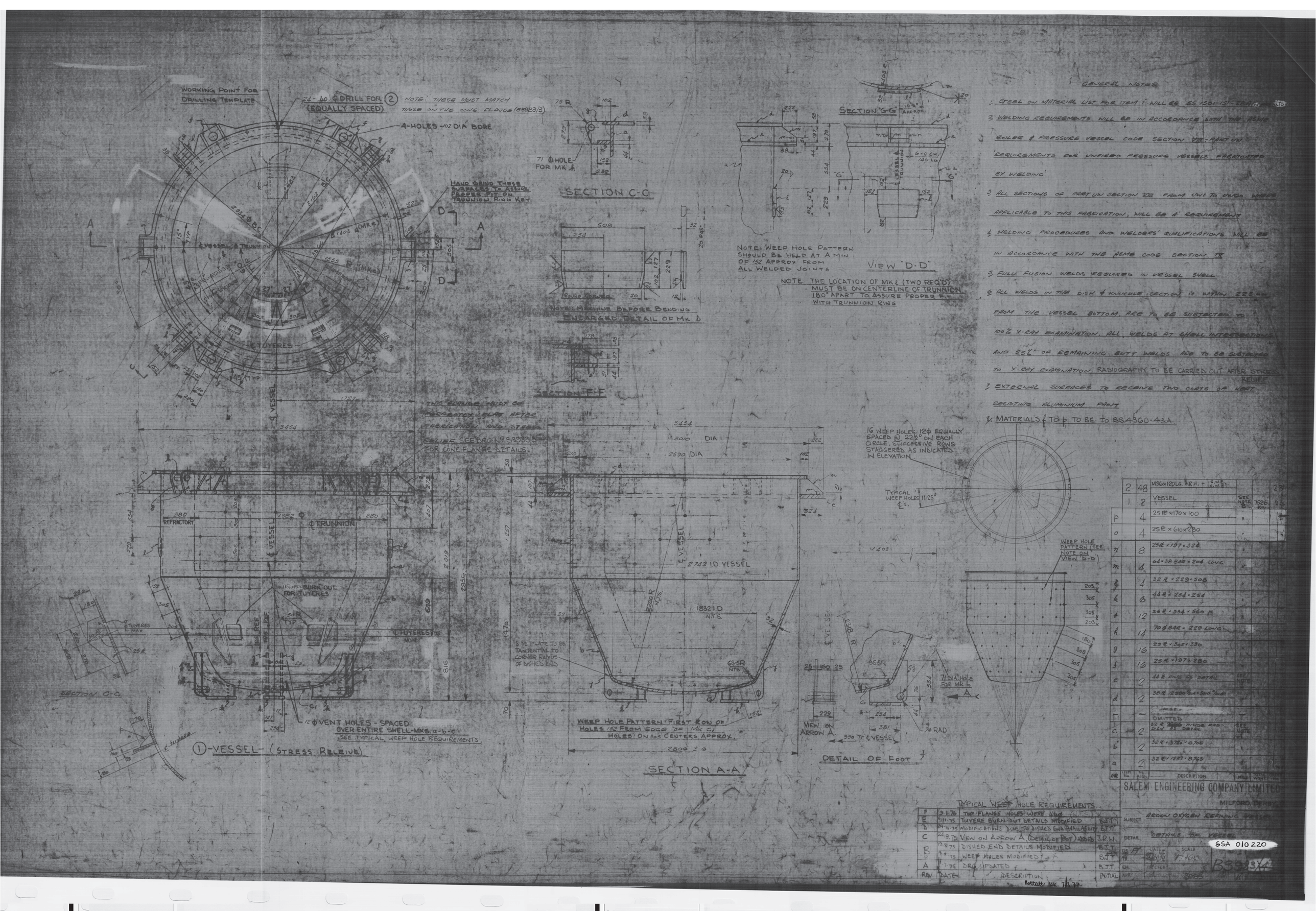

GENERAL NOTES

1. STEEL ON MATERIAL LIST FOR ITEM 1 WILL BE BS 1501-151-28A
2. WELDING REQUIREMENTS WILL BE IN ACCORDANCE WITH THE ASME BOILER & PRESSURE VESSEL CODE SECTION VIII - PART UW 'REQUIREMENTS FOR UNFIRED PRESSURE VESSELS FABRICATED BY WELDING'
3. ALL SECTIONS OF PART UW SECTION VIII FROM UW1 TO UW60 WHERE APPLICABLE TO THIS FABRICATION, WILL BE A REQUIREMENT
4. WELDING PROCEDURES AND WELDERS' QUALIFICATIONS WILL BE IN ACCORDANCE WITH THE ASME CODE SECTION IX
5. FULL FUSION WELDS REQUIRED IN VESSEL SHELL
6. ALL WELDS IN THE DISH & KNUCKLE SECTION IE WITHIN 225 mm FROM THE VESSEL BOTTOM, ARE TO BE SUBJECTED TO 100% X-RAY EXAMINATION. ALL WELDS AT SHELL INTERSECTIONS AND 25% OF REMAINING BUTT WELDS ARE TO BE SUBJECTED TO X-RAY EXAMINATION. RADIOGRAPHY TO BE CARRIED OUT AFTER STRESS RELIEF
7. EXTERNAL SURFACES TO RECEIVE TWO COATS OF HEAT RESISTING ALUMINIUM PAINT
8. MATERIALS f TO p TO BE TO BS 4360-43A

mk	No. off	DESCRIPTION	MATL	UNIT WGT
2	48	M36x120LG. F.R.H. + 1 S.W.E. (L.W.E.)		23
1	2	VESSEL	SEE NOTE 8	7526 kg
p	4	25 PL × 170 × 100		
o	4	25 PL × 610 × 280		
n	8	25 R × 197 × 328		
m	4	64 × 38 BAR × 204 LONG		
l	4	32 R × 229 × 508		
k	6	44 R × 254 × 254		
j	12	26 R × 334 × 560		
h	14	70 Φ BAR × 220 LONG		
g	16	25 R × 305 × 330		
f	16	25 R × 197 × 280		
e	2	44 R ENG RS DETAIL	SEE NOTE	
d	2	38 R 2500 mm × 500 mm		
c1	—	OMITTED		
c	2	32 R 2500 INSIDE DIA DISH AS DETAIL	SEE NOTE	
b	2	32 R × 372 × 6,706		
a	2	32 R × 1257 × 8,763		

SALEM ENGINEERING COMPANY LIMITED
MILFORD, DERBY.

SUBJECT: ARGON OXYGEN REFINING VESSEL
DETAIL: DETAILS OF VESSEL
DR. B.J.T. DATE 7.1.75 SCALE 1/16
TR. 10.1.75
CH. TECHNICAL
APP. CONTRACTING SERVICES
B33 BXA

SSA 010220

TYPICAL WEEP HOLE REQUIREMENTS

REV.	DATE	DESCRIPTION	INITIAL
F	9.1.76	TOP FLANGE HOLES WERE 16mm	
E	4.11.75	TUYERE BURN-OUT DETAILS MODIFIED	B.J.T.
D	29.10.75	MODIFICATIONS DUE TO DISHED END DETAIL AGREED	B.J.T.
C	24.9.75	VIEW ON ARROW A (DETAIL OF FOOT) ADDED	J.P.W.
B	19.8.75	DISHED END DETAILS MODIFIED	B.J.T.
	8.8.75	WEEP HOLES MODIFIED	B.J.T.
A	7.7.75	DRG. UPDATED	B.J.T.

Mottatte 16.12.77