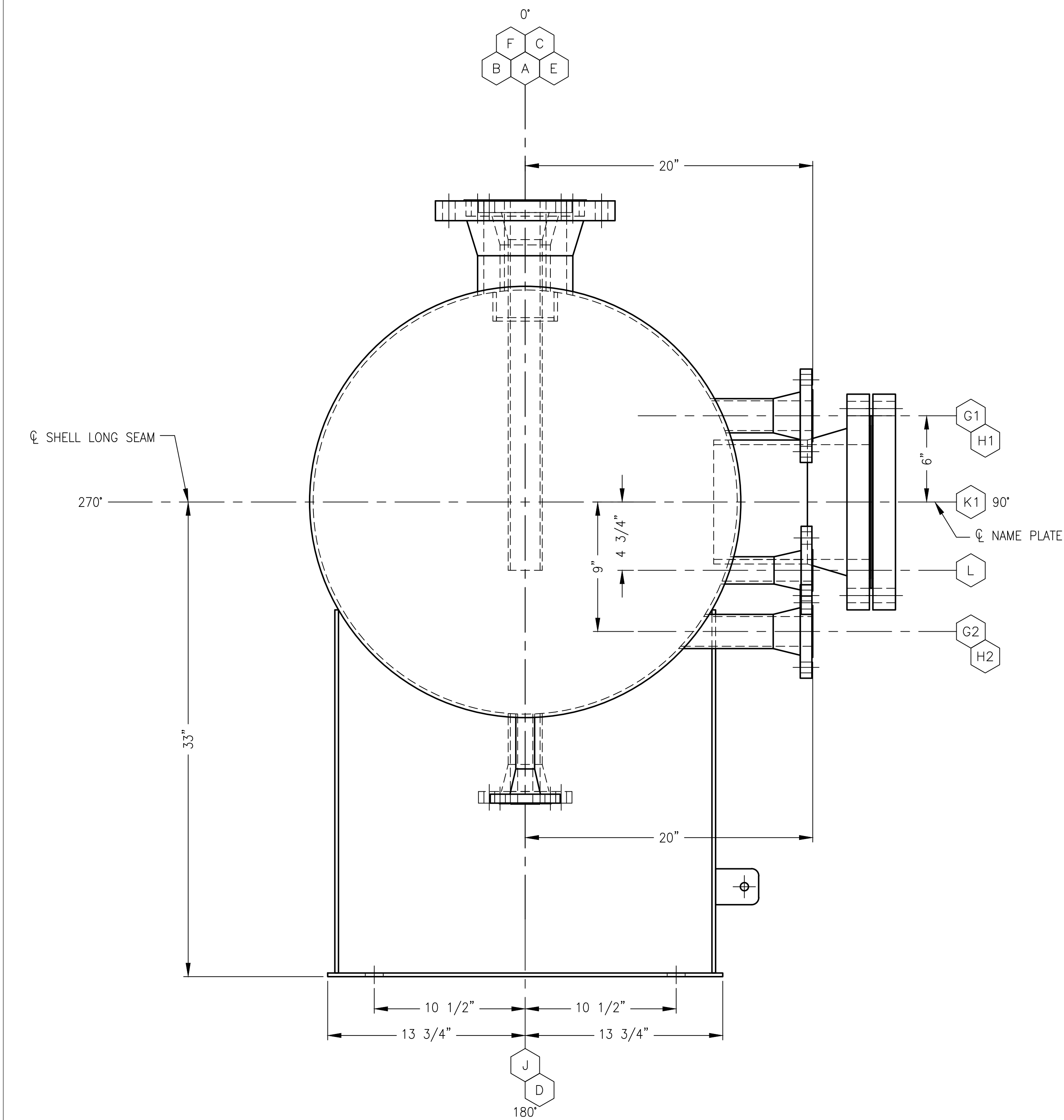
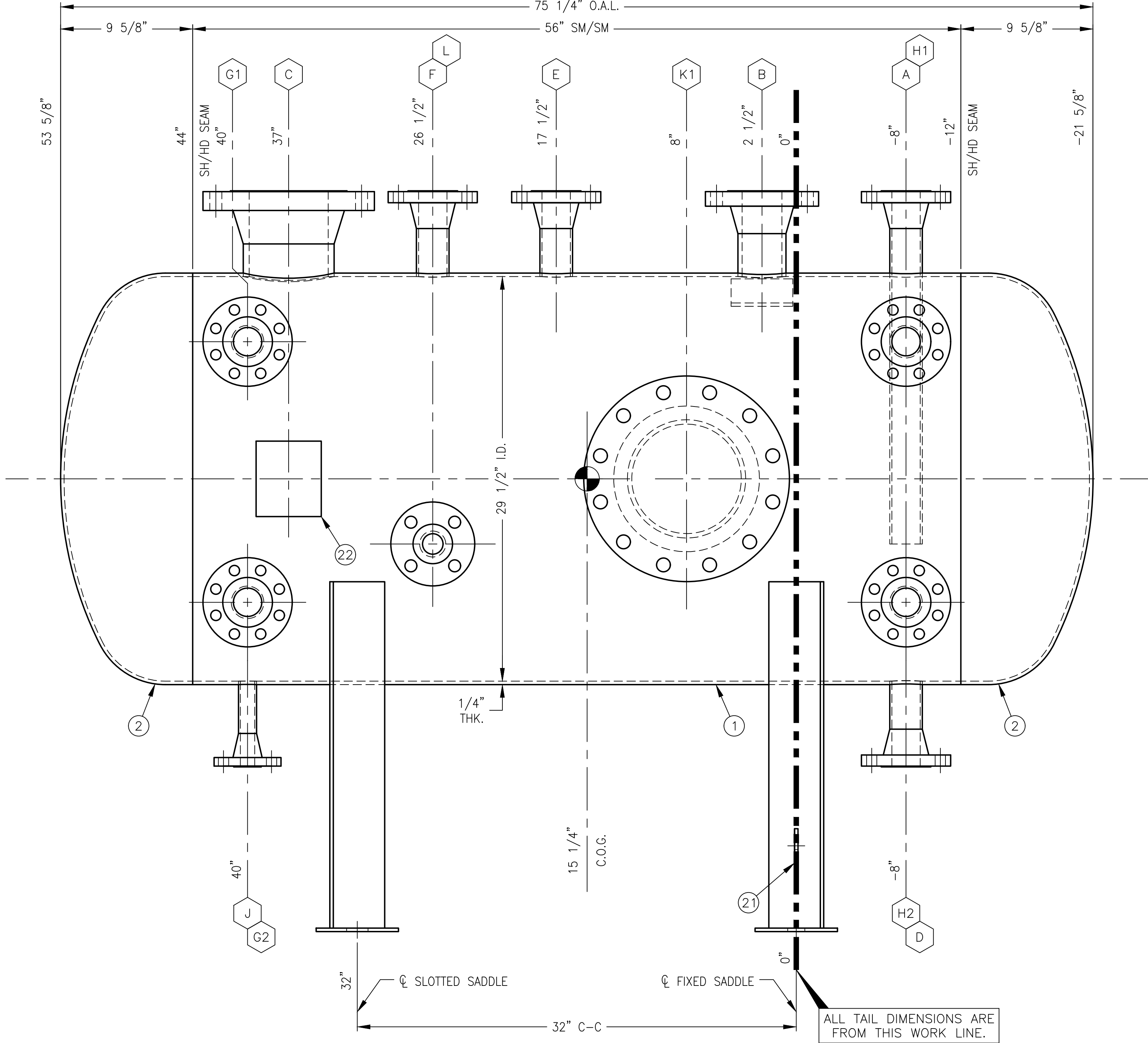




