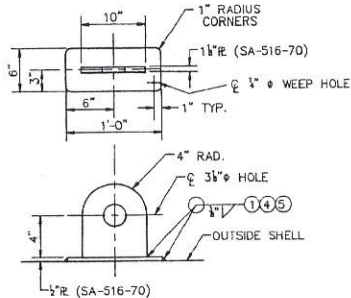
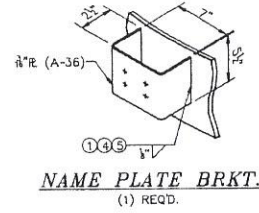


LIFTING LUG DETAIL
(2) REQD 180° APART

SHOP/FIELD NOTE
USE SPREADER BAR DURING ALL LIFTING OPERATIONS.



TAIL LUG DETAIL
(1) REQD

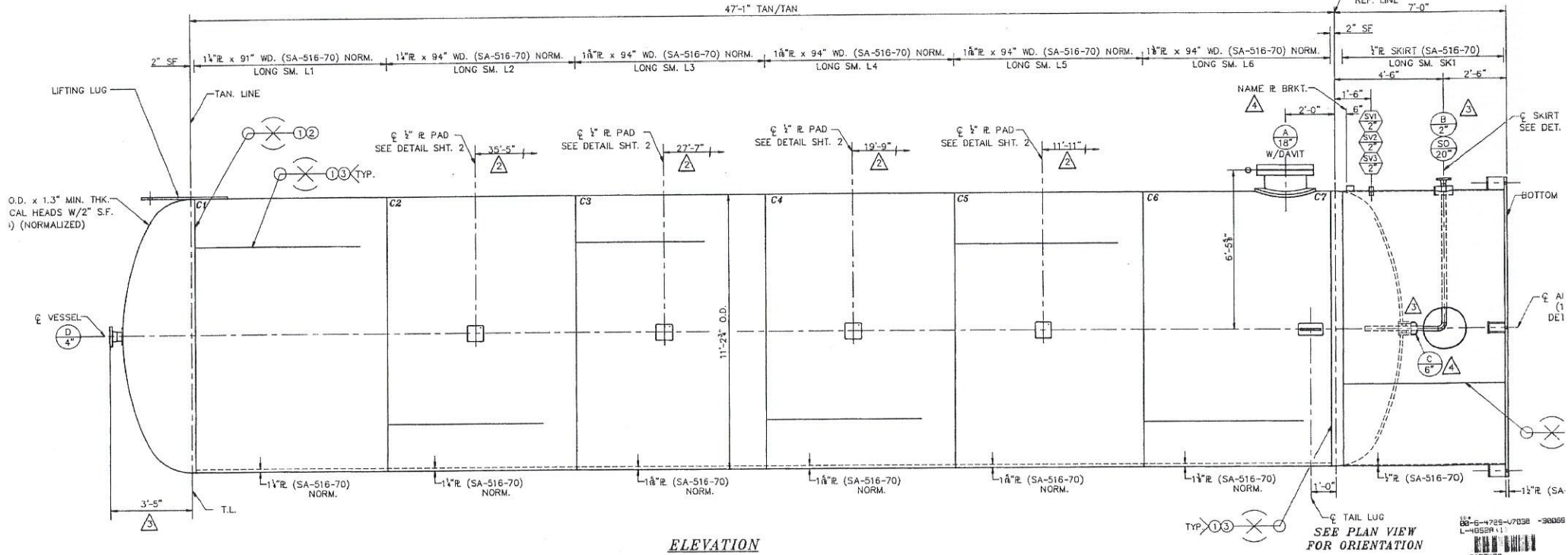


NAME PLATE BRKT.
(1) REQD.

WELDING PROCEDURES	
1	1.01
2	4.01
3	4.10
4	2.0B
5	3.01
6	5.03
7	1.04
8	1.05

	NAT'L BD NO	
	CERTIFIED BY	
	Modern Welding Company	
	of Owensboro, Inc.	
OWENSBORO, KENTUCKY		
MAWP	300	PSI AT 2
MIN DESIGN METAL TEMP	-20	°F AT
MFG'S NO	8644A	YEAR BUILT
VACUUM		PSI AT
EST. WT. EMPTY	110,000	LBS.
ITEM#	V703B (B644A)	
P.O. NO.:	OD-30069	PROJECT NO. OD-

