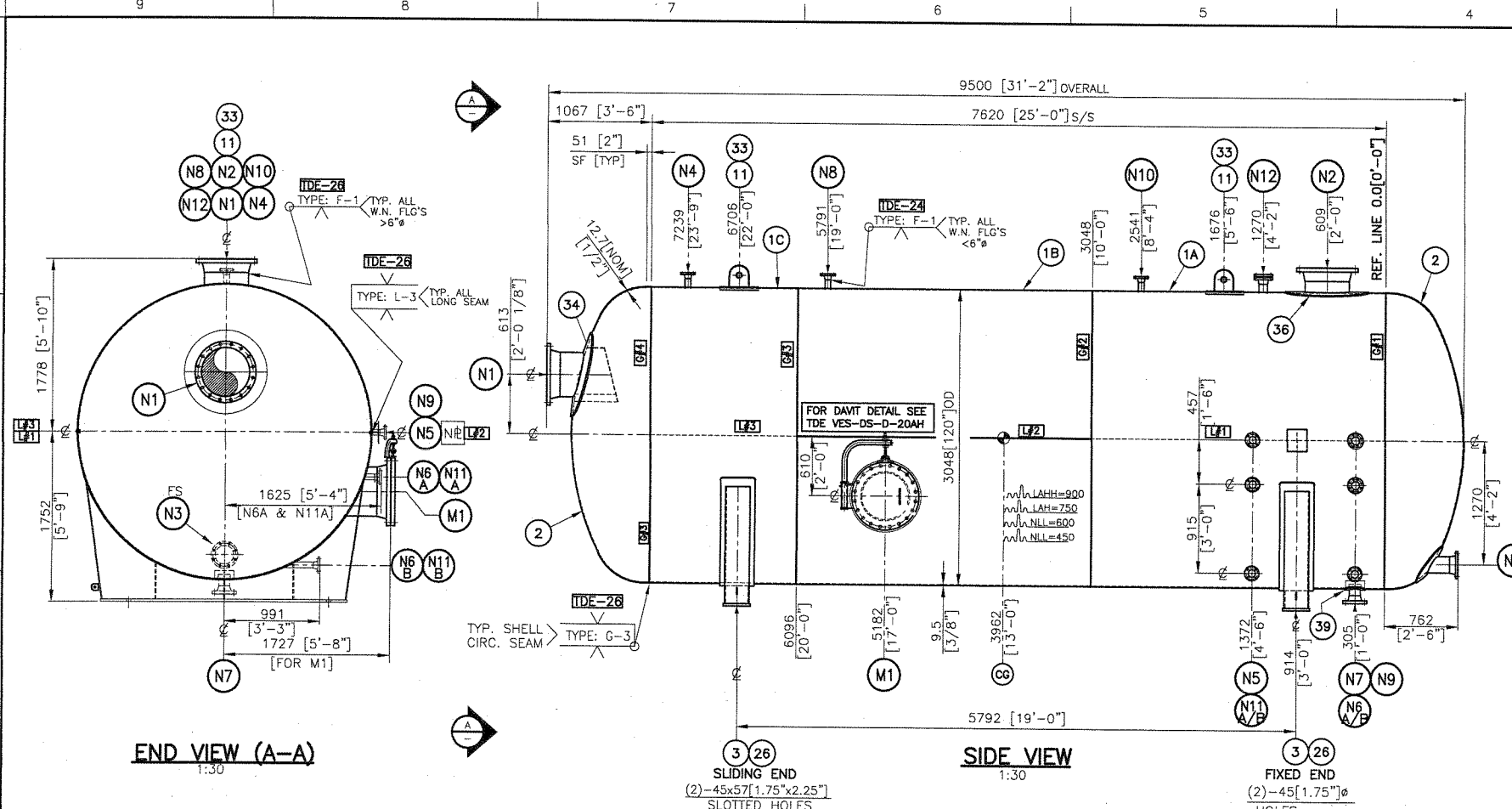
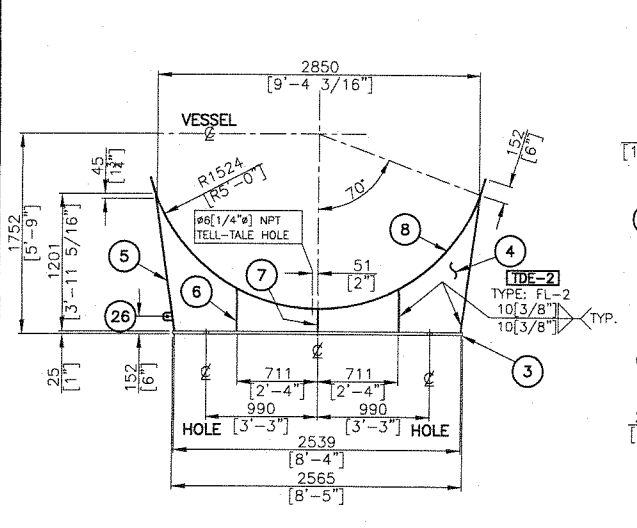


