

WELDING PROCEDURES	
A	2.01
B	4.01

NAT'L. BD. NO. ++

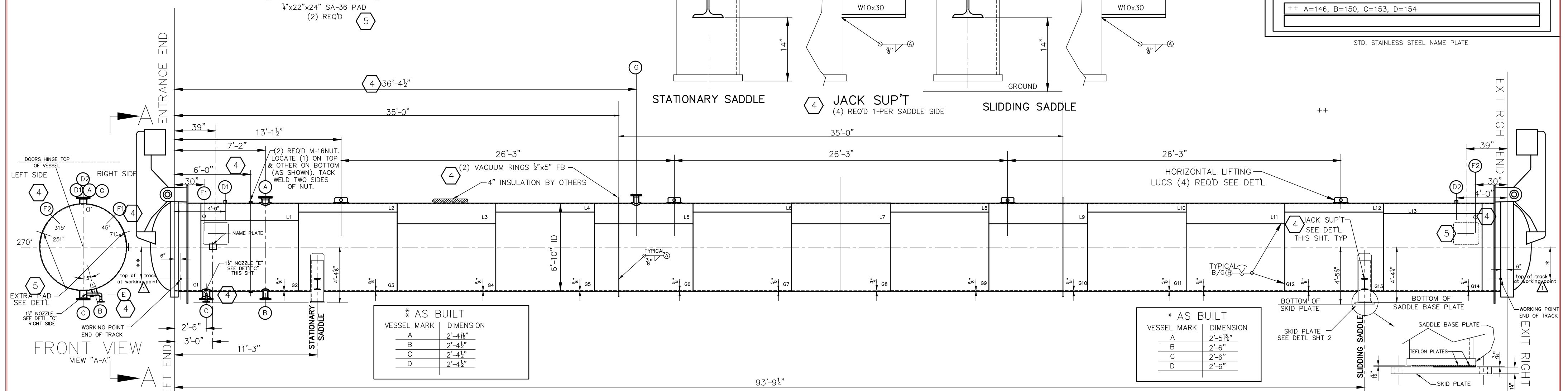
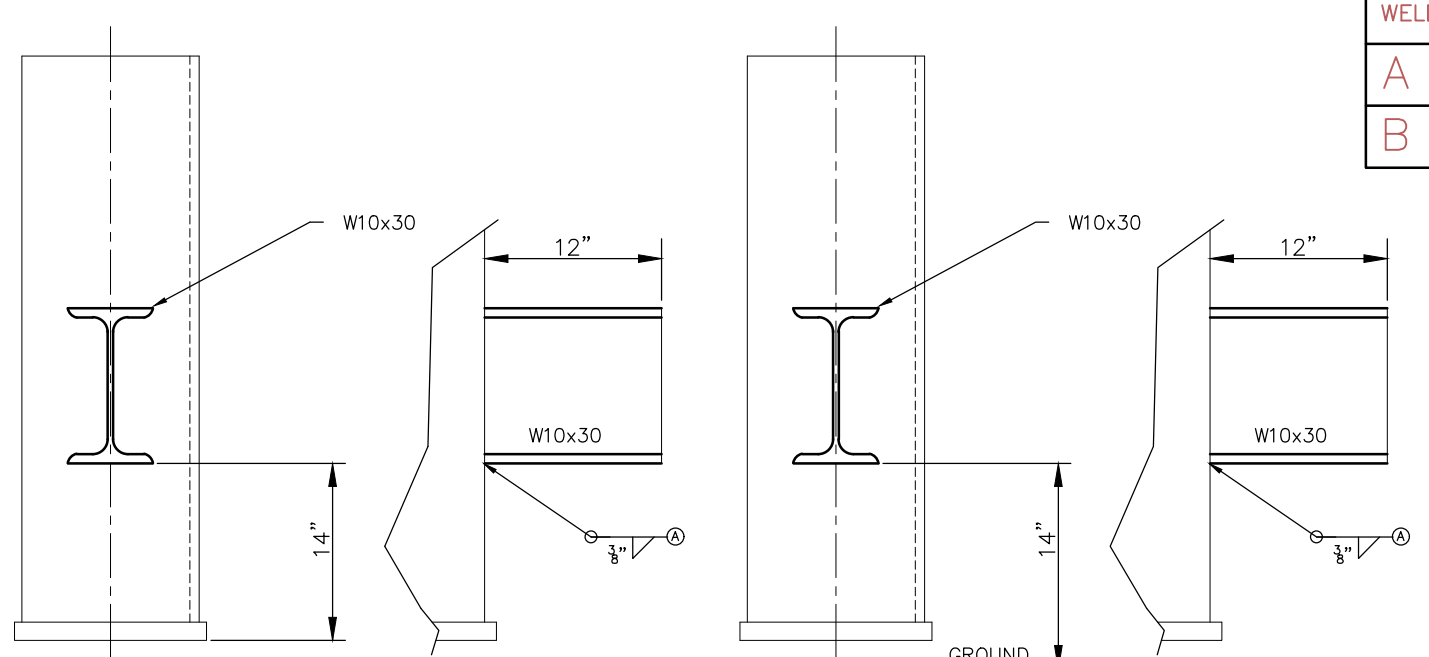
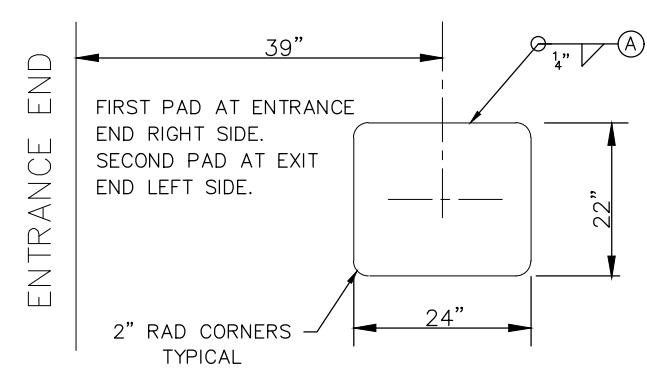
U
W
RT-2

CERTIFIED BY
MODERN WELDING COMPANY OF GEORGIA, INC.
AUGUSTA, GEORGIA

M.A.W.P. 240 P.S.I. AT 400 °F
MIN. DESIGN METAL TEMP. -20 °F AT 240 P.S.I.
MFG'S NO. 8065 YEAR BUILT 1997
VACUUM 15 P.S.I. AT 400 °F
ITEM NO. A-H HYDRO 360 P.S.I.

