

ELEVATION VIEW

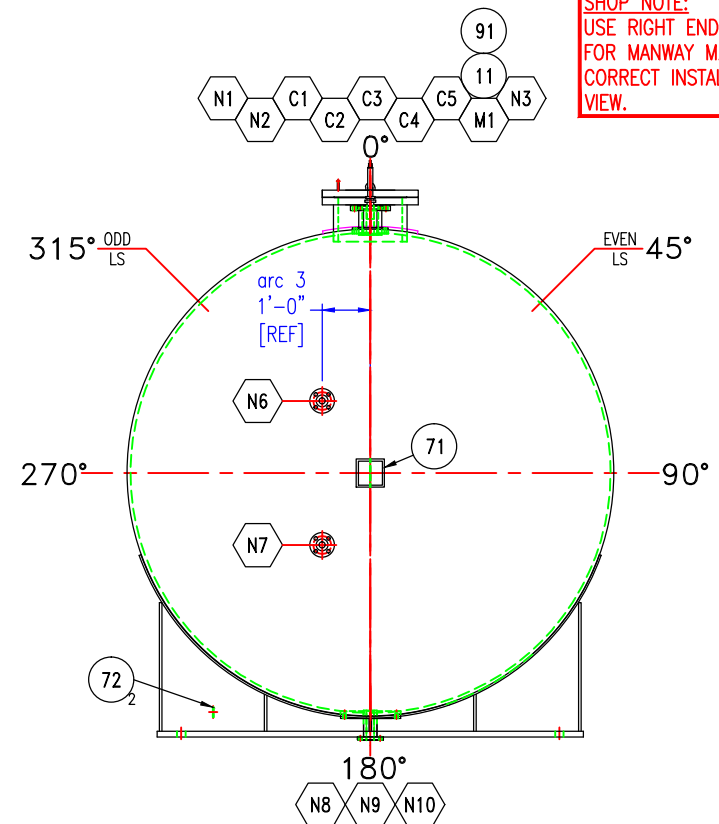
ITEMS IN THIS VIEW MAY BE ROTATED FOR CLARITY
SEE PLAN VIEW FOR TRUE ORIENTATION

MARKING NOTE:
1. LETTERS TO BE STENCILED ON VESSEL w/BLACK PAINT
2. "EAST" AND SHIPPING WEIGHT IN TONS TO STENCILED AT 90° & 270° ON EAST END OF VESSEL AS SHOWN.

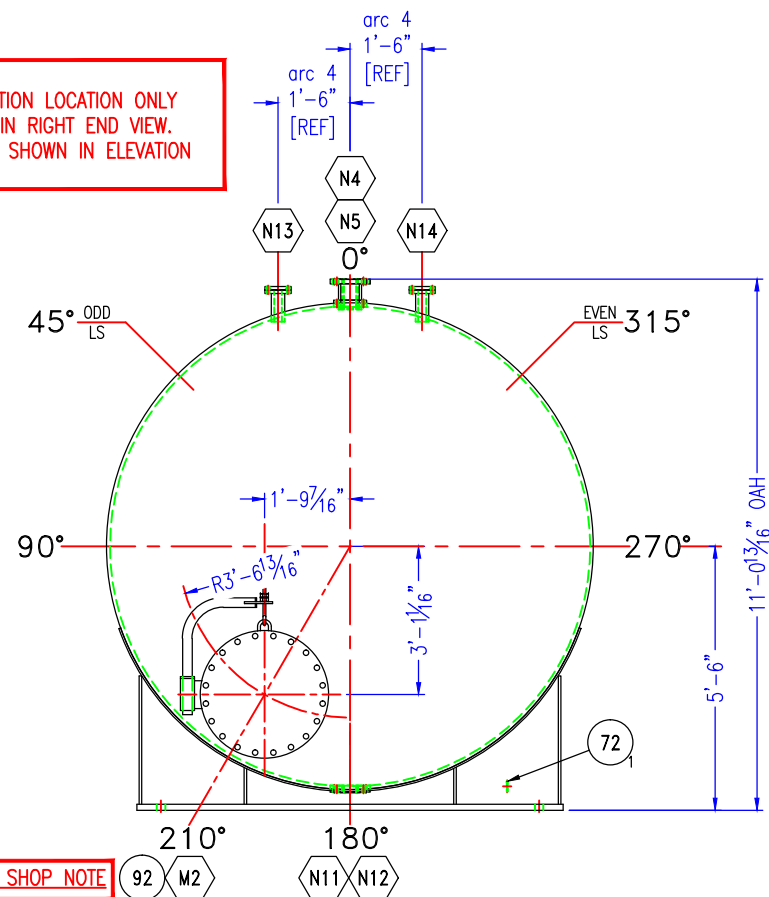
TAG # _____ 6" LETTERING
SHIPPING WEIGHT IN TONS _____ 6" LETTERING
EAST _____ 9" LETTERING