END VIEW
(TRUE ORIENTATION)

WELDING PROCEDURES	
GIRTH WELDS:	300
NOZZLE BRANCH WELDS:	300
FILLET WELDS:	300



ELEVATION
(SEE END VIEW FOR TRUE ORIENTATIONS)

SHEET 1 OF 4

REFERENCE DRAWINGS

HV-2112003CA-02_____BOM, DESIGN DATA, NOTES
HV-2112003CA-03_____NOZZLE DETAILS
HV-2112003CA-04_____SADDLE & LUG DETAILS

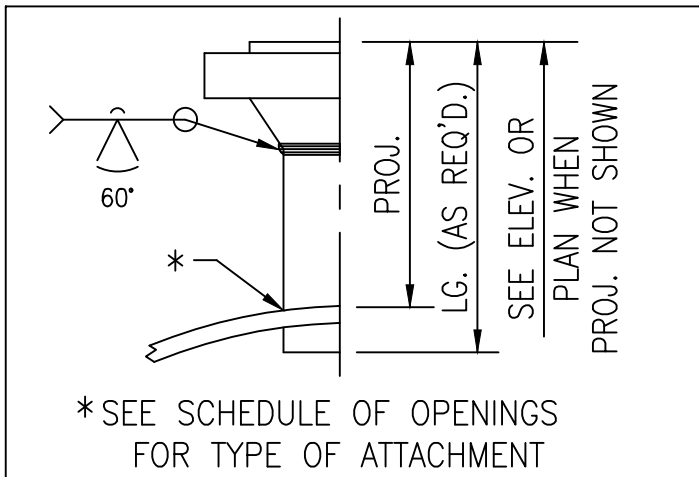
FOR FABRICATION

HVM BY: Kevin Griffith	DATE:	INI:
QA/QC BY: Russ Granger	DATE:	INI:

P.O. NO.: P0110862/63

L	1	1 1/2"	300#	RFWN	90°	5 1/2"	—	SA312-TP316/L	—	I	1/4"	—	—	27, 28	TE
K1	1	8"	300#	RFWN	90°	9"	1"	SA312-TP316/L	—	II	3/8"	—	—	11 — 16	HANDHOLE
J	1	1"	300#	RFWN	180°	6"	—	SA312-TP316/L	—	I	3/16"	—	—	3, 4	CONDENSATE BLOWDOWN
H2	1	2"	300#	RFWN	90°	7 3/16"	—	SA312-TP316/L	—	I	3/16"	—	—	5, 8	LT CONNECTION
H1	1	2"	300#	RFWN	90°	5 13/16"	—	SA312-TP316/L	—	I	3/16"	—	—	5, 7	LT CONNECTION
G2	1	2"	300#	RFWN	90°	7 3/16"	—	SA312-TP316/L	—	I	3/16"	—	—	5, 8	BRIDLE/LT
G1	1	2"	300#	RFWN	90°	5 13/16"	—	SA312-TP316/L	—	I	3/16"	—	—	5, 7	BRIDLE/LT
F	1	2"	300#	RFWN	0°	6"	—	SA312-TP316/L	—	I	3/16"	—	—	5, 6	PT
E	1	2"	300#	RFWN	0°	6"	—	SA312-TP316/L	—	I	3/16"	—	—	5, 6	PCV & PSV
D	1	2"	300#	RFWN	180°	6"	—	SA312-TP316/L	—	I	3/16"	—	—	5, 6	REBOILER DRAW (TO 500-E-1001)
C	1	6"	300#	RFWN	0°	6"	—	SA312-TP316/L	—	I	3/8"	—	—	23, 24	STEAM OUTLET
B	1	3"	300#	RFWN	0°	6"	—	SA312-TP316/L	—	I	1/4"	—	—	9, 10	EXCHANGER TWO PHASE INLET #2 (FROM 500-E-1001)
A	1	2"	300#	RFWN	0°	6"	19 7/16"	SA312-TP316/L	—	II	3/16"	—	—	5, 29	TWO PHASE INLET #1 (FROM 600-E-1001)
MK	QTY.	SIZE	RATING	FLG. TYPE	ORIENT.	O.S.	I.S.	NOZZLE NECK	REINF. PAD	TYPE	A	B	C	B.O.M. ITEM No's.	SERVICE/REMARKS

NOZZLE DETAILS



NOTE: ALL NOZZLES TO BE FLUSH WITH SHELL I.D. EXCEPT THOSE CALLED AS SET ON, OR WITH INTERNAL PROJECTION.

TYPE I	TYPE II	LONG/GIRTH SEAMS

0	01/15/2022	RELEASED FOR FABRICATION	I.T.	K.G.	G.C.
REV	DATE	DESCRIPTION	DRN	CKD	APPD.
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CUSTOMER: BAYOTECH					
DRAWING TITLE:					
30" O.D. x 56" SM/SM STEAM DRUM GENERAL ARRANGEMENT					
DRAWN BY:	I. TORRES	DATE:	01/15/22	JOB NO.	HV-2112003
CHECKED BY:	K. GRIFFITH	DATE:		SCALE:	1" = 5"
APPROVED BY:	G. CASCO	DATE:		DRAWING	HV-2112003CA-01
				REVISION	0



TACK NAMEPLATE TO
VESSEL @ 4 CORNERS



Certified By: SEE TABLE

NB #

Houston Vessel Manufacturing LLC



U

RT3

225/15.5	PSIG/BAR @	425/218	°F/°C	
MAXIMUM ALLOWABLE WORKING PRESSURE				
—	PSIG/BAR @	—	°F/°C	
MAXIMUM ALLOWABLE WORKING PRESSURE				
-20/-29	°F/°C @	225/15.5	PSIG/BAR	
MINIMUM DESIGN METAL TEMPERATURE				
EMPTY		1000	LBS	S/N SEE TABLE

TEST

308/21.3

PSIG/BAR

YEAR

2022

STEAM DRUM

TAG # SEE TABLE

NAME PL. TABLE		
NB #	SERIAL #	TAG #
LATER	8388	300-V-1001
LATER	8389	300-V-1001

②② NAMEPLATE
ONE REQUIRED

DESIGN DATA:

CONSTRUCTION SHALL BE IN ACCORDANCE WITH ASME SECTION VIII DIV. 1
CODE STAMP IS REQ'D. NATIONAL BD. REG. IS REQ'D.
DESIGN PRESS. (INTERNAL) 225 P.S.I.G. @ 425 °F
DESIGN PRESS. (EXTERNAL) — P.S.I. @ — °F
M.A.W.P. 225 P.S.I.G. @ 425 °F LIMITED BY DESIGN
HYDROSTATIC TEST 308 P.S.I.G. (NEW) IN HORIZONTAL POSITION
CORROSION ALLOWANCE: SHELL 0" HEADS 0" NOZZLES 0"
RADIOGRAPHY: SHELL(LONG SM) SPOT UW-11(b)/ TYPE 1
SHELL(GIRTH SM) —
HEAD/SHELL SPOT UW-11(b)/ TYPE 1
JOINT EFF.: HEADS 0.85 SHELL(LONG SM) 0.85 SHELL(GIRTH SM) 0.85
OTHER NDE EXAM. —

P.W.H.T. (STRESS RELIEVE) — MINUTES AT — °F CODE CYCLE
WEIGHTS & CAPACITY
EMPTY 1,000 LBS. HYDRO 2,800 LBS. CAPACITY 207 US GAL

NOTES:

1. FLANGE BOLT HOLES SHALL STRADDLE NORMAL VESSEL CENTERLINES UNLESS NOTED.
2. WELDS SHALL BE NEAT IN APPEARANCE, FREE OF SLAG, UNDERCUTS, AND OTHER DEFECTS.
3. NOZZLE AND TAIL DIMENSION TOLERANCES SHALL BE $\pm 1/8$ INCH UNLESS OTHERWISE NOTED.
4. VESSEL SHALL BE CLEANED OF SCALE, OIL, WELD SPATTER, AND ALL OTHER FOREIGN MATTER BEFORE HYDROSTATIC TESTING.
5. COAT ALL NOZZLE GASKET SURFACES WITH PROTECTIVE LUBRICANT BEFORE BLANKING FOR SHIPMENT.
6. PROTECT ALL MACHINED SURFACES AND THREADED CONNECTIONS WITH WOOD OR PLASTIC PROTECTORS BEFORE SHIPMENT.
7. EXPOSED INSIDE EDGES SHALL BE CHAMFERED OR ROUNDED.
8. ALL BUTT WELDS ARE TO BE FULL PENETRATION WELDS.
9. FLANGE SHALL BE PARALLEL WITHIN 0.5° IN ANY PLANE.
10. IF RE-ENFORCING PADS ARE TO BE SEGMENTED THEN THE FOLLOWING RULES MUST BE FOLLOWED.
EACH BUTT WELD IS RADIOGRAPHED OR ULTRASONICALLY EXAMINED TO CONFIRM FULL PENETRATION, OR FOR OPENINGS IN CYLINDERS, THE WELD IS ORIENTED AT LEAST 45° FROM THE LONGITUDINAL AXIS OF THE CYLINDER. EACH SEGMENT TO HAVE ONE $1/4"$ NPT TELL TALE HOLE.
11. SPREADER BAR SHALL BE USED FOR VESSEL LIFTS.

COATINGS:

INTERIOR:
SURFACE N/A
COATING: N/A
COLOR: N/A

EXTERIOR:
SURFACE PREP: SUGAR BLAST
FIRST COAT: N/A
FINISH COAT: N/A
COLOR: N/A

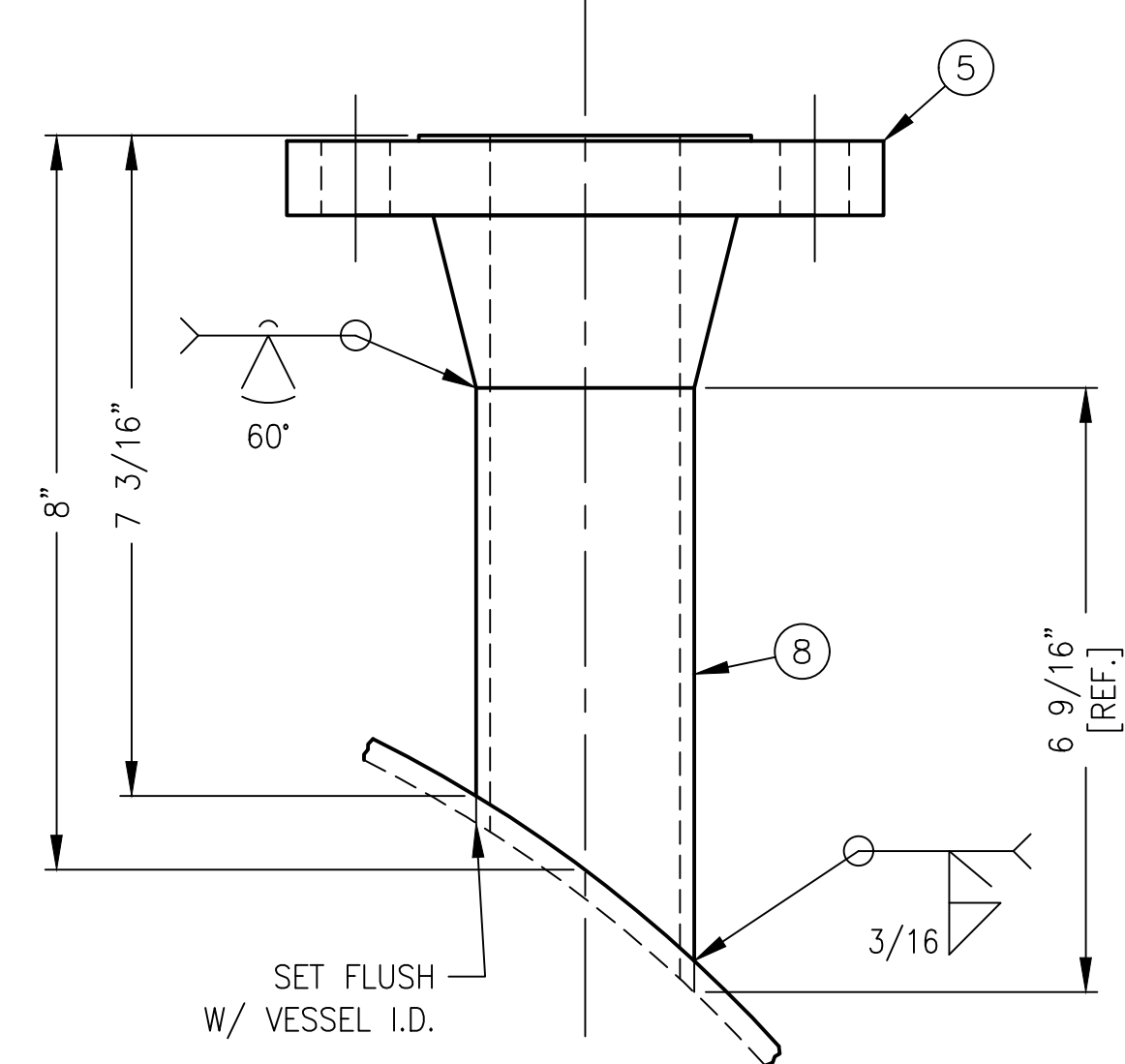
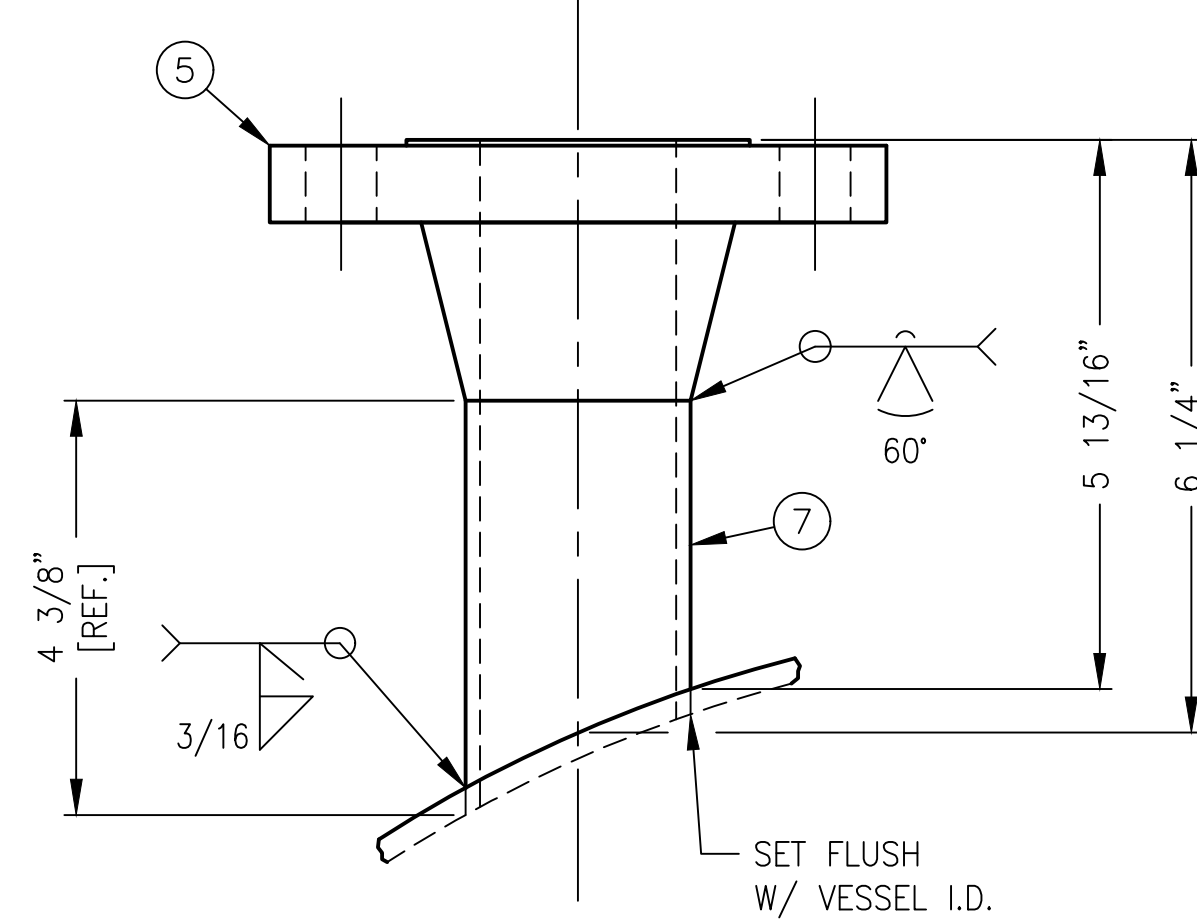