++ A=146, B=150, C=153, D=154

STD. STAINLESS STEEL NAME PLATE



*** AS BUILT**

VESSEL MARK	DIMENSION
A	2'-4 1/8"
B	2'-4 1/2"
C	2'-4 1/2"
D	2'-4 1/2"

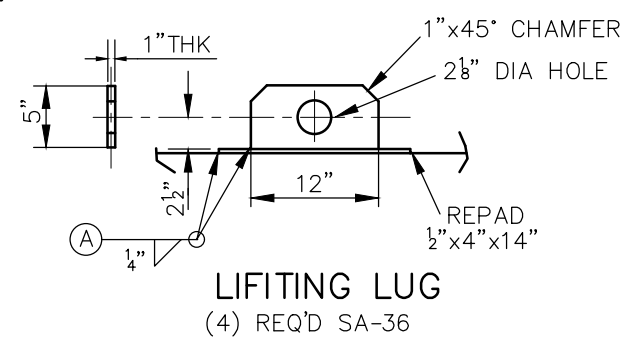
*** AS BUILT**

VESSEL MARK	DIMENSION
A	2'-5 1/8"
B	2'-6"
C	2'-6"
D	2'-6"

***** AS BUILT**

VESSEL MARK	DIMENSION
A	105'-0 1/2"
B	105'-0 1/2"
C	104'-11 1/2"
D	104'-11 1/2"

ELEVATION VIEW



- SHOP NOTES**
- SHOP TO SET ALL FLANGES PARALLEL TO TRACK.
 - ADD PIPING TO SAFETY VALVE FOR DOOR, TO BLOW STEAM BACK.

GENERAL NOTES

CONSTRUCTION PER ASME SECT VIII, DIV 1, '95 EDITION, '95 ADD. CODE SYMBOL IS REQ'D.

MIN DESIGN METAL TEMP °F AT PSIG
DESIGN PRESSURE: INT 240 PSIG EXT 15 PSIG
DESIGN TEMPERATURE: INT 400° EXT 400°
MAX ALLOWABLE WORKING PRESSURE: PSIG

LIMITED BY: SHELL

JOINT EFF: 100% STRESS RELIEF IS NOT REQ'D.

RADIOGRAPH: FULL LONG SEAMS, SPOT PLUS GIRTH SEAMS

CORROSION ALLOWANCE: 0"

VESSEL HYDROSTATIC TEST: 360 PSIG

INSPECTION BY H.S.B.I. & I. INSP AND CUSTOMER.

MATERIAL SHELL: SA-516-70 HEADS: SA-516-70
FLANGES: SA-105 COUPLINGS: SA-105 SUPPORTS: SA-36
PIPE: SA-106B REPADS: SA-516-70
INT BOLTING: SA-307 GR2 NUTS: STD
EXT BOLTING: SA-193-B7 NUTS: SA-194-2H
GASKETS: NONE

SANDBLAST EXT: NONE
SANDBLAST INT: NONE
SHIPPING COVERS: 3/4" PLYWOOD

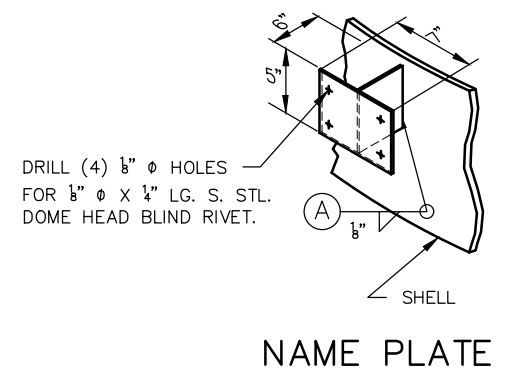
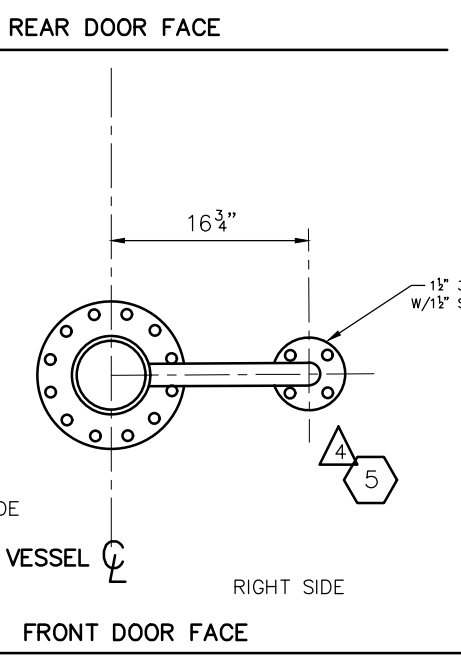
ALL NOZZLES AND MANWAY BOLT HOLES TO STRADDLE NORMAL CENTER LINES OR THEIR PARALLEL LINES UNLESS OTHERWISE NOTED.

EST WT EMPTY: 100,000 LBS
EST WT FULL OF WATER: 355,000 LBS
EST WT FULL OF PRODUCT: 210,500 LBS

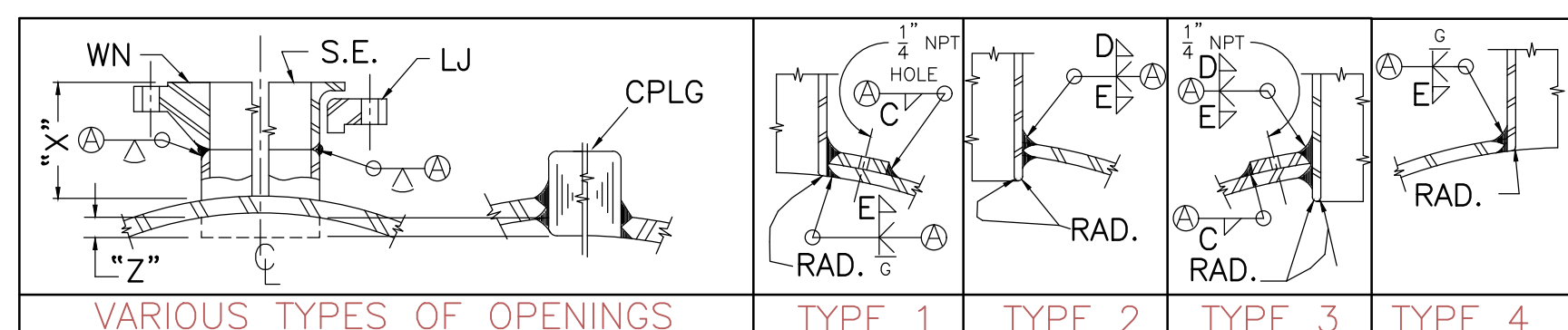
MODERN WELDING CO.
AUGUSTA, GEORGIA
NOVEMBER 12, 1997

"AS BUILT DWG"

CERTIFIED FOR FABRICATION
MANAGER: Robert Brown
ENGINEER: Duke Oakes
DATE: APRIL 17, 1997
MODERN WELDING COMPANY OF AUGUSTA, GEORGIA



DETAIL AT NOZZLE "C" PLAN VIEW



MARK NO.	NO. REQ'D	SIZE	SERIES	DESCRIPTION	DIM "Z"	DESCRIPTION	THK	MINIMUM PAD WIDTH	TYPE	DIM "X"	WELD A	WELD B	WELD C	WELD D	WELD E	Y	N	THK	DESCRIPTION	NO	TYPE	DIA	LENGTH	REMARKS	
4	1	3"	300#	RFWN	3/8"	SCH 80	3/8"	2"	3	8"	1/2"	1/2"	1/2"	1/2"	1/2"	N									
F	2	1"	6000#	FULL THD CPLG	3/8"				2							N								RECORDER	
E	1	1 1/2"	300#	RFWN	0"	SCH 160			4							N									
D	2	3/4"	6000#	FULL THD CPLG	1/4"				2							N									
C	1	6"	300#	RFWN	0"	SCH 80	1/2"	2"	1	8"	3/8"	3/8"	3/8"	3/8"		N									
B	1	4"	300#	RFWN	3/8"	SCH 80	3/8"	2"	3	8"	3/8"	3/8"	3/8"	3/8"		N									
A	1	6"	300#	RFWN	3/8"	SCH 80	1/2"	2"	3	8"	3/8"	3/8"	3/8"	3/8"		N									

