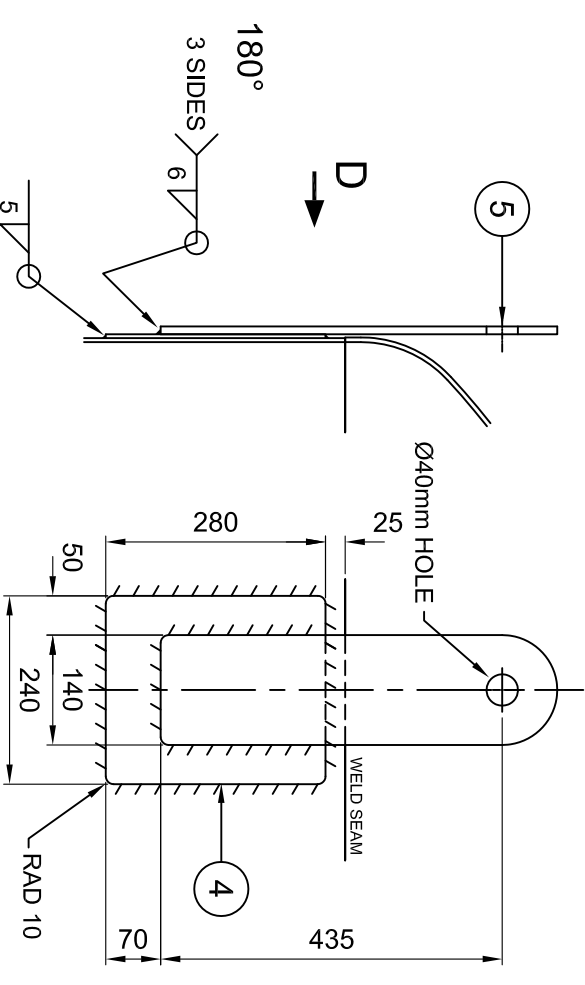
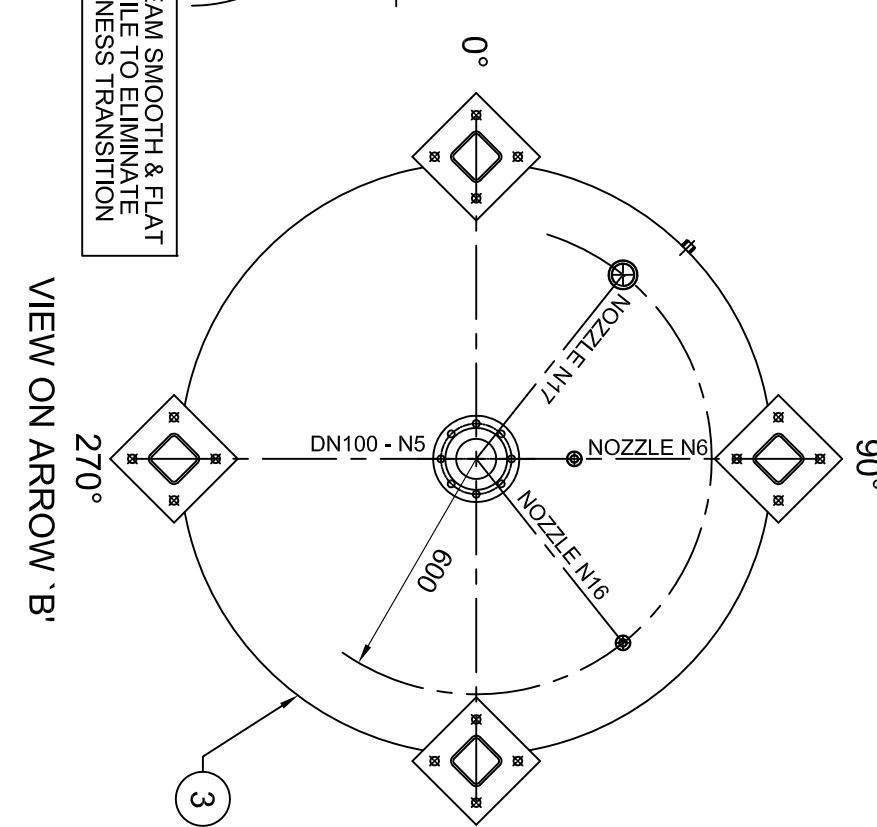
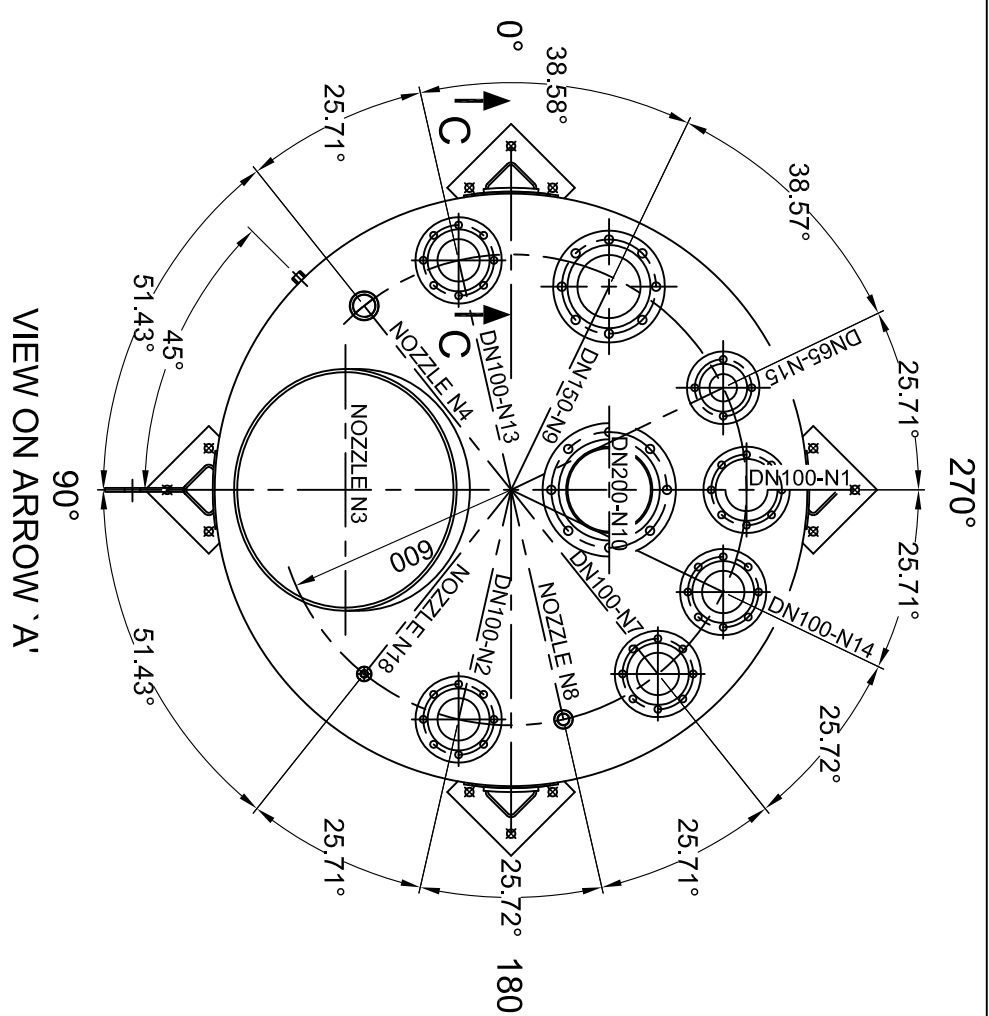
