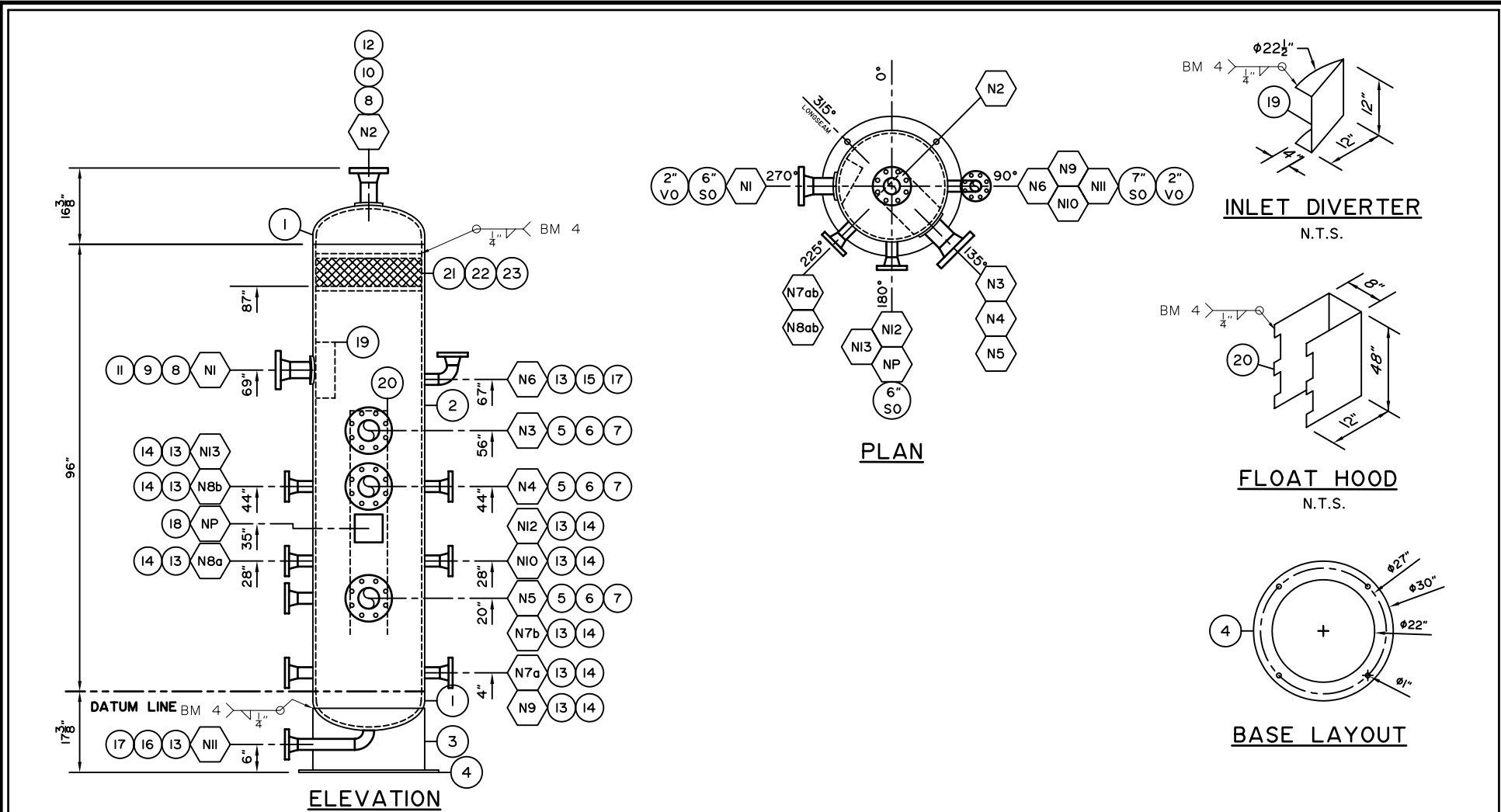
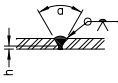
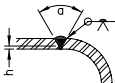
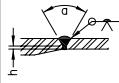
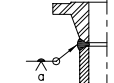
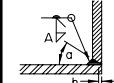
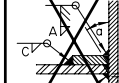
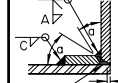
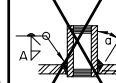
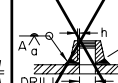
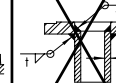
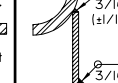
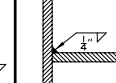
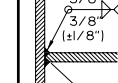




INSIDE & OUTSIDE OF NOZZLE BE ROUNDED PER UG-76(C)

WELD DETAIL 1	WELD DETAIL 2	WELD DETAIL 3	WELD DETAIL 4	WELD DETAIL 5	WELD DETAIL 6	WELD DETAIL 7	WELD DETAIL 8	WELD DETAIL 9	WELD DETAIL 10	WELD DETAIL 11	WELD DETAIL 12	WELD DETAIL 13	WELD DETAIL 14	
ROOT: BM-4 F&C: BM6 TN  WITHOUT BACKING R=1/8" (±1/8") α=60° (±15°) h=1/16" (±1/16")	ROOT: BM-4 F&C: BM6 TN  WITHOUT BACKING R=1/8" (±1/8") α=60° (±15°) h=1/16" (±1/16")	ROOT: BM-4 F&C: BM6 TN  3:1 TRANSITION R=1/8" (±1/8") α=60° (±15°) h=1/16" (±1/16")	ROOT: BM-2 OR BM-4 F&C: BM-2 OR BMS-710M HT  R=1/8" (±1/8") α=75° (±15°)	ROOT: BM-2 F&C: BM-2 OR BMS-710M HT  R=1/8" (±1/8") α=40° (±15°) h=1/8" (±1/16")	ROOT: BM-2 F&C: BM-2 OR BMS-710M HT  R=1/8" (±1/8") α=40° (±15°) h=1/16" (±1/16")	ROOT: BM-2 F&C: BM-2 OR BMS-710M HT  R=1/8" (±1/8") α=40° (±15°) h=1/8" (±1/16")	ROOT: BM-2 F&C: BM-2 OR