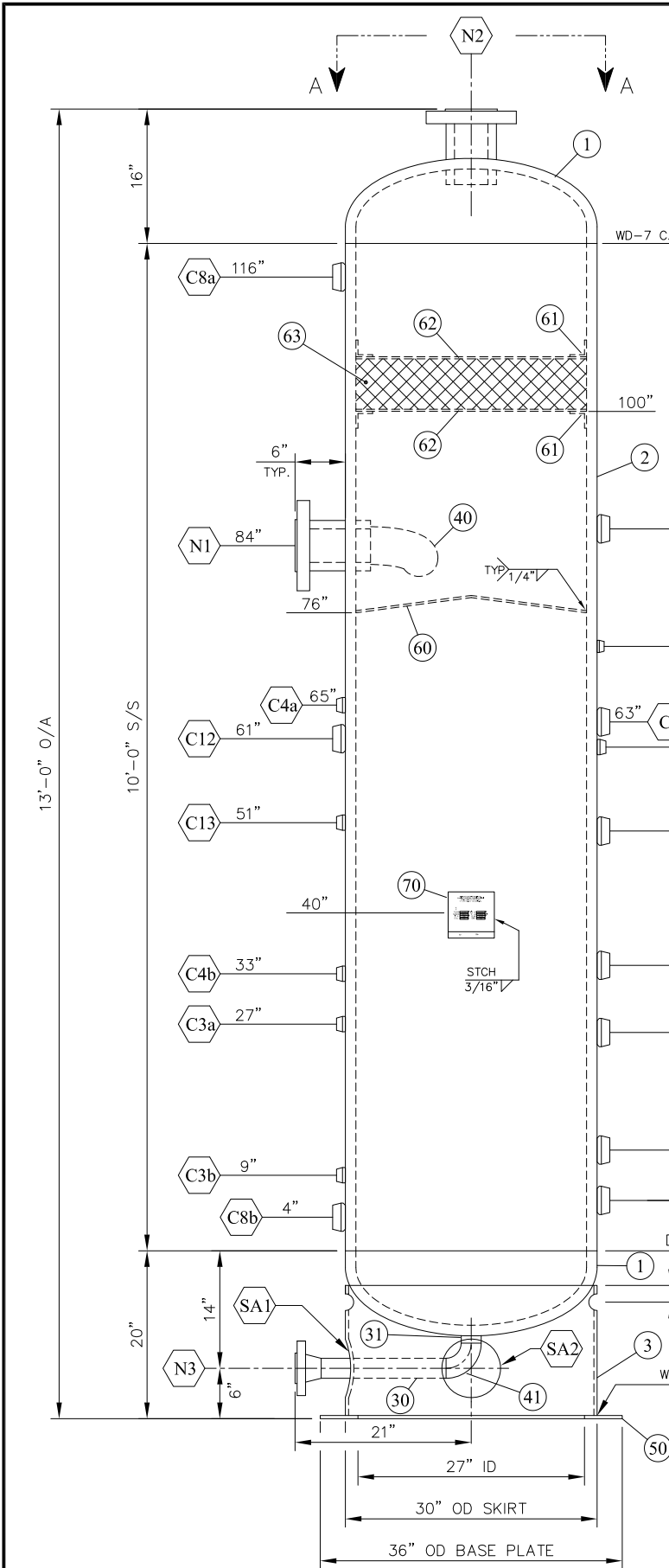
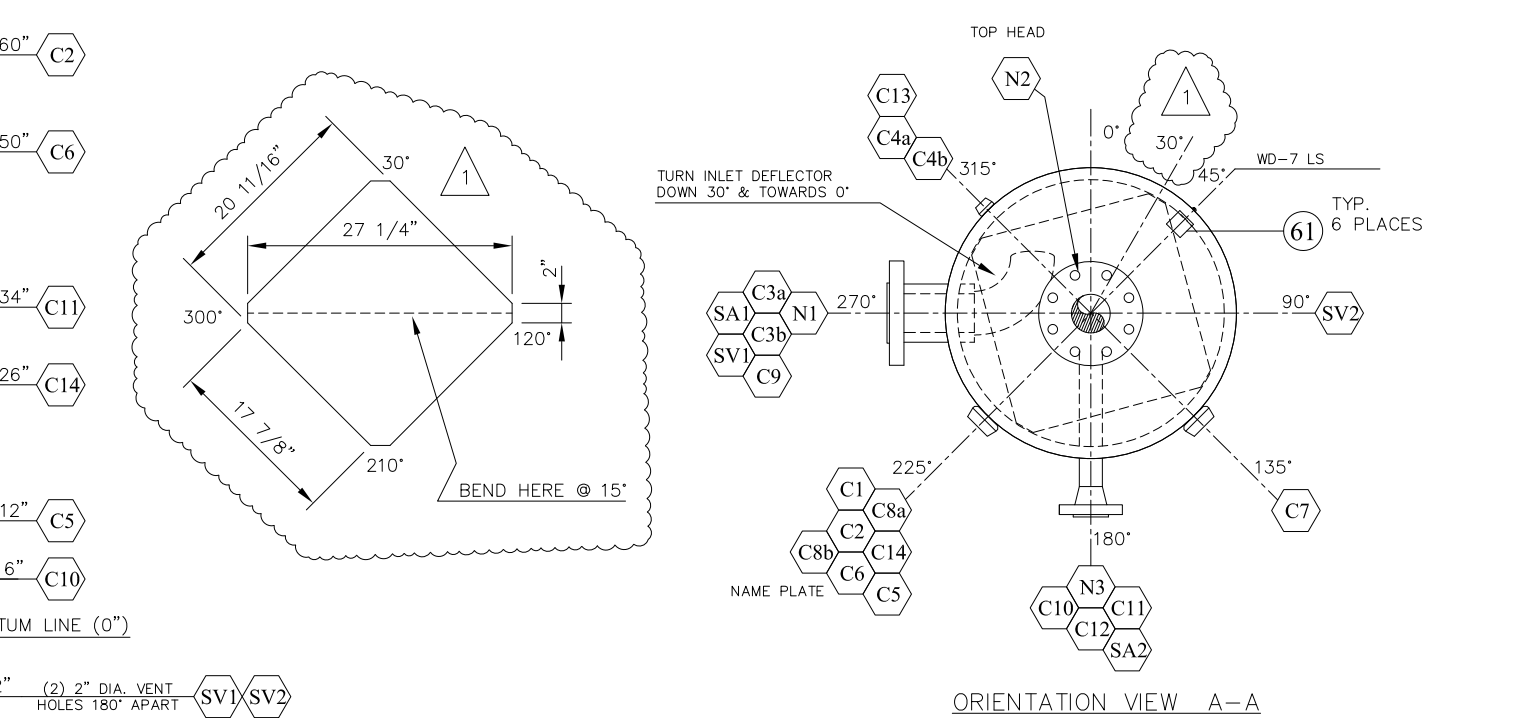