STD STAINLESS STEEL NAME PLATE



ELEVATION

SEE PLAN VIEW FOR ORIENTATION

FINISH 125-250 AARB

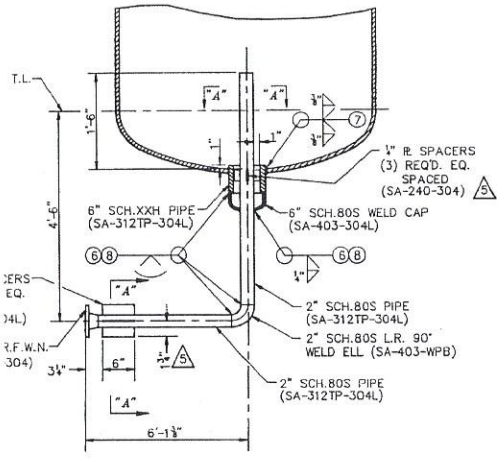
SIZE	SERIES	DESCRIPTION	DA.	DESCRIPTION	THK	WIDTH	TYPE	DIM. "X"	WELD A	WELD B	WELD C	WELD D	WELD E	WELD F	Y	N	THK	DESCRIPTION	NO.	TYPE	DIA.	LENGTH	REMARKS
18"	300#	R.F.L.W.N.	18" ID	1 1/2" WALL	1 1/2"	4 1/2" WD.	6								Y			FLEXITALLIC	24	STUD	1 1/2"	7 3/4" LG. W/(2) NUTS	MANWAY W/DAVIT
2"	300#	R.F.W.N.		SCH. 80S PIPE			9								N								INLET / OUTLET
4"	300#	R.F.W.N.		SCH. 120 PIPE	3/4"	2" WD.	6								N								VENT
6"		SEE DETAIL		SCH. XXH PIPE																			SUMP

SEE GENERAL NOTES & PLAN VIEW ON SHT. 2

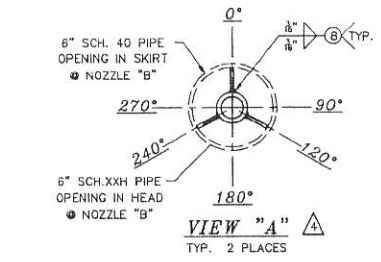
FLANGE OR CPLG	NECK	REINF. PAD	ATTACHMENTS	BLD	GASKET	BOLTING	REMARKS						
TYPE 2	TYPE 3	TYPE 4	TYPE 5	TYPE 6	TYPE 7	TYPE 8	TYPE 9	TYPE 10	 FOR PROJ. SEE ELEV.			VARIOUS TYPES OF OPENINGS	

NO. REQ'D	ONE (1)	ITEM NO.	V703
ST	BS	AS BUILT	1/21 1998
ST	BS	ADDED ITEM "C" TO NOZZLE SCH. MOVED NAME PLATE BRKT.	1/16 1998
ST	BS	REVISED WELD PROC. REVISED NOZZLE B REVISED PROJECTION @ NOZZLE "D"	1/5 1998
ST	BS	REVISED REPAD ELEVATIONS	12/4 1997
ST	BS	FINAL CERTIFIED	11/19 1997
BY	AP	REVISION	DATE NO

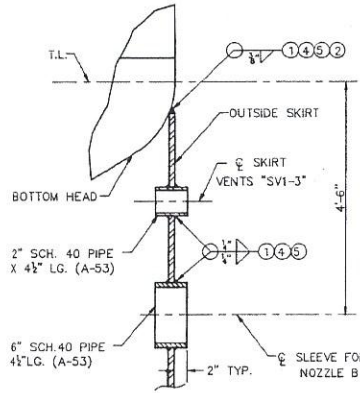
NO. REQ'D	ONE (1)	ITEM NO.	V703
modern welding company of owens			
P.O. Box 1450 1450 E. Parrish Ave. Owensboro, KY. 42302			Plate Fa Div. (502) 6
AIR PRODUCTS and CHEMICALS SALISBURY-PURDUE FARA			
11'-2 1/2" O.D. x 47'-1" TAN/TAN VERTICAL PRODUCT	DWN. BY	DATE	10-28-97
SCALE	NON		
CHK. BY	JLJ	JOB NO.	8644 A
DWG. NO.	L-4		
APR. BY	JLJ	P.O. NO.	OD-30069
SHT. NO.	1		



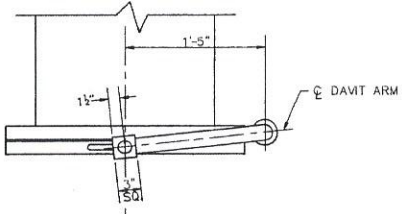
NOZZLE B DETAIL (A)



