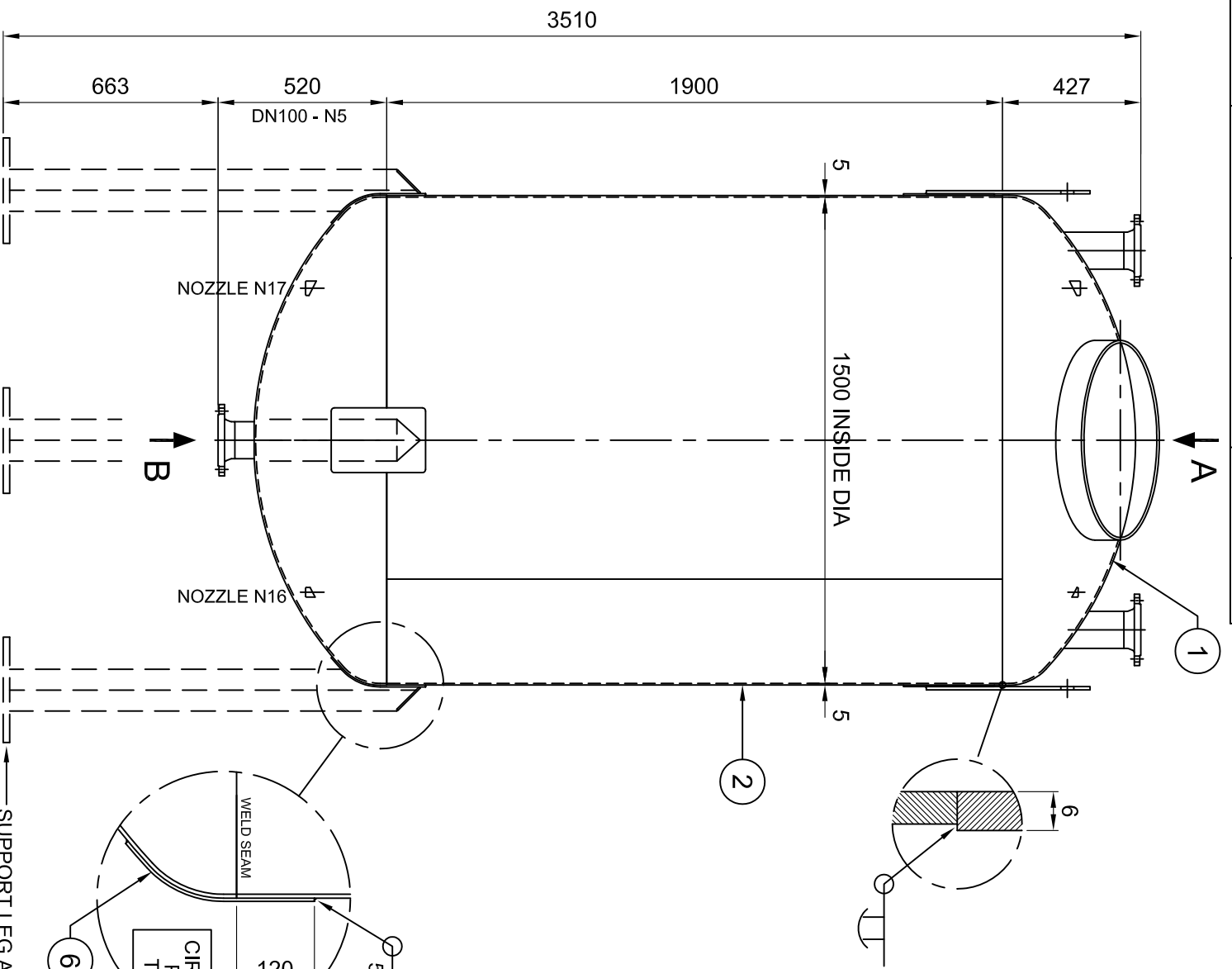
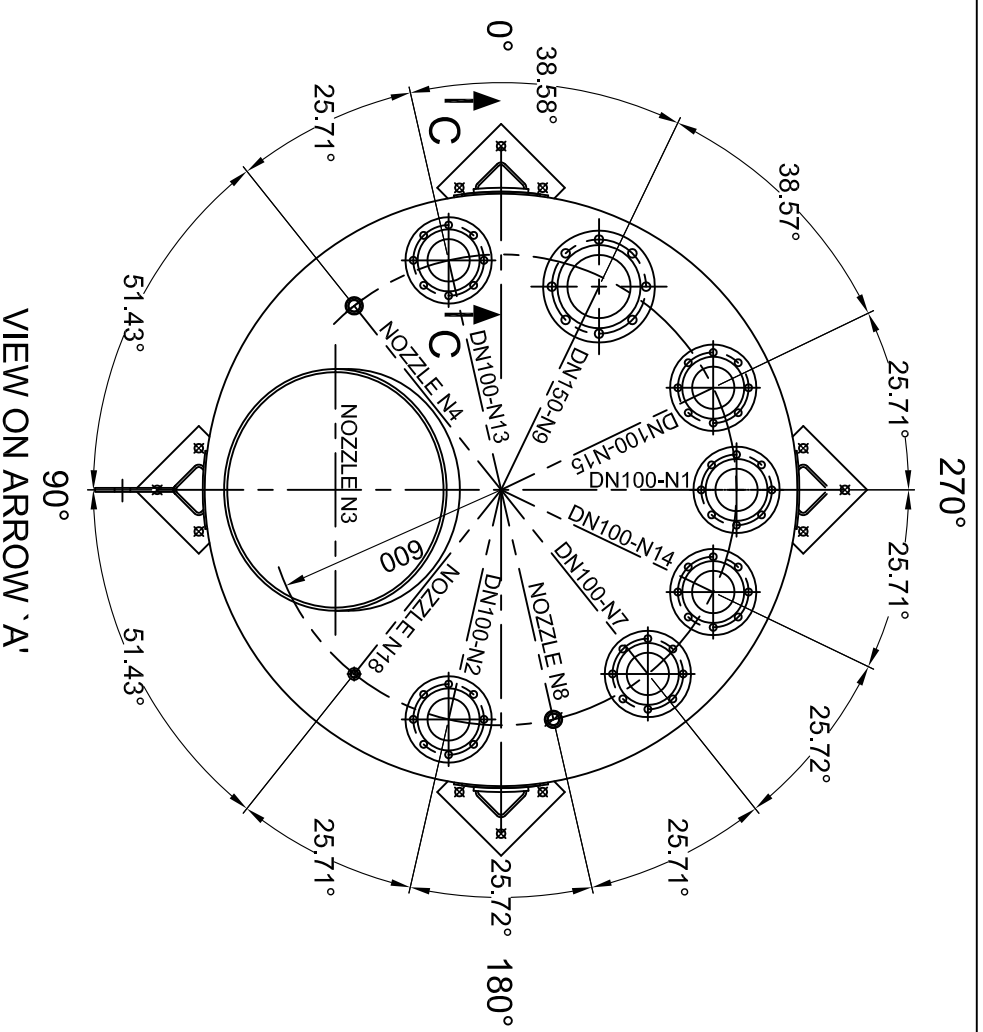


