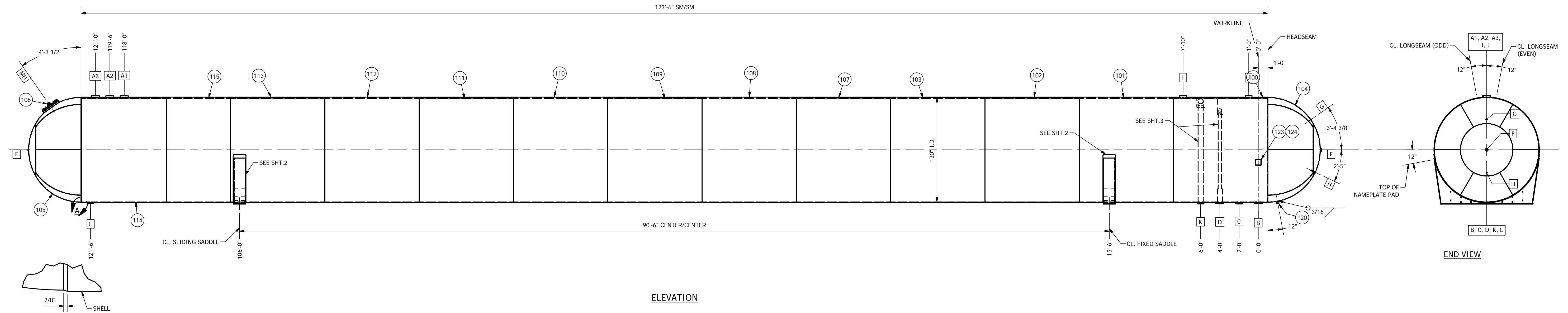


REV	DESCRIPTION	DATE
1	Q.C. REVIEW	3/1/19

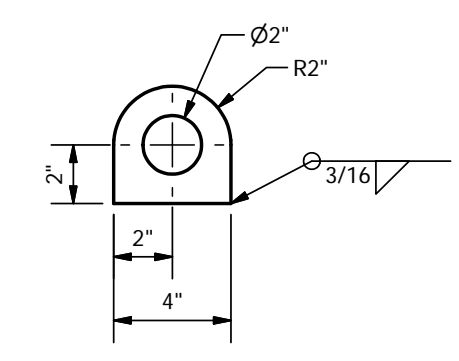
NOTE: ALL DIM. ARE GIVEN FROM WORKLINE U.N.O.



ELEVATION

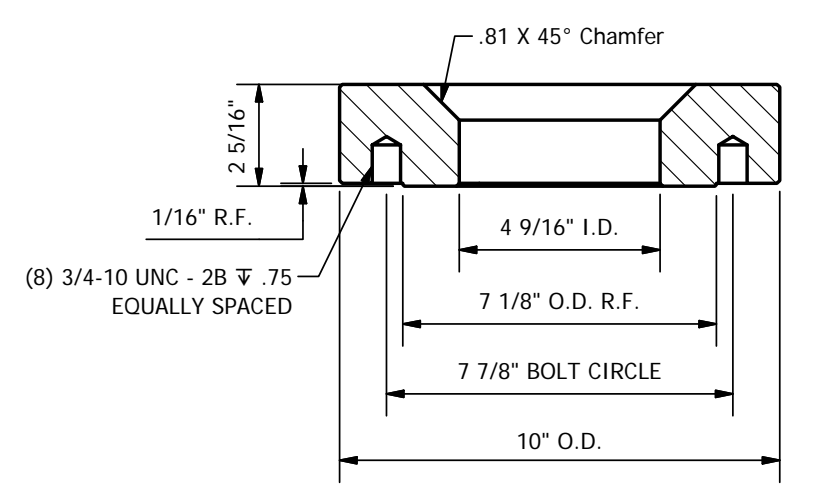
END VIEW

DETAIL A



DET'L ITEM #106

WELD PROCEDURES	
JOINT DESCRIPTION	WELD PROCEDURE
SHELL LONGSEAM/ROUNDSEAM	A101016, GAA110-01
STARTING HEAD TO SHELL	A101012 (L71/960), S10C02 (8018C2)
CLOSING HEAD TO SHELL	A101012, S10C02, F101002
FITTINGS TO SHELL	F10111 (UC71)
FITTINGS TO HEAD & MANWAY	F10111
MISC.	F10111



DET'L OPENING "B & D"

