number and size) (Description or sketch)

STAYS	No.	Size	Material	Welded or Riveted	Area to be Surveyed	Maximum Allowable Working Pressure
(a) F. H.						
(b) R. H.						
(c) Through						
(d) Diagonal and Gusset Stays						

13. STAY BOLTS: XXXX If hollow XXXX 14. Maximum pitch X Diameter XXXX
(Iron or Steel) (Size of hole) (Horizontal) (Vertical) (Over the threads)

15. SAFETY VALVE outlets: No. 0 Size XXXX

16. FUGING PLUG (if used): No. 0 Diameter and material of filling XXXX Location XXXX

17. OUTLETS: No. 0 Size XXXX Material of nozzle or reinforcement XXXX How attached XXXX
(Riveted, Welded, etc.)

18. DRAIN connection 2 in. HAND HOLDS OR SIGHT HOLDS XXXX
(Size) (Number, size, and location)

19. MANHOLES: 1 18" Dia. Top Reinforcement XXXX
(Number) (Size and location of each) (Riveted, Welded, etc.)

20. NONPRESSURE PARTS. (a) Supporting lugs XXXX Supporting skirts XXXX (b) Other nonpressure parts XXXX
(Number) (Kind and number)

(c) Where and how attached XXXX

21. Bursting pressure 1000 psi Hydrostatic test 400 lb 22. Constructed for pressure of 200 psi Factor of safety 5

Remarks: Vessel to be used for propane storage.
(Vessel to be used for air, gas, ammonia, etc.)
Hammer tested at 300 lb.

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.

Date April 29, 1947 Signed Bethlehem Steel Company by J. Pennington
(Manufacturer)

Certificate of authorization expires December 31, 1949.

CERTIFICATE OF SHOP INSPECTION

Insurance Company's Serial Number T-165-771-60

VESSEL MADE BY Bethlehem Steel Co. Pennsylvania, Pa.

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

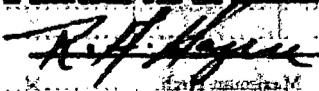
Pennsylvania and employed by the Western Iron and Foundry Co.

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

April

1927, and certify that the comments made on this report are correct, corresponding with the mill test reports of material as furnished by the builder, 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.

W.A. Hagen



N. Y. 1220

Inspector for State or Daily Insurance Company.