BY	AP	REVISION	DATE	NO
		DIM WAS 4 3/4". MODERN SET DIM TO 7 1/2"	05MAY 1997	1
		ADDED SHOP NOTE 1.	29APR 1997	2
		CRITICAL DIMENSIONS WERE 2'-6" & 2'-7 1/2"	24APR 1997	3

NO.	DESCRIPTION	DATE	BY
1	AS BUILT	NOV 1997	
2	ADDED (2) EXTRA REPADS AT 71" & 251"	18JUN 1997	
3	ADD NOZ'S F,G, NOZ E WAS ON 45", ADD M-16NUT, 18MAR ADDED BEAM TO SADDLE FOR FIELD ERECTION. ADDED SHOP NOTE 2. ADDED VACUUM RINGS.	18MAR 1997	
4	REVERSED SHIMS, EXIT SADDLE HEIGHT WAS 4'-6 3/8". ENTRANCE SADDLE HEIGHT WAS 4'-5".	18MAR 1997	
5	RENAMED ALL NOZZLES.	22NOV 1996	
6	NOZZLES A,H1-H6 DELETED, VERIFIED 2'-6" FROM VESSEL C TO TOP OF TRACK. NOZZLES B,C MOVED PER SVANHOLM DWG#1270Z	08NOV 1996	

MODERN WELDING COMPANY OF GEORGIA INC.

PO Box 10067
300 Prep Phillips Dr
Augusta GA 30903

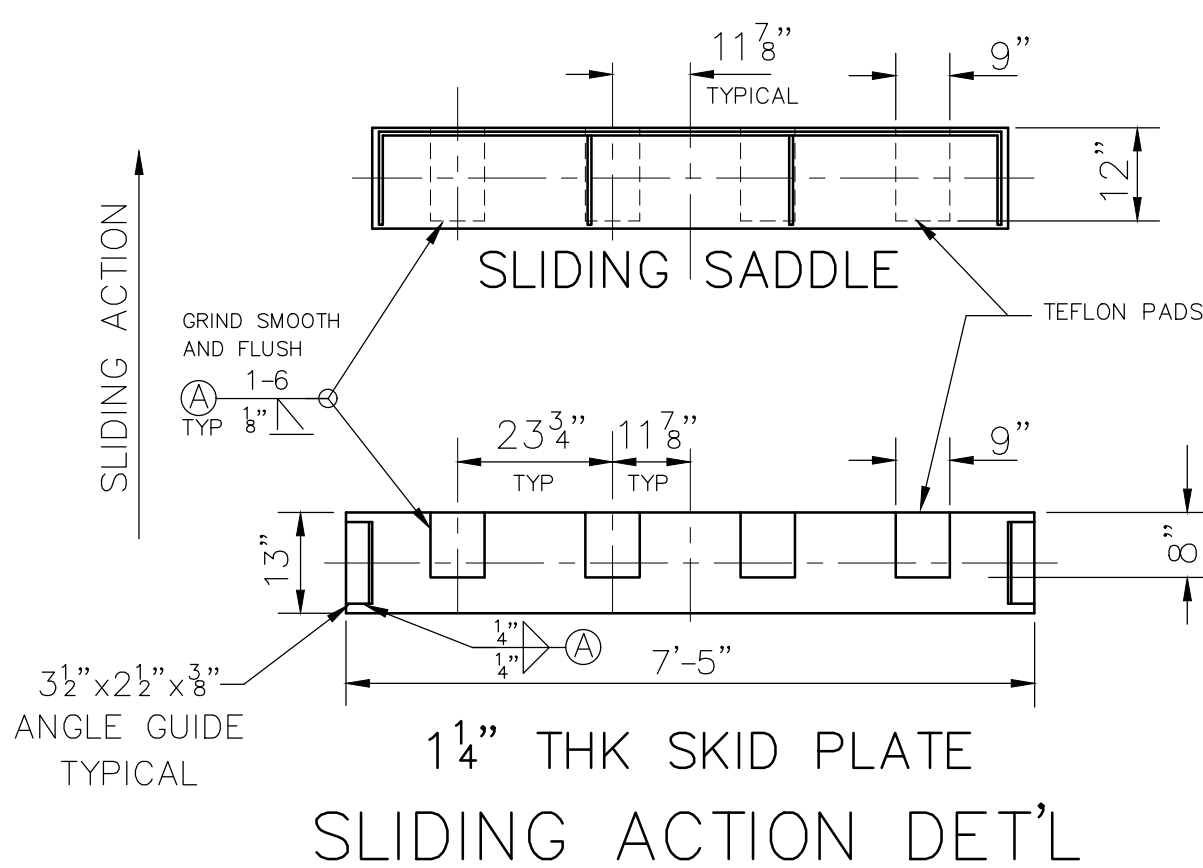
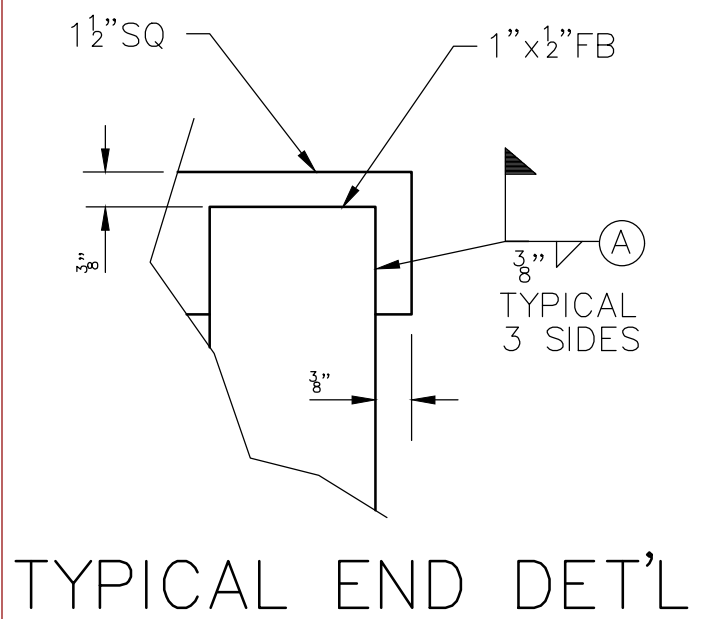
PLANT #14
(706)722-3411
FAX: (706)724-8133