TYP. CPL'G & STUDDING OUTLET WELD DET'L

CERTIFIED BY: 15766

MAMP: 250 AT: 125 °F

U: MEMT: 113 AT: 250 PSIG

S/N: 15472 YEAR: 2019

RT: 4

HD: HEMI WC: 90,000 GAL

GL: 1.610 OD: 131.628 IN

SHELL THK: 7/16 IN HEAD THK: 420 IN

MO: 56483 OSSA: EA13 27

COINCIDENT MDMT: -20°F @ 164 PSI

THIS CONTAINER SHALL NOT CONTAIN A PRODUCT THAT HAS A VAPOR PRESSURE IN EXCESS OF 215 PSIG AT 100 °F

X-RAY	
JOINT DESCRIPTION	X-RAY
HEADS	SPOT UW-11(b)/TYPE 1
STARTING HEAD TO SHELL	SPOT UW-11(b)/TYPE 1
SHELL LONG SEAMS	FULL UW-11(a)/TYPE 1
SHELL ROUND SEAMS	FULL UW-11(a)/TYPE 1
CLOSING HEAD TO SHELL	SPOT UW-11(b)/TYPE 1

VESSEL DESIGN DATA & INSPECTION NOTES
 CODE: 2017 ED. ASME, SECT. VIII, DIV. 1
 CONSTRUCTION: WELDED
 INTERNAL DESIGN PRESS: 250 PSIG @ +125 °F
 EXTERNAL DESIGN PRESS: PSIG @ °F
 EXTERNAL OPERATING PRESS: PSIG @ °F
 MAX. ALLOW. WORKING PRESS: 250 PSIG @ +125 °F
 HYDROSTATIC TEST: 325 PSIG @ AMBIENT °F
 SHELL THICKNESS: .714" NOM
 HEAD THICKNESS: .420" MIN
 CONE: NONE
 CORROSION ALLOWANCE: NONE
 HEAT TREAT: NONE
 X-RAY: RT 4
 APPLY SYMBOL OR STAMP: PER ASME
 INSPECTION: NATIONAL BOARD

GENERAL NOTES

- All bolts to straddle normal centerline unless otherwise noted.
- Vessel to be cleaned after testing.
- All openings are to be protected prior to shipment.
- Approximate weight 133,500 lbs.
- Welding procedures SEE ABOVE.
- A longitudinal & transverse workline to be stamped on vessel prior to layout of nozzles and attachments.
- Tolerances to be per tolerance sheet.
- All flanges to be ASME B16.5-2013.
- All couplings to be ASME B16.11-LATEST EDITION.
- All elbows to be ASME B16.9-LATEST EDITION.
- Flanges over 24" to be ASME "B16.47-2011".

SURFACE PREPARATION: EXTERIOR TO BE POWER TOOL CLEANED

PAINT: (1) COAT OF SHERWIN WILLIAMS MACROPOXY 646 EPOXY PRIMER

MARK	QUAN	SIZE	RAT	FAC	TYPE	SERVICE	NOZZLE OD	WALL THK.	PAD THK.	PAD WIDTH	OS PROJ	IS PROJ	WELD A	WELD B	WELD C	BEVEL	B.O.M. NUMBER	
MH	1	16"	150#	RF	STUDDING OUTLET	MANWAY W/BLIND	23.5"	3.75"	----	----	----	----	0"	3/8	----	7/16	FULL	116
L	1	2"	300#	RF	STUDDING OUTLET	DRAIN	6.5"	1.9375"	----	----	----	----	0"	3/8	----	3/4	FULL	126
K	1	3"	300#	RF	STUDDING OUTLET	VAPOR W/ STANDPIPE	8.25"	2.3125"	----	----	----	----	0"	3/8	----	3/4	FULL	125
J	1	3"	300#	RF	STUDDING OUTLET	VAPOR	8.25"	2.3125"	----	----	----	----	0"	3/8	----	3/4	FULL	125
I	1	3"	300#	RF	STUDDING OUTLET	VAPOR	8.25"	2.3125"	----	----	----	----	0"	3/8	----	3/4	FULL	125
H	1	1/2" X 7"	3000#	THR'D	CPL'G	THERMOWELL	1.375"	.267"	----	----	----	----	3/4"	----	1/4	1/4	----	119
G	1	3/4"	6000#	THR'D	CPL'G	PRESSURE/LIQUID LEVEL	1.75"	.35"	----	----	----	----	3/8"	----	3/8	3/8	----	118
F	1	2 1/2"	3000#	THR'D	CPL'G	FLOAT/ROTARY GAUGE	3.625"	.375"	----	----	----	----	3/8"	----	3/8	3/8	----	117
E	1	1"	3000#	THR'D	CPL'G	INSPECTION	1.75"	.2175"	----	----	----	----	1/4"	1/4	1/4	----	----	122
D	1	4"	300#	RF	STUDDING OUTLET	SPRAYFILL W/ STANDPIPE	10.0"	2.71875"	----	----	----	----	0"	15/16	----	3/4	FULL	127
C	1	3"	300#	RF	STUDDING OUTLET	LIQUID	8.25"	2.3125"	----	----	----	----	0"	3/8	----	3/4	FULL	125
B	1	4"	300#	RF	STUDDING OUTLET	LIQUID	10.0"	2.71875"	----	----	----	----	0"	15/16	----	3/4	FULL	127
A1-A3	3	4"	300#	RF	STUDDING OUTLET	RELIEF	10.0"	3.0"	----	----	----	----	0"	3/8	----	3/4	FULL	121