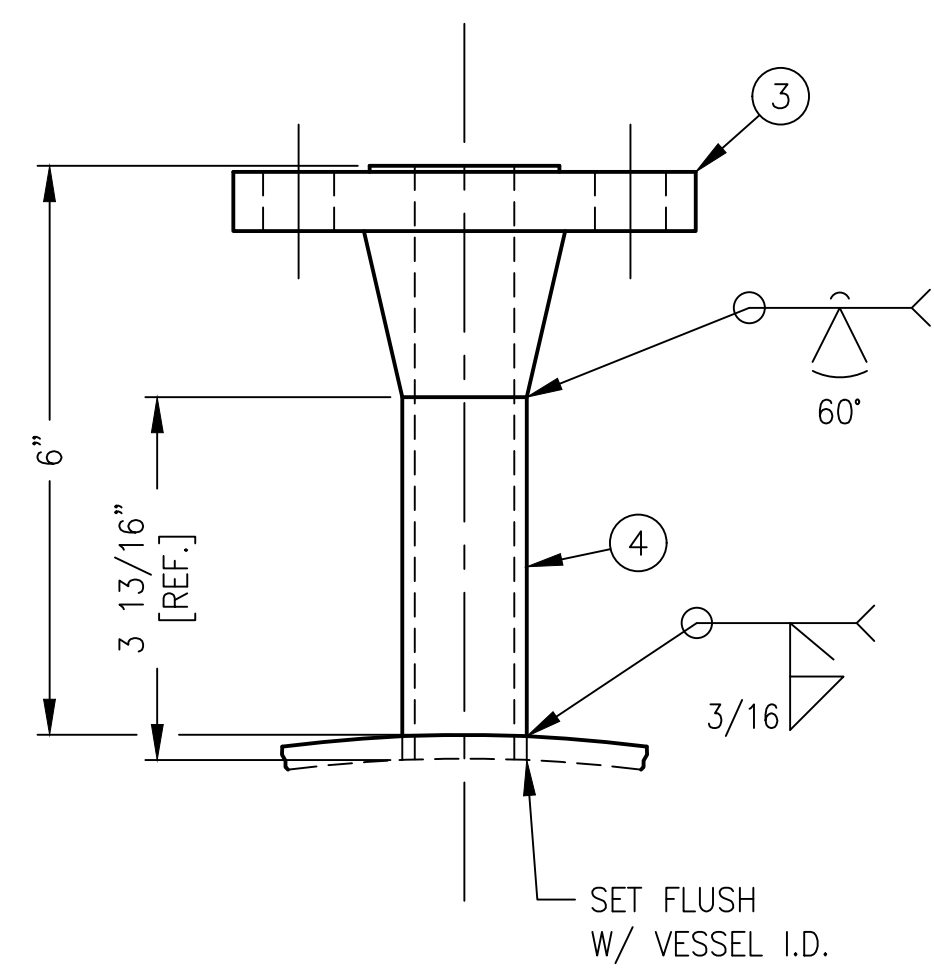
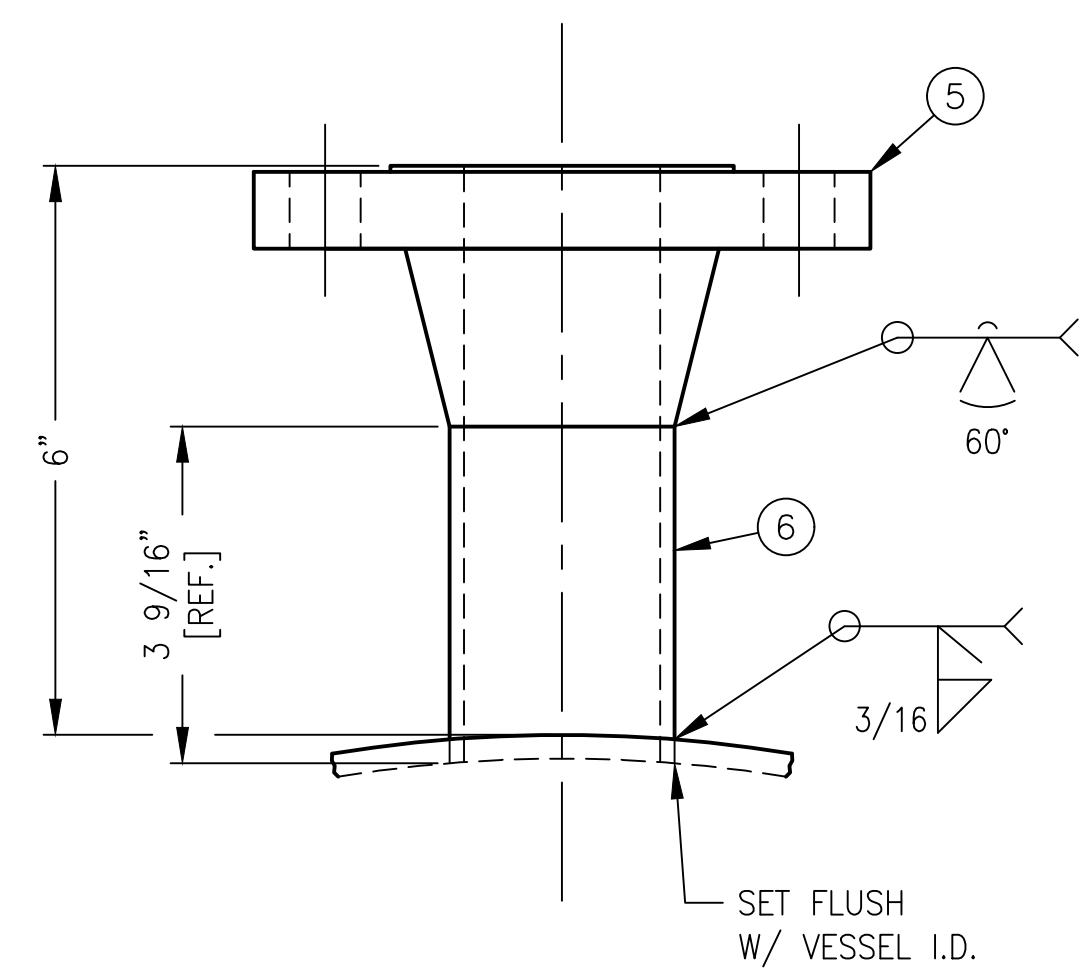