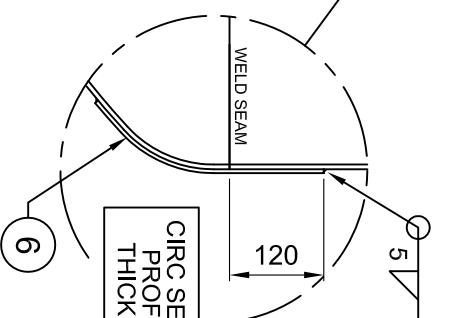
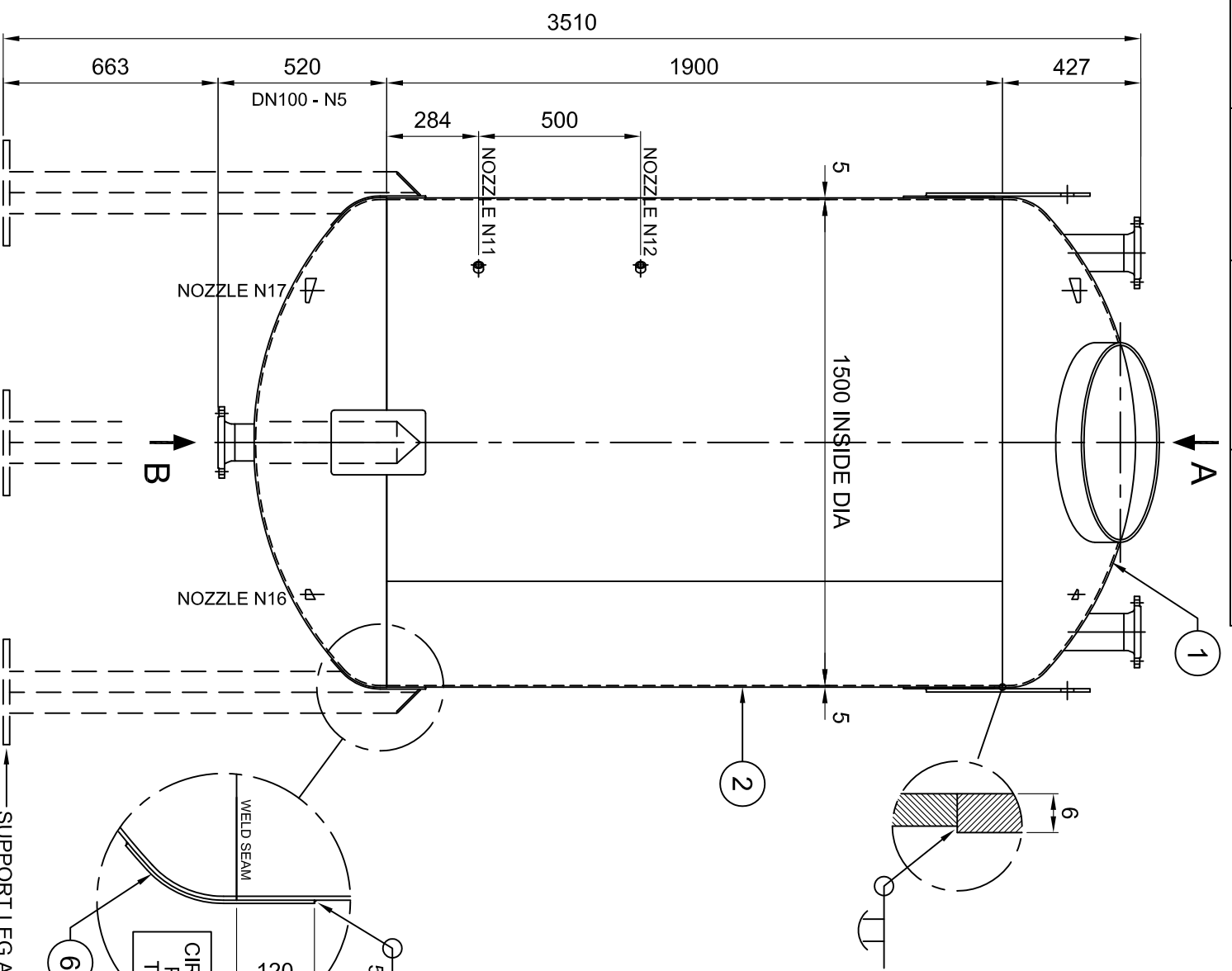