VESSEL MARKINGS DETAIL
not to scale

SHOP NOTE:
USE RIGHT END VIEW FOR INSTALLATION LOCATION ONLY FOR MANWAY M2. SHOWN ROTATED IN RIGHT END VIEW. CORRECT INSTALLATION ORIENTATION SHOWN IN ELEVATION VIEW.



LEFT END VIEW
TRUE ORIENTATION
(UNLESS OTHERWISE NOTED)



SEE SHOP NOTE

RIGHT END VIEW
TRUE ORIENTATION
(UNLESS OTHERWISE NOTED)

APPROVED FOR FABRICATION

ENG. _____ DATE _____
Q.C. _____ DATE _____

ASME	CERTIFIED BY TUBULAR STRUCTURES INTERNATIONAL, L.L.C. (Name of Manufacturer)	
	U	MAWP 250 psi at 150 ° F
W	MAEWP _____ psi at _____ ° F	
RT-1	MDMT 16 ° F at 250 psi	
H031026		
Customer PO Number	372-(1-2)	
PROpane STORAGE Service	Manufacturer's Serial Number	
---	2013	
Hydrostatic Test Temperature	Year Built	

REVISIONS					
NO	DESCRIPTION	BY	DATE	CHK	DATE
A	SUBMITTED FOR APPROVAL	WD	9/11/13		
B	RESUBMITTED FOR APPROVAL	WD	10/7/13		
C	RESUBMITTED FOR APPROVAL	WD	10/22/13		
D	RESUBMITTED FOR APPROVAL	WD	11/11/13		
E	RESUBMITTED FOR APPROVAL	DC	11/25/13		
F	RESUBMITTED FOR APPROVAL	DC	11/26/13		
G	RESUBMITTED FOR APPROVAL	DC	11/27/13		
O	RELEASED FOR FABRICATION	DC	12/10/13		

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Tubular Structures International, L.L.C.

