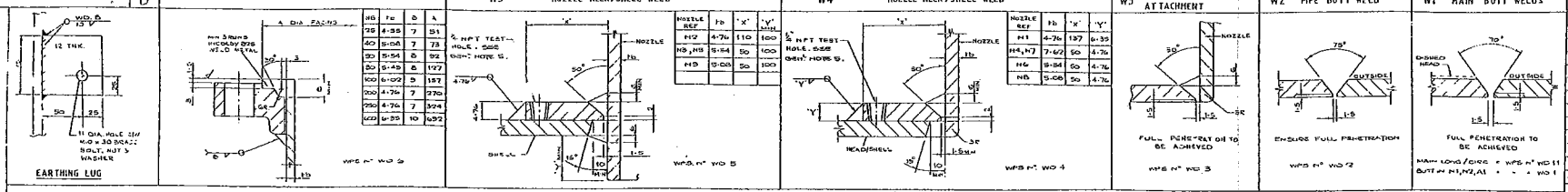
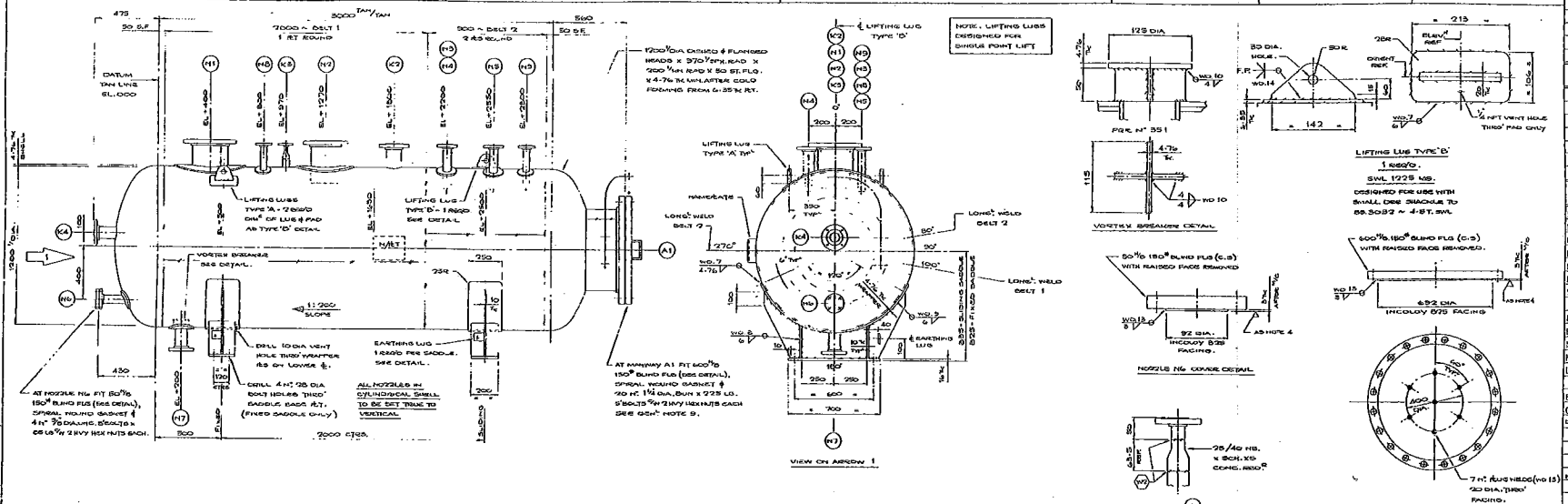
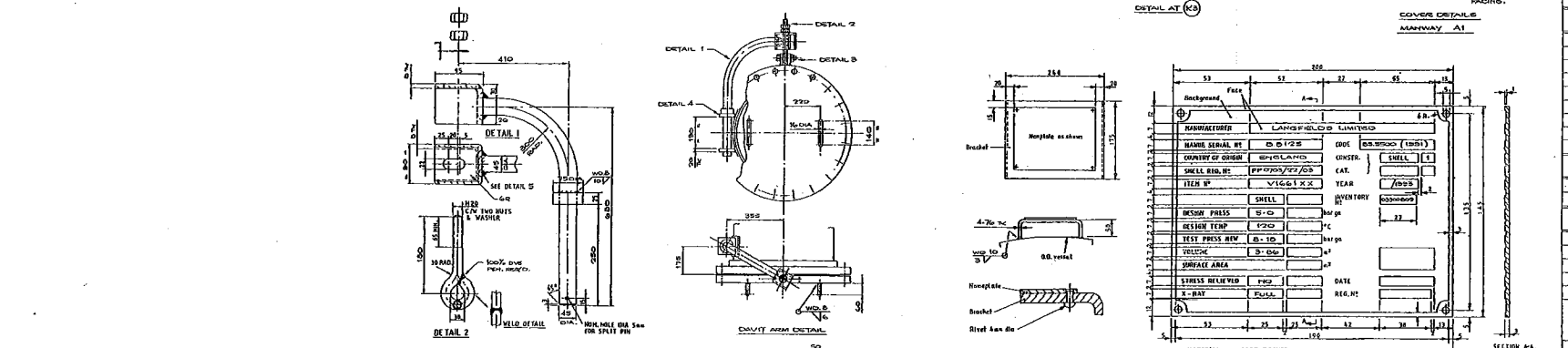
DRG. No. B.8125/1 REV. D