PORT No.	PORT SIZE	PIPE SIZE	PORT DESCRIPTION
N1	DN100 PN 16	4" NB SCH.10 (3.05 WALL)	TO PRE-TREAT
N2	DN100 PN 16	4" NB SCH.10 (3.05 WALL)	BURSTING DISK
N3	600mm IDIA	N/A	MANWAY
N4	2" BSP (F)	N/A	PRESSURE TRANSDUCER
N5	DN100 PN 16	4" NB SCH.40 (6.02 WALL)	OUTLET TO CONDITIONING
N6	1/2" BSP (F)	N/A	TEMPERATURE PROBE
N7	DN100 PN 16	4" NB SCH.10 (3.05 WALL)	FROM MICROWAVE
N8	1" BSP (F)	N/A	COMPRESSED AIR
N9	DN150 PN 16	6" NB SCH.10 (3.4 WALL)	PRESSURE BALANCE
N10	DN200 PN 10	8" NB SCH.10 (3.76 WALL)	AGITATOR
N11	1/2" BSP (F)	N/A	TEMP PROBE
N12	1/2" BSP (F)	N/A	TEMP PROBE
N13	DN100 PN 16	4" NB SCH.10 (3.05 WALL)	SPARE
N14	DN100 PN 16	4" NB SCH.10 (3.05 WALL)	SPARE
N15	DN65 PN 16	2.5" NB SCH.10 (3.05 WALL)	STEAM
N16	1/2" BSP (F)	N/A	LEVEL SENSOR
N17	2" BSP (F)	N/A	PRESSURE TRANSDUCER
N18	1/2" BSP (F)	N/A	LEVEL SENSOR



