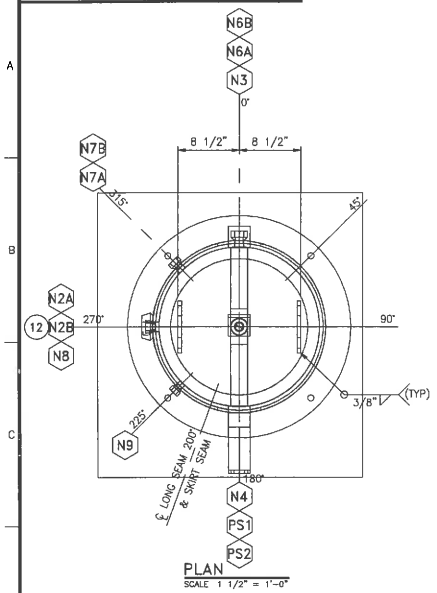
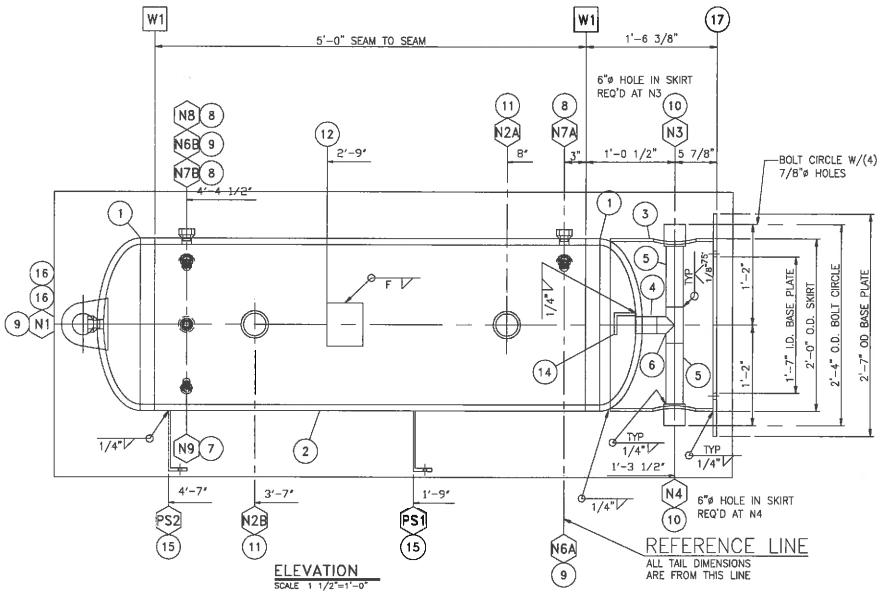
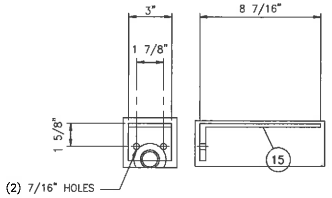
VESSEL WT. EMPTY: 1852 LBS.



PLAN
SCALE 1 1/2" = 1'-0"



ELEVATION
SCALE 1 1/2"=1'-0"



DETAIL PS-1 & PS-2
SCALE 3"=1'-0" (2 REQ'D)

REPAD NOTE:
1. DRILL AND TAP 1/4" NPT TELLTALE HOLES THRU EACH REINFORCING PAD. LOCATE THE CENTER OF THE HOLE 3/4" FROM THE OUTER EDGE. REPAD SHOULD BE PLACED ON VESSEL SO THAT WEEPHOLE IS ORIENTED AT THE LOW POINT OF THE NOZZLE WHEN THE VESSEL IS IN SERVICE.