SVANHOLM INTERNATIONAL, LTD.
82"ID x 105'-0" FACE-FACE

DWN BY: D.Oakes DATE: SEP96 SCALE: NONE

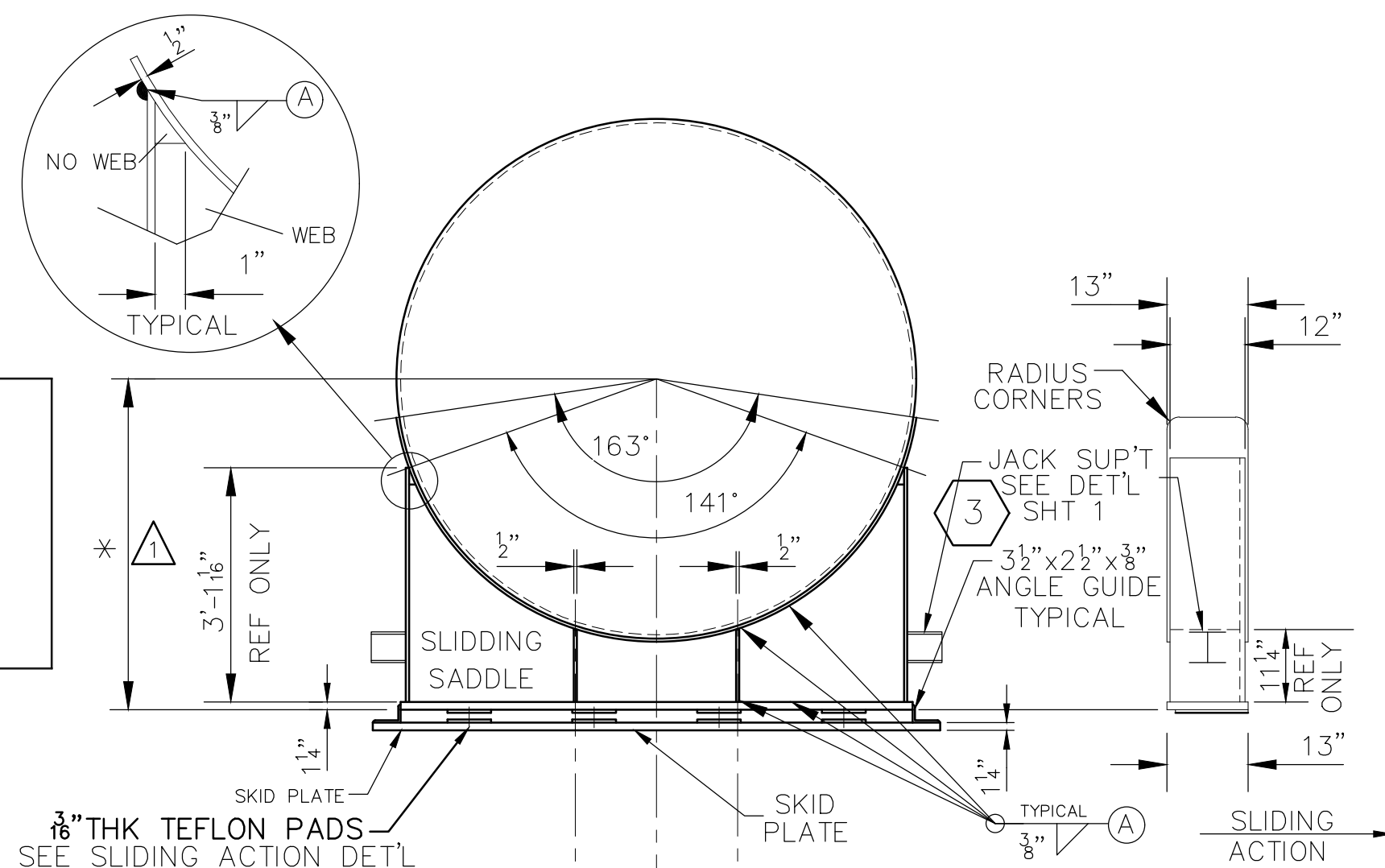
CHK BY: RBrown JOB # 8065 REV. 10 DWG # 14-8065