DESIGN & FABRICATION CODE : ASME SECTION VIII DIV.1, 2015 & PED CAT14

FABRICATION NOTES

- ALL WELDS TO BE BY MEANS OF PLASMA / TIG, MIG & MMA.
- THE SHELL, DISHED ENDS AND ALL PARTS IN CONTACT WITH THE CONTENTS OF THE TANK SHALL BE OF STAINLESS STEEL.
- DESIGN CODE ASME SECTION VIII DIVISION 1 2015
DESIGN METAL TEMPERATURE: 20°C TO +170°C (+4°F TO +338°F)
MAWP: 6.0 bar
DESIGN PRESSURE: 7.0 bar
TEST PRESSURE: 10.5 bar
EXTERNAL PRESSURE: 0.21 bar
INTERNAL PRESSURE: -20°C @ 6.0 bar
- ALL CORNERS & SHARP EDGES TO BE ROUNDED OFF.
VESSEL SEAMS MACHINE WELDED CHEMICALLY CLEANED AND FINISHED.
FINAL FINISH ON ALL GROUND AREAS TO BE NOT COARSER THAN 180 GRIT.
- LONGITUDINAL WELD SEAMS SPOT RADIOGRAPHY
CIRCUMFERENTIAL WELD SEAMS SPOT RADIOGRAPHY
- HYDRAULIC TEST CERTIFIED BY APPROVED INSPECTION AUTHORITY.
- CORROSION ALLOWANCE - NIL
- VESSEL MATERIALS:-

SHELL :- 5.0mm THK STAINLESS STEEL TO SA240 - 316 & 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 - 220 N/mm²
0.2% PROOF STRESS @ 170°C - 166 N/mm²
1.0% PROOF STRESS @ 20°C - 260 N/mm²
1.0% PROOF STRESS @ 170°C - 199 N/mm²
MIN ELONGATION - 40%
PLATE FINISH AS SUPPLIED 2B

END :-
6.0mm THK STAINLESS STEEL TO SA240 - 316 & 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 - 220 N/mm²
0.2% PROOF STRESS @ 170°C - 166 N/mm²
1.0% PROOF STRESS @ 20°C - 260 N/mm²
1.0% PROOF STRESS @ 170°C - 199 N/mm²
MIN ELONGATION - 40%
PLATE FINISH AS SUPPLIED 2B

- ONE LIFTING LUG DOUBLER TO VESSEL, 100% DPI
- ONE LIFTING LEG TO VESSEL, 100% DPI
- IMPACT TEST EXEMPTIONS AS PER ASME UHA-51 (PI)(1)(a) + UHA-51 (e)(2)
- MAX GROSS WEIGHT 3600 KG
- TARE WEIGHT 870 KG

ITEM No.	QUANTITY	MATERIAL	DESCRIPTION	PART/DRAWING No.
6	4	SA240 - 304	SUPPORT LEG DOUBLER - 5 THK	E6952/16
5	2	STAINLESS STEEL 304	LIFTING LUG - 10 THK	E4840/09
4	2	SA240 - 304	LIFTING LUG DOUBLER - 5 THK	B7910/15 'B' ITEM 4
3	1	STAINLESS STEEL 316	BOTTOM DISHED END ASSY	B7909/15 'B'
2	1	STAINLESS STEEL 316	SHELL SECTION ASSY	B7909/15 'B'
1	1	STAINLESS STEEL 316	TOP DISHED END ASSY	B7908/15 'B'

UBH INTERNATIONAL LIMITED
BUNSCOUGH, LANCASHIRE LA0 0SL, ENGLAND.
TEL : 01704 898500 FAX : 01704 898518

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	MODIFICATION	MOD. BY
3	22.02.16	NOZZLES N4 & N17 WERE 1" NOW 2" BSP	PB
2	18.02.16	TEST PRESSURE ADDED ITEM 6 CIRC NOTE ADDED	PB
1	01.02.16	ASME SPEC ADDED FABRICATION NOTES	PB
0	11.01.16	NOZZLE N10 WAS DN200 PN16 NOW DN200 PN10 NEW DRAWING	PB

CUSTOMER	DRN.	DATE	TITLE
W2 ENERGY 3.3K15_108 VESSEL ASSEMBLY-B	PB	11 JAN 16	VESSEL ASSEMBLY
JOB No. 15/110 & 143	SCALE 1:10	CHKD.	3,900 LITRE
CAD FILENAME	DRAWING No. B7910/16 'B'		