PRINTED: Tuesday, July 15, 2014 11:49:14 AM DWG NAME: H:\PROJECTS\New NDS\Design\Drawing\Wess\DR\VES\DR-40-ME-DR-0004-1-1 Rev. DR Cryogenic Flare Knock Out Drum 003-09-0300 SNA3491.dwg
 UPDATED: Tuesday, July 15, 2014 11:49:12 AM DR: Sroitz



NOZZLE SCHEDULE AND NOZZLE WELDING DETAILS													
TYPE: F-1	TYPE: L-1-G-1	TYPE: L-3-G-3	TYPE: N-1-C-1	TYPE: N-2-C-2	TYPE: N-2-R	TYPE: FL-1	TYPE: FL-2						
MARK QTY		SIZE	CLASS TYPE	SCH	SERVICE	PROJECTION	REPAID	WELDING	FILLET WELD SIZE	NOZZLE	BILL OF MATERIAL	WELD	
						OUTSIDE	INSIDE	WIDTH	THICK	A	B	C	D
N1	1	450 [18"]	150	RFWN	40S	GAS INLET	254 [10"]	---	---	N-2R	10 [3/8"]	---	---
N2	1	450 [18"]	150	RFWN	40S	GAS OUTLET/PSV	254 [10"]	---	---	N-2R	10 [3/8"]	---	---
N3	1	150 [6"]	150	RFWN	40S	ELECTRIC HEATER	---	---	---	N-2R	10 [3/8"]	---	---
N4	1	50 [2"]	150	RFWN	80S	DEEP CUT CLOSED DRAIN INLET	152 [6"]	---	---	N-2	10 [3/8"]	---	---
N5	1	50 [2"]	150	RFWN	80S	PIT	152 [6"]	---	---	N-2	10 [3/8"]	---	---
N6	2	50 [2"]	300	RFWN	80S	LG/LIT	---	---	---	N-2	10 [3/8"]	---	---
N7	1	100 [4"]	150	RFWN	80S	LIQUID TRUCK OUT	152 [6"]	---	---	N-2R	10 [3/8"]	---	---
N8	1	50 [2"]	150	RFWN	80S	FUEL GAS	152 [6"]	---	---	N-2	10 [3/8"]	---	---
N9	1	50 [2"]	150	RFWN	80S	TIIT	152 [6"]	---	---	N-2	10 [3/8"]	---	---
N10	1	50 [2"]	150	RFWN	80S	SPARE c/w VALVE	152 [6"]	---	---	N-2	10 [3/8"]	---	---
N11	2	50 [2"]	150	RFWN	80S	LIT	---	---	---	N-2	10 [3/8"]	---	---
N12	1	80 [3"]	150	RFWN	80S	VENTILATION CONN. c/w BLIND	152 [6"]	---	---	N-2	10 [3/8"]	---	---
M1	1	500 [20"]	150	RFWN	40S	MANWAY c/w BLIND	---	---	---	N-2R	10 [3/8"]	---	---

