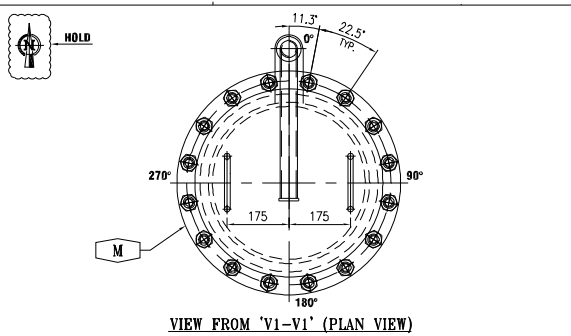
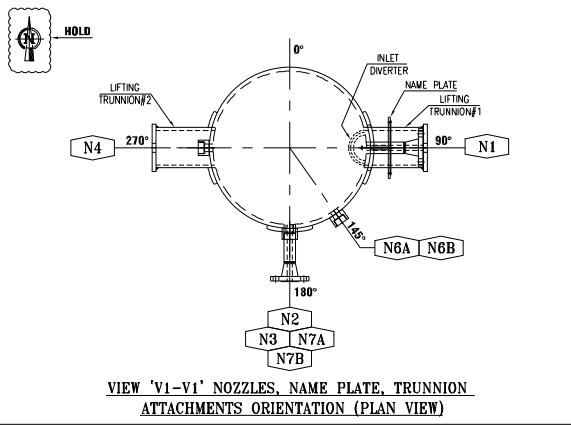


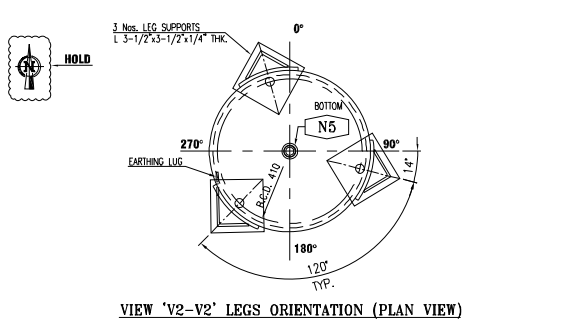
ELEVATION
NOT TRUE ORIENTATION VIEW



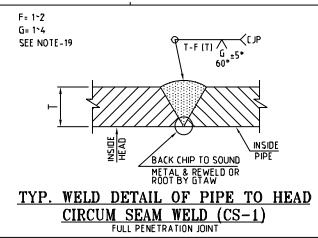
VIEW FROM 'V1-V1' (PLAN VIEW)



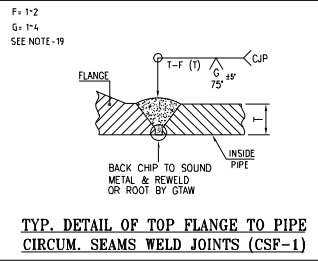
VIEW 'V1-V1' NOZZLES, NAME PLATE, TRUNNION ATTACHMENTS ORIENTATION (PLAN VIEW)



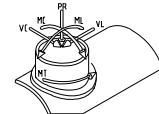
VIEW 'V2-V2' LEGS ORIENTATION (PLAN VIEW)



TYP. WELD DETAIL OF PIPE TO HEAD CIRCUM. SEAM WELD (CS-1)
FULL PENETRATION JOINT



TYP. DETAIL OF TOP FLANGE TO PIPE CIRCUM. SEAMS WELD JOINTS (CSF-1)



N1 & N2	25 (1")	71B	71B	71B	190	190	190
NOZZLE TAG	DN (NPS)	PR	VC	VL	MC	ML	MT
NOZZLE		DIRECT LOADS (N)			MOMENT LOADS (NM)		

