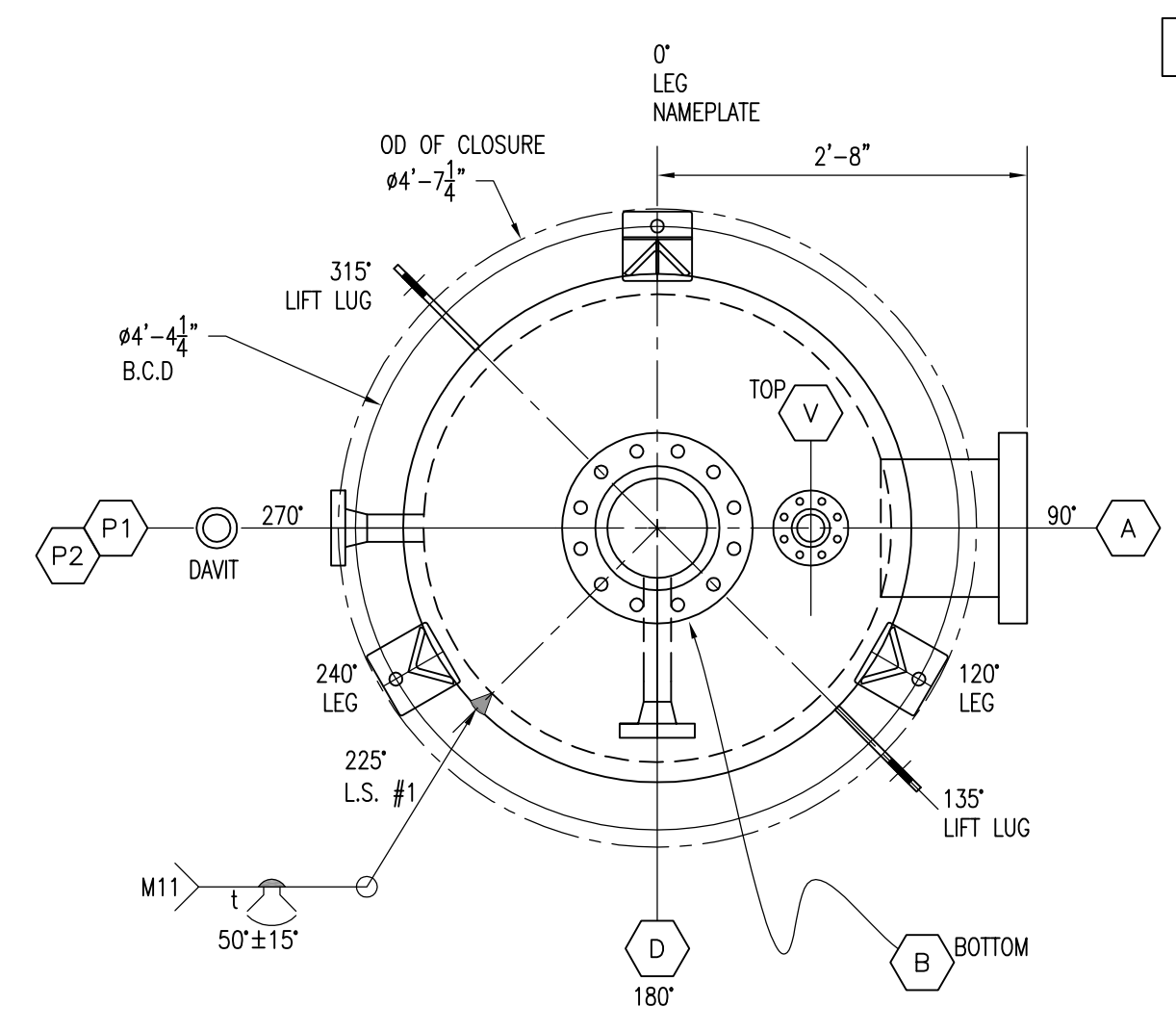
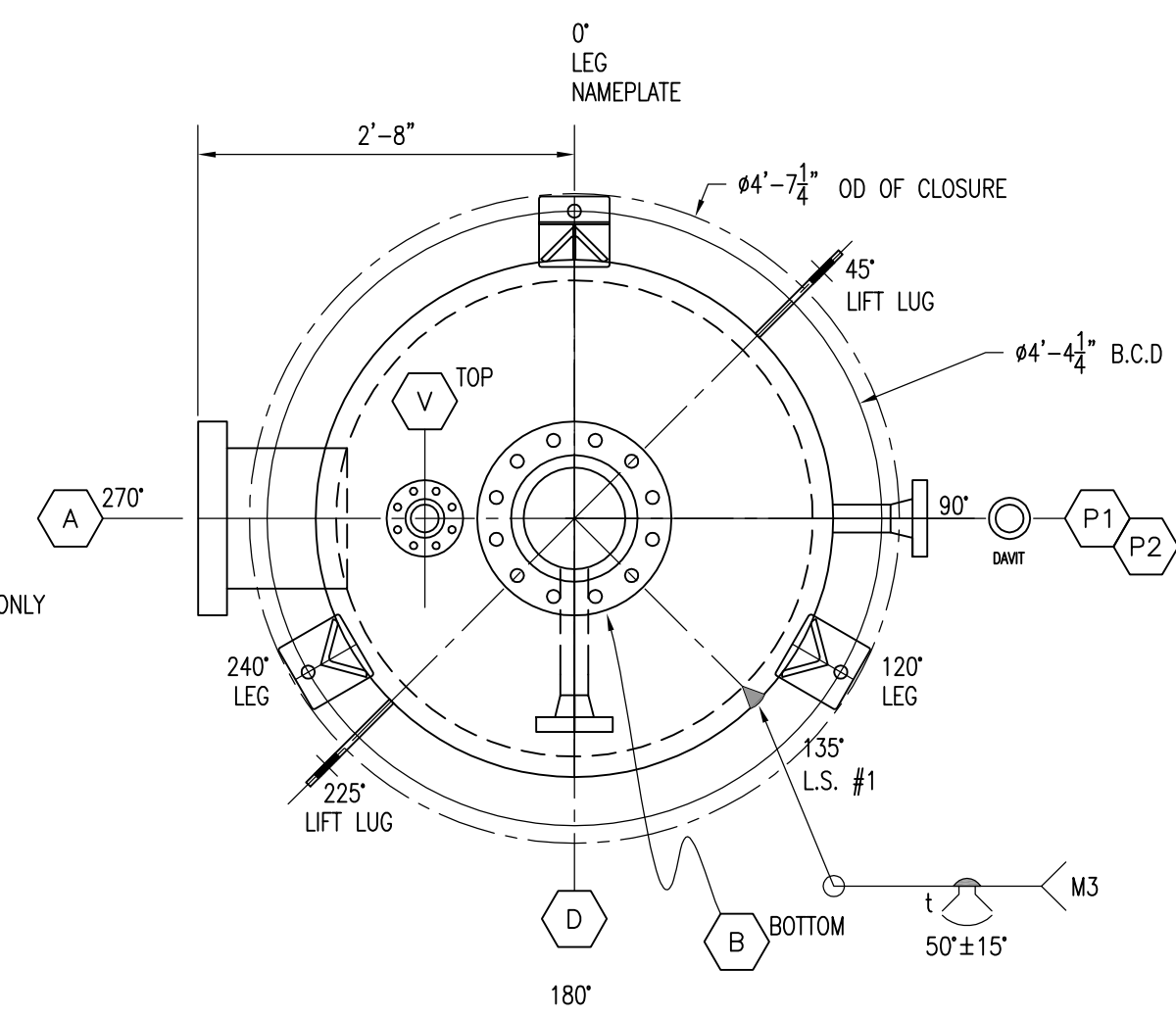


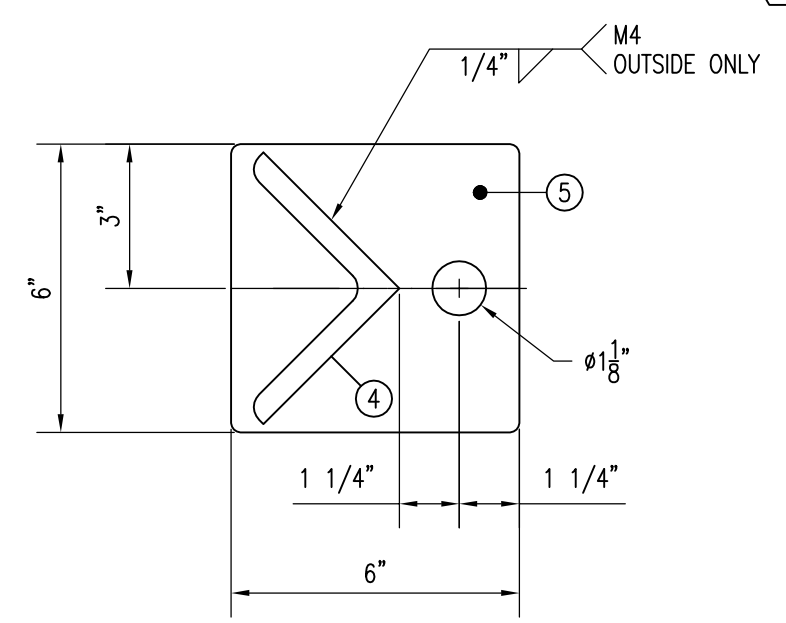
ELEVATION VIEW
(NOT A TRUE ORIENTATION)
SCALE 1:16



ORIENTATION VIEW, TAG F-1040
(CLOSURE REMOVED FOR CLARITY)
SCALE 1:16

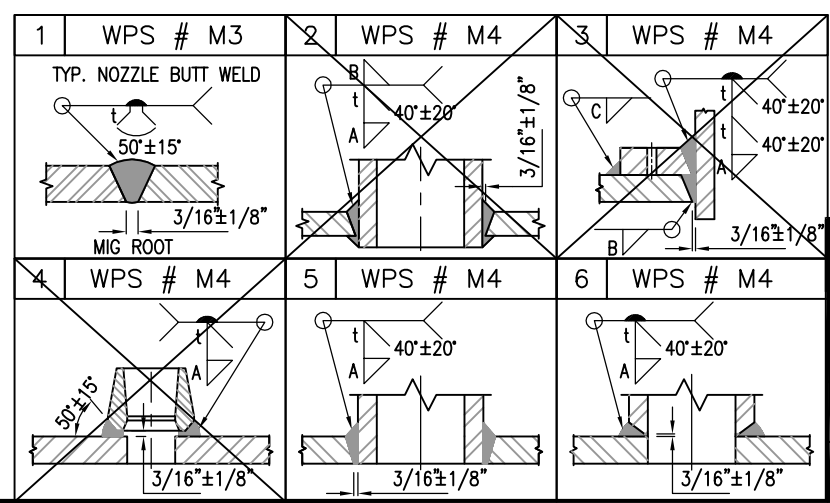


ORIENTATION VIEW, TAG F-1050
(CLOSURE REMOVED FOR CLARITY)
SCALE 1:16



LEG DETAIL
(3) - REQ'D
SCALE 1:4

- NOTES:
- WELD PROCEDURE W1425.2 A.Q.P. #1214(S)
 - ALL DIMENSIONS ± 1/8" UNLESS OTHERWISE NOTED
 - ALL BOLT HOLES TO STRADDLE CENTERLINE
 - USE TACK WELD PROCEDURE M4
 - RADIUS ALL CORNERS INSIDE 1/8"
 - CHARPY IMPACT TEST REQUIRED ON SHELL AND HEAD (ITEMS 1 AND 2) ALL OTHER ITEMS ARE IMPACT TEST EXEMPT PER UCS-66(b)
 - PRODUCTION IMPACT TESTING REQUIRED FOR 1 3/4" WELDS @ -20°F
 - UT SCAN PER UA-435 ON 1 3/4" THICK SHELL AND HEAD ON 4" GRID AND SCAN 2" FROM ALL WELD PREP'S
 - UT CAT "D" JOINTS BEFORE PWHT.
 - MPI CAT "D" JOINTS BEFORE & AFTER PWHT, BOTH INTERNALLY AND EXTERNALLY
 - PLATE MATERIAL CHEMISTRY REQUIREMENTS:
 - C.E. = $C + Mn/6 + (Cr+Mo+V)/5 + (Ni+Cu)/15 \leq 0.45$
 - Mn/C ≥ 2.5
 - S ≤ 0.003%
 - HIC TESTS ON SHELL & HEAD PER NACE TM0284 (INCLUSION SHAPE CONTROL PRACTICES-CALCIUM ADDITION)
 - HARDNESS:
 - 200 HBW IN WELD DEP.
 - 248 HV 10 IN HAZ
 - ALL PRESSURE RETAINING WELDS AND ALL CAT "D" WELDS > 6" DIA. REQ. HARDNESS TESTING WITH A MINIMUM OF THREE (3) TESTS PER WELD CATEGORY: PARENT METAL, WELD METAL & HAZ
 - MPI LIFT LUGS
 - PREHEAT MATERIALS ≥ 1" TO 200F
 - REMOVE ALL WELD SPATTER
 - GRIND SMOOTH AS REQUIRED AND AS ACCESS PROVIDES
 - PREP FOR INTERNAL COATING ONLY.
 - EXTERNAL PREP: SP-6 SANDBLAST ONLY
 - INTERNAL COATING AND EXTERNAL PAINT AND PRIMER - BY OTHERS
 - VESSEL REG'D UNDER DWG R4515-1 Rev. 0
 - REF DWG D4515-1 Rev. 0 FOR INTERNAL DETAILS
 - COVER ALL OPENINGS WITH 5/8" PLYWOOD PRIOR TO SHIPPING
 - BUILT TO CNRL GENERAL SPECIFICATION: PRESSURE VESSELS, SECTION #7.00, SUB-SECTION #7.02: SOUR SERVICE SUPPLEMENT FOR PRESSURE VESSELS.



VESSEL OPENING SCHEDULE										WELD SIZE		
NOZZ	REMARKS	SIZE	QTY	RATE	TYPE	BORE	EX. PRJ.	INT. PRJ.	WELD DET.	UPPER 'A'	INSIDE 'B'	REPAD 'C'
M	ACCESS	44"	1	600#	QOC	40.5"	-	-	-	-	-	-
V	VENT	2"	1	600#	RFLWN	-	-	-	-	-	-	-
P1,2	DPI	2"	2	600#	RFWN	160	8"	FLUSH	1.5	5/16"	-	-
D	DRAIN	2"	1	600#	RFWN	160	8"	FLUSH	1.5	5/16"	-	-
B	OUTLET	8"	1	600#	HBLWN	7 5/8"	AS SHOWN	FLUSH	5	1/2"	-	-
A	INLET	8"	1	600#	HBLWN	7 5/8"	10"	FLUSH	5	1/2"	-	-