SCHEDULE OF OPENINGS

144	1	1/4" X 4 1/2" I.D. X 6 7/8" O.D. PLATE	SA-516 GR. 70		
143	1	6" SCH. 40 (280" WALL) PIPE X 16" LG.	SA-106-B		M
142	1	4" SCH. 40 (.237" WALL) B.W. TEE	SA-234-WPB		
141	1	4" STD. WT. (.237" WALL) PIPE X 94" LG.	SA-106-B		
140	1	1/4" X 6" PL. X 27 5/16" LG. (CUT & BEND PER DET'L)	SA-516 GR. 70		M
139	1	6" SCH. 40 (280" WALL) B.W. TEE	SA-234-WPB		
138	1	6" SCH. 40 (280" WALL) PIPE X 120" LG.	SA-106-B		
137	1	1/4" X 9 5/8" PL. X 21 5/16" LG. (CUT PER DET'L)	SA-516 GR. 70		M
136	1	1" X 15" PL. X 116" LG.	SA-516 GR. 70		
135	4	1/2" X 13 3/4" PL. X 3 7/16" LG. (TRIM AS REQ'D)	SA-516 GR. 70		
134	2	3/8" X 16" PL. X 195" LG. (ROLL TO 131 7/16" I.D.)	SA-516 GR. 70		M
133	4	1/2" X 56 3/8" PL. X 65 5/16" LG. (CUT PER DET'L)	SA-516 GR. 70		
132	2	1/2" X 3 7/16" PL. X 38 1/2" LG. (TRIM AS REQ'D)	SA-516 GR. 70		
131	4	1/2" X 13 7/8" PL. X 8 13/16" LG. (TRIM AS REQ'D)	SA-516 GR. 70		
130	4	1/2" X 13 7/8" PL. X 17 15/16" LG. (TRIM AS REQ'D)	SA-516 GR. 70		
129	1	1" X 15" PL. X 116" LG.	SA-516 GR. 70		
128	4	1/2" X 14" PL. X 56 15/16" LG. (TRIM AS REQ'D)	SA-516 GR. 70		
127	2	4" 300# R.F. STUDDING OUTLET X 2 5/16" MIN. THK. (MACH. PER DET'L)	SA-516 GR. 70N		M
126	1	2" 300# R.F. STUDDING OUTLET X 2 1/4" THK. W/ 2 5/8" BORE	SA-516 GR. 70N	13682	M
125	4	3" 300# R.F. OUTLET X 2 1/2" MIN. THK. W/ 3 5/8" BORE	SA-516 GR. 70N	13684	M
124	1	ABOVE GROUND NAMEPLATE	Stainless Steel		
123	1	1/4" X 7 1/2" PL. X 7 1/2" LG.	SA-516 GR. 70		
122	1	1" 3000# THREADED HALF COUPLING	SA-105	1230-2	R
121	3	2 1/2" THK. X 3 1/2" I.D. X 10 1/2" O.D.	SA-516-70N	13417	M
120	1	3/8" PL. X 3" X 3"	SA-516 GR. 70	13420	M
119	1	1/2" X 7" LG. THERMOWELL	SA-105	1157-7	R
118	1	3/4" 6000# THREADED FULL COUPLING	SA-105	1238-9	R
117	1	2 1/2" 3000# THREADED HALF COUPLING	SA-105	1234-8	R
116	1	16" 150# R.F. MANWAY W/ BLIND		17074	
115	1	0.714" X 79 3/4" PL. X 410 5/8" LG. (ROLL 130" I.D.)	SA-612		M
114	1	0.714" X 107" PL. X 410 5/8" LG. (ROLL 130" I.D.)	SA-612		M
113	1	0.714" X 117 3/4" PL. X 410 5/8" LG. (ROLL 130" I.D.)	SA-612		M
112	1	0.714" X 117 3/4" PL. X 410 5/8" LG. (ROLL 130" I.D.)	SA-612		M
111	1	0.714" X 117 3/4" PL. X 410 5/8" LG. (ROLL 130" I.D.)	SA-612		M
110	1	0.714" X 117 3/4" PL. X 410 5/8" LG. (ROLL 130" I.D.)	SA-612		M
109	1	0.714" X 117 3/4" PL. X 410 5/8" LG. (ROLL 130" I.D.)	SA-612		M
108	1	0.714" X 117 3/4" PL. X 410 5/8" LG. (ROLL 130" I.D.)	SA-612		M
107	1	0.714" X 117 3/4" PL. X 410 5/8" LG. (ROLL 130" I.D.)	SA-612		M
106	1	3/8" X 4" PL. X 4" LG. (CUT PER DET'L)	SA-516 GR. 70		
105	1	.420" MIN. THK. X 130" I.D. HEMI-HEAD (STRAPPING=411.4375")		56865-8	M
104	1	.420" MIN. THK. X 130" I.D. HEMI-HEAD (STRAPPING=411.5")		56865-5	M
103	1	0.714" X 117 3/4" PL. X 410 5/8" LG. (ROLL 130" I.D.)	SA-612		M
102	1	0.714" X 117 3/4" PL. X 410 5/8" LG. (ROLL 130" I.D.)	SA-612		M
101	1	0.714" X 117 3/4" PL. X 410 5/8" LG. (ROLL 130" I.D.)	SA-612		M
100	1	0.714" X 117 3/4" PL. X 410 11/16" LG. (ROLL 130" I.D.)	SA-612		M