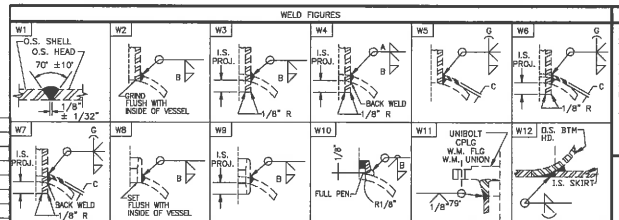
BILL OF MATERIAL

MARK NO.	QTY	PART NUMBER	DESCRIPTION	MATERIAL
1	2	HSD24000875CA	HEAD 24" OD 2:1 ELLIP 7/8" NOM 0.8125" MIN	SA-516-70N
2	1	HANO-467524016	SHELL 24" X 7/8" X 5'-0" ROLLED	SA-516-70
3	1	PP24008ECJ	PIPE ERW 24" S/10 X 1'-2 3/8" LG (BOE-PBE)	SA-53-B
4	1	PP0200JSCA	PIPE SMLS 2" S/80 X 3 1/8" LG (BOE-POE)	SA-106-B
5	2		PIPE SMLS 2" S/80 SMLS X 9" LG (BOE-POE)	SA-106-B
6	1	FWTS0200JCA	TEE BW 2" X 2" X 2" SCH 80	SA-234-WPB
7	1	FOCL0050LCA	COUP-O-LET 1/2" 6000#	SA-105
8	3	FOCL0075LCA	COUP-O-LET 3/4" 6000#	SA-105
9	3	FOCL0100LCA	COUP-O-LET 1" 6000#	SA-105
10	2	FFCF0200TXSJCA	COUPLING 2" 3000# THRD X SW	SA-105
11	2	FOTL0200JCA	THREAD-O-LET 2" 3000#	SA-105
12	1	NAME-HANOVESSEL08	NAMEPLATE 5" X .06" X 6" LG CODE	316 SS
14	1	STAN0300X0300X0037CE	ANGLE 3" X 3" X 3/8" X 3" LG	SA-36
15	2	STCS1000X0153CE	CHANNEL 10" @ 15.3#/FT X 3" LG	SA-36
16	2	HANO-464483011	LIFT LUG 1/2" X 6 1/2" X 7 1/4" W/3" HOLE 10,000#	SA-516-70
17	1	PLVQ0500CA	PLATE 1/2" X 2'-7" OD	SA-516-70

****NOTE****
IF CODE CASE 2235 IS UTILIZED THE STAMPING WILL BE UT. IF "RT" IS UTILIZED WITH "UT", THE APPROPRIATE "RT" STAMPING WILL BE APPLIED WITH THE UT STAMPING.

U W RT-2
CERTIFIED BY: EXTERRAN. FAC. CODE CLB
MAWP 1440 PSI @ 350 °F
MAEWP PSI @ °F
MDMT -20 °F @ 1440 PSI
S/N: WT. 1,852LB.
YEAR WIP NO
DWG NO HANO-485524020
24" OD X 5'-0" S/S BLOWCASE V-115

WELD FIGURES



FABRICATION & WELD NOTES

1. DRILL & TAP 1/4" NPT TELLTALE HOLE IN ALL REINFORCING PADS. (SEE ABOVE)
2. INSIDE EDGES OF NOZZLE NECKS SHALL BE ROUNDED TO 0.125" RAD OR HALF THE WALL THICKNESS IF LESS THAN 0.250".
3. ALL DIMENSIONS ARE ± 0.125" EXCEPT AS NOTED.
4. ALL HEAD TO SHELL WELD JOINTS TO REFERENCE W1 (SEE WELD FIGURES).
5. ALL INSIDE COMPONENTS ARE SEAL WELDED, 3/16" MIN.
6. IF CODE CASE 2235 IS UTILIZED THE STAMPING WILL BE UT. IF RT IS UTILIZED W/UT, THE APPROPRIATE RT STAMPING WILL BE APPLIED WITH THE UT STAMPING.
7. WELD PROCEDURES: gf_1-1_N_o_h, gfa_11-12_N_ohV-20, mm_1-1_N_o_h, gfa_11-12_pw_oc-20, gf_81-11_N_oV-50

