



FABRICATION NOTES

- ALL WELDS TO BE BY MEANS OF PLASMA / TIG, MIG & MMA.
- THE SHELL, DISHED END & CONE AND ALL PARTS IN CONTACT WITH THE CONTENTS OF THE TANK SHALL BE OF STAINLESS STEEL.
- DESIGN CODE IS ASME SECTION VIII DIVISION 1 (WHERE APPLICABLE).
DESIGN TEMPERATURE: -20°C TO +150°C
WORKING PRESSURE: ATMOSPHERIC
DESIGN PRESSURE: 0.1 bar
- ALL CORNERS & SHARP EDGES TO BE ROUNDED OFF. VESSEL SEAMS MACHINE WELDED, CHEMICALLY CLEANED AND RINSED.
FINAL FINISH ON ALL GROUND AREAS TO BE NOT COARSER THAN 180 GRIT.
- WELDS INSPECTED TO ASME SECTION VIII DIVISION 1.
- SPOT RADIOGRAPHY REQUIRED ON ALL SHELL JOINTS PLUS SOME T-JOINTS. HEADS 100% IF FABRICATED FROM TWO PLATES.
- HYDRAULIC TEST CERTIFIED BY APPROVED INSPECTION AUTHORITY.
- VESSEL MATERIALS:-

SHELL:-
4.0mm THK STAINLESS STEEL TO EN 10028-7 1.4401/1.4404
MAX. CARBON CONTENT - 0.03%
GUARANTEED MIN UTS @ 20°C - 530 N/mm²
0.2% PROOF STRESS @ 20°C - 240 N/mm²
0.2% PROOF STRESS @ 150°C - 152 N/mm²
1.0% PROOF STRESS @ 20°C - 270 N/mm²
1.0% PROOF STRESS @ 150°C - 181 N/mm²
MIN ELONGATION - 40%
PLATE FINISH AS SUPPLIED 2B

END & CONE:-
5.0mm THK STAINLESS STEEL TO EN 10028-7 1.4401/1.4404
MAX. CARBON CONTENT - 0.03%
GUARANTEED MIN UTS @ 20°C - 530 N/mm²
0.2% PROOF STRESS @ 20°C - 240 N/mm²
0.2% PROOF STRESS @ 150°C - 152 N/mm²
1.0% PROOF STRESS @ 20°C - 270 N/mm²
1.0% PROOF STRESS @ 150°C - 181 N/mm²
MIN ELONGATION - 40%
PLATE FINISH AS SUPPLIED 2B

SECTION E-E
TYPICAL FOUR PLACES

SECTION C-C

VIEW ON ARROW 'D'

PORT No.	PORT SIZE	PIPE SIZE	PORT DESCRIPTION
N1	DN50 PN 16	2" NB SCH.40 (3.9 WALL)	WATER INLET
N2	DN100 PN 16	4" NB SCH.10 (3.05 WALL)	ODDOR SCRUBBER
N3	600mm I/DIA	N/A	MANWAY
N4	DN100 PN 16	4" NB SCH.10 (3.05 WALL)	FEEDSTOCK INLET
N5	DN100 PN 16	4" NB SCH.10 (3.05 WALL)	PRESSURE BALANCE
N6	1" BSP (F)	N/A	REGIRC INLET
N7	DN150 PN 16	6" NB SCH.40 (7.1 WALL)	REGIRC OUTLET
N8	DN200 PN 16	8" NB SCH.10 (3.76 WALL)	REGIRC INLET
N9	DN200 PN 16	8" NB SCH.10 (3.76 WALL)	REGIRC INLET
N10	DN200 PN 16	8" NB SCH.10 (3.76 WALL)	REGIRC INLET
N11	1/2" BSP (F)	N/A	TEMPERATURE PROBE
N12	DN50 PN 16	2" NB SCH.40 (3.9 WALL)	FEEDSTOCK OUTLET
N13	1/2" BSP (F)	N/A	LEVEL SENSOR
N14	600mm I/DIA	N/A	MANWAY
N15	DN100 PN 16	4" NB SCH.10 (3.05 WALL)	SPARE
N16	DN100 PN 16	4" NB SCH.10 (3.05 WALL)	SPARE
N17	1" BSP (F)	N/A	SAMPLE POINT

ITEM No.	QUANTITY	MATERIAL	DESCRIPTION	PART/DRAWING No.
1	1	STAINLESS STEEL 316	TOP DISHED END ASSY	B7897/15 LH
2	1	STAINLESS STEEL 316	SHELL SECTION ASSY	B7899/15 LH
3	1	STAINLESS STEEL 316	BOTTOM CONE ASSY	B7898/15 LH
4	2	STAINLESS STEEL 304	LIFTING LUG DOUBLER - 5 THK	B7899/15 LH ITEM 4
5	2	STAINLESS STEEL 304	LIFTING LUG - 10 THK	E4840/09
6	4	STAINLESS STEEL 304	SUPPORT LEG DOUBLER - 5 THK	E6937/15
7				
8				
9				

CUSTOMER		TITLE	
JOB No.	SCALE	DRN.	PB
142 ENERGY33KX15_108V VESSEL ASSEMBLY.LH	1:20	21 DEC 15	
CAD FILENAME		DRAWING No.	
I\2 ENERGY\33KX15_108V VESSEL ASSEMBLY.LH		B7899/15 LH	
MOD. BY		VESEL ASSEMBLY	
		35,000 LITRE	

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UNSPECIFIED
TOLERANCES (mm)
0-2500 ±2.0
2501-5000 ±4.0
5001-11000 ±6.0

DO NOT SCALE
IF IN DOUBT, ASK
CAD DRAWING - DO NOT
ALTER MANUALLY

REVISION	DATE	NEW DRAWING	MOD. BY
0	21.12.15		

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