BILL OF MATERIAL

TRANSTECH ENERGY

MO NO. 56483 UNITS REQ'D. ONE

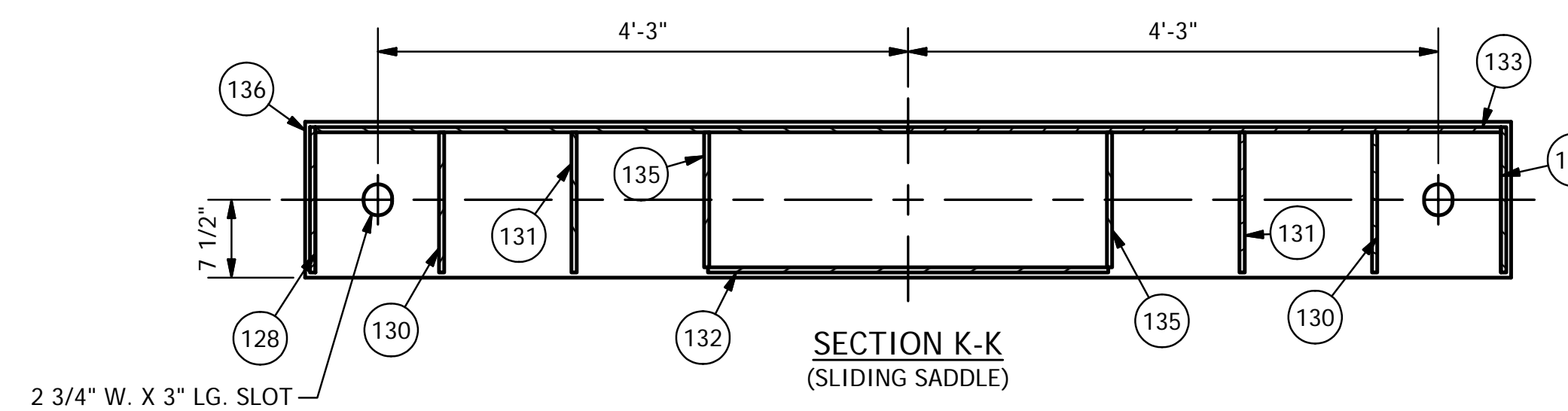