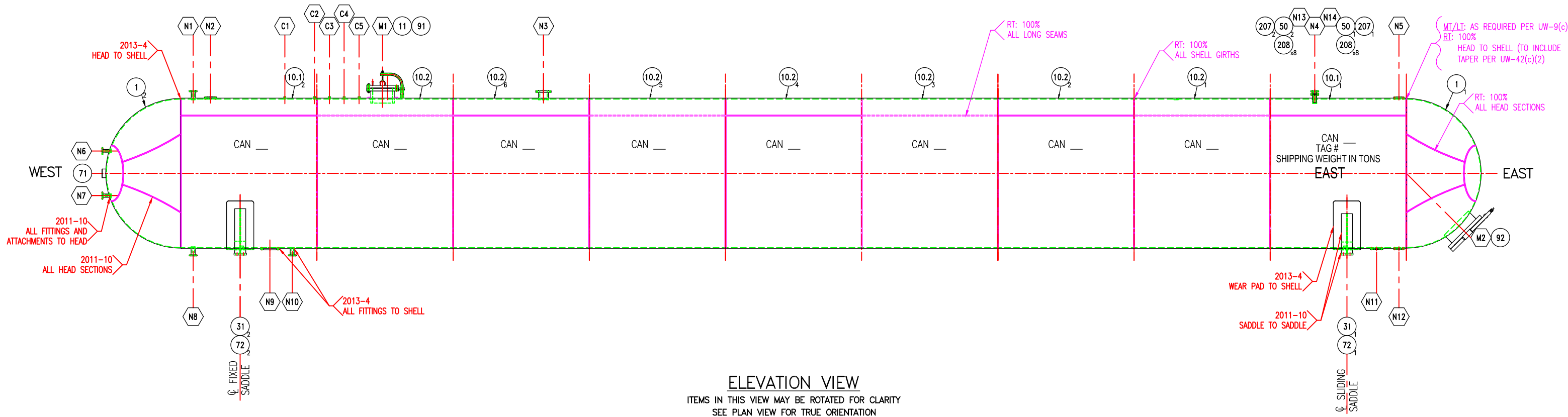
2201 JUDITH ROAD P.O. BOX 337
MCGREGOR, TEXAS 76657
TEL: 254-840-3355
FAX: 254-840-3358

TSI

CUSTOMER: **TRANS TECH ENERGY**

DESCRIPTION: 10'-0" ID x 82'-6" S/S VESSEL (V-2389/2390)
APPROX. 60,000 GAL PROPANE BULLET TANK (2 IDENT.)
GENERAL ARRANGEMENT

SCALE: 1/4" = 1'-0" I.W.O. NO. ---
DRAWN: DC | DATE: 12/10/13 | CUSTOMER P.O. H031026
CHKD: _____ DWG. NO. 372-(1-2) | SHT 2 | REV -0-



ELEVATION VIEW
ITEMS IN THIS VIEW MAY BE ROTATED FOR CLARITY
SEE PLAN VIEW FOR TRUE ORIENTATION

QC WELD MAP				
	GIRTH SEAMS		LONG SEAMS	
	ID	OD	ID	OD
CAN 1				
CAN 2				
CAN 3				
CAN 4				
CAN 5				
CAN 6				
CAN 7				
CAN 8				
CAN 9				
GS 10				

OD ARC LENGTHS FOR SHELL/SKIRT	
45°	
90°	
135°	
180°	
arc 1	
arc 2	
arc 3	
arc 4	

*ARC LENGTHS TO BE DETERMINED AFTER ROLL

APPROVED FOR FABRICATION

ENG. _____ DATE _____

Q.C. _____ DATE _____

REVISIONS				
NO	DESCRIPTION	BY	DATE	CHK DATE
A	SUBMITTED FOR APPROVAL	WD	9/11/13	
B	RESUBMITTED FOR APPROVAL	DC	10/8/13	
C	RESUBMITTED FOR APPROVAL	WD	10/22/13	
D	RESUBMITTED FOR APPROVAL	WD	11/11/13	
E	RESUBMITTED FOR APPROVAL	DC	11/25/13	
F	RESUBMITTED FOR APPROVAL	DC	11/26/13	
G	RESUBMITTED FOR APPROVAL	DC	11/27/13	
O	RELEASED FOR FABRICATION	DC	12/10/13	

Tubular Structures International, L.L.C.

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CUSTOMER: TRANS TECH ENERGY

DESCRIPTION: 10'-0" ID x 82'-6" S/S VESSEL (V-2389/2390)
APPROX. 60,000 GAL PROPANE BULLET TANK (2 IDENT.)
WELD AND NDE MAP

SCALE: NTS W.O. NO. --

DRAWN: DC DATE: 12/10/13 CUSTOMER P.O. H031026

CHKD: _____ DWG. NO. 372-(1-2) SHT 3 REV -0-

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Tubular Structures International, L.L.C.