DESIGN CONDITION

CODE	BS.5500 (1991) CATEGORY 1
OTHER SPECS	SHELL DEP 31.22.10.32 GEN (MARCH 89)
DESIGN PRESS	5.0 BARG
DESIGN TEMP	120 °C
CORROSION ALL	1 mm
RADIOGRAPHY	100 %
STRESS RELIEF	NONE
PRODUCT DENSITY	520 kg/m³
WIND SPEED	N.A
INSULATION	NONE
CONTENTS	BLOWDOWN LIQUID
NDT (ADDITIONAL)	100% MPT/DPT OF ALL WELDS, EXCEPT FULL PENETRATION BUTT WELDS, FOR SURFACE FLAWS.
TEST PRESS (NEW)	6.15 BARG (HOLD FOR 1 HR MIN)
TEST PRESS (PERIODIC)	5.46 BARG

WEIGHTS

EMPTY	1223 KG
TEST	5068 KG
OPERATING	5068 KG
VOLUME	3.86 m³

MATERIALS

SHELL	INCOLOY 825 (BS.3072 NA16)
HEADS	
COMPENSATION PLATES	
INTERNALS	
PIPE/ATS NOZZLES	BS.3074 NA16 / BS.3072 NA16
FLANGES	ASTM A105 c/w 825 WELD OVERLAY
SADDLE (WRAPPER PL)	INCOLOY 825 (BS.3072 NA16)
(BODY)	BS EN 10025 Fe 430
BLIND FLANGES	ASTM A105 CLAD WITH INCOLOY 825 PLT.
EARTHING LUG	BS. EN 10025 Fe 430
NAMEPLATE BRKT	INCOLOY 825 (BS.3072 NA16)
NAMEPLATE	CAST BRONZE
LIFTING LUGS (PAD)	INCOLOY 825 (BS.3072 NA16)
(LUG)	ST.ST BS 1501-316-S11
BOLTS	ASTM A193 GR.B7/A194-2H
GASKET	INCOLOY 825 SPIRAL WOUND ASBESTOS FILLED C/W INNER INCOLOY RINGS
DAVIT ARM	CARBON STEEL

	PADS	LUGS
• BRACKETS (DETAIL 4)	INCOLOY 825	ST.ST. BS.1501-316-S11
• BOLT	ASTM A193-B7 / A194-2H	
• EYEBOLT	ASTM A320-B8	

NOTE: MAXIMUM CONTENT OF CARBON STEEL ASTM MATERIALS 0.03%

SURFACE PREPARATION

INCOLOY 825 ~ SELF COLOUR ~ THE WELDS TO BE FREE OF SPATTER AND OXIDATION REMOVED.