PORT No.	PORT SIZE	PIPE SIZE	PORT DESCRIPTION
N1	DN100 PN 16	4" NB SCH.10 (3.05 WALL)	TO PRE-TREAT
N2	DN100 PN 16	4" NB SCH.10 (3.05 WALL)	BURSTING DISK
N3	600mm IDIA	N/A	MANWAY
N4	1" BSP (F)	N/A	PRESSURE TRANSDUCER
N5	DN100 PN 16	4" NB SCH.40 (6.02 WALL)	OUTLET TO MICROWAVE
N6	1/2" BSP (F)	N/A	TEMPERATURE PROBE
N7	DN100 PN 16	4" NB SCH.10 (3.05 WALL)	FROM PRE-TREAT
N8	1" BSP (F)	N/A	COMPRESSED AIR
N9	DN150 PN 16	6" NB SCH.10 (3.4 WALL)	PRESSURE BALANCE
N10			
N11			
N12	DN100 PN 16	4" NB SCH.10 (3.05 WALL)	SPARE
N13	DN100 PN 16	4" NB SCH.10 (3.05 WALL)	SPARE
N14	DN100 PN 16	4" NB SCH.10 (3.05 WALL)	STEAM
N15	1/2" BSP (F) E43300	N/A	LEVEL SENSOR
N16	1" BSP (F) E2010171	N/A	PRESSURE TRANSDUCER
N17	1/2" BSP (F) E43300	N/A	LEVEL SENSOR
N18			