BMS-710M HT  R=1/8" (±1/8") α=40° (±15°) h=1/16" (±1/16")	ROOT: BM-2 F&C: BM-2 OR BMS-710M HT  R=1/8" (±1/8") α=40° (±15°) h=1/16" (±1/16")	ROOT: BM-2 F&C: BM-2 OR BMS-710M HT  R=1/8" (±1/8") α=40° (±15°) h=1/16" (±1/16")	ROOT: BM-2 F&C: BM-2 OR BMS-710M HT  R=1/8" (±1/8") α=40° (±15°) h=1/16" (±1/16")	ROOT: BM-4 F&C: BM-4 OR BMS-710M HT  3/16" (±1/16") 3/16" (±1/16")	ROOT: BM-4 F&C: BM-4 OR BMS-710M HT  TYPICAL NON PRESSURE ATTACHMENT WELD	ROOT: BM-4 F&C: BM-4 OR BMS-710M HT  3/8" (±1/8") 3/8" (±1/16") α=30° (±15°)	
NOZ	NO.	SIZE	RATING	TYPE OF	OD OF	PROJECTION	REIF PAD	WELD	FILLET WELD	WELD SIZE	BILL OF MAT'L		REMARKS	
NO.	REQ'D	REQ'D		SERVICE	NOZ NECK	OUTSIDE	INSIDE	OD x THK	DETAIL	A	B	C	ITEM No.	
N1	I	3"	300	INLET	3.5"	8	.	6" X 5/8"	4,8	1/2	.	1/2	8,9,11	.
N2	I	3"	300	OUTLET	3.5"	8	.	6" X 5/8"	4,8	1/2	.	1/2	8,10,12	INSPECTION
N3	I	4"	300	LSHH	4.5"	8	.	7" X 1/2"	4,8	1/2	.	3/8	5,6,7	.
N4	I	4"	300	LC	4.5"	8	.	7" X 1/2"	4,8	1/2	.	3/8	5,6,7	.
N5	I	4"	300	LC	4.5"	8	.	7" X 1/2"	4,8	1/2	.	3/8	5,6,7	INSPECTION
N6	I	2"	300	PSV	2.375"	6	.	.	4,6	3/8	.	.	13,15,17	.
N7ab	2	2"	300	LG	2.375"	6	.	.	4,6	3/8	.	.	13,14	.
N8ab	2	2"	300	LG	2.375"	6	.	.	4,6	3/8	.	.	13,14	.
N9	I	2"	300	DUMP	2.375"	6	.	.	4,6	3/8	.	.	13,14	.
N10	I	2"	300	DUMP	2.375"	6	.	.	4,6	3/8	.	.	13,14	.
N11	I	2"	300	DRAIN	2.375"	6	.	.	4,6	3/8	.	.	13,16,17	.
N12	I	2"	300	TI	2.375"	6	.	.	4,6	3/8	.	.	13,14	.
N13	I	2"	300	PI	2.375"	6	.	.	4,6	3/8	.	.	13,14	.