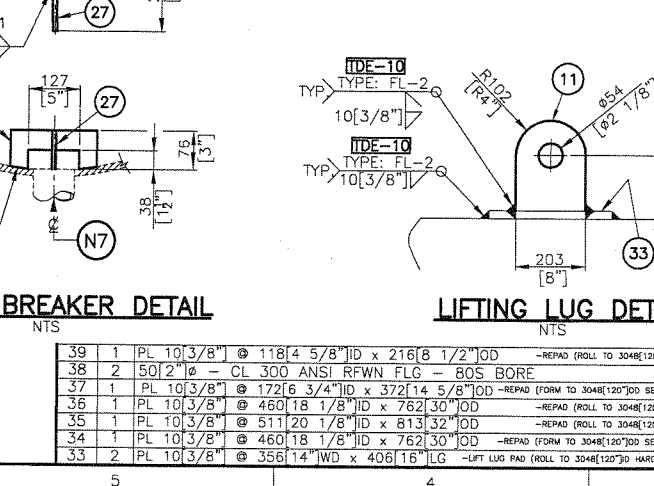
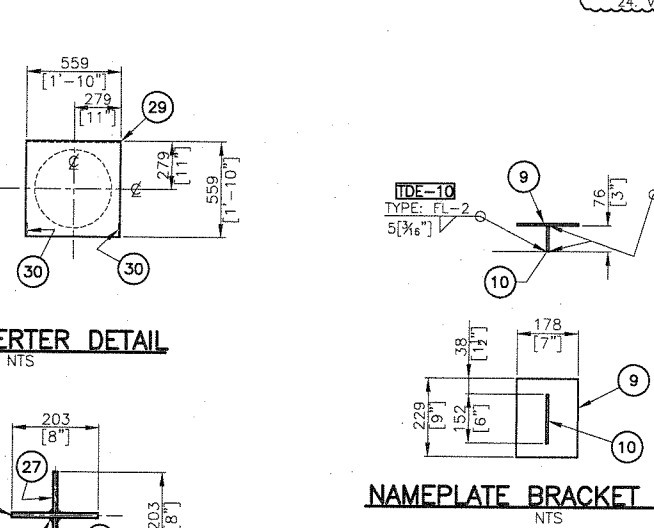
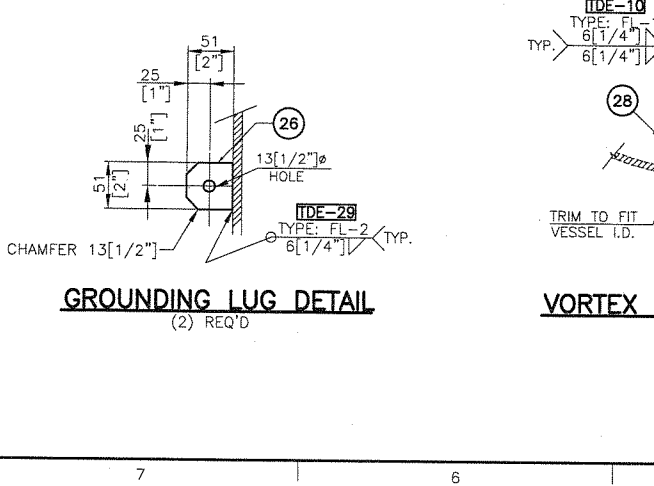
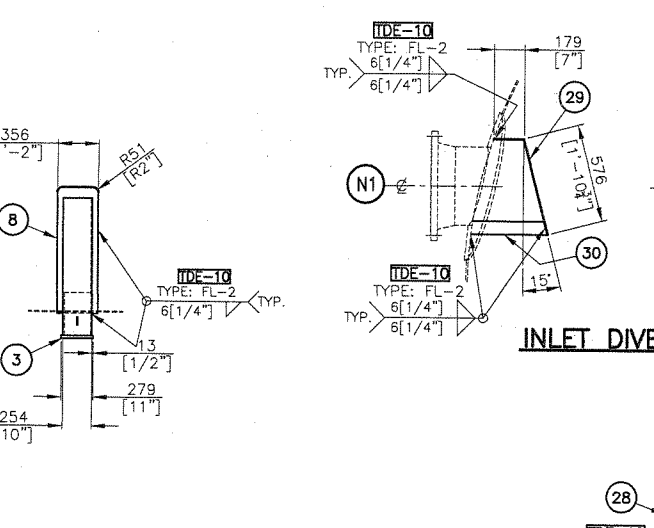
- GENERAL NOTES:**
- DESIGN & CONSTRUCTION IN ACCORDANCE WITH ASME CODE, SECTION VIII, DIV. I, 2010 EDITION, 2011 ADDENDA.
 - PROCESS REQUIREMENTS: 350 kPag @ 93°C [50 psig @ 200°F].
 - MAMP: 876 kPag [98 psig], (LIMITED BY HEADS).
 - HYDROSTATIC TEST: 876 kPag [127 psig], FOR 60 MINUTES (CHART RECORDED)
 - CORROSION ALLOWANCE: 0 mm [0"]
 - POST WELD HEAT TREATMENT: NOT REQUIRED.
 - RADIOGRAPHY: RT-1, PER UW-11(a) AND 20% NOZZLE TO FLANGE BUTT WELDS
 - MINIMUM DESIGN METAL TEMP.: -128°C [-198°F] @ 676 kPag [98 psig]
 - WELDING: EXEMPT PER UHA-51(d)(1)(a). WELDING CONSUMABLES TO BE USED SHALL BE QUALIFIED TO -188°C [-198°F]
 - USE "TDE" WPS#: 861.2 (TDE-10, TDE-24, TDE-26)