SUBJECT TO INSPECTION BY EXTERRAN & AI

SHOP RECORDS REQ'D ☐ MAT'L RECORDS [X] NAMEPLATE RUBBING
☐ STRESS RELIEVE CHART ☐ TEST PRESSURE CHART
STENCIL OPENINGS [X] YES ☐ NO

GENERAL NOTES

DESIGN PRESSURE: 1440 P.S.I DESIGN TEMPERATURE: 350 °F
RADIOGRAPH: RT-2 STRESS RELIEVE: NO
CORROSION ALLOWANCE: 0" HYDROSTATIC TEST: 1872 P.S.I.
VESSEL JOINT EFFICIENCY: 100 %
INITIAL TEST: N/A P.S.I.
HAMMER TEST: N/A P.S.I.

STRENGTH OF 70,000 P.S.I. HEAD THICKNESS DETERMINED USING A TENSILE STRENGTH OF 70,000 P.S.I.
PAINT SPECIFICATIONS:
CLEAN ALL SURFACES THOROUGHLY AND PAINT AS FOLLOWS
PRIMER: FINISH:

2013 EDITION, --- ADDENDA
CONSTRUCTION SECT. VIII
ASME CODE DIV. 1
APPLY SYMBOL PER PAR. UG-116

EXTERRAN.
ISSUED FOR CONSTRUCTION
DATE:
SIGN:

SCHEDULE OF OPENINGS

MK	QTY.	SIZE	ASA RATING	TYPE & FACING	SERVICE	I. S. PROJ.	O. S. PROJ.	WELD FIG. NO.	L. S. FILLET A	O. S. FILLET B	PAD FILLET C
N9	1	1/2"	6000#	COUP-O-LET	PRESSURE INDICATOR	–	–	W13	–	1/4"	
N8	1	3/4"	6000#	COUP-O-LET	TEMPERATURE INDICATOR	–	–	W13	–	1/4"	
N7B	1	3/4"	6000#	COUP-O-LET	LEVEL GAUGE	–	–	W13	–	1/4"	
N7A	1	3/4"	6000#	COUP-O-LET	LEVEL GAUGE	–	–	W13	–	1/4"	
N6B	1	1"	6000#	COUP-O-LET	LEVEL SWITCH	–	–	W13	–	1/4"	
N6A	1	1"	6000#	COUP-O-LET	LEVEL SWITCH	–	–	W13	–	1/4"	
N4	1	2"	3000#	COUPLING	DRAIN	–	SEE ELEV	W2	–	3/8"	
N3	1	2"	3000#	COUPLING	LIQUID INLET/OUTLET	–	SEE ELEV	W2	–	3/8"	
N2B	1	2"	3000#	THREAD-O-LET	LIQUID LEVEL CONTROL	–	–	W10	–	3/8"	
N2A	1	2"	3000#	THREAD-O-LET	LIQUID LEVEL CONTROL	–	–	W10	–	3/8"	
N1	1	1"	6000#	COUP-O-LET	GAS OUTLET	–	–	W13	–	3/8"	

REV.	DESCRIPTION	DATE	BY	CK
1	REVISED TO REMOVE N5 & ROTATE N6A, N6B & N8	4/26/11	JLV	

REVISIONS

TOLERANCES	
CUTS	±1/8"
ANGLES	±1/2°
WELD ASS'Y.	±1/4"
WIP NO.	
ITEM NO.	–

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EXTERRAN.
2207 FM 949
ALLEYTON, TEXAS 78935
PH. 979-732-2327

CUSTOMER: EXTERRAN STOCK
TITLE: 24" OD X 5'-0" S/S @ 1440# VERTICAL BLOWCASE ~ V-115

DRAWN	DATE	APPROVED	SCALE	NO. REQ'D
JG	07/16/10		AS NOTED	

DRAWING NO. HANO-485524020
SHT. NO. 1 of 1
REV. 1