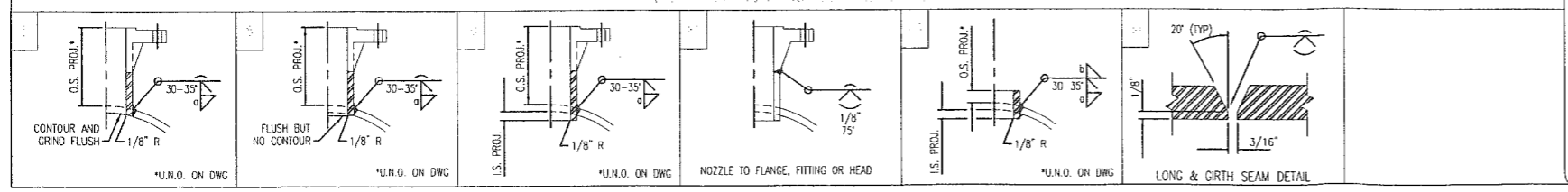


REF. DWG. No.	ITEM	QTY.	U/M	DESCRIPTION	MATL.
	1	2	EA	HEAD, ASME 2:1 ELLIP.; 30" I.D., 0.250" MIN. THK., 0.3125" NOM. THK. w/ 2" SF	SA516-70
	2	1	EA	PLATE; 3/8" THK. x 36" x 95 7/16", ROLLED TO 30" I.D. x 36" LG	SA516-70
	3	1	EA	FLANGE; 3"-150# RF WN, SCH 80 BORE	SA-105
	4	3	EA	FLANGE; 2"-150# RF WN, SCH 160 BORE	SA-105
	5	1	LF	PIPE; 3" SCH 80 PIPE, SMLS	SA106-B
	6	2	LF	PIPE; 2" SCH 160 PIPE, SMLS	SA106-B
	7	2	EA	COUPLING, FULL; 1"-3000# (NPT)	SA-105
	8	4	EA	PLATE; 1/2" THK. x 4" x 4"	SA-36
	9	17	LF	ANGLE; 3" x 3" x 3/8" (CUT AS REQ'D)	SA-36
	10	1	EA	ASME CODE PLATE	316SS
500,031	11	1	EA	STD NAME PLATE BRACKET	SA36
	12	2	EA	PLATE; 3/8" THK. x 4" x 6 5/8" LG	SA516-70
	13	2	EA	PLATE; 3/8" THK. x 2" x 2"	SA516-70
	14	1	EA	ELBOW, WELD; 2" SCH 160 90° SR	SA234-WPB
	15	1	EA	PLATE; 1/4" THK. x 3" x 7 1/2" LG	SA516-70

MARK	REQD	DESCRIPTION	SERVICE	NECK	PROJECTION	REINFORCING PAD SIZE	WELDING DETAIL NO.	WELD SIZE	REMARKS	BOM ITEMS
N5	1	3"-150# RF WN	DISCHARGE TO P420	3 1/2"	80	SEE ELEV	-	3, F1	1/4"	3,5,15
N4A/B	2	1"-3000# CPLG	LEVEL GAUGE	1 3/4"	-	1 5/8" 3/8"	-	C3	1/4" 3/8"	7
N3	1	2"-150# RF WN	VENT/PSV	2 3/8"	160	SEE ELEV	-	5, F1	1/4"	4,6
N2	1	2"-150# RF WN	FILL	2 3/8"	160	SEE ELEV	-	5, F1	1/4"	4,6
N1	1	2"-150# RF WN	COOLING OIL INLET	2 3/8"	160	SEE ELEV	-	10, F1	1/4"	4,6,14



NAT'L. BD. NO. 385

CERTIFIED BY:  
**ITS**  
ITS Engineered Systems, Inc.

213 PSIG AT 350° F  
MAWP

30" I.D. x 3'-0" S/S  
SIZE

-20° F @ 200 PSI  
MDMT

1695  
JOB#

1695-4  
SERIAL#

2003  
YEAR BUILT

BUILT FOR:  
ITS ENSYN L.L.C.  
COOLING OIL SURGE DRUM, V-410  
P.O. No. 114026-003P

NAMEPLATE BRACKET WELD DETAIL

TOLERANCES UNLESS SPECIFIED OTHERWISE  
PIPING AND STRUCTURAL DIMENSIONS ± 1/4"  
MACHINING ± .010"  
CONCENTRICITY .010" TIR  
FINISH 250

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IN ACCORDANCE WITH ASME CODE - SEC. VIII, DIV. 1, 2001 EDITION; A-02 ADDENDA.  
CODE STAMP REQ'D: YES NAT'L. BD. NO. REQ'D: YES OUTSIDE INSP. REQ'D: NO

ADD'L SPECS: NONE

DESIGN PRESS: 200 PSI AT DESIGN TEMP: 350 °F  
MAWP (INT): 213 PSI AT MAX TEMP: 350 °F  
MAWP (EXT): AT MAX TEMP:

LIMITED BY: FLANGES  
MDMT: -20 °F AT: 200 PSI  
JOINT EFFICIENCY (HEAD): 70% JOINT EFFICIENCY (SHELL): 70%  
RADIOGRAPHY: NONE STRESS RELIEVE: NONE  
HYDRO TEST PRESS: 260 PSI BASED ON: 1.3 x D.P.  
CORROSION ALLOWANCE: 0.0625" LETHAL SERVICE: NO

ADD'L NDE/NDT:

MATERIAL: (DOMESTIC OR FOREIGN) MILL TEST REPORTS REQ'D: PRESS. RETAIN'G MTL

SHELL: SA516-70 FLG/CPL: SA105  
HEADS: SA516-70 PIPE: SA106-B SMLS  
HEAD TYPE: 2:1 ELLIP. EXT ATTACH: SA36, SA516-70  
FITTINGS: INT ATTACH: NONE  
STUDS/NUTS: SA193-B7/SA194-2H INSULATION: NONE  
GASKETS: SUPPORTS: SA516-70/SA36

PAINTING:  
EXTERNAL:  
SURFACE PREP: PER SSPC-SP10  
COAT 1: ZINC PRIMER, 2-3 MILS DFT  
COAT 2:  
COAT 3:  
INTERNAL: NONE

SHIPPING WT: 696 LBS WT FULL OF WATER: 1972 LBS

- NOTES (INCLUDES DIMENSIONS):
- WELD PER ASSIGNED PROJECT WELDING LIST-1695.
  - GRIND ALL ROUGH EDGES & CORNERS. RADIUS ALL NOZZLES 1/8" MINIMUM RADIUS.
  - FLANGED BOLT HOLES TO STRADDLE NORMAL CENTER LINES.
- SUPPLY LISTS:
- ALL EXPOSED NOZZLE FACES TO BE FITTED W/ APPROPRIATE PLASTIC NOZZLE PROTECTORS.

ISSUED FOR FABRICATION

REV.	DATE	DESCRIPTION	DWN	CHK
0				

ITS ENGINEERED SYSTEMS, INC.  
a subsidiary of OFFSHORE TOOL & BERRY CORPORATION

30" I.D. x 3'-0" S/S COOLING OIL SURGE DRUM, V-410  
RTP DEMONSTRATION PLANT  
ITS ENSYN L.L.C.

APP. BY: 1695 ACCT. No. DATE: 800,930 SCALE: 1:8  
JOB No. SHT. 1 OF 1 REV. 0