TSI FORM 15/EXHIBIT C

BILL OF MATERIALS

CUSTOMER: TRANS TECH ENERGY
DESCRIPTION: 10'-0" ID x 82'-6" S/S VESSEL (V-2389/2390)
APPROX 60,000 GAL PROPANE BULLET TANK (2 IDENT)

FOR VESSEL:

372-

REVISIONS 0 RELEASED FOR FABRICATION

DC 12/10/13

Table with 5 columns: *QTY, PART#, PART NAME, DESCRIPTION, MATERIAL. Includes subassembly 'EXISTING DUMMY FLANGE SUBASSEMBLY' with parts like FLANGE WRAP and FLANGE SEGMENT.

Table with 5 columns: *QTY, PART#, PART NAME, DESCRIPTION, MATERIAL. Includes subassembly 'EXISTING SWEEPS' with parts like WRAP SWEEP and CAN SWEEP.

Table with 5 columns: *QTY, PART#, PART NAME, DESCRIPTION, MATERIAL. Includes subassembly 'VESSEL BODY COMPONENTS' with parts like RIGHT HEAD and LEFT HEAD.

Table with 5 columns: *QTY, PART#, PART NAME, DESCRIPTION, MATERIAL. Includes subassembly 'CANS' with parts like EXTERIOR CAN and INTERIOR CAN.

Table with 5 columns: *QTY, PART#, PART NAME, DESCRIPTION, MATERIAL. Includes subassembly 'REQUIRED NOZZLE REPADS' with part MW REPAD.

Table with 5 columns: *QTY, PART#, PART NAME, DESCRIPTION, MATERIAL. Includes subassembly 'VESSEL SUPPORTS' with parts like WEAR PAD, BASEPLATE, WEB, and various RIBS.

Table with 5 columns: *QTY, PART#, PART NAME, DESCRIPTION, MATERIAL. Includes subassembly 'FITTINGS (SEE FITTINGS SCHEDULE)' with various flanges, blinds, and studs.

Table with 5 columns: *QTY, PART#, PART NAME, DESCRIPTION, MATERIAL. Includes subassembly 'LUGS, CLIPS & BRACKETS' with parts like STANDOFF, BACKING PLATE, and TSI NAMEPLATE.

Table with 5 columns: *QTY, PART#, PART NAME, DESCRIPTION, MATERIAL. Includes subassembly 'SUB# 72 TSI STD GROUND LUG WELDMENT' with part GROUND LUG.

Table with 5 columns: *QTY, PART#, PART NAME, DESCRIPTION, MATERIAL. Includes subassembly 'BLINDS, INTERNALS & ATTACHMENTS' with subassembly 'SUB# 91 16" MANWAY w/DAVIT SUBASSEMBLY'.

Table with 5 columns: *QTY, PART#, PART NAME, DESCRIPTION, MATERIAL. Includes subassembly 'SUB# 92 24" MANWAY w/DAVIT SUBASSEMBLY' with various flanges, blinds, and studs.

Table with 5 columns: *QTY, PART#, PART NAME, DESCRIPTION, MATERIAL. Includes subassembly 'GASKETS & HARDWARE' with various gaskets and studs.

*QTY = QTY SHOWN IS FOR (1) VESSEL
#QTY = QTY SHOWN IS FOR (1) SUBASSEMBLY
♦(QTY) = INDICATES A DUPLICATE ENTRY (DISREGARD NOTED ENTRY)
** STUD SET = 1 STUD (OR EYEBOLT) AND 2 HEAVY HEX NUTS, UNLESS NOTED OTHERWISE



Tubular Structures International, L.L.C.