BILL OF MATERIAL												
ITEM	QTY.			DESCRIPTION								
1	2			S.E. HEAD, 24"OD X 0.750" NOM. (0.6875" MIN.), SA516-70N								
2	1			SHELL, 24"OD X 0.625" NOM. X 8'-0" LONG, SA516-70N								
3	1			PIPE, 24" SCH. STD (0.375"), SA53B OR SAI06B X I3 1/4" LONG								
4	1			BASE RING, 30"OD X 22"ID X 1/2", A36/44W								
5	3			RFWN, 4" 300 ANSI SCH. I60, SAI05N								
6	3			PIPE, 4" SCH. I60 (0.531"), SAI06B X 4 I3/16" LONG								
7	3			ROLLED REPAD, 7"OD X 1/2"TK (ROLLED TO 24"ID), SA516-70N								
8	2			RFWN, 3" 300 ANSI SCH. I60, SAI05N								
9	1			PIPE, 3" SCH. I60 (0.438"), SAI06B X 5" LONG								
10	1			PIPE, 3" SCH. I60 (0.438"), SAI06B X 4 I5/16" LONG								
11	1			ROLLED REPAD, 6"OD X 5/8"TK (ROLLED TO 24"ID), SA516-70N								
12	1			DISHED REPAD, 6"OD X 5/8"TK (DISHED TO 24"ID), SA516-70N								
13	10			RFWN, 2" 300 ANSI SCH. I60, SAI05N								
14	8			PIPE, 2" SCH. I60 (0.344"), SAI06B X 3 5/16" LONG								
15	1			PIPE, 2" SCH. I60 (0.344"), SAI06B X 3 I1/16" LONG								
16	1			PIPE, 2" SCH. I60 (0.344), SAI06B X I2 1/4" LONG								
17	2			WELD 90, 2" SCH. I60 LR, SA234WPB								
18	1			TAG PLATE HOLDER, SA36 8 VESSEL ID PLATE, ALUM.								
19	1			INLET DIVERTER, I2" X I2", I/4", SA36 (SEE DETAIL)								
20	1			FLOAT HOOD , 8" X I2" X 4', 3/16", SA36 (SEE DETAIL)								
21	1			DEM, 24"OD X 6"TK, I PC NO GRD, 9LB 316LSS								
22	A/R			FLAT, I/4" X I", A36/44W								
23	A/R			FLAT EXP. METAL, 3/4" X 9LB, CS								
	03	06	09	AS-BUILT						MWC	MK	MK
	I2	I7	08	ISSUED FOR CONSTRUCTION					K2480.23	MWC	MK	MK
REV.	MM	DD	YY	DESCRIPTION					CALC NO.	BY	CHK'D	APP'D
No.	DATE											
ASME 2007 ED. 2007 ADD. CODE SECT. VIII DIV. I												
BMS AQP (S) IO09 REGISTERED WELD PROCEDURE 505.2												
FOR VESSEL TOLERANCES, SEE WELDER HANDBOOK												
VESSEL TYPE: VERTICAL												
M.A.W.P.: 720 PSIG (4964 kPa) AT +I00°F (+38°C)												
M.D.M.T.: -20°F (-29°C) AT 720 PSIG (4964 kPa)												
IMPACT TESTING EXEMPT PER UG20f (I-5)												
P.W.H.T.: YES I150°F FOR 60 MIN.												
RADIOGRAPHY: RT-I CIRC.: FULL LONG: FULL												
JOINT EFFICIENCY: HEADS: I.00 SHELL: I.00												
CORROSION ALLOWANCE: I/8"												
HYDROSTATIC TEST: IO80 PSIG (7446 kPa)												
VOLUME: 23.27ft³ (0.66m³)												
WEIGHT (DRY): 3000 lb (I36I kg)												

CLIENT:		 BROMLEY MECHANICAL SERVICES <i>A DIVISION OF ARGO SALES LTD.</i>	
EXSHAW OIL CORP C/O TUNDRA ENGINEERING		925 23 Street SW, Medicine Hat, Alberta, Canada T1A 8R1 Ph: (403) 526-3142 Fax: (403) 526-1061 Toll Free (800) 215-9806	
PROJECT:			
SPIRIT RIVER 05-36 SATELLITE			
TITLE:			
24"OD X 8'-0" X 720 PSI VESSEL			
CRN.: K 2480.23/K 1528.1		Wo No.: 33264	SERIAL No.: 828800-828801
DRAWN BY: M. CASH		REV. No.: 1	DATE: MM/DD/YY 03/06/09
DATE: MM/DD/YY 12/17/08		SCALE: 3/8"=1'	CAD No.: 33264