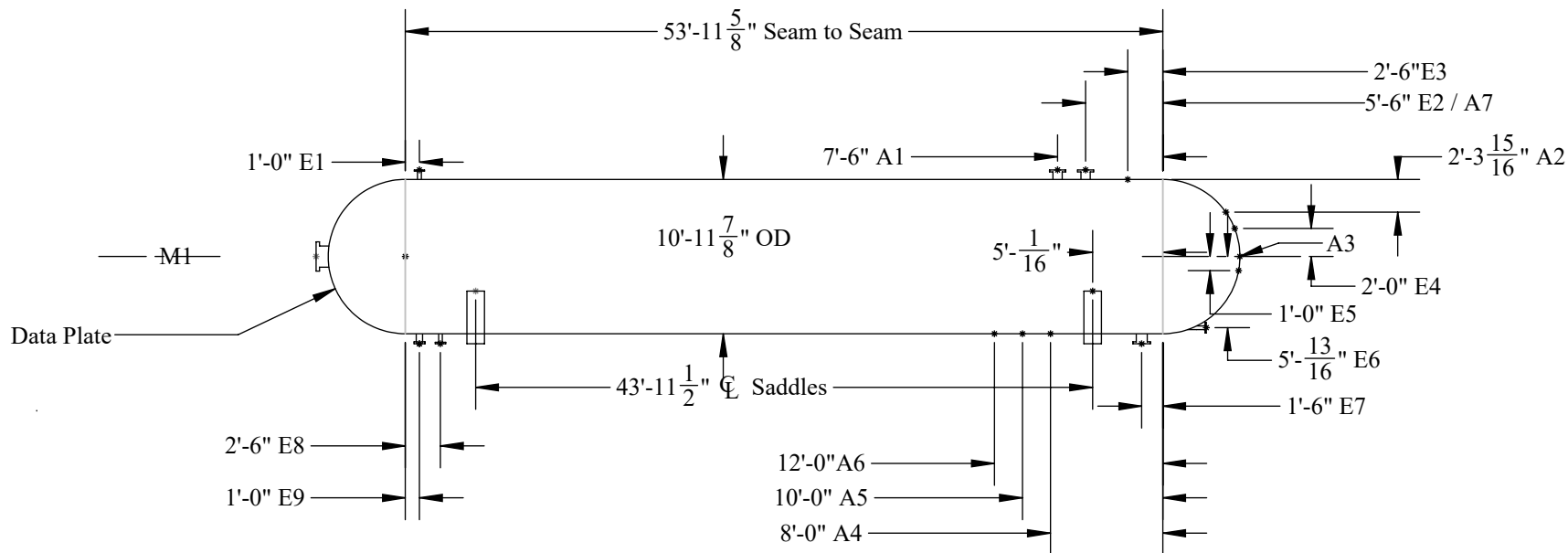




Existing Nozzles

M1 18" 150# Manway
 E1 2" 150# RFLWN
 E2 4" 150# RFLWN
 E3 1" 6,000# Half Coupling
 E4 1/2" 6,000# Half Coupling
 E5 3/4" 6,000# Half Coupling
 E6 2" 150# RFLWN
 E7 6" 150# RFLWN
 E8 2" 150# RFLWN
 E9 3" 150# RFLWN

Installer to blind for service
Replace flange with 4" 300# SA-105 RFWN
Installer to plug for service
Installer to plug for service
Installer to plug for service
Installer to install fabricated thermowell (Sheet 4)
Installer to plug for service
Installer to plug for service
Installer to plug for service

Added Nozzles

A1 4" 300# SA-105 RFHB
 A2 3/4" NPT 6,000# SA-105 Half Coupling
 A3 2-1/2" NPT 6,000# SA-105 Half Coupling
 A4 3" NPT 6,000# SA-105 Half Coupling
 A5 3" NPT 6,000# SA-105 Half Coupling
 A6 3" NPT 6,000# SA-105 Half Coupling
 A7 4" 300# SA-105 RFWN