TSI FORM 15/EXHIBIT C

QC BILL OF MATERIALS

CUSTOMER: TRANS TECH ENERGY
 DESCRIPTION: 10'-0" ID x 82'-6" S/S VESSEL (V-2389/2390)
 APPROX 60,000 GAL PROPANE BULLET TANK (2 IDENT)

FOR VESSEL:

372-

REVISIONS 0 | RELEASED FOR FABRICATION | DC | 12/10/13

INSPECTION PARTS & TOOLING

EXISTING DUMMY FLANGE SUBASSEMBLY

*QTY	PART#	PART NAME	DESCRIPTION	MATERIAL	HEAT NO
4	0.1	FLANGE WRAP	PL 1" THK x 4" x 18'-0"	CS	N/R
16	0.2	FLANGE SEGMENT	PL 1" THK x 10'-3 5/8" ID x 10'-11 5/8" OD x 45° BURNED SHAPE	CS	N/R

* QTY SHOWN IS FOR 1 SET = 2 DUMMY FLANGES = 1 VESSEL

EXISTING SWEEPS

*QTY	PART#	PART NAME	DESCRIPTION	MATERIAL	HEAT NO
1	0.3	WRAP SWEEP	PL THK AS AVAILABLE x 1'-4" x 7" BURNED SHAPE	CS	N/R
1	0.4	CAN SWEEP	PL THK AS AVAILABLE x 1'-4" x 7" BURNED SHAPE	CS	N/R

VESSEL BODY COMPONENTS

HEADS

*QTY	PART#	PART NAME	DESCRIPTION	MATERIAL	HEAT NO
1	1-1	RIGHT HEAD	Ø10'-0" ID x 0.532" THK (0.504" MIN) ASME 2:1 ELLIP	SA-516-70	
1	1-2	LEFT HEAD	Ø10'-0" ID x 0.532" THK (0.504" MIN) ASME 2:1 ELLIP	SA-516-70	

CANS

*QTY	PART#	PART NAME	DESCRIPTION	MATERIAL	HEAT NO
2	10.1	9'-2" EXTERIOR CAN	PL 13/16" THK x 9'-2" x 31'-7 9/16" [379.54"] ROLLED TO Ø10'-0" ID	SA-612	QC PL TRAVELER
7	10.2	9'-2" INTERIOR CAN	PL 13/16" THK x 9'-2" x 31'-7 9/16" [379.54"] ROLLED TO Ø10'-0" ID	SA-612	QC PL TRAVELER

REQUIRED NOZZLE REPADS

*QTY	PART#	PART NAME	DESCRIPTION	MATERIAL	HEAT NO
1	11	MW REPAD	PL 3/4" THK x 31" OD x 24 1/8" ID ROLLED TO Ø10'-1 5/8" ID	SA-516-70	QC PL TRAVELER

VESSEL SUPPORTS

SUB# 31 SADDLE PAIR SUBASSEMBLY

*QTY	PART#	PART NAME	DESCRIPTION	MATERIAL	HEAT NO
2	31.1	WEAR PAD	PL 1/2" THK x 2'-0" x 11'-8 11/16" [140.68"] ROLLED TO Ø10'-1 5/8" ID	SA-516-70	QC PL TRAVELER
2	31.2	BASEPLATE	PL 1" THK x 1'-1" x 8'-10 1/2" w/BURNED BOLT HOLES	SA-516-70	N/R
2	31.3	WEB	PL 1/2" THK x 8'-8 1/8" x 2'-8 5/8" BURNED SHAPE	SA-516-70	N/R
4	31.4	OUTSIDE RIB	PL 1/2" THK x 12" x 2'-8 5/8"	SA-516-70	N/R
8	31.5	MIDDLE RIB	PL 1/2" THK x 5 3/4" x 9 11/16"	SA-516-70	N/R
4	31.6	CENTER RIB	PL 1/2" THK x 5 3/4" x 3 11/16"	SA-516-70	N/R
♦2	72	GROUND LUG	PL 1/4" THK x 2 1/2" x 2 1/2"	SA-516-70	N/R

FITTINGS (SEE FITTINGS SCHEDULE)