APR BY: RBrown PO # AZ01-1001 SHT # 1 OF 3



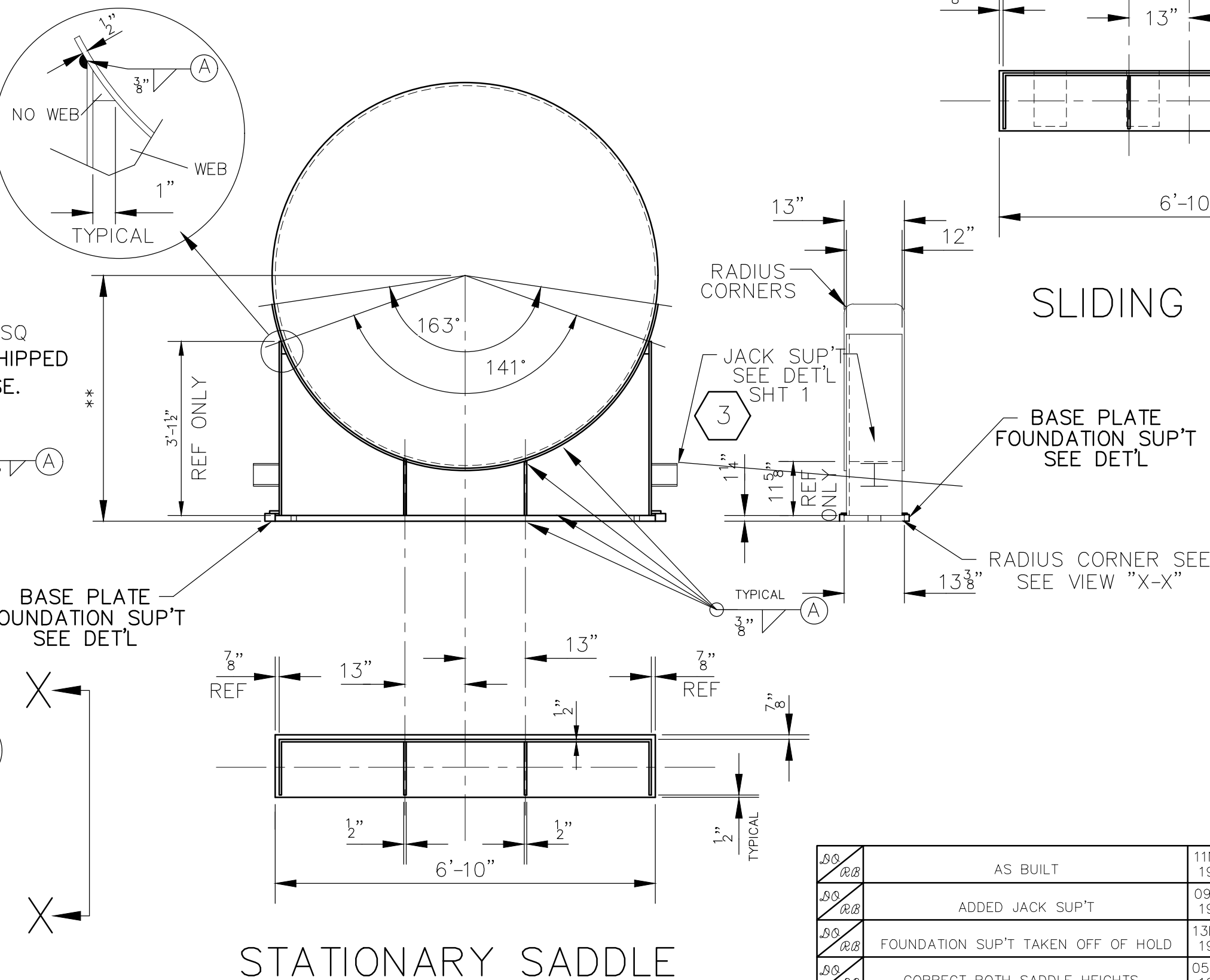
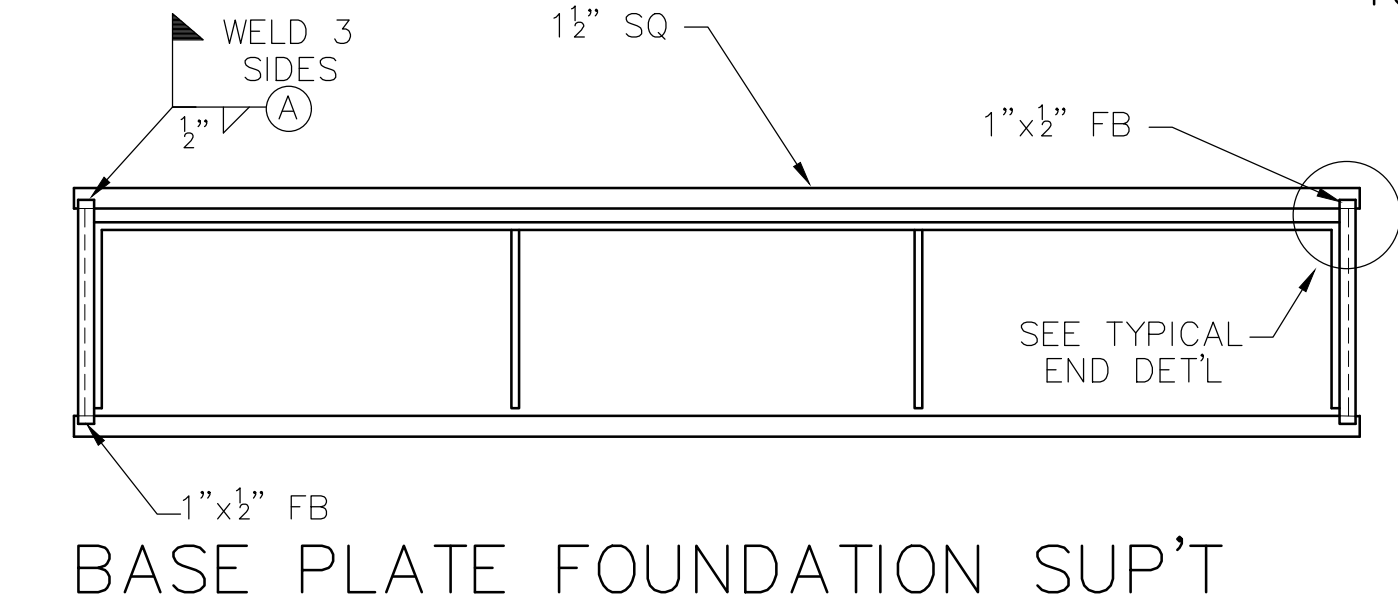
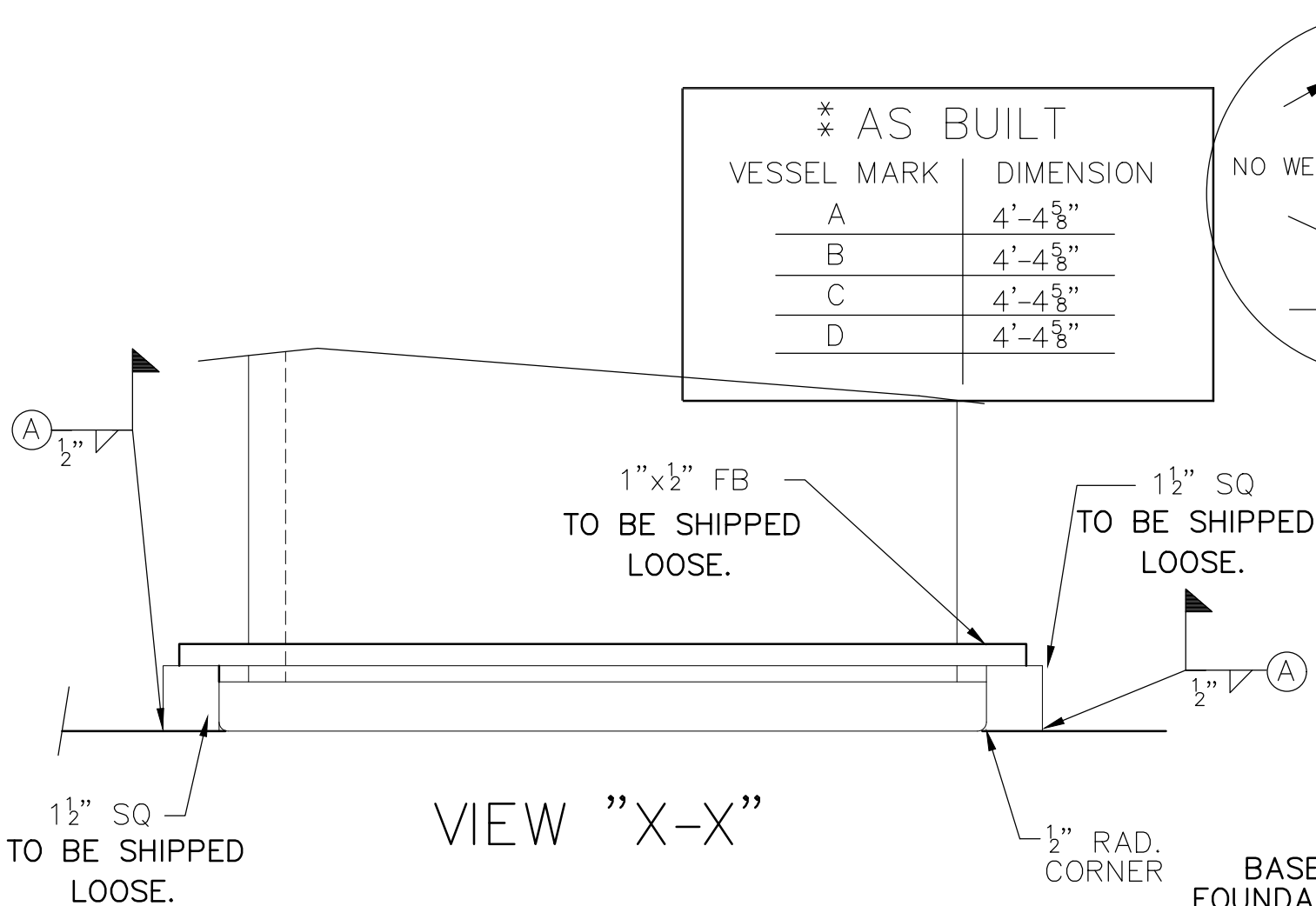
* AS BUILT

VESSEL MARK	DIMENSION
A	4'-4"
B	4'-4 1/4"
C	4'-4 1/4"
D	4'-4 1/4"



* AS BUILT

VESSEL MARK	DIMENSION
A	4'-4 5/8"
B	4'-4 5/8"
C	4'-4 5/8"
D	4'-4 5/8"