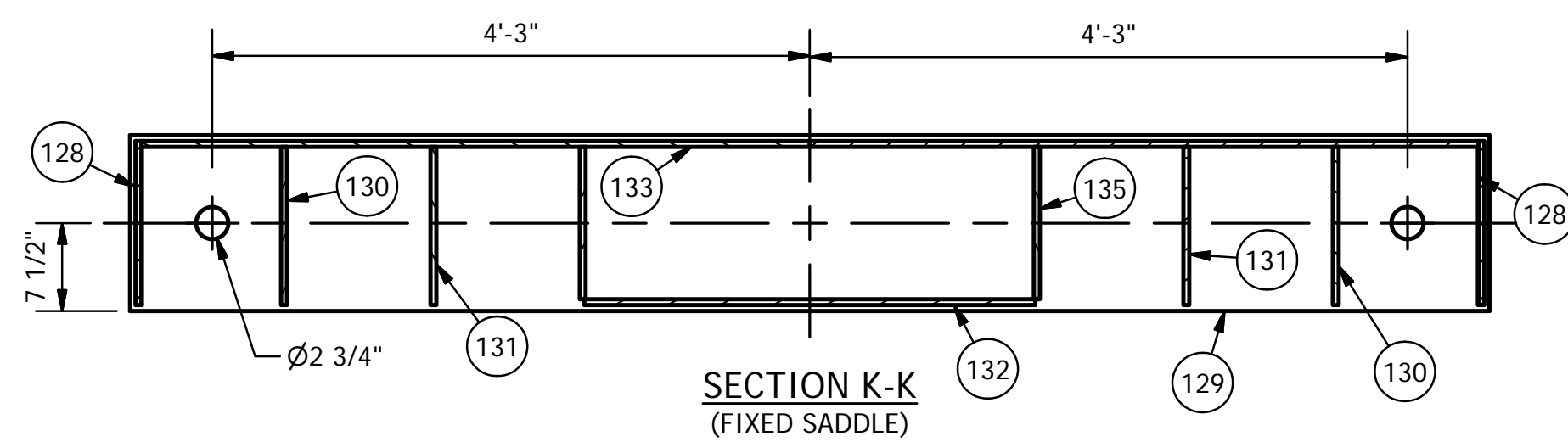
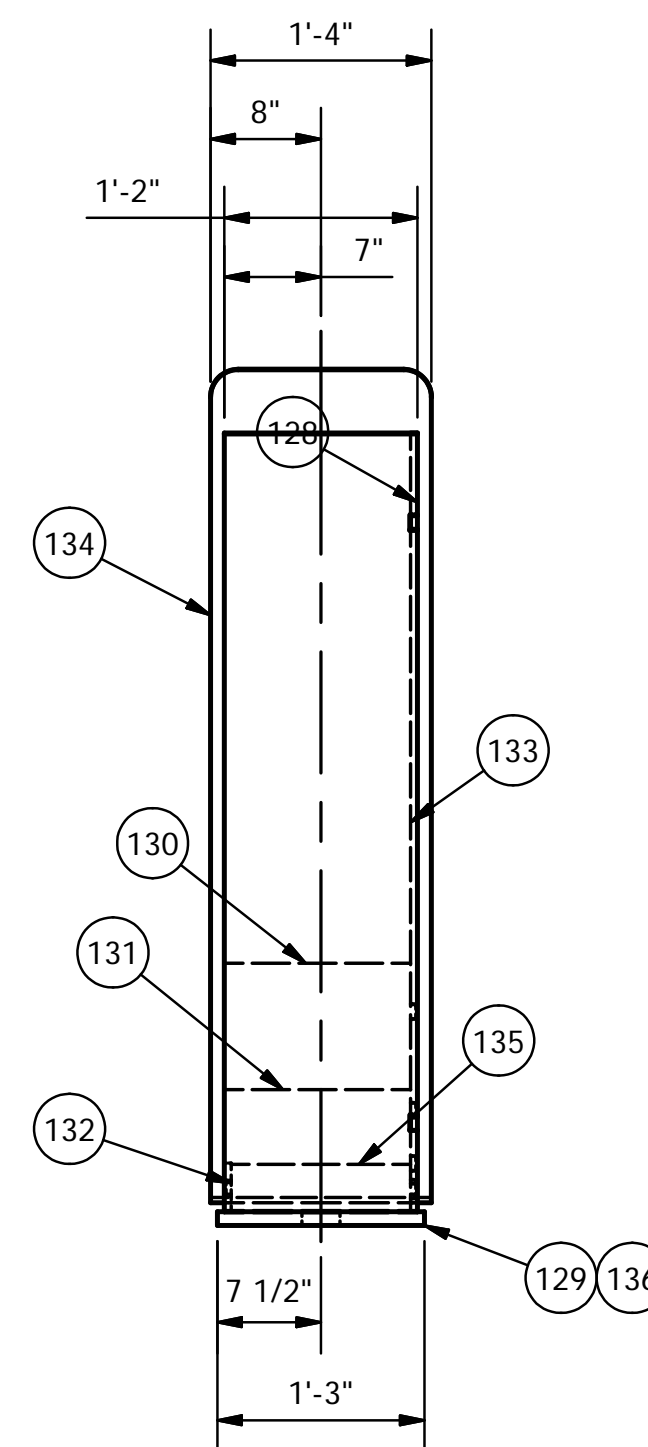