NOZZLE LOADING DATA

GENERAL NOTES:-

1. ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED.
2. NOZZLE FLANGES SHALL BE IN ACCORDANCE WITH ASME B16.5. ED.2013
3. ALL BOLT HOLES OF FLANGES AND ANCHOR SUPPORT SHALL STRADDLE THE NORMAL VESSEL VERTICAL CENTERLINE.
4. FULL PENETRATION WELD SHALL BE USED FOR MANWAY & ALL NOZZLE.
5. LONGITUDINAL AND CIRCUMFERENTIAL SEAMS IN SHELLS AND ALL SEAMS IN HEADS SHALL BE FULL PENETRATION SINGLE BUTT WELD OF THE 'V TYPE.
6. THE VESSEL SHALL BE CLEANED INSIDE AND OUTSIDE OF WELD SPATTER, WELD SLAG, FLUX DEPOSITS, BURRS AND SPLINTERS, LOOSE MILL SCALE AND ALL OTHER FOREIGN MATTER.
7. THE TEMPERATURE OF THE VESSEL AND TEST WATER SHALL NOT BE LOWER THAN 10 °C. WATER MUST BE CLEAN, WITHOUT CONTAMINANTS.
8. AFTER THE HYDROSTATIC TEST, THE VESSEL SHALL BE THOROUGHLY RINSED WITH THE WATER (SAME QUALITY AS OF HYDROTEST WATER), AND DRIED WITH AIR.
9. ALL GREASE, RUST, LOOSE SCALE, OIL, DIRT, SAND AND SEDIMENTS SHALL BE REMOVED. FINAL CLEANING SHALL BE MADE AFTER THE VESSEL HAS BEEN DRAINED FOLLOWING HYDRO TEST.
10. ALL INSIDE EDGES OF NOZZLES AND CONNECTIONS, WHETHER FLUSH OR EXTENDED SHALL BE ROUNDED OFF TO A MINIMUM RADIUS OF 3mm.
11. 100% DYE PENETRANT TEST SHALL BE PERFORMED ON THE ALL WELD JOINTS.
12. ALL NOZZLES JOINTS WITH FLANGES SHALL BE 100% RADIOGRAPHED.
13. UT OF NOZZLE TO SHELL JOINT SHALL BE 100%.
14. ALL WELDING SYMBOLS MUST COMPLY AWS A2.4. & ASME IX.
15. HYDRO TEST SHALL BE DONE IN HORIZONTAL POSITION.
18. THE FINISH OF CONTACT FACE SHALL BE SMOOTH FINISH OR STOCK FINISH ACCORDING TO THE TYPE OF GASKET USED FOR THE PIPING.
19. VARIATION IN WELD GAP "G" SHALL BE NOT MORE THAN 1.5 mm.
20. INNER SURFACE OF VESSEL MUST BE BARE, CLEAN I FREE FROM DUST / PARTICLES.
21. NO WELDING SHALL BE DONE ON PRESSURE CONTAINING PARTS OF VESSEL AFTER HYDROTEST.
22. ALL SHARP EDGES & DISCONTINUOUS WELDED PORTION SHALL BE GROUND SMOOTH.
23. ALL NOZZLE REINFORCING PADS SHALL BE PROVIDED WITH J" NPT TAPPED HOLE LOCATED IN LOWER PART FOR PNEUMATIC TESTING.
24. ALL NOZZLE EXCEPT COUPLING SHALL BE FLUSH WITH INSIDE OF VESSEL WALL UNLESS OTHERWISE SPECIFIED.
25. ALL THE FLANGE RATING SHALL BE MINIMUM CLASS 150.

MATERIALS SPECIFICATION

SHELL	A 106 GR.B	SUPPORT LEG'S / PAD	A-36 / A 516 GR.70
HEAD	A 234 WPB	LIFTING TRUNNION /PAD	A106 GR.B / A 516 GR.70.
FLANGES	A 105 N	FITTINGS (INT. & EXT.)	A 105 N
NOZZLES NECK	A 106 GR.B	NAME PLATE/BRACKET	SS 304 / A 516 GR.70
GASKET	SPIRAL WOUND, SS 316L, GRAPHITE FILLED	EARTHING LUGS	SS 304
BOLTS/NUTS	A 193 BM / A 194 2M		

PAINTING SPECIFICATION

EXTERNAL SURFACE PREPARATION & PAINTING	
SURFACE PREPARATION	SAND BLASTING SA 2 1/2
PAINTING	2 COAT HIGH BUILD EPOXY 75 μ
	TOTAL DFT 75 μ

MECHANICAL DESIGN DATA

CODE	ASME SECTION VIII DIVISION 1, EDITION 2015
ASME CERTIFICATION MARK/ NB REGISTRATION	NO/NO
EQUIPMENT	INSTRUMENT GAS SCRUBBER
VOLUME m3	0.3
DESIGN PRESSURE (INT. / EXT.) kpa(g) [psi(g)]	1723.68 [250] / FV
DESIGN TEMPRATURE (INT / EXT) °C [°F]	65.56 [150] / 65.56 [150]
OPERATING PRESSURE (MIN. / MAX.) kpa(g) [psi(g)]	689.473 [100] / 1378.95 [200]
OPERATING TEMPERATURE (MIN. / MAX.) °C /°F	-23.33[-10] / 48.89 [120]
MAWP (INT) (51 TEMPERATURE (HOT & CORRODED) kpa(g) [psi(g)] @ °C [°F]	1863.79 [270.32] @ 65.56 [150]
MAWP (EXT) (5) TEMPERATURE (HOT & CORRODED) kpa(g) [psi(g)] @ °C [°F]	FV @ 65.56 [150]
MAP @ TEMPERATURE (COLD & NEW) kpa(g) [psi(g)] @ °C [°F]	1960 [284.28] @ 21.11 [70]
MDMT (a) MAWP °C [°F] @ kpa(g) [psi(g)]	-29 [- 20.2] @ 1863.79 [270.32]
RADIOGRAPHY	100% [RT-1]
JOINT EFFICIENCY	1
CORROSION ALLOWANCE mm	3
HYDRO TEST PRESSURE kpa(g) [psi(g)]	2422.92 [351.42]
PWHT	NO
IMPACT TEST	NO
PERSONNEL PROTECTION	NO
INSULATION	NO
FIRE PROOFING	NO
LADDER, PLATFORM	NO
SEISMIC CODE	UBC-1997
SEISMIC ZONE	2B ; 1-1.25
WIND CODE	ASCE 7-10
WIND SPEED Km/h	160
INTERNAL COATING	NO
SUPPORT	LEG'S