*QTY	PART#	PART NAME	DESCRIPTION	MATERIAL	HEAT NO
1	41	FLANGE	Ø24" RFLWN 300# x 12" LG	SA-105	FITTINGS SCHED
1	42	BLIND	Ø24" RF BLIND 300#	SA-105	
1	43	FLANGE	Ø16" RFLWN 300# x 12" LG	SA-105	FITTINGS SCHED
1	44	BLIND	Ø16" RF BLIND 300#	SA-105	
1	45	STUDDING OUTLET	Ø8" RFSTUD 300# x STD THK	SA-105	FITTINGS SCHED
1	46	FLANGE	Ø6" RFLWN 300# x 9" LG	SA-105	FITTINGS SCHED
2	47	STUDDING OUTLET	Ø4" RFSTUD 300# x STD THK w/MODIFIED BORE Ø5.63" ID	SA-105	FITTINGS SCHED
2	48	STUDDING OUTLET	Ø3" RFSTUD 300# x STD THK w/MODIFIED BORE Ø3.57" ID	SA-105	FITTINGS SCHED
6	49	FLANGE	Ø2" RFLWN 300# x 9" LG	SA-105	FITTINGS SCHED
1	50-1	BLIND FOR N13	Ø2" RF BLIND 300#	SA-105	
1	50-2	BLIND FOR N14	Ø2" RF BLIND 300#	SA-105	
2	51	FLANGE	Ø1 1/2" RFLWN 300# x 9" LG	SA-105	FITTINGS SCHED
5	52	COUPLING	Ø3/4" FCPLG 6000# x STD LG	SA-105	FITTINGS SCHED

LUGS, CLIPS & BRACKETS

SUB# 71 TSI STD NAMEPLATE SUBASSEMBLY

*QTY	PART#	PART NAME	DESCRIPTION	MATERIAL	HEAT NO
1	71.1	STANDOFF	PL 1/4" THK x 7" x 3"	SA-516-70	QC PL TRAVELER
1	71.2	BACKING PLATE	PL 1/4" THK x 7" x 7"	SA-516-70	QC PL TRAVELER
1	71.3	TSI NAMEPLATE	PL 1/4" THK x 6" x 6" (ETCHED AND DRILLED B/O)	SS	QC PL TRAVELER

SUB# 72 TSI STD GROUND LUG WELDMENT

*QTY	PART#	PART NAME	DESCRIPTION	MATERIAL	HEAT NO
2	72	GROUND LUG	PL 1/4" THK x 2 1/2" x 2 1/2"	SA-516-70	QC PL TRAVELER

BLINDS, INTERNALS & ATTACHMENTS

SUB# 91 Ø16" MANWAY w/DAVIT SUBASSEMBLY

*QTY	PART#	PART NAME	DESCRIPTION	MATERIAL	HEAT NO
♦1	43	FLANGE	Ø16" RFLWN 300# x 12" LG	SA-105	♦
♦1	44	BLIND	Ø16" RF BLIND 300#	SA-105	♦
♦1	11	MW REPAD	PL 3/4" THK x 31" OD x 24 1/8" ID ROLLED TO Ø10'-1 5/8" ID	SA-516-70	♦
1	91.1	DAVIT-BLIND U-RING	Ø3/4" BAR x 10 5/16" LG HOT ROLLED	SA-36	N/R
1	91.2	DAVIT ARM CAP	PL 1/4" THK x 1 7/8" OD	SA-516-70	N/R
1	91.3	DAVIT ARM	Ø1 1/2" PIPE XH 0.200" WALL x 2'-7 5/8" LG HOT ROLLED TO 90°	SA-106-B	N/R
1	91.4	DAVIT ARM STOPPER	PL 5/8" THK x 3" OD x 2 1/16" ID	SA-516-70	N/R
1	91.5	DAVIT ARM SLEEVE	Ø2" PIPE XH 0.218" WALL x 7 3/4" LG	SA-106-B	
1	91.6	DAVIT CONNECTOR PL	PL 5/8" THK x 5 13/16" x 8 3/4" BURNED SHAPE	SA-516-70	N/R
1	91.7	HANDLE	Ø3/4" BAR x 1'-1 3/8" LG HOT FORMED	SA-36	N/R
♦1	201	GASKET	Ø16" GASKET 300# x 1/8" THK	304 SS	♦
♦20	202	STUD SET**	Ø1 1/4" x 7 1/2" LG STUD 8 THREAD SERIES 8UN	SA-193-B7/SA-194-2H	♦
♦1	203	EYEBOLT SET**	Ø3/4" x 7 1/2" SHANK (SEE DWG FOR DIM REQ'D) w/2 NUTS AND 1 WASHER	CS	♦