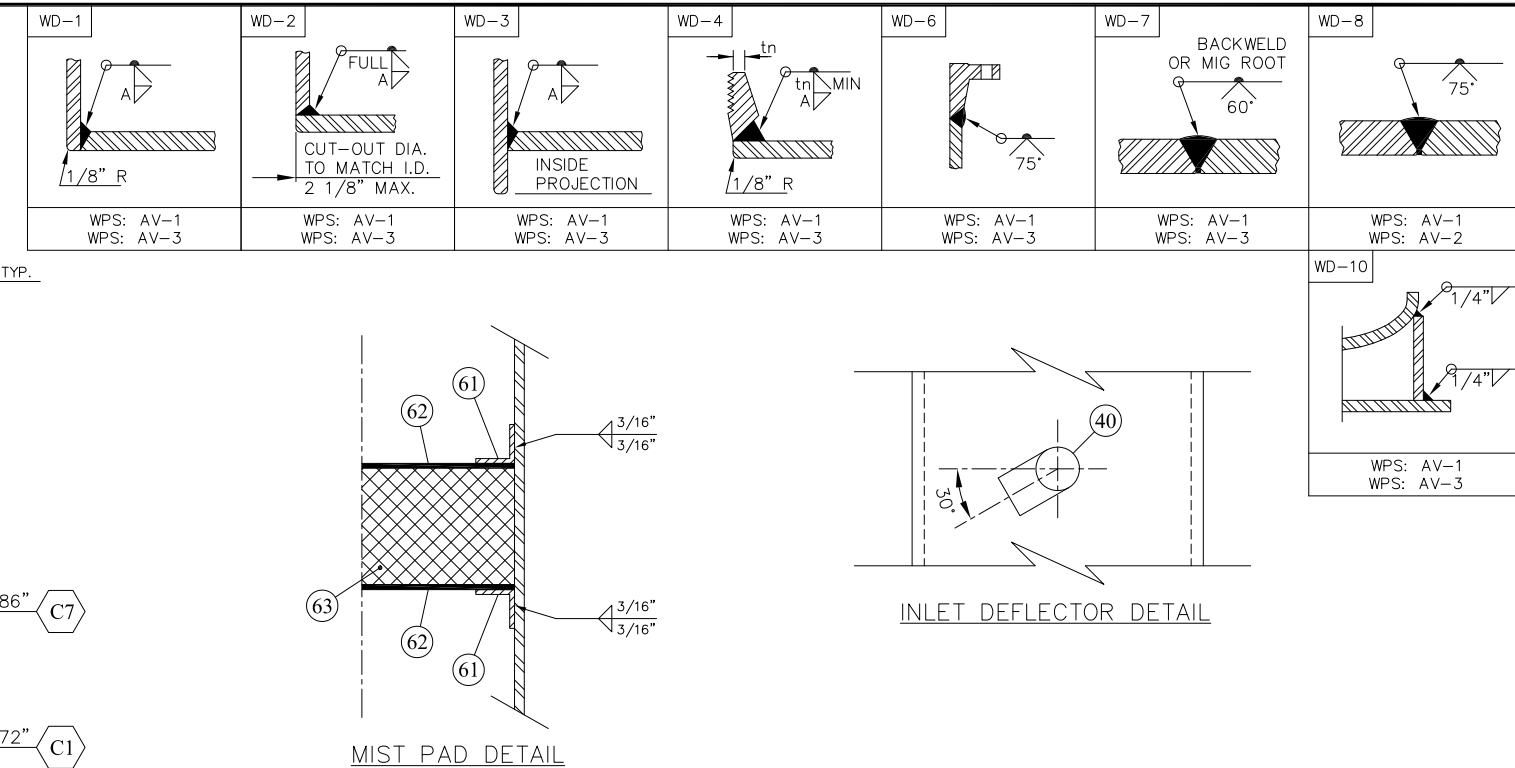