Pressure Relief
85% Fill/Pressure Gauge
Liquid Level Gauge
Liquid Outlet
Liquid Inlet / Pump Return
Vapor Standpipe Port (Installer provided*)
Pressure Relief

*See sheet 4

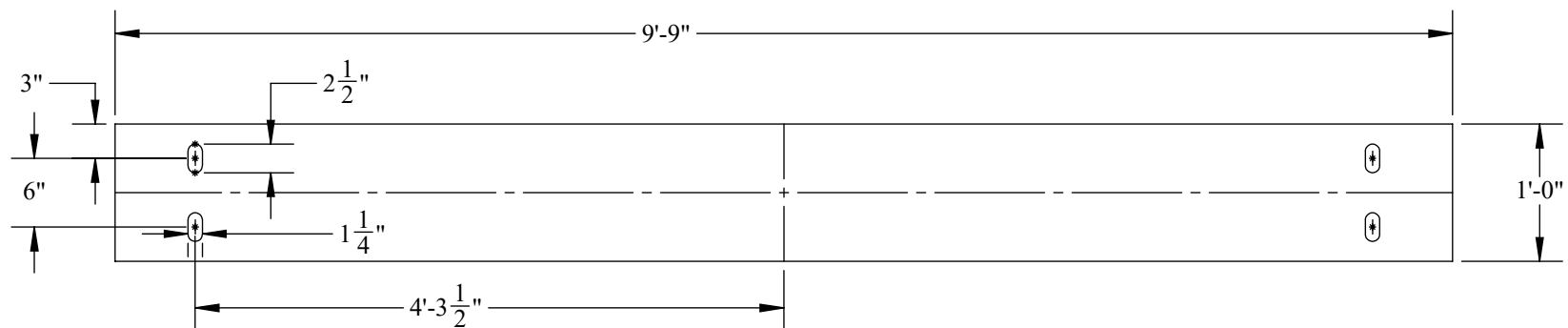
Vessel Information

Manufacturer	AMF Beaird	Max. Temp.	100°F (1966)
MAWP	250 psi	143770-1	143770-2
Manufacturer's Serial Number	81662	143770-6	143770-7
National Board Number	81663	81667	81668
Stress Relieved	Required after alterations are complete		
Shell Radiography	Complete, Joint Efficiency 100%, SA-212B Flange 70,000 psi Tensile		
Head Radiography	Complete, Joint Efficiency 100%, SA-455B Flange 73,000 psi Tensile		
Shell Thickness	15/16 inch	ID	130"
Head Thickness	.528 inch	Int. Rad.	65.02"
Estimated weight	90k lbs		
Shipping dimensions	x' " x'		



(4) AMF Beaird
 42,000 gallon capacity
 LP - NH3 Alteration
 TE Job Number ---

SIZE A	25-PW-01-1	
	1/8/25	SHEET 1 OF 4

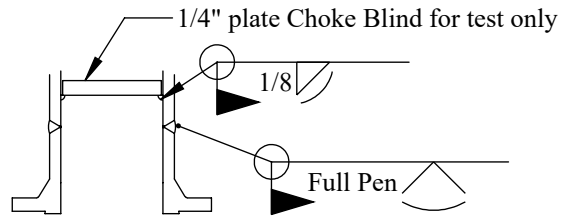


Both saddle foot plates are identical
Saddle Dimensions have not been field verified

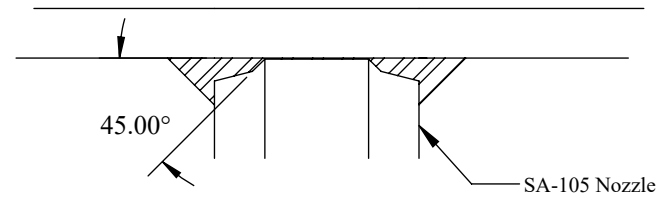


(4) AMF Beaird (Whitecourt AB)
 Saddle Foot Plate Measurements
 42,000 Gallon Capacity
 TE Job Number ---