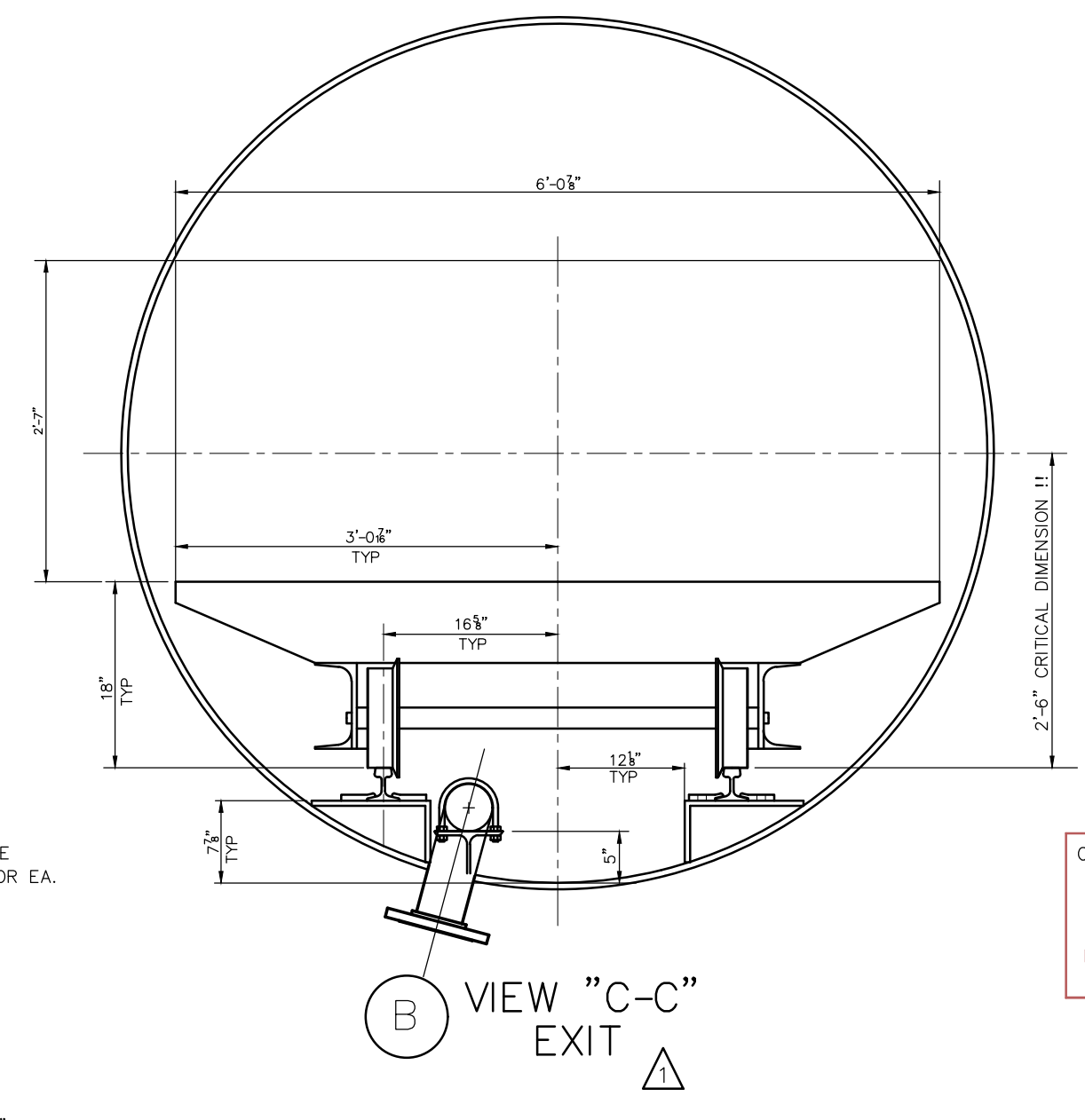
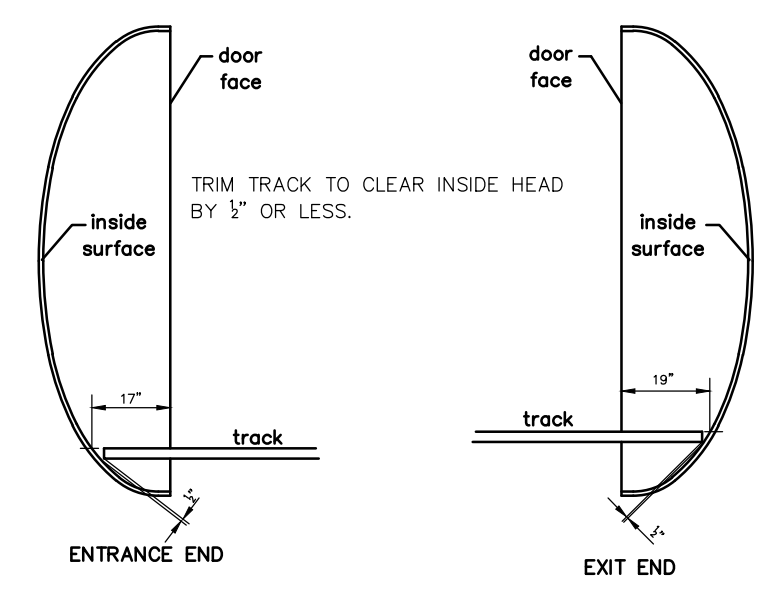
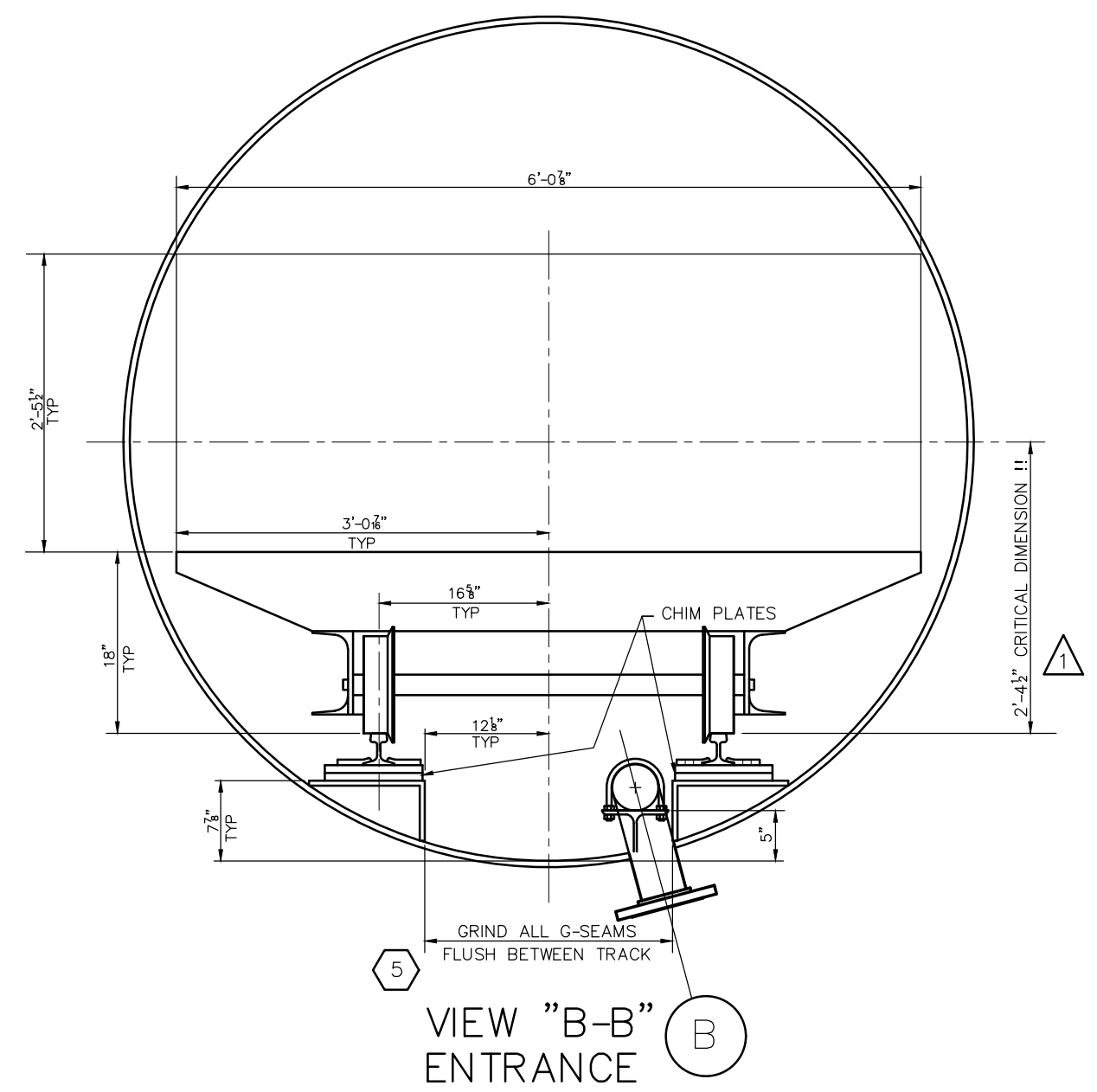