STANDARD TOLERANCES	
WELD PREPARATION:	FABRICATION:
LAND: 1/16" ± 1/32"	GENERAL DEVIATION: ± 1/8"
ROOT GAP: 1/8" ± 1/16"	OVERALL LENGTH: ± 1/4"
ANGULAR: ± 15°	ANGULAR: ± 1°



GENERAL NOTES	
1. QUALITY CONTROL PROGRAM NO.: AQP-1531	13. MAX CUT OUT FOR NPT CONNECTIONS AS FOLLOWS: 2" NPT: 2.125"
2. WELDING PROCEDURE REGISTRATION NO.: WP 3328.2	1.5" NPT: 1.900"
3. SERVICE: W.O.G.	1" NPT: 1.315"
4. CAPACITY: 42.8 CUBIC FT. (1.21 CUBIC METER)	3/4" NPT: 1.050"
5. SURFACE PREPARATION: AS PER CLIENT SPECIFICATIONS	1/2" NPT: 0.840"
6. PRIME: AS PER CLIENT SPECIFICATIONS	
7. PAINT: AS PER CLIENT SPECIFICATIONS	
8. ALL BOLT HOLES TO STRADDLE CENTERLINES.	14. AS PER MATERIAL SUBSTITUTION PROCEDURE
9. CLEAN AND COVER ALL OPENINGS FOR SHIPMENT.	AVF-QC-PRO-001 Rev0, MATERIAL CAN BE
10. USE WPS AV-1 OR AV-3 FOR ALL TACK AND ATTACHMENT WELDS OR REPAIR.	ACCEPTED FOR THE FOLLOWING MATERIALS ONLY:
11. REFERENCE CALCS: 30-2-1440-4358-1 R7	- USE SA-333 Gr.6 IN PLACE OF SA-106-B
30-2-1440-4358-2 R7	- USE SA-350-LF2 CL1 IN PLACE OF SA-105N
30-2-1440-4358-3 R5	- USE SA-420 WPL6 IN PLACE OF SA-234 WPB
	- USE 44W IN PLACE OF SA-36
	- USE SA-516 70N IN PLACE OF SA-36
	AND/OR 44W
12. PREHEAT AS PER WPS	