SIZE A	25-PW-01-1	
	1/8/25	SHEET 2 OF 4



Nozzles (Note 1 and 2) weld details
 Remove Choke Blind after pressure test
 Grind choke blind and back of root pass smooth



Nozzles A1 through A6 weld details

Nozzle	Size	Rating	Type	ID	OD	Ext. Proj.	Int. Proj.	Ext. Fillet	Int. Fillet	Pad OD	Pad Th.	Pad Fillet	Notes
E2 / A7	4"	300	RFWN	3.826	4.5	6	0	-	-	-	-	-	
A1	4"	300	RFHB	3.83	6.62	6	0	.5	-	-	-	-	
A2	3/4" NPT	6,000	HC	.78	1.75	1	0	.25	-	-	-	-	
A3	2-1/2" NPT	6,000	HC	2.5625	3.625	1.8125	0	.375	-	-	-	-	
A4	3" NPT	6,000	HC	3.125	5	2.125	0	.375	-	-	-	-	
A5	3" NPT	6,000	HC	3.125	5	2.125	0	.375	-	-	-	-	
A6	3" NPT	6,000	HC	3.125	5	2.125	0	.375	-	-	-	-	

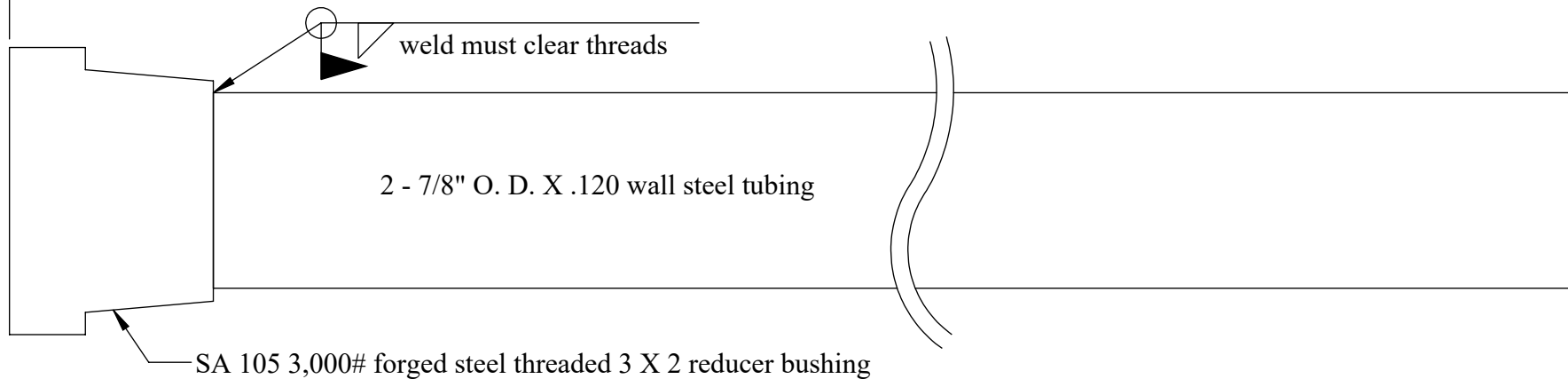
1. Weld with 70,000 psi tensile low hydrogen electrode
2. Electrode oven required
3. Weld new nozzles in place before cutting penetrations
4. Dye Penetrant Examination required before pressure testing
5. Pneumatic pressure test to 313 psi
6. Drill or torch cut holes to interior after pressure test is complete
7. Finished holes must be round and smooth with no torch gouges



(4) AMF Beaird 42,000 gallon
 LP - NH3 Storage
 Nozzle Weld Details
 TE Job Numbers ---

SIZE A	25-PW-01-1	
	1/8/25	SHEET 3 OF 4

Overall Length = 10' 8"



