



FABRICATION NOTES

- ALL WELDS TO BE BY MEANS OF PLASMA / TIG, MIG & MMA.
- THE SHELL, DISHED END & CONE AND ALL PARTS IN CONTACT WITH THE CONTENTS OF THE TANK SHALL BE OF STAINLESS STEEL.
- DESIGN CODE IS ASME SECTION VIII DIVISION 1 (WHERE APPLICABLE).
DESIGN TEMPERATURE: -20°C TO +80°C
WORKING PRESSURE: ATMOSPHERIC
DESIGN PRESSURE: 0.1 bar
- ALL CORNERS & SHARP EDGES TO BE ROUNDED OFF. VESSEL SEAMS MACHINE WELDED, CHEMICALLY CLEANED AND RINSED.
FINAL FINISH ON ALL GROUND AREAS TO BE NOT COARSER THAN 180 GRIT.
- WELDS INSPECTED TO ASME SECTION VIII DIVISION 1.
- SPOT RADIOGRAPHY REQUIRED ON ALL SHELL JOINTS PLUS SOME T-JOINTS. HEADS 100% IF FABRICATED FROM TWO PLATES.
- HYDRAULIC TEST CERTIFIED BY APPROVED INSPECTION AUTHORITY.
- VESSEL MATERIALS:-

SHELL:-
4.0mm THK STAINLESS STEEL TO 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 - 240 N/mm²
0.2% PROOF STRESS @ 150°C - 192 N/mm²
1.0% PROOF STRESS @ 150°C - 210 N/mm²
MIN. ELONGATION - 40%
PLATE FINISH AS SUPPLIED 2B

END & CONE:-
5.0mm THK STAINLESS STEEL TO 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 - 240 N/mm²
0.2% PROOF STRESS @ 150°C - 152 N/mm²
1.0% PROOF STRESS @ 20°C - 270 N/mm²
1.0% PROOF STRESS @ 150°C - 181 N/mm²
MIN. ELONGATION - 40%
PLATE FINISH AS SUPPLIED 2B

SECTION E-E
TYPICAL FOUR PLACES

SECTION C-C

VIEW ON ARROW 'D'

PORT No.	PORT SIZE	PIPE SIZE	PORT DESCRIPTION
N1	600mm I/DIA	N/A	MANWAY
N2	DN80 PN 16	3" NB SCH.10 (3.05 WALL)	FEEDSTOCK INLET
N3	DN80 PN 16	3" NB SCH.10 (3.05 WALL)	DIGESTATE LINE
N4	DN150 PN 16	6" NB SCH.10 (3.4 WALL)	HOPPER INLET
N5	DN150 PN 16	6" NB SCH.10 (3.4 WALL)	RECIRC. INLET
N6	DN150 PN 16	6" NB SCH.40 (7.1 WALL)	RECIRC. OUTLET
N7	1/2" BSP (F)	N/A	TEMPERATURE PROBE
N8	DN150 PN 16	6" NB SCH.10 (3.4 WALL)	FEEDSTOCK OUTLET
N9	1/2" BSP (F) E43300	N/A	LEVEL SENSOR
N10	DN100 PN 16	4" NB SCH.10 (3.05 WALL)	PRESSURE BALANCE
N11	DN100 PN 16	4" NB SCH.10 (3.05 WALL)	ODDOR SCRUBBER
N12	DN200 PN 16	8" NB SCH.10 (3.76 WALL)	RECIRC. INLET
N13	DN200 PN 16	8" NB SCH.10 (3.76 WALL)	RECIRC. INLET
N14	DN200 PN 16	8" NB SCH.10 (3.76 WALL)	RECIRC. INLET
N15	DN80 PN 16	3" NB SCH.40 (3.05 WALL)	FEEDSTOCK OUTLET
N16	DN100 PN 16	4" NB SCH.10 (3.05 WALL)	STEAM FROM SBP
N17	DN100 PN 16	4" NB SCH.10 (3.05 WALL)	SPARE
N18	DN100 PN 16	4" NB SCH.10 (3.05 WALL)	SPARE
N19	1/2" BSP (F)	N/A	AERATION CONE

ITEM NO.	QUANTITY	MATERIAL	DESCRIPTION	PART/DRAWING No.
1	1	STAINLESS STEEL 316	TOP DISHED END ASSY	B7896/15
2	1	STAINLESS STEEL 316	SHELL SECTION ASSY	B7896/15
3	1	STAINLESS STEEL 316	BOTTOM CONE ASSY	B7896/15
4	2	STAINLESS STEEL 304	LIFTING LUG DOUBLER - 5 THK	B7894/15 LH ITEM 4
5	2	STAINLESS STEEL 304	LIFTING LUG DOUBLER - 10 THK	E4840/09
6	4	STAINLESS STEEL 304	SUPPORT LEG DOUBLER - 5 THK	E6930/15
7				
8				
9				

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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	NEW DRAWING	MOD. BY
0	8.12.15		

CAD FILENAME: I\H2 ENERGY\50K15_104\VESSEL_ASSEMBLY-RH

DRN.	PB	DATE	TITLE
SCALE	1:20	8 DEC 15	VESSEL ASSEMBLY
DRAWING No.	B7894/15 RH		50,000 LITRE

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