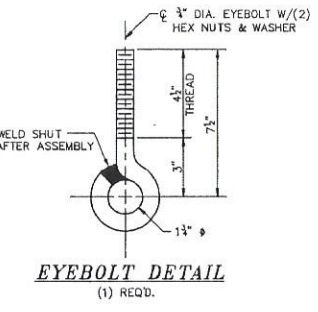
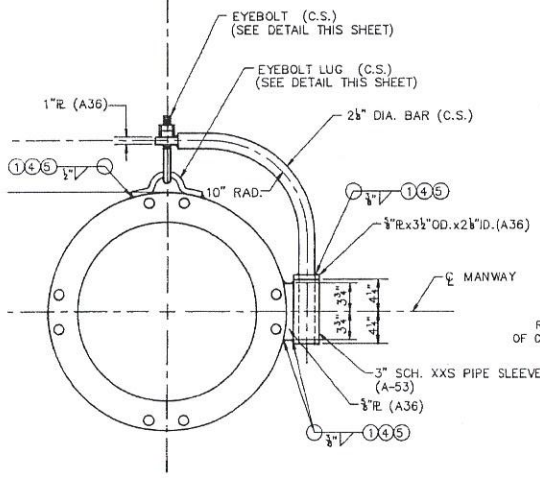
VIEW "A"
TYP. 2 PLACES



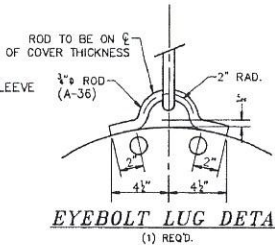
SKIRT / HEAD & SKIRT OPENING DETAIL



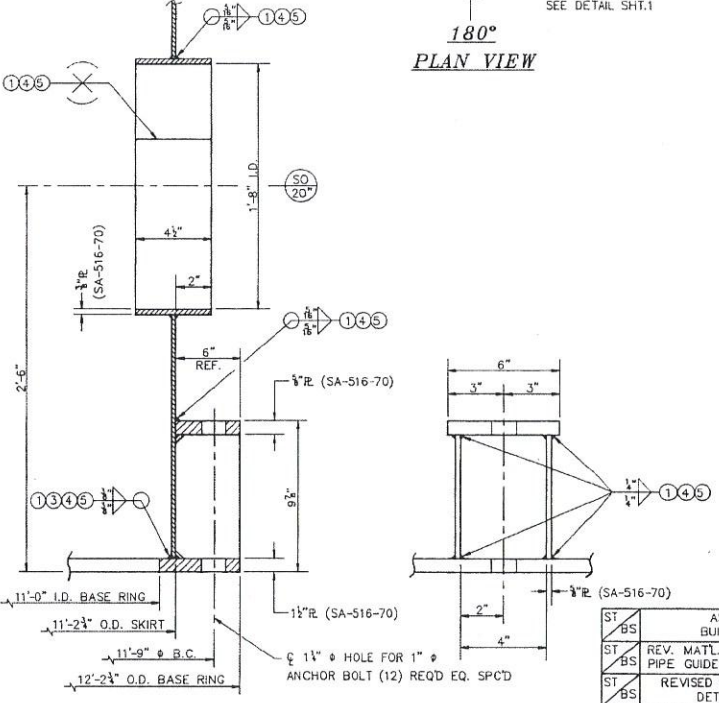
18\"/>



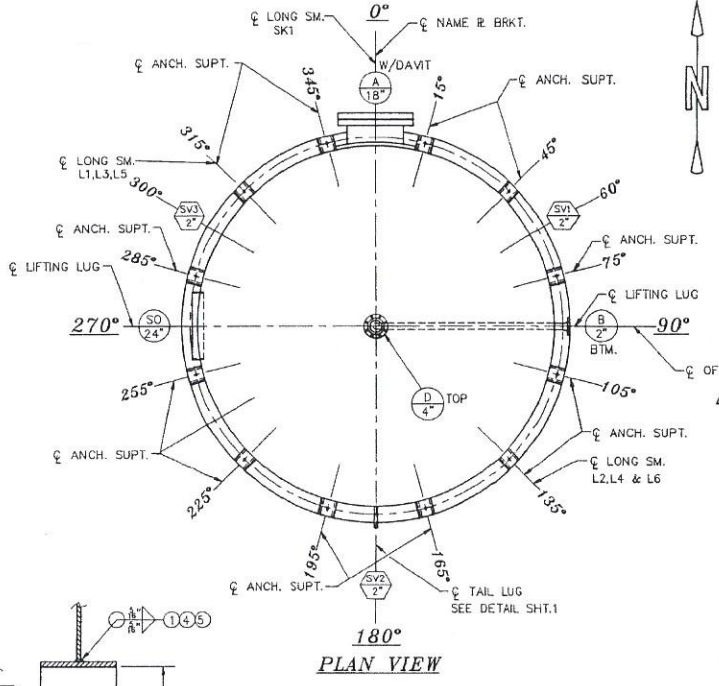
EYEBOLT DETAIL
(1) REQ'D.