Align reducer and pipe coaxially

Start a 3" 3,000# threaded coupling after completion to make sure welds do no interfere with threads

The 3" coupling is an inspection tool only, not to be shipped with standpipe

Pressure test 30 psi when finished

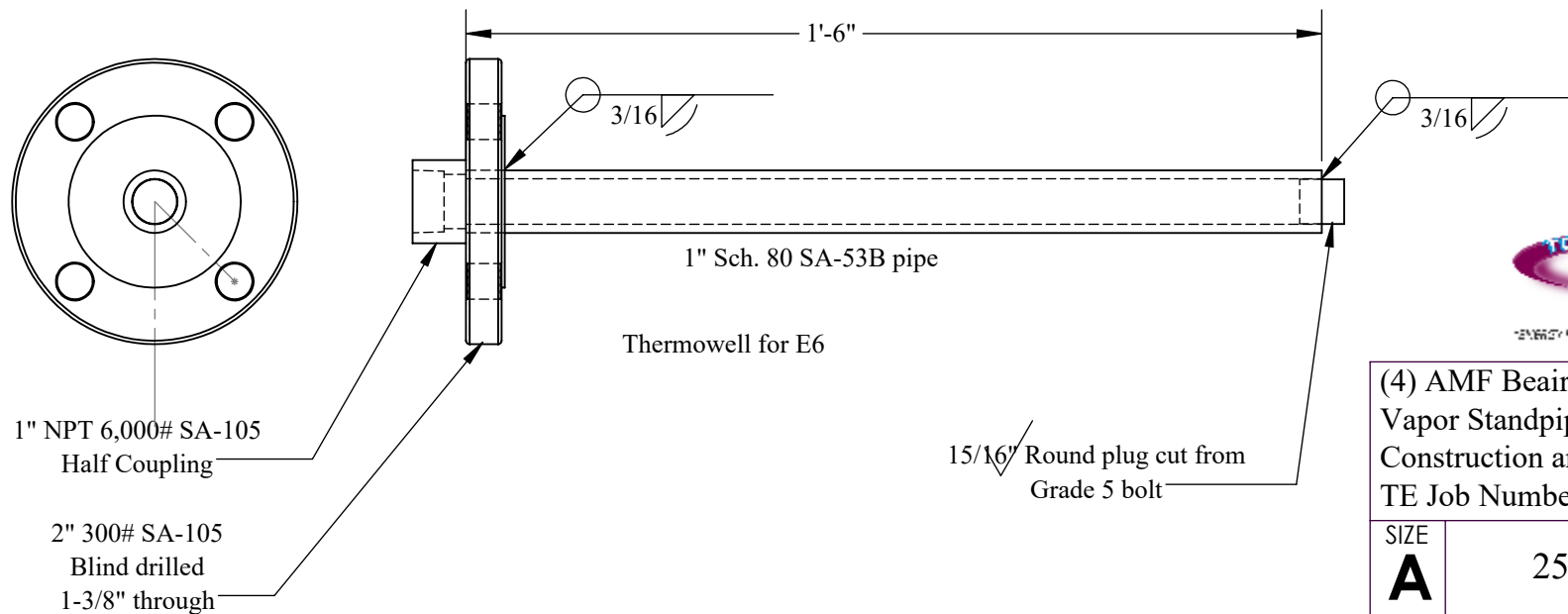
Installation by customer (install standpipe before setting on piers):

Clean 2" NPT threads with wire brush

Apply thin layer of pipe dope, wrapped with Teflon tape on threaded portion

Install one 6' piece of 2" NPT threaded pipe into reducer to facilitate starting into nozzle

Tighten securely to ensure no leaks



(4) AMF Beaird Alterations
Vapor Standpipe and Thermowell
Construction and Weld Details
TE Job Number ---

SIZE A	25-PW-01-1	
	1/8/25	SHEET 4 OF 4