

WELDING DETAIL OF SHELL TO NOZZLE PIPE & NOZZLE PIPE TO FLANGE

WELDING DETAIL OF DISH END TO NOZZLE PIPE & NOZZLE PIPE TO FLANGE

SHELL LONGITUDINAL/CIRCUMFERENTIAL SEAM WELDING DETAIL

WELDING DETAIL FOR SHELL TO DISH END

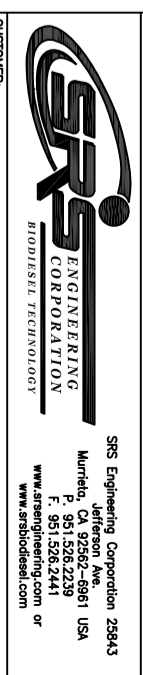
NOZ. NO.	SIZE	SCH./THK.	FLANGE CLASS	FLANGE TYPE	FACE	SERVICE	PROU. FROM CL.
N23	6"	SCH 40	150 #	SO	RF	FEED INLET FROM FS-2	23"
N22	1 1/2"	SCH 40	150 #	SO	RF	RUPTURE DISC	25"
MA/B	24"	5/16" THK	150 #	SO/BL	-	MAN HOLE (FAB)	25"
N21	1/2"	SCH 40	150 #	SO	RF	FROM BOTTOM PUMP	22"
N20	1"	SCH 40	150 #	SO	RF	LEVEL SWITCH	22"
N19	1"	SCH 40	150 #	SO	RF	PRESSURE GAUGE	22"
N18	8"	SCH 40	150 #	SO	RF	HAND HOLE	22"
N17	1 1/2"	SCH 40	150 #	SO	RF	DRAIN	22"
N16	3"	SCH 40	150 #	SO	RF	TO REBOILER PUMP	22"
N15	1 1/2"	SCH 40	150 #	SO	RF	BOTTOM DISCHARGE	22"
N14	1"	SCH 40	150 #	SO	RF	LEVEL TRANSMITTER	22"
N13A	2"	SCH 40	150 #	SO	RF	LEVEL TRANSMITTER	22"
N12	1"	SCH 40	150 #	SO	RF	RTD	22"
N11	6"	SCH 40	150 #	SO	RF	HOT SOLVENT INLET	22"
N10A	1"	SCH 40	150 #	SO	RF	FEED INLET FORM FS-1	23"
N9	6"	SCH 40	150 #	SO	RF	RTD	22"
N8	1"	SCH 40	150 #	SO	RF	RTD	22"
N7A	1"	SCH 40	150 #	SO	RF	REFLUX INLET	22 7/8"
N6A	2 NPT	1500#	FULL COUPLING	SO	RF	VIEWPORT	-
N5	1"	SCH 40	150 #	SO	RF	PRESSURE GAUGE	22"
N4	1"	SCH 40	150 #	SO	RF	RTD	22"
N3	4 1/2"	SCH 40	150 #	SO	RF	REFLUX INLET	22 7/8"
N2	2"	SCH 40	150 #	SO	RF	PSV	-
N1	6"	SCH 40	150 #	SO	RF	VAPOUR OUTLET	-

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- NOTES :-
1. ALL DIMENSIONS ARE IN INCH UNLESS OTHERWISE SPECIFIED.
 2. ALL BOLT HOLES SHOULD BE STRADDLE THE MAIN CENTRE LINES.
 3. LINER WELDING TO BE CARRIED OUT BY TIG WELDING.
 4. HYDROTEST OF THE EQUIPMENT SHALL BE DONE WITH THE SERVICE GASKET.
 5. ALL FASTENERS SHOULD BE UNC THREADED.
 6. ALL INTERNAL WELD SEAM TO BE GROUND SMOOTH /FLUSH AND RADIUSED.
 7. ALL WELDS (EXCEPT FILLETS) SHALL BE CHIPPED BACK TO SOUND METAL AND REWELD FROM SECOND SIDE, WHEREVER BACK CHIPPING IS NOT POSSIBLE ROOT RUN SHALL BE DONE BY TIG WITH INERT GAS PURGING.
 8. ALL MACHINED SURFACES, BOLTS & NUTS SHALL BE PROTECTED WITH ACID FREE GREASE.
 9. ALL FILLET WELDS SHALL BE 0.18" UNLESS OTHERWISE SPECIFIED.
 10. ALL NOZZLES PIPES BELOW 1 1/2" SHOULD BE PROVIDED WITH 2 NOS OF TEMPORARY STIFFENERS WELDED AT 90° AS SHOWN BEFORE FULL WELDING.
 11. EXTERNAL SURFACE TO BE AOD PICKLED & GLAZING EXTERNAL SURFACE SHOULD BE 48 MIRROR FINISH.
 12. ALL BODY FLANGE BOLTS SHOULD BE HIGH TENSILE, A 325 QUALITY, NUTS STITCH WELDED.
 13. ALL 'C' SEAM & 'U' SEAMS SHOULD BE D.P. TESTED. (i.e ROOT RUN & FIRST RUN)
 14. ALL WELDING SHOULD BE CARRIED OUT BY QUALIFIED WELDER ONLY.
 15. ALL BODY FLANGES SHOULD BE ULTRASONICALLY TESTED.
 16. ALL BODY FLANGES SHOULD BE PROTECTED WITH ZINC SPRAY COATING, AFTER FULL WELDING.
 17. DELETED
 18. ALL NOZZLES (INCLUDING MAN WAY NOZZLES) SHOULD BE 48 MIRROR FINISHED BEFORE FITMENT TO SHELL, SKIRT & EQUIPMENT etc.
 19. INSULATION SHELL AND PATCH PLATE SHOULD BE STITCH WELDED 0.06" FILLET x 1" (L2" SPACING)
 20. ALL PAD PLATES FOR NOZZLES AND CHAIR SUPPORT SHOULD BE FULLY WELDED, BEFORE FITMENT TO SHELL OR SKIRT.
 21. COLUMN REBOILER BOTTOM DISH SHOULD BE 48 MIRROR FINISHED



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 www.srisengineering.com or
 www.srisinc.com

CUSTOMER: _____

DRAWING DESCRIPTION: COLUMN ASSEMBLY DRAWING

SCALE: 1" = 35"

DWG NO: B01-PRT-COL-ASSY-01

DESIGN DATA: CODE - GOOD ENGG. PRACTICE

DATE: _____

DESIGNED BY: V.V.C.

CHECKED BY: _____

APPROVED BY: _____

SHEET 1 OF 1