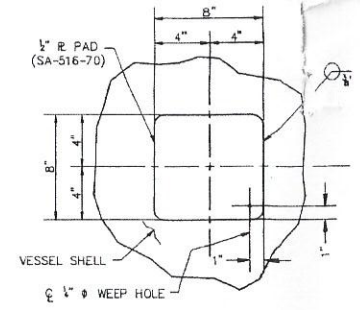
EYEBOLT LUG DETAIL
(1) REQ'D.



ANCHOR CHAIR DETAIL
(12) REQ'D



180\"/>



DETAIL OF PADS
(4) REQ'D.

GENERAL NOTES
 CONSTRUCTION PER ASME SECT VIII, DIV 1, '95 EDITION, '96 ADD. CODE SYMBOL IS REQ'D.
 MIN DESIGN METAL TEMP: F -20 AT 300 PSI
 DESIGN PRESSURE: INT 300 PSI EXT PS
 DESIGN TEMPERATURE: INT 200 F EXT F
 JOINT EFF: 100% STRESS RELIEF IS NOT REQ'D.
 RADIOGRAPH: FULL CORROSION ALLOWANCE: 1/8"
 VESSEL HYDROSTATIC TEST: 450 PSIG
 INSPECTION BY H.S.B.I. & I. INSP. AND CUSTOMER.
 MATERIAL SHELL: SA-516-70 NORM. HEADS: SA-516-70 NORM.
 REPADS: SA-516-70 NORM.
 FLANGES: SA-105/SA-182F-304L PIPE SA-106B/A-S3/SA-31 SUPPORTS: SA 516 70 NORM.
 EXT BOLTING: SA-193-B7 NUTS: SA-194-2H
 GASKETS: FLEXITALIC STYLE CO. 316L SS WINDINGS W/ FLEXICAF FILLER AND CARBON STEEL GAGE RING
 SANDBLAST EXT: SSPC-SP6 COMMERCIAL BLAST PAINT:
 APPLY DUPONT #25P (GRAY) TO A D.F.T. OF (8) MILS. TO W/ (2) COAT OF DUPONT MURON #333 (WHITE) TO A D.F.T. OF 11-PER COAT. TOTAL D.F.T. OF PAINT ON VESSEL = (11-12) MILS.

SHIPPING COVERS: 1/2" PLYWOOD W/BOLTS
 ALL NOZZLES AND MANWAY BOLT HOLES TO STRADDLE NORMAL CENTER LINES OR THEIR PARALLEL LINES UNLESS OTHERWISE NOTED.
 MATERIAL TEST REPORTS: ARE REQ'D.

EST WT EMPTY: 110,000 LBS
 EST WT FULL OF WATER: 411,355 LBS
 CUSTOMER STANDARDS:
 API SPEC. NO. 6-4729-4703B/C-0001
 REF DWGS:

SHOP NOTES
 1. INTERIOR SHALL BE POWER TOOL CLEANED.
 2. ONE SPARE GASKET SHALL BE PROVIDED FOR MANWAY.
 3. ALL ATTACHMENT WELDS SHALL CLEAR SEAM WELDS BY 1/8" LEA (2) PLATE THICKNESSES. IF UNAVOIDABLE, THE SEAM WELD SH. BE GROUND FLUSH & RADIOGRAPHICALLY EXAMINED BEFORE THE ATTACHMENT.
 4. VESSEL SHALL BE SHIPPED W/LIFTING LUGS IN THE HORIZONTAL & TAILING LUG FACE UP.

NO. REQ'D ONE (1)		ITEM NO. V703	
ST	AS BUILT	1/21	1998
ST	REV. MATL. GRADE PIPE GUIDES NOZZ. B	1/12	1998
ST	REVISED NOZZ. B DETAIL	1/5	1998
ST	LOCATED REPADS IN PLANVIEW	12/4	1997
BS	ADDED NOTES 3 & 4	11/24	1997
ST	FINAL CERTIFIED	11/20	1997
BY	REVISION	DATE	NO

modern welding company of owens!
 P.O. Box 1450
 1450 E. Parrish Ave.
 Owensboro, KY. 42302

AIR PRODUCTS and CHEMICALS, SALISBURY-PURDUE FARMS
 11'-2 1/2" O.D. x 47'-1" TAN/TAN VERTICAL PRODUCT

DWN. BY: JAJ DATE: 10-29-97 SCALE: NON
 CHK. BY: JJS JOB NO. 8544 A DWG. NO. L-1
 APR. BY: JJS P.O. NO. OD-30069 SHT. NO. 2