 - PAINT: PER (GS-6100) P1; SURFACE PREPARATION SSPC SP-6. PRIMER: IMMERSION GRADE EPOXY 4-6 MILS DFT. FINISH: URETHANE 2-4 MILS DFT. (ON SADDLES ONLY). FINISH COLOR LIGHT GREY. (ON SADDLES ONLY)
 - INSULATION: N/A
 - SHIPPING WEIGHT: 8618 kg [19000 lb]; HYDRO: 71668 kg [158000 lb]
 - CAPACITY: 63 m³ [2223 ft³]
 - REMOVE ALL WELD SLAG.
 - VESSEL TO BE THOROUGHLY CLEANED INSIDE & OUTSIDE.
 - PSV: ON PIPING.
 - ALL NOZZLE NECKS TO BE ROUNDED w/ MIN. RADIUS OF 3 mm [1/8"] FROM VESSEL INTERIOR.
 - MANUFACTURING TOLERANCES TO TDE VESSEL DESIGN STANDARD (DWG. No.: DS-VES-TOLERANCES) OR RELEVANT CODE SECTION.
 - 100% UT OF CAT "D" WELDS.
 - ALL RE-PADS SHOULD HAVE 6mm [1/4"] NPT TELL-TALE HOLE.
 - RE-PAD AIR TEST: 175 kPag [25.4 psig]
 - ALL AREAS WHERE TEMPORARY ATTACHMENTS HAVE BEEN REMOVED, ARC STRIKES GROUND AND BACK GOUGED AREAS MUST BE LIQUID PENETRANT TESTED.
 - VESSEL PRODUCTION WELDS TO BE FERRITE TESTED FN-3-10.