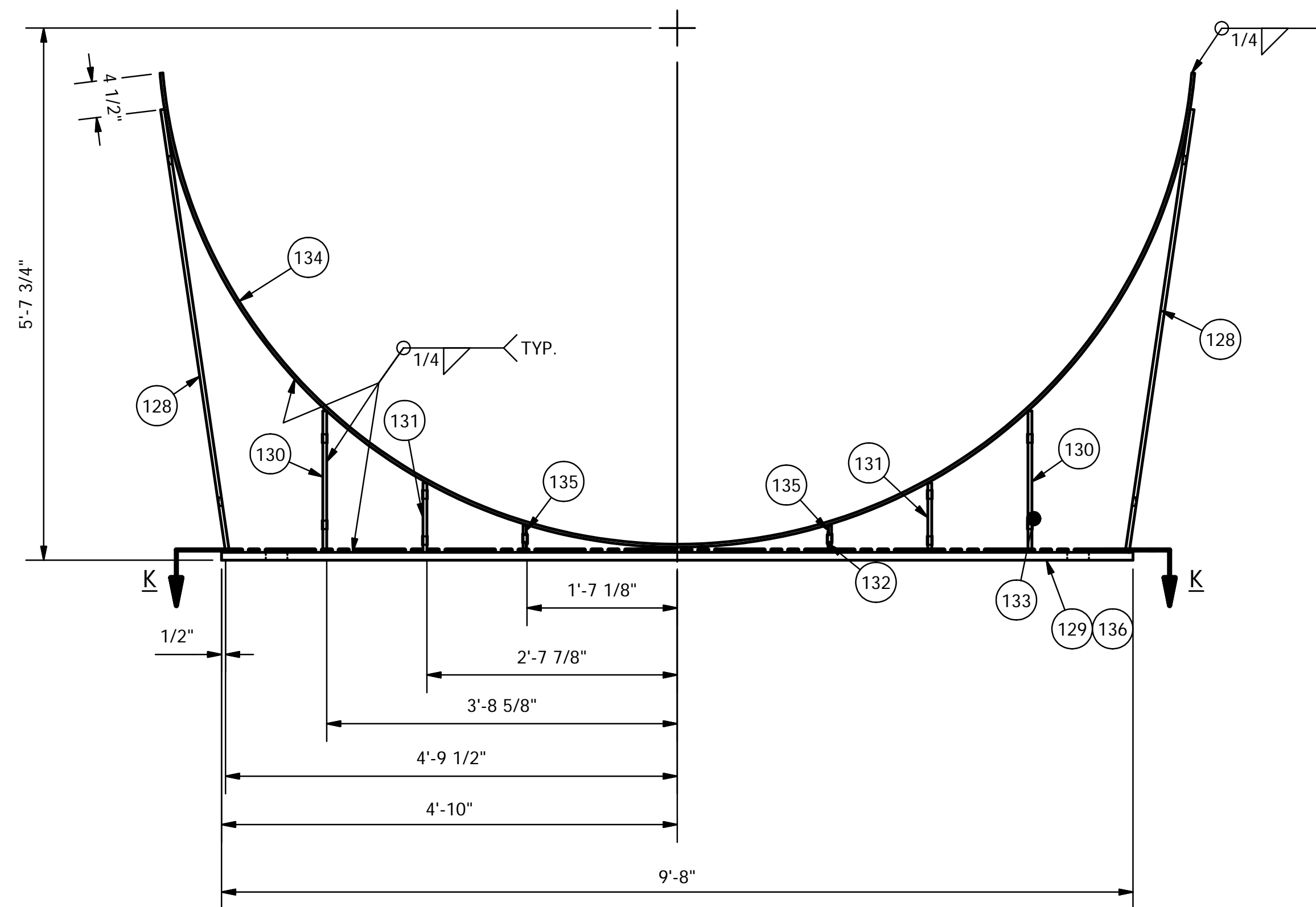
CUSTOMER: **TRANS TECH ENERGY**