BILL OF MATERIALS				DESCRIPTION		MATERIAL	
ITEM	QTY						
1	2	HEAD - 30" OD x 1.25" THK (1.1875" MIN) 2:1 SE, 2"SF (HOT FORMED)				SA-516-70N	
2	1	SHELL PLATE - 30" OD x 1.25" THK x 10'-0" LG (COLD FORMED)				SA-516-70N	
3	1	SKIRT PIPE - 30" x 3/8" THK. x 15-3/4" LG CUT TO SUIT				SA-36/44W	
10	2	FLANGE - 4" CLASS 600 RFLWN x 9" LG - 1.00" THK				SA-350-LF2-CL1	
11	1	FLANGE - 2" CLASS 600 RFWN SCH 160				SA-350-LF2-CL1	
20	10	TOL - 2" NPT CLASS 3000				SA-105N	
21	6	TOL - 3/4" NPT CLASS 3000				SA-105N	
22	1	TOL - 1/2" NPT CLASS 3000				SA-105N	
30	1	PIPE - 2" SCH 160 (.343") x 14-3/4" LG				SA-106-B	
31	1	PIPE - 2" SCH 160 (.343") x 7/8" LG				SA-106-B	
40	1	ELBOW - 4" SCH XH LR 90° WELD				SA-234-WPB	
41	1	ELBOW - 2" SCH 160 LR 90° WELD				SA-234-WPB	
50	1	BASE PLATE - 3/8" THK x 36" OD x 27" ID CUT PER DETAIL				SA-36/44W	
60	1	DIVERTOR, 1/4" THK, 20-11/16" SQ, 27-1/4" WD BREAK @ 15°&TRIM				SA-36/44W	
61	12	MIST SUPPORTS - 2" x 2" x 1/4" THK ANGLE IRON x 2" lg				SA-36/44W	
62	2	MIST SUPPORTS - 3.0LBS STRUCTURAL GRATING CUT TO 26.5" DIA				CS	
63	1	MISTEX - 9#/CUBIC FT x 6"THK ROLL TO 27.5" DIA				316L SS	
70	1	ALLIED VESSEL FABRICATION NAMEPLATE & BRACKET ASSEMBLY				SA-1011	

