



ITEM	P/N	DESCRIPTION	QTY
1	H30313J	HEAD 30.00 OD 0.293M/0.313N CS SA516-70 SE 2:1 JOG	2
2	A10051-300-SL	SHEL BURNT 0.313 SA455 54.25 X 30.00 OD	1
3	F102001	WELD FLG 2.000 NPT CS SA181-70 RAD 958 O/R	3
4	F101000	WELD FLG 1.000 NPT CS SA181-70 FLAT 255	3
5	F100500	WELD FLG 0.500 NPT CS SA181-70 FLAT 253	1
6	F100250	WELD FLG 0.250 NPT CS SA181-70 FLAT 251	1
7	S102186	SKIRT ASY. 23.5 OD W/8.000\"/>	

**SHELL CUT SIZE IS REFERENCE ONLY
 **CPLG & FITTING 0.50 EXT PROJ TYP
 **HEAD THICKNESS SHOWN IS SPECIFIED MINIMUM
 **RADIUS INSIDE PROJECTED EDGES OF NOZZLES 1/8\"/>

FRONT VIEW TRUE ELEVATION

REV	DATE	DESCRIPTION	ENG	QCM	AI/DATE
3	10/15/18	UPDATED TO DIVISIONAL WELD PROCEDURES	MG	BW	NA
4	12/3/2020	UPDATED CRN	RM	N/A	N/A
5	8/3/21	ADDED JOINT DETAIL SKETCH	RM	N/A	

TRAVELER REQUIRED No FIXTURE REQUIRED No IF YES THEN FIXTURE # _____

RELEASED TO PRODUCTION		TOLERANCES ARE PER EN1370 STEEL FAB STANDARD TOLERANCES UNLESS OTHERWISE SPECIFIED		DESIGN & CALCULATIONS COMPLY WITH ASME CODE SECTION VIII, DIV1. LATEST EDITION	
SALES ORDER#		QTY:		SPVG STOCK	
RELEASE DATE:		NB/SERIAL#			
HEAD THK: <u>.293</u> MIN C.A.: --- MAT'L <u>SA516-70</u> EFF <u>85</u> %		NAT'L BD: YES STAMP " U "		ENG. APP'L / DATE SAB - 12/14/2011	
SHELL THK: <u>.313</u> NOM C.A.: --- MAT'L <u>SA455</u> EFF <u>70</u> %		VOLUME: APPROX 200 GAL		QCM. APP'L / DATE JP-12/16/2011	
MAY 2018		MAWP <u>300</u> PSI AT <u>400</u> °F		A.I. VERIFICATION / DATE BQ-12/16/2011	
SHIPPING WEIGHT: 695 LBS		MDMT <u>-20</u> °F AT <u>300</u> PSI		STEEL FAB	
CRN: L4037.56789012NTY3		TEST: HYDRO AT <u>390</u> PSI			
		TEST: PNEU AT --- PSI		BURLINGTON, ONT LEBANON, VA	
		DATE: 12/13/2011		DRAWN BY: KRG P/N A10051-300	

FINISH SPECIFICATION

ALL TANKS REQUIRE:
 INTERIOR AND EXTERIOR TO BE FREE OF WELD
 SPATTER, DRY INTERIOR AFTER HYDROTEST, VACUUM
 INTERIOR FREE OF LOOSE PARTICLES

PRE-ASSEMBLY SURFACE PREP:

POST-ASSEMBLY SURFACE PREP:

EXTERIOR FINISH:

POWDER PAINT EXT STD GRAY PRIMER (PL216QF)

INTERIOR FINISH:

** DO NOT PAINT SEALING SURFACES OF FLANGES **
 ** DO NOT PAINT STAINLESS STEEL NAMEPLATES **

ADDITIONAL NOTES:

OUTSIDE SERVICE VERIFICATION

WHEN PRODUCT IS SHIPPED DIRECT TO CUSTOMER FROM VENDOR,
 OUTSIDE VENDOR SHALL SIGN OFF INDICATING ACCEPTANCE OF
 ALL CRITERIA ON FINISH SPECIFICATIONS. FINISH SPECIFICATIONS
 SHALL BE SIGNED BY VENDOR & RETURNED TO STEEL FAB AFTER
 JOB IS COMPLETE.

SIGNED _____ DATE _____

SHIPPING AND PACKAGING

GENERAL NOTES

PLUG ALL UNPLUGGED OPENINGS WITH PLASTIC PLUGS AFTER PAINTING
 BUILD SKID SO THAT TANK DOES NOT EXTEND BEYOND EDGES OF SKID
 USE FOAM UNDER BANDS

REFER TO SHOP ORDER - SHIPPING WORK GUIDELINES, FOR ADDITIONAL
 INSTRUCTIONS (IF APPLICABLE)

PACKAGING MATERIALS

REFER TO PALLET DRAWING _____

PALLET SIZE ___ X ___ COLOR CODE: _____

STACK PER PALLET DRAWING USING CARDBOARD, BANDS, FOAM, AND
 SHRINK WRAP AS APPLICABLE

ADDITIONAL SHIPPING INSTRUCTIONS

DOCUMENTATION

WELD JOINT DETAILS

DESIGN & CALCULATIONS COMPLY WITH ASME CODE SECTION VIII, DIV1. LATEST EDITION			
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	A.I. VERIFICATION / DATE BQ-12/16/2011		
STEEL FAB			
BURLINGTON, ONT.		LEBANON, VA	
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