P.O. NO. P000012040 ITEM #

130" I.D. X 1,610" O.A.L.
90,000 W.G. CAP. LPG STORAGE TANK

DES.	DWN.BY:	DATE	DWG. NO.	REV.
D = DOMESTIC MATERIAL; M = MILL TEST REPORT; A = APPROVED VENDOR LIST.	R = RECORD; C = VENDOR CERTIFICATION OF DOMESTIC ORIGIN.	saultman	5/27/2019	L15472
APPROVED BY:				1

SCALE: N.T.S.



REFERENCE DRAWINGS

MO NO. 56483 UNITS REQ'D. ONE

CUSTOMER
TRANS TECH ENERGY

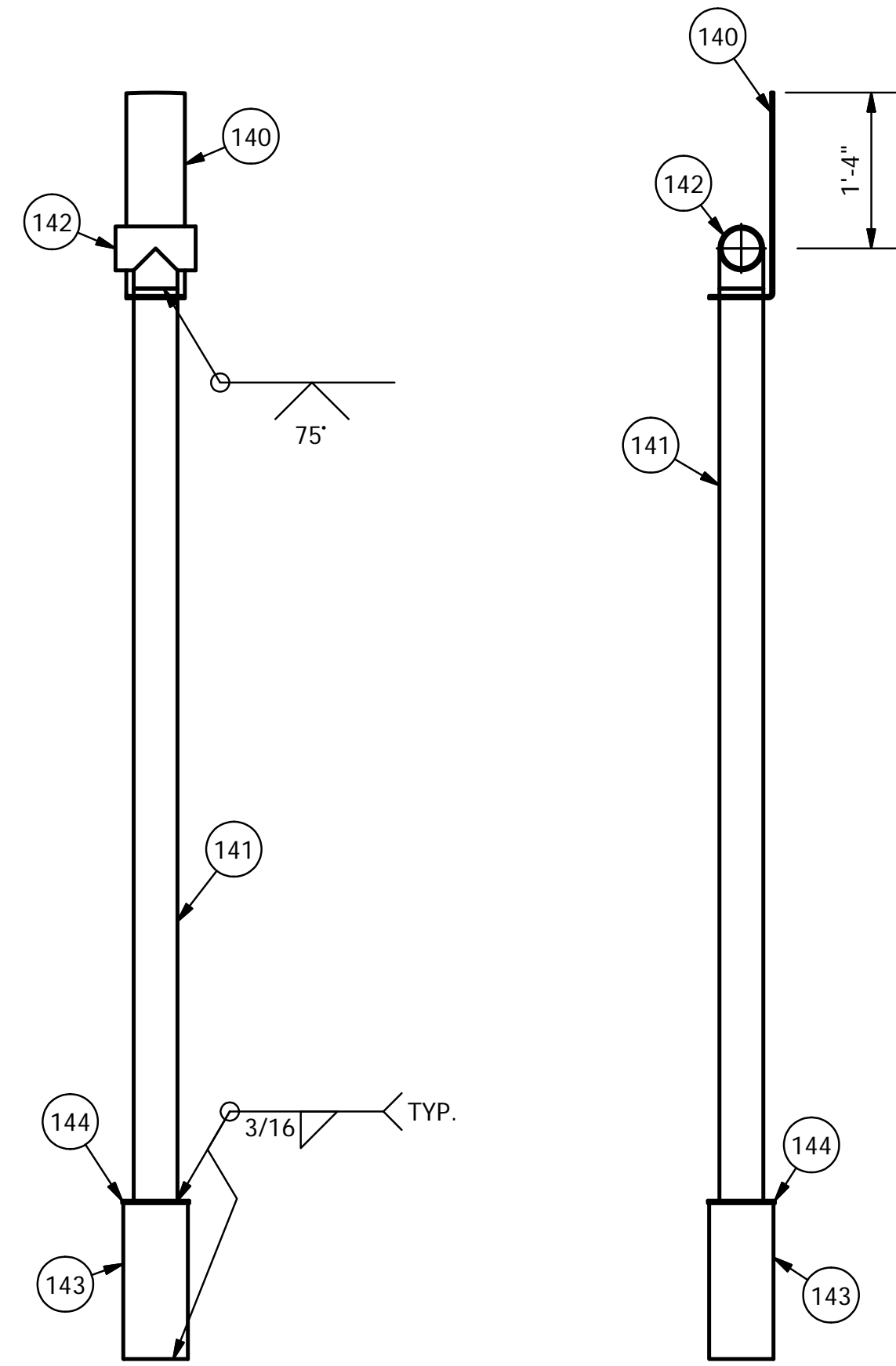
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SADDLE DETAIL'S

