

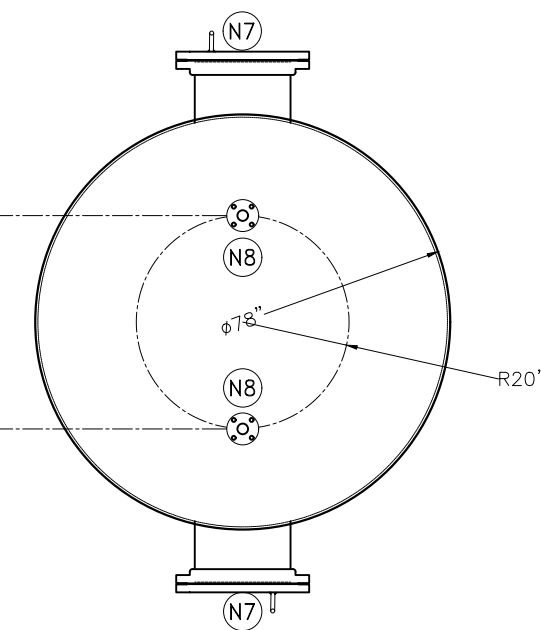
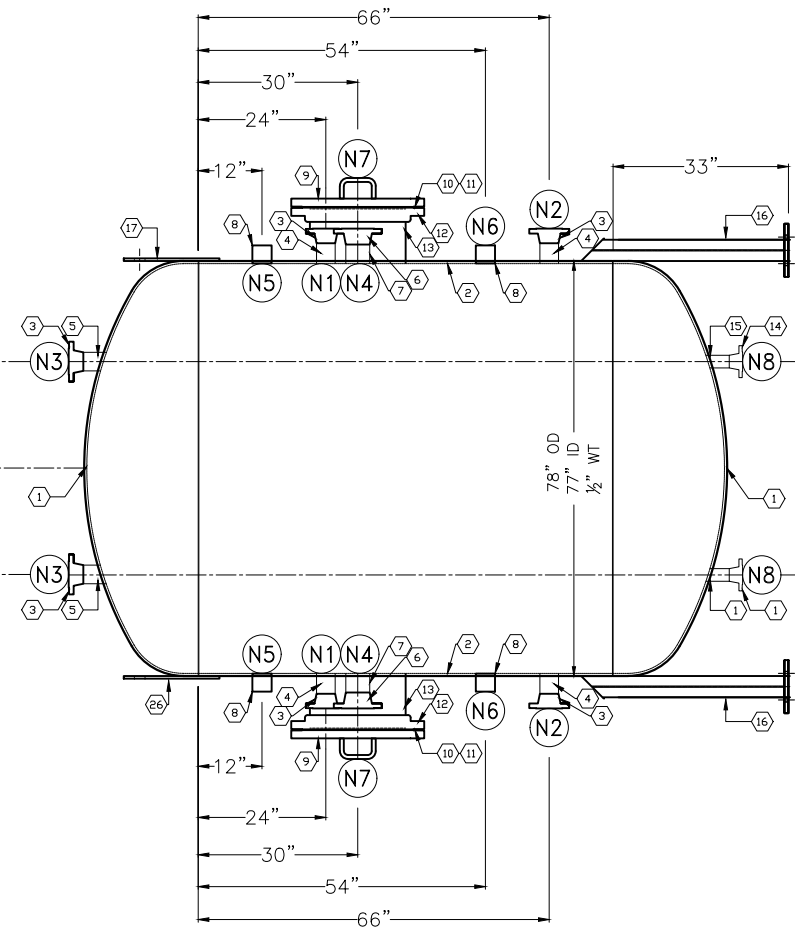
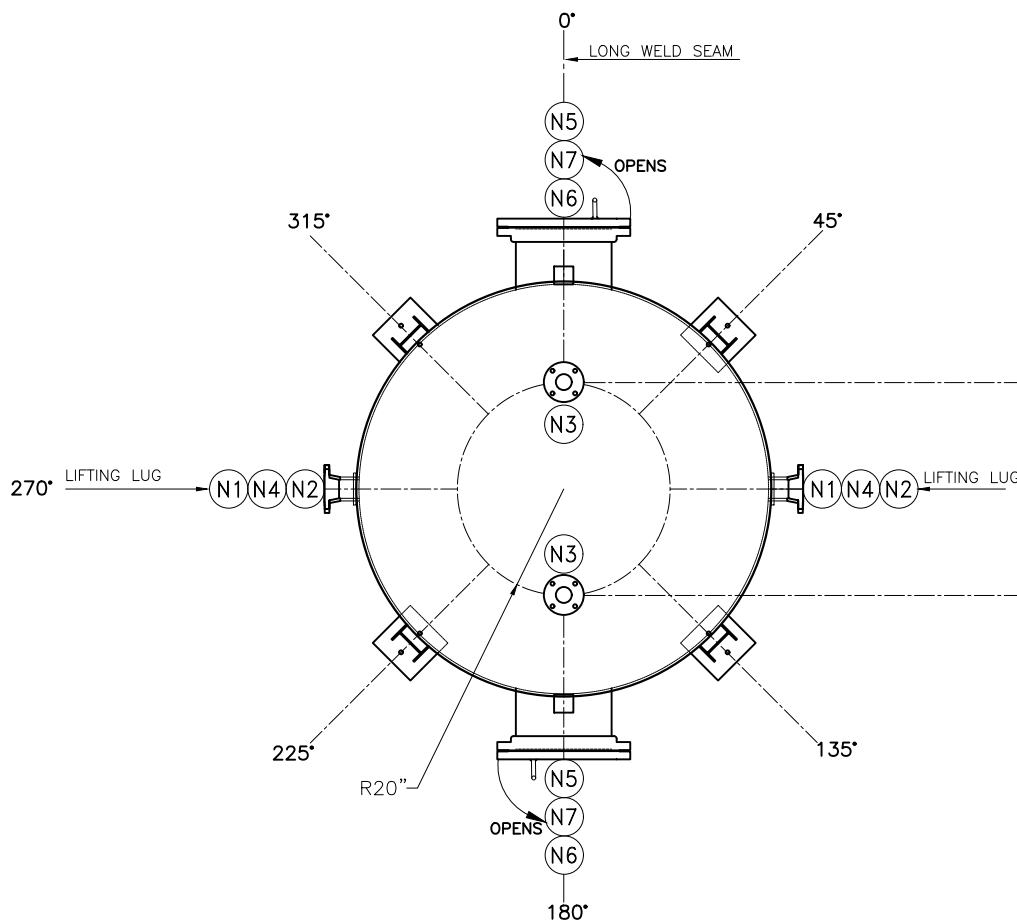
- NOTES:
1. FLANGE BOLT HOLES TO STRADDLE VESSEL CENTERLINES.
  2. DIMENSIONAL TOLERANCES SHALL BE AS PER VEFV 1102.
  3. GROOVE AND FILLET WELDS TO BE DYE PENETRANT TESTED PER ASME SEC VIII DIV 1
  4. FULL PENETRATION WELDS SHALL BE DP/MP TESTED (MP PREFERRED) AT BACK CHIPPED AND FINISHED WELD SURFACES AFTER HYDRO TEST.
  5. WELD PROCEDURE: SPSGMFCSAWPI/SPSGMFCPI-1
  6. DRILL AND TAP 1/8" N.P.T. HOLE IN REINFORCING PADS.