SUB# 92 Ø24" MANWAY w/DAVIT SUBASSEMBLY

*QTY	PART#	PART NAME	DESCRIPTION	MATERIAL	HEAT NO
♦1	41	FLANGE	Ø24" RFLWN 300# x 12" LG	SA-105	♦
♦1	42	BLIND	Ø24" RF BLIND 300#	SA-105	♦
1	92.1	DAVIT-BLIND U-RING	Ø3/4" BAR x 10 3/4" LG HOT ROLLED	SA-36	N/R
2	92.2	DAVIT ARM CAP	PL 1/4" THK x 2 3/8" OD	SA-516-70	N/R
1	92.3	DAVIT ARM	Ø2" PIPE XXH 0.436" WALL x 4'-5 1/8" LG HOT ROLLED TO 90°	SA-106-B	N/R
1	92.4	DAVIT ARM STOPPER	PL 3/4" THK x 3" OD x 1 13/16" ID	SA-516-70	N/R
1	92.5	DAVIT ARM SLEEVE	Ø2 1/2" PIPE S/40 0.203" WALL x 9" LG	SA-106-B	
1	92.6	DAVIT CONNECTOR PL	PL 3/4" THK x 2 3/16" x 7" BURNED SHAPE	SA-516-70	N/R
1	92.7	HANDLE	Ø3/4" BAR x 1'-1 3/4" LG HOT FORMED	SA-36	N/R
♦1	204	GASKET	Ø24" GASKET 300# x 1/8" THK	304 SS	♦
♦24	205	STUD SET**	Ø1 1/2" x 9" LG STUD 8 THREAD SERIES 8UN	SA-193-B7/SA-194-2H	♦
♦1	206	EYEBOLT SET**	Ø3/4" x 7 1/2" SHANK (SEE DWG FOR DIM REQ'D) w/2 NUTS AND 1 WASHER	CS	♦

GASKETS & HARDWARE

*QTY	PART#	PART NAME	DESCRIPTION	MATERIAL	HEAT NO
1	201	GASKET	Ø16" GASKET 300# x 1/8" THK	304 SS	N/R
20	202	STUD SET**	Ø1 1/4" x 7 1/2" LG STUD 8 THREAD SERIES 8UN	SA-193-B7/SA-194-2H	
1	203	EYEBOLT SET**	Ø3/4" x 7 1/2" SHANK (SEE DWG FOR DIM REQ'D) w/2 NUTS AND 1 WASHER	CS	N/R
1	204	GASKET	Ø24" GASKET 300# x 1/8" THK	304 SS	N/R
24	205	STUD SET**	Ø1 1/2" x 9" LG STUD 8 THREAD SERIES 8UN	SA-193-B7/SA-194-2H	
1	206	EYEBOLT SET**	Ø3/4" x 7 1/2" SHANK (SEE DWG FOR DIM REQ'D) w/2 NUTS AND 1 WASHER	CS	N/R
2	207	GASKET	Ø2" GASKET 300# x 1/8" THK	304 SS	N/R
16	208	STUD SET**	Ø5/8" x 3 1/2" LG STUD 8 THREAD SERIES 8UN	SA-193-B7/SA-194-2H	

*QTY = QTY SHOWN IS FOR (1) VESSEL

#QTY = QTY SHOWN IS FOR (1) SUBASSEMBLY

♦(QTY) = INDICATES A DUPLICATE ENTRY (DISREGARD NOTED ENTRY)