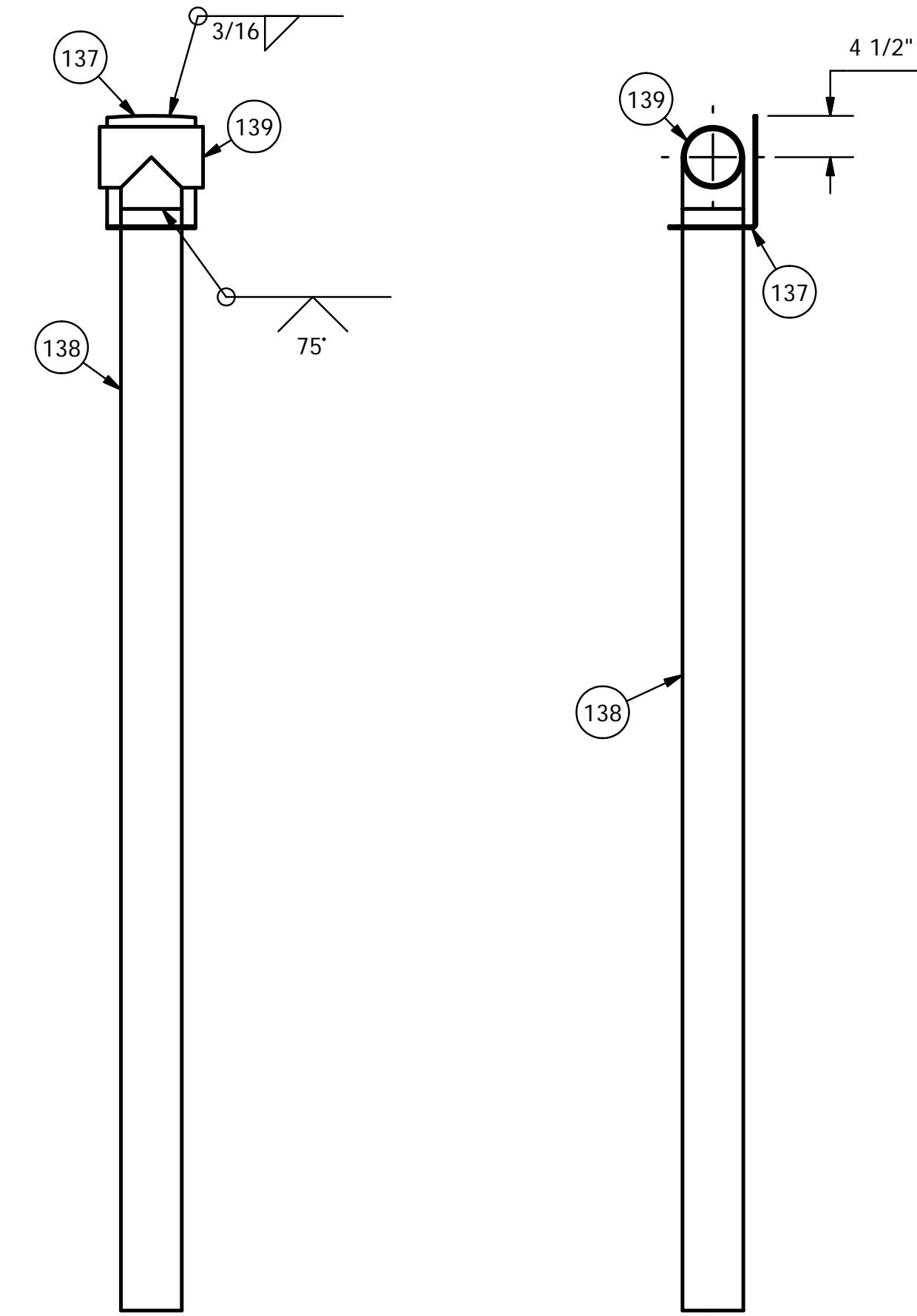
DES.
D = DOMESTIC MATERIAL:
M = MILL TEST REPORT:
A = APPROVED VENDOR LIST:

R = RECORD:
C = VENDOR CERTIFICATION:
OF DOMESTIC ORIGIN

DWN.BY: saultman	DATE: 6/27/2018	DWG. NO. L15472	REV. 1
CKD.BY:			
APPROVED BY:		SCALE: N.T.S.	



STANDPIPE DET'L @ "D"



STANDPIPE DET'L @ "K"



REFERENCE DRAWINGS

MO NO. 56483 UNITS REQ'D. ONE

CUSTOMER
TRANS TECH ENERGY

P.O. NO. PO00012040 ITEM#

STANDPIPE DETAIL'S

DES.	DATE	DWG. NO.	REV.
D = DOMESTIC MATERIAL: M = MILL TEST REPORT: A = APPROVED VENDOR LIST:	R = RECORD: C = VENDOR CERTIFICATION: OF DOMESTIC ORIGIN	DWN.BY: saultman CKD.BY: APPROVED BY:	6/27/2018 L15472 1
		SCALE: N.T.S.	