BILL OF MATERIAL

NO	QTY	UNITS	DESCRIPTION	MATERIAL SPEC
1	2	EA	77" ID 2:1 ELLIP HEAD, 1/2" NOM THK (1/16" MIN) W/ 2" SF 30° O/S BEVEL AND 1/16" LAND	SA-516-GR70
2	1	EA	77" ID x 1/2" THK x 77 1/16" L ROLLED AND TACKED SHELL W/ 30° O/S BEVEL, 1/16" LAND @ ENDS AND LONG SEAM, WELD GAP 3/16"	SA-516-GR70
3	6	EA	3" 150# RFWN FLG, SCH -, 125-250 micro-in.	SA-105
4	4	EA	NPS 3 SCH - SMLS PIPE, CUT LENGTH 3 1/16"	SA-106B
5	2	EA	NPS 3 SCH - SMLS PIPE, CUT LENGTH 4 3/16"	SA-106B
6	2	EA	4" 150# RFWN FLG, SCH -, 125-250 micro-in.	SA-105
7	2	EA	NPS 4 SCH - SMLS PIPE, CUT LENGTH 3 3/8"	SA-106B
8	4	EA	NPS 2 6000# THRD CPLG	SA-105

BILL OF MATERIAL

NO	QTY	UNITS	DESCRIPTION	MATERIAL SPEC
9	2	EA	18" RF BLD FLG W/HINGE AND HANDELS (SEE DET. PAGE)	SA-105
10	2	EA	NPS 18 .145" THK 150# FLEXITALLIC SOLID METAL CORE FLEXPOR FACING; NON-ASBESTOS FIBER; METAL; NICKEL (ASME B16.20 KAMMPROFILE) GASKET	
11	32	EA	1 1/8" SERIES 8 BOLTS, 4.8" LONG W/ NUTS AND WASHERS	SA-193 B7
12	2	EA	18" 150# RFSO FLG, 125-250 micro-in.	SA-105
13	2	EA	NPS 18 SCH - SMLS PIPE, CUT LENGTH 11 7/16"	SA-106B
14	2	EA	2" 150# RFWN FLG, SCH -, 125-250 micro-in.	SA-105
15	2	EA	NPS 2 SCH - SMLS PIPE, CUT LENGTH 4 7/16"	SA-106B
16	4	EA	LEG SUPPORT (SEE DETAIL PAGE)	SA-106B
17	2	EA	LIFTING LUGS (SEE DETAILS THIS PAGE)	SA-36



W  
RT-3

MAWP  PSIG @  °F  
 MDMT  °F @  PSIG  
 MAWP (EXT)  °F @  PSIG

MFG S/N  YR BUILT

HYDROSTATIC TEST  PSIG  
 CORROSION ALLOWANCE

DESIGN DATA

CONSTRUCTION IN ACCORDANCE WITH 2017 EDITION OF A.S.M.E. CODE SECTION VIII DIVISION 1 (ADDENDA)

CODE STAMP  YES  REQ'D.

DESIGN PRESS. (INT)  P.S.I.G. TEMP.  °F  
 DESIGN PRESS. (EXT)  P.S.I.G. TEMP.  °F

M.A.W.P.  P.S.I.G. LIMITED BY   
 M.A.P. (N.&C.)  P.S.I.G. LIMITED BY

HYDROSTATIC TEST (N.&C.)  P.S.I.G.  
 CORROSION ALLOW. SHELL 1/8" HEAD 1/8" NOZZ. 1/8"

P.W.H.T. (STRESS RELIEVE)  N/A MINUTES  N/A °F  
 RADIOGRAPH RT-3 JOINT EFF. 85 %

INSPECTION BY  CODE INSPECTOR

EST. WEIGHT EMPTY  LBS.  
 EST. OPERATING WEIGHT  LBS.  
 EST. WEIGHT FULL OF WATER  LBS.

MARK	REQUIRED	NPS SIZE	RATING AND TYPE	SERVICE	SEAMLESS PIPE SPEC	FLANGE	NECK SCHEDULE	PROJECTION OUT INCLUDING RF	PROJECTION IN	REINFORCEMENT PAD SIZE OD x THK	WELD DETAIL NUMBER	41	R41	43	R43	44	45	BOM ITEM NO.'S
N1	2	3"	150# RFWN	PROCESS IN	SA 106B	SA105	-	6"	FLUSH	-	VI,XII	7/16	1 1/8	3/8	1 3/16	-	-	3,4
N2	2	3"	150# RFWN	PROCESS OUT	SA 106B	SA105	-	6"	FLUSH	-	VI,XII	7/16	1 1/8	3/8	1 3/16	-	-	3,4
N3	2	3"	150# RFWN	GAS OUT	SA106B	SA105	-	6"	FLUSH	-	X	7/16	1 1/8	-	-	-	-	3,5
N4	2	4"	150# RFWN	SG	SA 106B	SA105	-	6"	FLUSH	-	X	9/16	1 13/16	-	-	-	-	6,7
N5	2	2"	3000# THRD CPLG	LSH	SA 105	-	-	2 1 3/16"	FLUSH	-	V,X	7/16	1 1/8	-	-	-	-	8
N6	2	2"	3000# THRD CPLG	LSL	SA 105	-	-	2 1 3/16"	FLUSH	-	V,XII	7/16	1 1/8	3/8	1 3/16	5/16	3/8	8
N7	2	18"	150# RFSO	MW	SA 106B	SA105	-	10"	FLUSH	-	VIII	3/8	-	-	-	-	-	9,10,11,12,13
N8	2	2"	150# RFWN	DRAIN	SA 106B	SA105	-	6"	FLUSH	-	VIII	3/8	-	-	-	-	-	14,15

NO.	BY	REVISION	DATE	CHECK APPR BY
A	BT	FIRST DRAFT	9-18-18	KK
B				
C				
1				
2				
3				
4				
5				