** STUD SET = 1 STUD (OR EYEBOLT) AND 2 HEAVY HEX NUTS, UNLESS NOTED OTHERWISE

JOB NO: 372- CUSTOMER: TRANSTECH ENERGY DATE: 12/10/13
 SERIAL NO: 372- DRAWING NO: 372-(1-2) NAT BOARD NO: REQUIRED
 WPS-LG SMS: 2013-2 GIRTH SMS: 2013-2/4 NOZZLES: 2013-4



ASME **CERTIFIED BY**
TUBULAR STRUCTURES INTERNATIONAL, L.L.C.
 (Name of Manufacturer)

U MAWP 250 psi at 150 °F
 W MAEWP _____ psi at _____ °F
 RT-1 MDMT 16 °F at 250 psi

H031026
 Customer PO Number 372-(1-2)
 PROPANE STORAGE Service Manufacturer's Serial Number
 --- 2013
 Hydrostatic Test Temperature Year Built

DESIGN REQUIREMENTS:

DESIGN PRESS: INT: 250 PSIG EXT: N/A DESIGN TEMP: 16°F/150°
 DESIGN FOR SPEC SERVICE (L, UB, LT): YES NO LT REC'D: YES NO
 1. CALCULATIONS: CERTIFIED: YES NO ON FILE: TSI JOB FILE
 REVIEWED BY A.I.: _____ DATE: _____
 2. QC REVIEWED: _____ DATE: _____

MATERIAL INSPECTION	CUST HOLD	QC	DATE	A.I.	A.I.	A.I.
				HOLD	CHK	DATE
Examine MTR's and compare to heat number						
1. Heads						
2. Shell						
Check thickness and surface:						
1. Heads						
2. Shell (plate)						
Examine cut edges of:						
1. Heads						
2. Shell (plate)						
3. Outlets						
Record mill stamping and transfers:						
1. Heads						
2. Shell (plate)						
Verify nozzle thickness and flange ratings:						
1. Nozzles						
2. Flanges						

NON-DESTRUCTIVE EXAMINATION AND TESTING	CUST HOLD	QC	DATE	A.I.	A.I.	A.I.
				HOLD	CHK	DATE
Radiography:						
1. Long seams					*	
2. Girth seams					*	
3. Nozzle attachments						
Ultrasonics:						
1. Nozzle attachments						
Test reinforcement pads:						
Final Inspection:						
1. Weld appearance and reinforcement					*	
2. Check fillet weld sizes						
3. Out of roundness						
4. Final dimension		*				
5. Name plate attached					*	
6. Check stamping on nameplate					*	

WELDING	CUST HOLD	QC	DATE	A.I.	A.I.	A.I.
				HOLD	CHK	DATE
1. Procedure Specification					*	
2. Procedure and performance qualifications					*	

POST FABRICATION	CUST HOLD	QC	DATE	A.I.	A.I.	A.I.
				HOLD	CHK	DATE
Post weld heat treatment:						
1. Type						
2. Thermocouples attached to item						
3. Charts reviewed						
4. Verify up, hold, and down periods						
Hydrostatic test:						
1. Pressure test					*	
2. Gauge S/N						
3. Code stamp					*	
Preparation for Shipping:						
1. Data report checked					*	
2. Sandblast						
3. Paint						
Final Acceptance:		*				

FABRICATION	CUST HOLD	QC	DATE	A.I.	A.I.	A.I.
				HOLD	CHK	DATE
Fabrication Inspection:						
1. Examine cut edges						
2. Procedure and performance qualifications						
3. Shell Layout						
4. Head Layout						
5. Course fitup						
6. Nozzle fitup		*				
7. Internal Check					*	
Check weld groove preparation:						
1. Long seams						
2. Girth seams						
3. Nozzle attachments						
Cutting, fitting, and alignment:						
1. Long seams						
2. Girth seams						
3. Nozzle attachments						
Check back chip surface:						
1. Long seams						
2. Girth seams						
3. Nozzle attachments						

Remarks:

