

**BSCo. CD7279 (T-4) for Skelly Oil Company**  
**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-98-52-253  
(Name and address of the manufacturer)
2. Manufactured for Skelly Oil Company, Mt. Pleasant, Michigan  
(Name and address of the purchaser)
3. Type Horizontal Unfired Pressure Vessel No. (BSCo. 2227) (N.B. 1726) Year built 1952  
(Horizontal or Vertical) (Mfrs. 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 C1. 2
6. STAMPS on shell plates A212 70,000 Rivets, stays, and braces Bolts-A193 Gr. B7  
(Brand and Lowest Tensile Strength) (Iron or steel)
7. SHELL PLATES 0.96 in. Butt straps 7 in. Style of seams: Longitudinal Double welded butt Girth Double welded butt  
(Plate Thickness) (Thickness) (Riveted, Forge Welded, Brazed, or Fusion Welded—Par. No.)
8. Diameter of rivet holes 7 in. Pitch of rivets 7 x 7 Efficiency of joint 80 %
9. GIRTH JOINTS 7 Diameter rivet holes 7 in. Pitch of rivets 7 in. No. of courses 7  
(Single or double riveted)
10. INNER SHELL 7 in. Style of seams: Longitudinal 7 Girth 7 Length of section or course 8 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 Ell in. Side to pressure Concave  
(Thickness) (Concave or convex)
- If removable, bolts used 7 or method of fastening 7  
(Number and size) (Describe or sketch)

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

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 & PRESSURE VESSEL INSPECTORS

13. STAY BOLTS: 7 If hollow 7 14. Maximum pitch 7 in.  
(Iron or Steel) (Size of hole) (Horizontal) (Vertical) (Other than through)
15. SAFETY VALVE OUTLETS: No. 6 Size 3/4 in.
16. FUSIBLE PLUG (if used): No. 1 Diameter and material of filling 3/4 in. Location 7
17. OUTLETS: No. 6 Size 1 1/2 in. Material of nozzle or reinforcement Steel How attached Welded  
(Riveted, Welded, etc.)
18. DRAIN CONNECTION: 7 in. HAND HOLDS OR SIGHT HOLDS 7  
(Size) (Number, size, and location)
19. MANHOLES: 1 18 in. 4'-2 1/2 in. from head seam Reinforcement 0.96 in. per. welded to shell  
(Number) (Size and location of each) (Riveted, Welded, etc.)
20. NONPRESSURE PARTS: (a) Supporting lugs 4 Supporting skirts 3 (b) Other nonpressure parts 4 ladders & plat. clips  
(Number) (Kind and number)  
 (c) Where and how attached 4 lugs & 3 clips welded to shell 3 shipping lugs  
7 clips welded to head 200 5
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 III for 250# w.p. and ASME 1949 code, para. UG-7 for 200# w.p., also complies with para UG-71 for 250# w.p. 3" nozzle proof tested.

Certificate of authorization expires 12/31/55

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 10/17/52

Signed BETHLEHEM STEEL COMPANY  
(Manufacturer)

M. T. Smith  
 M. T. Smith

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BSCo. 2227

### CERTIFICATE OF SHOP INSPECTION

N.B. 1726

Insurance Company's Serial Number... T-98-52-253

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.....

10/17/52, 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. Dingle*  
J. A. Dingle

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