LIST OF MATERIALS				
ITEM	QTY	DESCRIPTION	MATERIAL	
1	1	SHELL: 44" OD x 1 3/4" THK x 4'-0" S/S	BBE SA-516 70N	
2	1	HEAD: 44" OD x 1 3/4" NOM. THK. (1.625" MIN) 2:1 SE	SA-516 70N	
3	1	CLOSURE: 44" OD SENTRY CRN: OH5992.2513	SA-350-LF2	
4	3	LEGS: 4" x 4" x 1/2" ANGLE x 4'-7 11/16" LG.	G-44W	
5	3	BASE PLATE: 1/2" THK x 6" W x 6" LG.	G-44W	
6	3	LEG COVERS: 11 GA. PLATE (CUT TO SUIT)	C.S.	
7				
8	1	8"-600# HBLWN x 12 13/16" LG CONTOUR FLUSH	SA-105N	
9	1	8"-600# HBLWN x 12" LG	SA-105N	
10	3	2"-600" RFWN, SCH-160 BORE	SA-105N	
11				
12	2	2" PIPE SMLS, SCH-160 x 6 7/8" LG.	POE/BOE SA-106B	
13				
14	1	2" PIPE SMLS, SCH-160 x 5 3/8" LG.	BBE SA-106B	
15				
16	2	LIFT LUGS: SEE DWG LL-4515	SA-516 70N	
17				
18	1	NAMEPLATE BRACKET, 6" x 6" LG. & STANDOFF	G-44W	
19	1	MOSS FABRICATION NAMEPLATE	SS	

* - CUSTOMER SUPPLIED

NOTE:
NICKLE COATED
BY OTHERS

CNRL P.O.# 381000-002

CONSTRUCTION:	ASME SEC VIII, DIV 1, UW-11(a), 2010 EDITION
DESIGN PRESSURE:	1440 PSIG 9928 kPag
DESIGN TEMPERATURE:	130 deg F 54 deg C
TEST PRESSURE:	1872 PSIG 12906 kPag
M.D.M.T.:	-20 deg F @ 1440 PSIG -29 deg C @ 9928 kPag
RADIOGRAPHY:	RT-1 (100% INCLUDING NOZZLES)
M.A.W.P.:	1440 PSIG @ 130 deg F 9928 kPag @ 54 deg C
C.A.:	1/8 in. 3.2 mm SERVICE: SOUR
STRESS RELIEVE:	130 MINS @ 1150F +/- 25F
SHIPPING WEIGHT:	12500 lbs. 5670 kg. VOLUME: 42.3 cu. ft. 1.20 cu. m
SERIAL NUMBER:	4515-1,-2 YEAR BUILT: 2011
NUMBER REQ'D:	TWO (2) C.R.N.: V5432.2

DESIGN DATA				
7	AS BUILT	NOV. 10'11	AGL	KM NOV. 10'11
6	CLOSURE VENT, INC. WITH CUST. SUPPLIED CLOSURE	NOV.03'11	CL	KM NOV.03'11
5	DAVIT ORIENTATION CHANGE	OCT.05'11	CL	KM OCT.05'11
4	DIM. CHANGE TO CONN 'D', REVISION TO LIFT LUGS	SEPT.19'11	CL	KM SEPT.21'11
3	ORIENTATION CHANGES (P1/2, D)	SEPT.01'11	CL	KM SEPT.01'11
2	ISSUED FOR FABRICATION	AUG.24'11	CL	KM AUG.24'11
1	CLIENT MARK-UPS	AUG.17'11	CL	KM AUG.22'11
0	ISSUED FOR APPROVAL	AUG.03'11	AGL	KM AUG.11'11

REVISIONS

MOSS FABRICATION LTD.
CALGARY mossfab@mossfabrication.com ALBERTA

TITLE: 44" O.D. BAG FILTER HOUSING
1-36 SOURCE WATER WELL, TAGS: F-1040, F-1050
LSD: 01-36-080-22 W4M

SIZE: 18 x 24	DATE: MAY.31'11	DRAWN: AGL	CLIENT: PSN/CNRL
JOB No.: 4515	SCALE: AS SHOWN	PROJ. ENGR: CL	DRAWING No. V4515-1
			REV: 7

PLOTTED BY: draiding 11/10/2011 3:12:28PM PLOTTED: Y:\4501-6000\4515\4515-1.dwg