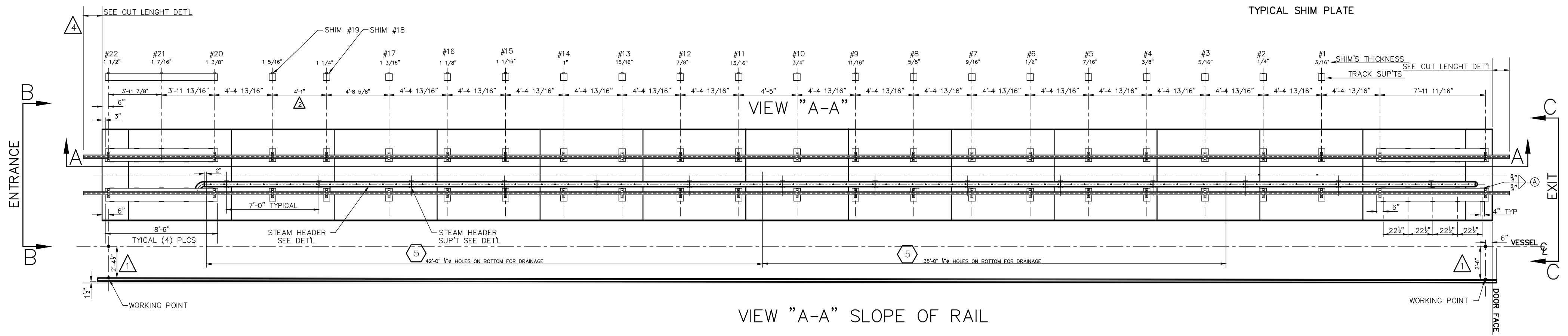
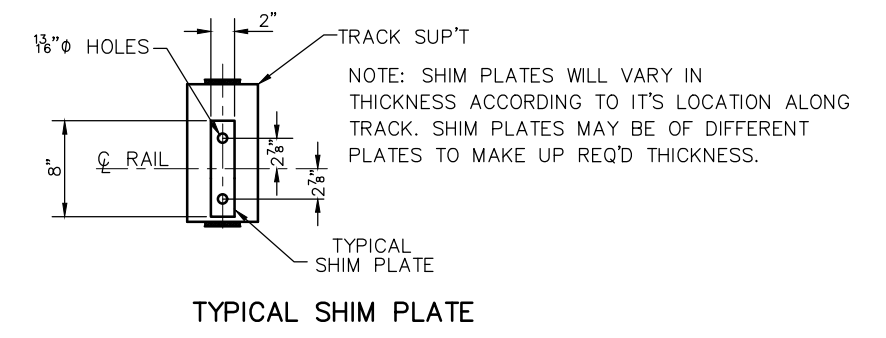