CONTROLLED RELEASE

JUL 16 2014

SIGNED: *mtw*



MARK QTY	SIZE	CLASS TYPE	SCH	SERVICE	PROJECTION	REPAID	WELDING	FILLET WELD SIZE	NOZZLE	BILL OF MATERIAL	WELD
32	1	80 [3"]	150	RFWN	40S	GAS INLET	---	---	N-2R	10 [3/8"]	---
31	1	80 [3"]	150	RFWN	40S	GAS INLET	---	---	N-2R	10 [3/8"]	---
30	2	PL 6 [1/4"]	---	---	---	---	---	---	---	---	---
29	1	PL 6 [1/4"]	---	---	---	---	---	---	---	---	---
28	1	FB 76x6 [3 x 1/4"]	---	---	---	---	---	---	---	---	---
27	2	FB 76x6 [3 x 1/4"]	---	---	---	---	---	---	---	---	---
26	2	FB 51x6 [2 x 1/4"]	---	---	---	---	---	---	---	---	---
25	9	50 [2"]	150	RFWN	80S	SML'S PIPE	---	---	N-2R	10 [3/8"]	---
24	7	50 [2"]	150	RFWN	80S	SML'S PIPE	---	---	N-2R	10 [3/8"]	---
23	1	80 [3"]	150	RFWN	40S	SML'S PIPE	---	---	N-2R	10 [3/8"]	---
22	1	80 [3"]	150	RFWN	40S	SML'S PIPE	---	---	N-2R	10 [3/8"]	---
21	1	100 [4"]	150	RFWN	80S	SML'S PIPE	---	---	N-2R	10 [3/8"]	---
20	1	100 [4"]	150	RFWN	80S	SML'S PIPE	---	---	N-2R	10 [3/8"]	---
19	1	150 [6"]	150	RFWN	80S	SML'S PIPE	---	---	N-2R	10 [3/8"]	---
18	1	150 [6"]	150	RFWN	80S	SML'S PIPE	---	---	N-2R	10 [3/8"]	---
17	2	450 [18"]	150	RFWN	40S	SML'S PIPE	---	---	N-2R	10 [3/8"]	---
16	2	450 [18"]	150	RFWN	40S	SML'S PIPE	---	---	N-2R	10 [3/8"]	---
15	1	GASKET & BOLTING FOR 500 [20"]	---	---	---	---	---	---	---	---	---
14	1	500 [20"]	150	RFWN	40S	SML'S PIPE	---	---	N-2R	10 [3/8"]	---
13	1	500 [20"]	150	RFWN	40S	SML'S PIPE	---	---	N-2R	10 [3/8"]	---
12	1	500 [20"]	150	RFWN	40S	SML'S PIPE	---	---	N-2R	10 [3/8"]	---
11	2	PL 19 [3/4"]	---	---	---	---	---	---	---	---	---
10	1	PL 6 [1/4"]	---	---	---	---	---	---	---	---	---
9	1	PL 6 [1/4"]	---	---	---	---	---	---	---	---	---
8	2	PL 10 [3/8"]	---	---	---	---	---	---	---	---	---
7	2	FB 178x10 [7 x 3/8"]	---	---	---	---	---	---	---	---	---
6	4	FB 229x10 [9 x 3/8"]	---	---	---	---	---	---	---	---	---
5	4	FB 254x10 [10 x 3/8"]	---	---	---	---	---	---	---	---	---
4	2	PL 10 [3/8"]	---	---	---	---	---	---	---	---	---
3	2	PL 25 [1"]	---	---	---	---	---	---	---	---	---
2	2	HEAD: 3048 [120"] OD x 9.5 [0.375"] THK ROLLED PL. @ 7620 [25'-0"] LG	---	---	---	---	---	---	---	---	---
1	1	SHELL: 3048 [120"] OD x 9.5 [0.375"] THK ROLLED PL. @ 7620 [25'-0"] LG	---	---	---	---	---	---	---	---	---

ITEM QTY	REVISION	DATE	MATERIAL DESCRIPTION	DATE	APPROVED	MATERIAL
1	1	4.07.15				
2	1	7.16.14				

FERRIER CENTRAL PROCESSING FACILITY

DEVON CANADA c/o WORLEY PARSONS

VESSEL ASSEMBLY DRAWING
3048mm [120"] OD x 7620mm [25'-0"] S/S
CRYOGENIC FLARE KO DRUM

12-118 AS SHOWN (1:30)

#3491 003-V-09-0300 DFR-40-ME-DR-0004