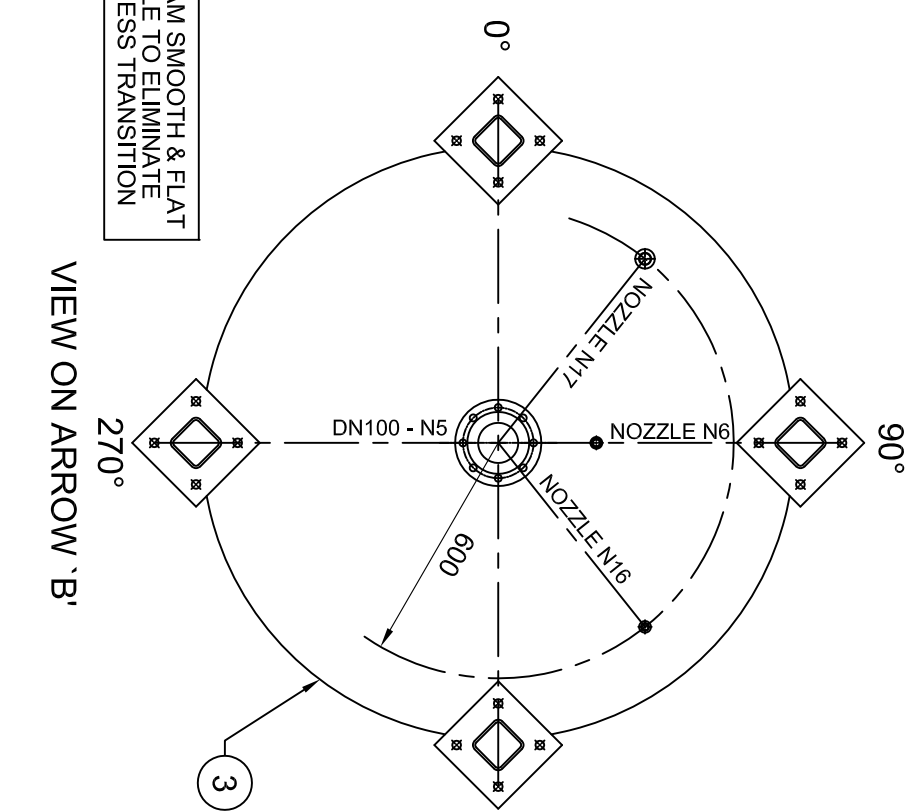


SIDE ELEVATION

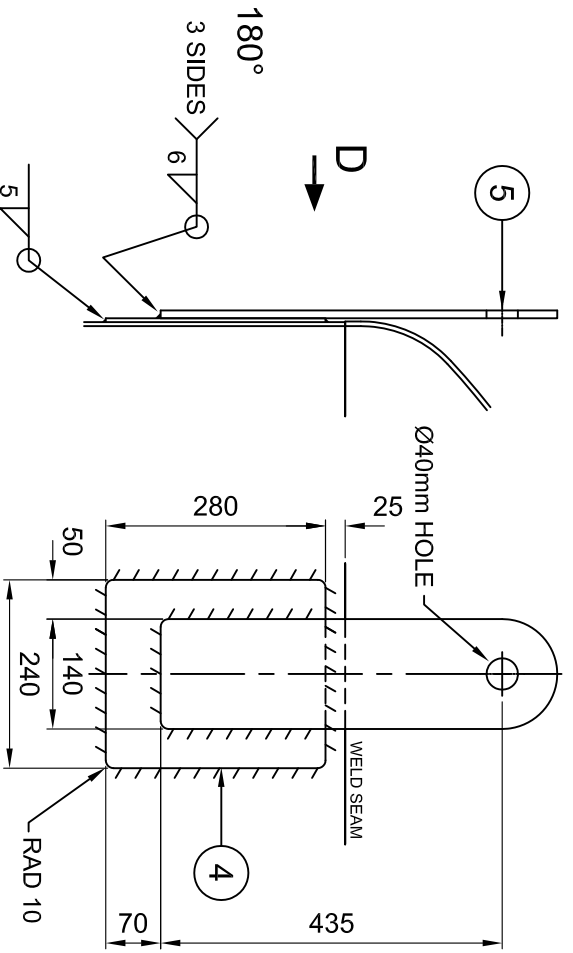
SUPPORT LEG ASSY
SEE DRG D5550/15



VIEW ON ARROW 'A'



VIEW ON ARROW 'B'



SECTION C-C VIEW ON ARROW 'D'
TYPICAL TWO PLACES

ITEM No.	QUANTITY	MATERIAL	DESCRIPTION	PART/DRAWING No.
6	4	SA240 - 304	SUPPORT LEG DOUBLER - 5 THK	E6952/16
5	2	STAINLESS STEEL 304	LIFTING LUG - 10 THK	E4840/09
4	2	SA240 - 304	LIFTING LUG DOUBLER - 5 THK	B7910/15 'A' ITEM 4
3	1	STAINLESS STEEL 316	BOTTOM DISHED END ASSY	B7909/15 'A'
2	1	STAINLESS STEEL 316	SHELL SECTION ASSY	B7909/15 'A'
1	1	STAINLESS STEEL 316	TOP DISHED END ASSY	B7908/15 'A'