ELEVATION VIEW A-A

NOZZLE SCHEDULE

MARK	SIZE	SCH	CLASS	TYPE	SERVICE	WELD	A	B	C	I.P.	ITEM NO'S
N1	4"	1.00"	600	RFLWN	INLET	3, 8	3/8"	—	—	1"	10,40
N2	4"	1.00"	600	RFLWN	GAS OUTLET	3	3/8"	—	—	1"	10
N3	2"	160	600	RFWN	DRAIN	2, 6, 8	3/8"	—	—	—	11,30,31,41
C1	1/2"	NPT	3000	TOL	PI	4	3/8"	—	—	—	22
C2	3/4"	NPT	3000	TOL	TI	4	3/8"	—	—	—	21
C3a/b	3/4"	NPT	3000	TOL	WATER LG	4	3/8"	—	—	—	21
C4a/b	3/4"	NPT	3000	TOL	HC LG	4	3/8"	—	—	—	21
C5	2"	NPT	3000	TOL	WATER LC	4	3/8"	—	—	—	20
C6	2"	NPT	3000	TOL	HC LC	4	3/8"	—	—	—	20
C7	2"	NPT	3000	TOL	PSV	4	3/8"	—	—	—	20
C8a/b	2"	NPT	3000	TOL	INSPECTION	4	3/8"	—	—	—	20
C9	2"	NPT	3000	TOL	HLSD	4	3/8"	—	—	—	20
C10	2"	NPT	3000	TOL	WATER OUTLET	4	3/8"	—	—	—	20
C11	2"	NPT	3000	TOL	HC OUTLET	4	3/8"	—	—	—	20
C12	2"	NPT	3000	TOL	SPARE	4	3/8"	—	—	—	20
C13	3/4"	NPT	3000	TOL	SPARE	4	3/8"	—	—	—	21
C14	2"	NPT	3000	TOL	SPARE	4	3/8"	—	—	—	20
SV2	2"				SKIRT VENT						
SV2	2"				SKIRT VENT						
SA1	7"				SKIRT ACCESS						
SA2	7"				SKIRT ACCESS						

CRN: W3960.2413		JOB#: V23-14610	
DESIGN DATA			
DESIGN & FABRICATE TO: ASME SECTION VIII, DIV 1, 2021 EDITION			
DESIGN PRESSURE & TEMPERATURE: 1440 PSIG AT 130° F			
MINIMUM DESIGN METAL TEMPERATURE: -20° F AT 1440 PSIG			
IMPACT TESTS: EXEMPT PER UG-20(f) 1-5, UCS-66A			
FLANGES PER UCS-66c			
RADIOGRAPHY - LONG SEAMS: FULL PER UW-11a			
RADIOGRAPHY - CIRC SEAMS: SPOT PER UW-11a5b (RT-2)			
PWHT: NO			
HYDROSTATIC TEST PRESSURE: 1878 PSIG			
CORROSION ALLOWANCE: 1/8"		WEIGHT EMPTY: 5,100 LBS	
HEAD THK. 1.1875" MIN		WEIGHT FULL OF WATER: 8,000 LBS	

1	06-04-23	ROTATED INLET DEFLECTOR PLATE	MEW	JH
0	29-03-23	ISSUED FOR CONSTRUCTION	MEW	JH
NO.	DATE	REVISION	BY	APP

ALLIED VESSEL FABRICATION LTD.

5302 - 42 STREET
STETTLER, AB T0C 2LO
TELEPHONE: (403) 742-6400 FAX: (888) 526-0274

DRAWN BY: MEW
CHECKED BY: JH

DATE: 02-19-2014
SCALE: NTS
CLIENT: TKS

BDD NO.: 4358
CUST. NO.: ---

ALLIED VESSEL FABRICATION

3 PHASE SEPARATOR
30" OD x 10'-0" SEAM TO SEAM
1440 PSIG AT 130° F

DWG. NO. 4358-13-2314610

REV. 1

THIS DRAWING IS THE EXCLUSIVE PROPERTY OF ALLIED VESSEL FABRICATION. IT MAY NOT BE REPRODUCED WITHOUT THE PERMISSION OF ALLIED VESSEL FABRICATION.