

9/8/2016

BWM-32

TITLE SEAM 16'-6" WAS 17'-9", ISSUED FOR FAB

02/10/2017 AS-BUILT: INCLUDED L.S. #s 3 & 4. ADDED MACH. BOSS NOTE

GENERAL NOTES:
1. QUALITY CONTROL PROGRAM NUMBER: AQP-1317(S)

2. WELDING PROCEDURE REGISTRATION NUMBER: WP1970.2
3. HEAD, SHELL & REPAD MATERIAL: SA-516-70N (IMPACT EXEMPT PER UG-20(f)(1-5))

4. FLANGE MATERIAL: SA-105-N (IMPACT EXEMPT PER UG-20(f)(1-5))
5. PIPE MATERIAL: SA-106-GRB (IMPACT EXEMPT PER UG-20(f)(1-5))

5. BOLTING MATERIALS: SA-193-B7M/SA-194-2HM (IMPACT EXEMPT PER UCS-66(c))

PRODUCTION IMPACTS: IMPACT EXEMPT PER UG-20(f)(1-5)

8. PREHEAT TO 250°F [121°C] ALL REPADS AND CAT D WELDS, REQUIRED FOR Cea > 0.4%

LENGTH

8'-2 7/8"

5'-1"

MATERIAL WEIGHT (lbs)

SA-516-70N

SA-516-70N

SA-516-70N

SA-516-70N

SA-516-70N

SA-333-GR6

SA-516-70N

SA-333-GR6

SA-105-N

SA-516-70N

SA-516-70N

2058.76

1857 08

12121.55

9282.06

6028.94

158.19

1521.97

167.57

90.52

325.81

33.52

408.55

310.53

37.58

35227.11

SELECT CHEMISTRY/HIC TESTING: NIL
 ULTRASONIC TESTING: 100% CAT D WELDS AND FILLET WELDS, WHERE ACCESSIBLE,

IF NOT ACCESSIBLE THEN MPI WILL BE USED

11. MAGNETIC PARTICLE TESTING: 100% OF FILLETS BEFORE PWHT MPI TEMPORARY ATTACHMENTS
MPI OF EXCAVATED AREAS DURING REPAIR ATTEMPT (IF NECESSARY)

12. RADIOGRAPHY: RT-1 PER UW-11(a), MAX 2 REPAIR ATTEMPTS, MIN 250°F FOR REPAIRS 13. VISUAL INSPECTION: ALL BUTT WELDS & FILLET WELDS

14. AIR SOAP LEAK TEST: RE-PADS ONLY AT 15 PSI 15. CORROSION ALLOWANCE: 1/8" [3.2mm] ON CARBON STEEL MATERIALS ONLY

STAINLESS STEEL TO BE EXEMPT 16. PWHT: YES AS PER UCS-56

HEAT FROM AMBIENT TO 800°F AT MODERATE RATE HEAT FROM 800°F TO 1150°F AT 400°F/HR HOLD AT 1150°F FOR 60 MINUTES COOL FROM 1150°F TO 800°F AT 500°F/HR FROM 800°F TO 300°F, AIR COOL IN FURNACE

PROTECT FLANGE FACES DURING PWHT 17. PWHT STENCIL - "POST WELD HEAT TREATED, DO NOT FLAME CUT OR WELD

ON THIS VESSEL"

18. HARDNESS TESTING: NIL

19. HYDROTEST: YES, 25 PSI, CHARTED 8 HOURS, NO DEAD WEIGHT 20. ALL WEAR PADS & REPADS TO HAVE 1/4" NPT WEEP HOLE LOCATED

AT LOWEST ELEVATION
21. EXTERNAL SANDBLAST: SSPC-SP5

22. EXTERNAL COATING:
PRIMER VESSEL: ONE (1) COAT GLIDDEN/DEVOE CATHA-COAT 304

TOPCOAT VESSEL: NIL
PRIMER STRUCTURAL: ONE (1) COAT DEVOE CATHA-COAT 304 INTERMEDIATE COAT: ONE (1) COAT DEVOE BAR-RUST 236 TOPCOAT STRUCTURAL: ONE (1) COAT DEVOE DEVTHANE 379

(COLOR: DARK GRAY FSC 26134)

23. INTERNAL SANDBLAST: NIL

24. INTERNAL COATING: NIL
25. WEIGHT FULL OF WATER: 255,000 LBS [115,675 kg]

26. INSULATION: MINERAL INSUL, 3" STARTING 24" FROM BTM SEAM C/W AL CLADDING

27. STRUCTURAL BASED ON S.G.=1.82 & HHLL=3'-5" FROM DATUM

28. ALL BOLT HOLES TO STRADDLE CENTERLINE

29. ALL OUTSIDE PROJECTIONS ARE TO BE MEASURED ALONG CENTERLINE OF NOZZLE

30. ALL INSIDE PROJECTIONS ARE TO BE MEASURED ALONG THE SHORTSIDE OF THE NOZZLE

31. FABRICATION TOLERANCES AS PER BW&ML DWG: T0L2002

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ΔD

1AM IDW

NHH JAM JDW

32. VESSEL REGISTRATION: NOT REQUIRED
33. VESSEL SERIAL NUMBER: 17135

## **DESIGN SPECIFICATIONS**

DESIGN & FABRICATE TO: 2015 EDITION ASME BOILER & PRESSURE VESSEL CODE SECTION VIII, DIVISION 1 DESIGN PRESSURE & TEMPERATURE: 14.9 PSI @ 351°F [103 kPa @ 177°C]

DESIGN EXTERNAL PRESSURE: NIL

MINIMUM DESIGN METAL TEMP: \_-20°F @ 14.9 PSI [-29°C @ 103kPa]

IMPACT TESTS: SEE NOTES 3-7

RADIOGRAPHY: RT-1 PER UW-11(a)

POST WELD HEAT TREATMENT: YES PER UCS-56 SEE NOTE 8 FOR PREHEAT HYDROSTATIC TEST PRESSURE: YES, 25 PSI [172 kPa] PREHEAT: 60°F [16°C]

CORROSION ALLOWANCE: 1/8" [3.2 mm] MAWP: 14.9 PSI @ 351°F [103 kPa @ 177°C]

HEAD THK. MIN.: 0.500" [12.700 mm] VOLUME: 3,536 ft<sup>3</sup> [100 m<sup>3</sup>]

WEIGHT EMPTY: 35,000 LBS [15,875 kg] WEIGHT FULL: 255,000 LBS [115,675 kg]

## WESTCOAST ENERGY INC.

174" OD x 16'-6" [4420mm x 5029mm] SULPHUR TAIL GAS COALESCER- TAG#: PV 17.43A VESSEL ASSEMBLY

QUOTE NUMBER: 07961	SALE ORDER: 004470	
	JOB ORDER:	SIZE
LOCATION: CHETWYND, BC	D3468	D
DATE: 03/15/2016	DOTOO	U
SHEET: 2 OF 8	DRAWING NO.:	REV.
CRN DWG: N/A	D3468-201	2
CRN NUMBER: N/A	D3400-201	5