MODERN WELDING CO.
 AUGUSTA, GEORGIA
 NOVEMBER 12, 1997
 "AS BUILT DWG"

CERTIFIED FOR FABRICATION
 MANAGER: Robert Brown
 ENGINEER: Duke Oakes
 DATE: APRIL 17, 1997
 MODERN WELDING COMPANY
 OF AUGUSTA, GEORGIA

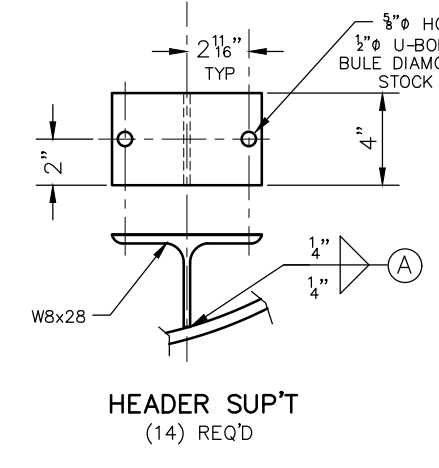
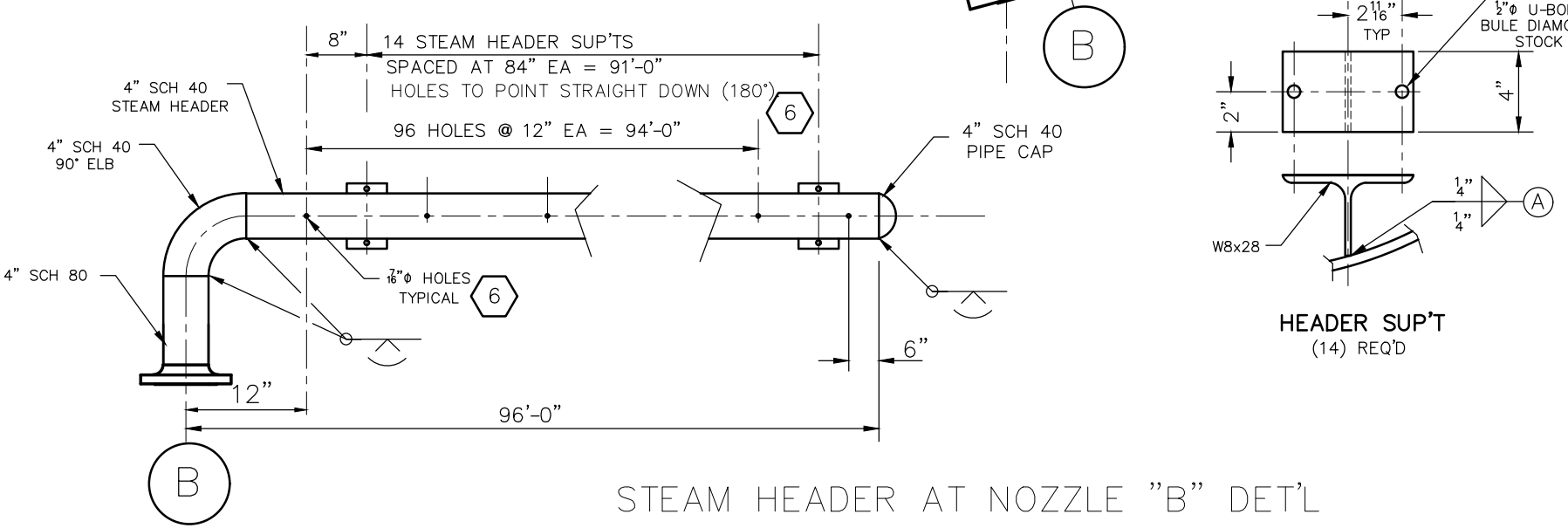
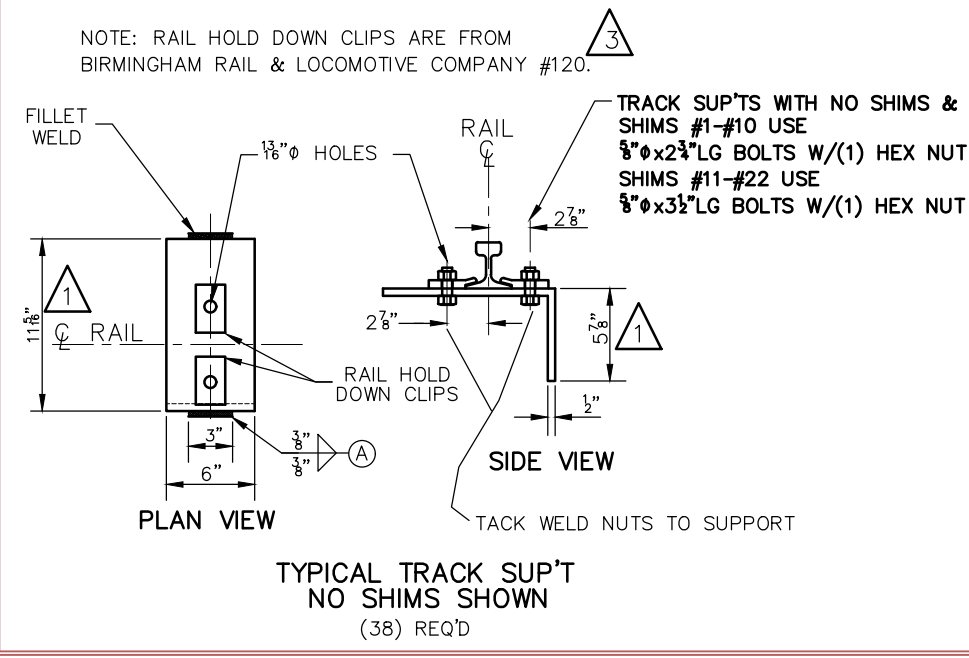
AS BUILT	11NOV 1997	4
ADDED JACK SUP'T	09JUN 1997	3
FOUNDATION SUP'T TAKEN OFF OF HOLD	13MAY 1997	2
CORRECT BOTH SADDLE HEIGHTS	05MAY 1997	1

ADD BASE PLATE FOUNDATION SUP'T DET'L. ADD NOTE TO GO TO W/INSIDE DOOR DIMENSIONS.	29APR 1997	1
ADDED SHOP NOTES, ANCHOR BOLTS NOW 2"Ø (2) REQ'D.	18MAR 1997	1
APPROVAL SET	22NOV 1996	1
REVISION	DATE	NO
# REQ'D (8) EIGHT	ITEM # A-H	
MODERN WELDING COMPANY OF GEORGIA INC. PO Box 10067 300 Prep Phillips Dr Augusta GA 30903		
SVANHOLM INTERNATIONAL, LTD. 82"ID x 105'-0" FACE/FACE		
DWN BY: <i>D.Oakes</i>	DATE 1996	SCALE NONE
CHK BY: <i>R.Brown</i>	JOB # 8065 REV. 1	DWG # 14-8065
APR BY: <i>R.Brown</i>	PO # AZ01-1001	SHT # 2 OF 3



MODERN WELDING CO.
AUGUSTA, GEORGIA
NOVEMBER 12, 1997
"AS BUILT DWG"

CERTIFIED FOR FABRICATION
MANAGER: Robert Brown
ENGINEER: Duke Oakes
DATE: APRIL 17, 1997
MODERN WELDING COMPANY
OF AUGUSTA GEORGIA



NO.	DESCRIPTION	DATE	BY	REASON
1	AS BUILT	12NOV 1997		
2	STEAM HOLES WERE 1/8". NOTE ADDED TO POINT STEAM HOLES STRAIGHT DOWN.	10JUL 1997		
3	GRIND ALL G-SEAMS FLUSH BETWEEN TRACK. ADDED (3) HOLES IN BOTTOM OF STEAM PIPE.	09JUN 1997		
4	ADDED EXTRA SET OF NUTS TO STEAM SUP'T. ADDED CUT LENGHT DET'L FOR RAIL END.	13MAY 1997		
5	CRANE RAIL CLIPS WERE 114	30APR 1997		
6	MOVED SHIM#18 TO FALL ON TRACK SPLICE	29APR 1997		
7	CRITICAL DIMENSION @ ENTRANCE WAS 2'-6" AND @ EXIT WAS 2'-7 1/2". ADDED VIEW "C-C", BENT PLATE WAS 9" WIDE & 4 3/8" HIGHT. PLACED END RAIL DET'L ON HOLD.	24APR 1997		

APPROVAL REVISIONS							
1	REVERSED SHIMS, ADDED CUSTOMER NOTE TO SEND SKETCH OF TRACK END.	18MAR 1997					
2	RENAMED ALL NOZZLES	22NOV 1996					
<table border="1"> <tr> <td># REQ'D</td> <td>ONE</td> <td>ITEM #</td> <td></td> </tr> </table>				# REQ'D	ONE	ITEM #	
# REQ'D	ONE	ITEM #					
MODERN WELDING COMPANY OF GEORGIA INC. PO Box 10067 300 Prep Phillips Dr Augusta GA 30903 PLANT #14 (706)722-3411 FAX: (706)724-8133							
SVANHOLM INTERNATIONAL, LTD. 82"ID x 105'-0" FACE-FACE							
DWN BY	D.Oakes	DATE	1996				
SCALE	NONE						
CHK BY	R.Brown	JOB #	8065 REV. C				
DWG #	14-8065						
APR BY	R.Brown	PO #	AZ01-1001				
SHT #	3 OF 3						