DESIGN & FABRICATION CODE : ASME SECTION VIII DIV.1, 2015 & PED CAT4

FABRICATION NOTES

- ALL WELDS TO BE BY MEANS OF PLASMA / TIG, MIG & MMA.
- THE SHELL, DISHED ENDS AND ALL PARTS IN CONTACT WITH THE CONTENTS OF THE TANK SHALL BE OF STAINLESS STEEL.
- DESIGN CODE ASME SECTION VIII DIVISION 1, 2015
DESIGN METAL TEMPERATURE: 20°C TO +170°C (+4°F TO +338°F)
MAWP: 6.0 bar
DESIGN PRESSURE: 7.0 bar
TEST PRESSURE: 10.5 bar
EXTERNAL PRESSURE: 0.21 bar
INTERNAL PRESSURE: 2.0 bar @ 6.0 Bar
- ALL CORNERS & SHARP EDGES TO BE ROUNDED OFF.
VESSEL SEAMS MACHINE WELDED CHEMICALLY CLEANED AND FINISHED.
FINAL FINISH ON ALL GROUND AREAS TO BE NOT COARSER THAN 180 GRIT.
- LONGITUDINAL WELD SEAMS SPOT RADIOGRAPHY
CIRCUMFERENTIAL WELD SEAMS SPOT RADIOGRAPHY
- HYDRAULIC TEST CERTIFIED BY APPROVED INSPECTION AUTHORITY.
- CORROSION ALLOWANCE - NIL
- VESSEL MATERIALS:-

SHELL :- 5.0mm THK STAINLESS STEEL TO SA240 - 316 & EN 10028-7 1.4401/1.4404
MAX. CARBON CONTENT - 0.03%
GUARANTEED MIN UTS @ 20°C - 530 N/mm²
0.2% PROOF STRESS @ 20°C - 220 N/mm²
1.0% PROOF STRESS @ 170°C - 166 N/mm²
1.0% PROOF STRESS @ 20°C - 260 N/mm²
1.0% PROOF STRESS @ 170°C - 199 N/mm²
MIN ELONGATION - 40%
PLATE FINISH AS SUPPLIED 2B

END :-
6.0mm THK STAINLESS STEEL TO SA240 - 316 & EN 10028-7 1.4401/1.4404
MAX. CARBON CONTENT - 0.03%
GUARANTEED MIN UTS @ 20°C - 530 N/mm²
0.2% PROOF STRESS @ 20°C - 220 N/mm²
1.0% PROOF STRESS @ 170°C - 166 N/mm²
1.0% PROOF STRESS @ 20°C - 260 N/mm²
1.0% PROOF STRESS @ 170°C - 199 N/mm²
MIN ELONGATION - 40%
PLATE FINISH AS SUPPLIED 2B

- ONE LIFTING LUG DOUBLER TO VESSEL, 100% DPI
- ONE LIFTING LEG TO VESSEL, 100% DPI
- IMPACT TEST EXEMPTIONS AS PER ASME UHA-51 (PI)(1)(a) + UHA-51 (e)(2)
- MAX GROSS WEIGHT 3600 KG
- TARE WEIGHT 870 KG

UBH INTERNATIONAL LIMITED
BURSCOUGH, LANCASHIRE LA0 0SL, ENGLAND.
TEL : 01704 898500 FAX : 01704 898518

UNSPECIFIED
TOLERANCES (mm)
0-2500 ±2.0
2501-5000 ±4.0
5001-11000 ±6.0

DO NOT SCALE
IF IN DOUBT, ASK
CAD DRAWING - DO NOT
ALTER MANUALLY

REVISION	DATE	MODIFICATION
3	22.02.16	NOZZLES N16, N17 & N18 NOW FREE ISSUE
2	18.02.16	TEST PRESSURE ADDED, ITEM 6 CIRC NOTE ADDED
1	1.02.16	ASME SPEC ADDED FABRICATION NOTES
0	08.01.16	NEW DRAWING

MOD. BY	DATE	MODIFICATION
PB	22.02.16	NOZZLES N16, N17 & N18 NOW FREE ISSUE
PB	18.02.16	TEST PRESSURE ADDED, ITEM 6 CIRC NOTE ADDED
PB	1.02.16	ASME SPEC ADDED FABRICATION NOTES
PB	08.01.16	NEW DRAWING

CUSTOMER	JOB No.	CAD FILENAME
	15/108 & 109	IH2 ENERGY\3.9K15_108VESSEL ASSEMBLY.A

DRN.	PB	DATE	TITLE
SCALE	1:10	CHKD.	
DRAWING No.	B7910/16 'A'		

DRN.	PB	DATE	TITLE
SCALE	1:10	CHKD.	
DRAWING No.	B7910/16 'A'		
	VESSEL ASSEMBLY 3,900 LITRE		