CARBON STEEL PARTS TO BE PAINTED IN ACCORDANCE WITH SHELL SPEC DEP 31.22.10.32 GEN. CLAUSE 4.5.1

SEE LANGFIELDS PAINT SPEC B.B124/9

INSPECTION

BUCMS / THIRD PARTY (PLANT SAFETY)

REFERENCE DRAWINGS

0703/22/03-V1661	DATA/REQUISITION SHEETS 1-4 etc

GENERAL NOTES

1. ALL DIMENSIONS ARE IN MILLIMETRES
2. ALL FLANGE BOLT HOLES ARE TO STRADDLE MAIN CENTRE LINES
3.
4. FLANGES ARE TO ANSI B16.5, WITH A GASKET SURFACE FINISH 3.2/6.3 AA. Ra.
5. A 1/8" NPT TELL TALE HOLE IS REQUIRED IN COMPENSATION PLATES FOR AIR TESTING TO 0.5 BAR G WITH SOAPY WATER. ON COMPLETION, HOLE TO BE LEFT UNPLUGGED AND FILLED WITH HIGH TEMPERATURE NON SOLIDIFYING COMPOUND TO PREVENT INGRESS OF WATER
6. VESSEL TESTED WITH TOWN'S WATER HAVING A MAX. CHLORIDE CONTENT OF 20 ppm. & FREE FROM SULPHIDES.
7. GASKET TYPE TO BE USED FOR HYDRO TEST IS SPIRAL WOUND 316L ST. STL. WITH C.STL INNER AND OUTER GUIDE RINGS.
8. PRODUCTION CONTROL TEST PLATES SHALL BE PROVIDED AT THE RATE OF TWO TEST PLATES PER 100 m OF BUTT WELD OR PART THEREOF (EXCEPTS LONG) AS PER DEP 31.22.10.32 GEN. CL 5.4.
9. MANWAY BOLTING WILL BE SUBJECTED TO BOLT TENSIONING. BOLTS TO BE ORDERED OVER LENGTH
10. INCREASE STD LENGTH BY 20 mm. MANWAY BOLT LENGTHS STATED INCLUDES THIS LENGTH.

NOZL Drawing No	7018146 Rev D
Project No	F6752
Requisition No	0703/22/03/03
Proc	A.S.I Sole Ach
Unit No	1400
Group	22
NOZL Equipment	T-5-DETAIL
Equipment No	V-1661
Area Code	C30

A1	600	6.35	150# RF SO		MANWAY	SEE DRG.	W1	W3	W6		4 NO BLD PLG/BOLTING/GASKET/DAVIT
K4	80	7.62			HIGH LEVEL ALARM	SEE DRG.		W3	W6		
K3	25/40	4.55/5.08			PRESSURE GAUGE	785		W3			1 NO 25/40 CONC. RED & 1 SCH. 80
K2	100	6.02			LEVEL ALARM INDICATOR	785		W3			
N9	20	5.08			NITROGEN.	785		W5			
N8	40	5.08			RECYCLE	785		W4			
N7	80	7.62			LIQUID OUTLET	800		W4			1 NO VORTEX BREAKER
N6	80	5.54			UTILITY CONNECTION	SEE DRG.		W4			1 NO BLD PLG/BOLTING/GASKET
N5	50	5.54			LIQUID INLET	785		W5			
N4	80	7.62			VAPOUR INLET	785		W4			
N3	80	5.54			DRAIN HEADER INLET	785		W5			
N2	200	4.76 / 6.35			RELIEF HEADER INLET	510	W1	W5	W6		
N1	250	4.76 / 6.35	150# RF SO		VENT	510	W1	W4	W6		
NO	NB	WALL THK	FLANGE RATING		SERVICE	QUANTITY	LOCATION	DESIGN TO BS	SEE W DETAILS		REMARKS

NOZZLE SCHEDULE

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SEE LANGFIELDS PAINT SPEC B.B124/9

INSPECTION

BUCMS / THIRD PARTY (PLANT SAFETY)

REFERENCE DRAWINGS

0703/22/03-V1661	DATA/REQUISITION SHEETS 1-4 etc

CERTIFIED FINAL DRAWING

LANGFIELDS LTD.
FINAL DRAWING
SIGNATURE DATE 22.9.92

LANGFIELDS LIMITED

MANUFACTURERS REF. B.8125

DESIGNED BY J. M. DIXON ASSOCIATES LTD. 39-41 WILLOWBANK, NEWTON-LE-WILLOWS, MERSEYSLDE, ENGLAND. WA12 0DQ
TEL. No. 0925 225961
REF 1072032

DRAWN BY R.Dawson CHECKED BY J.M.Dixon
DATE 15/3/93 DATE 23-3-93

SCALE 1:12.5

7018146-D

TITLE ACIDIFICATION RELIEF & BLOWDOWN VESSEL
ITEM V.1661

DRG. No. B.8125/1 REV D