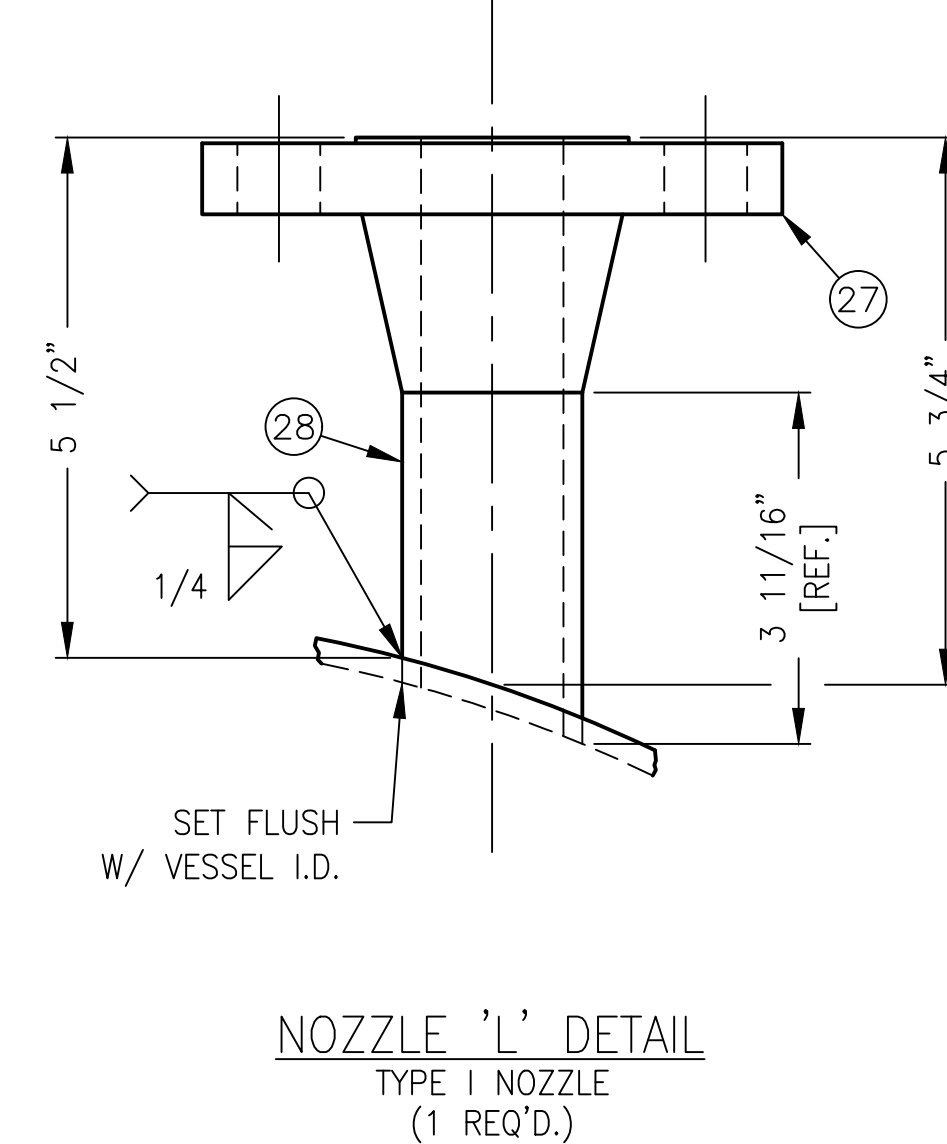
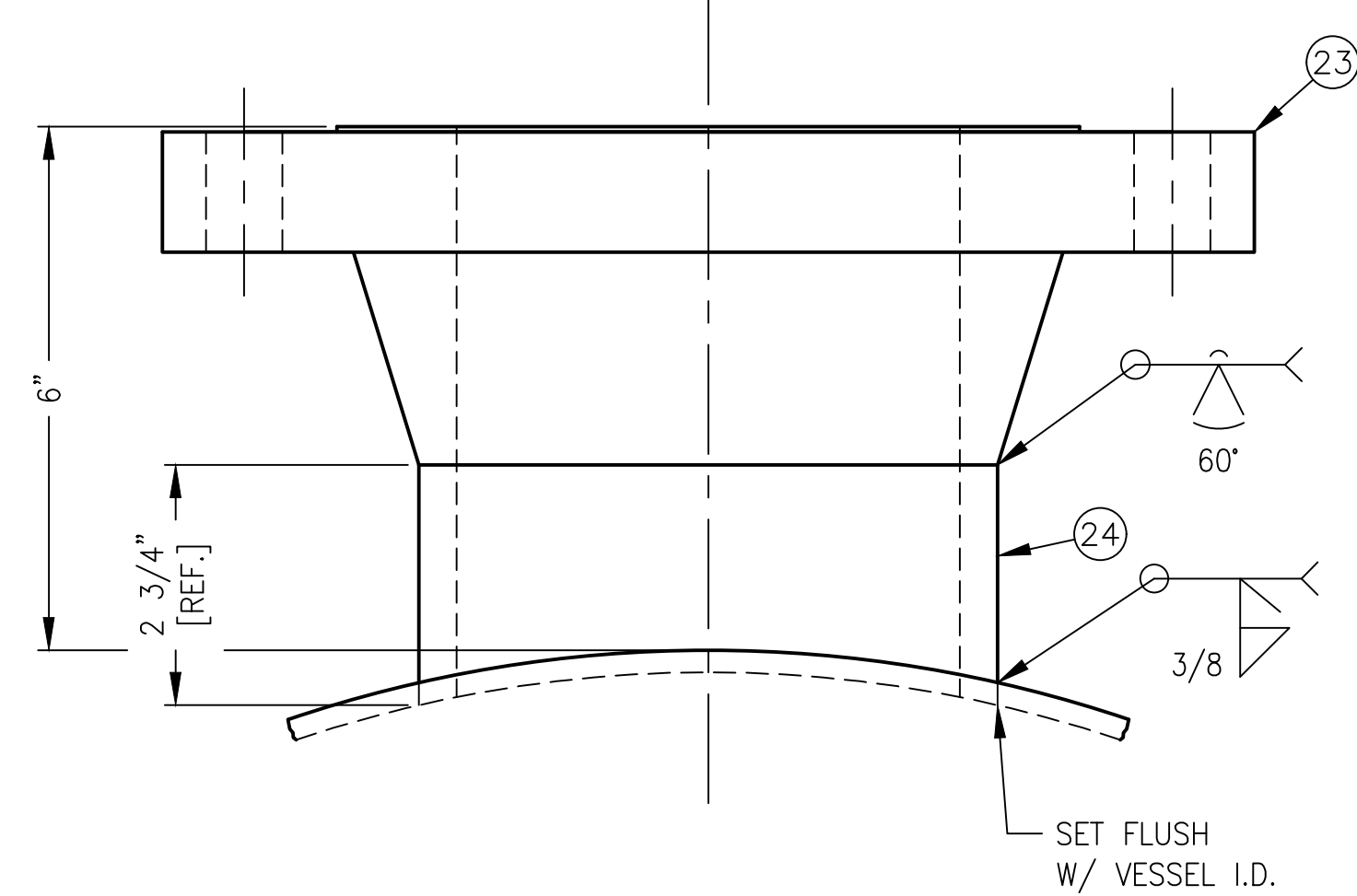
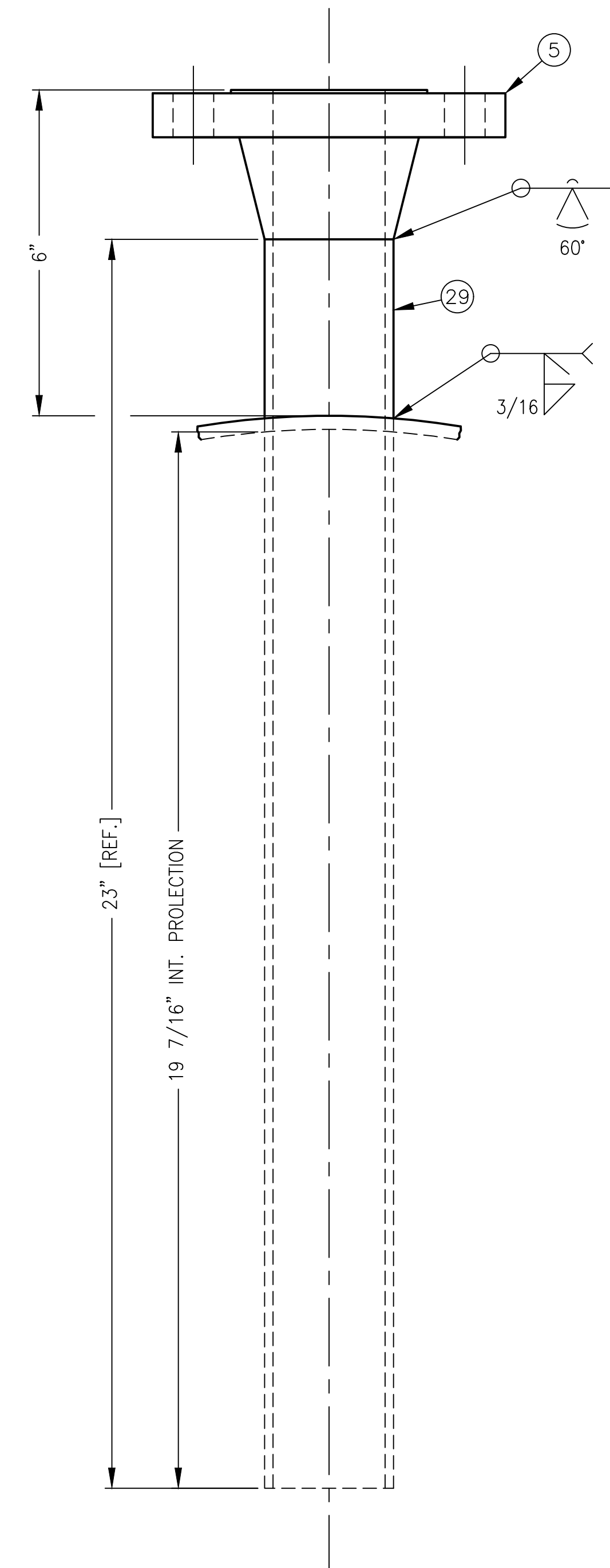
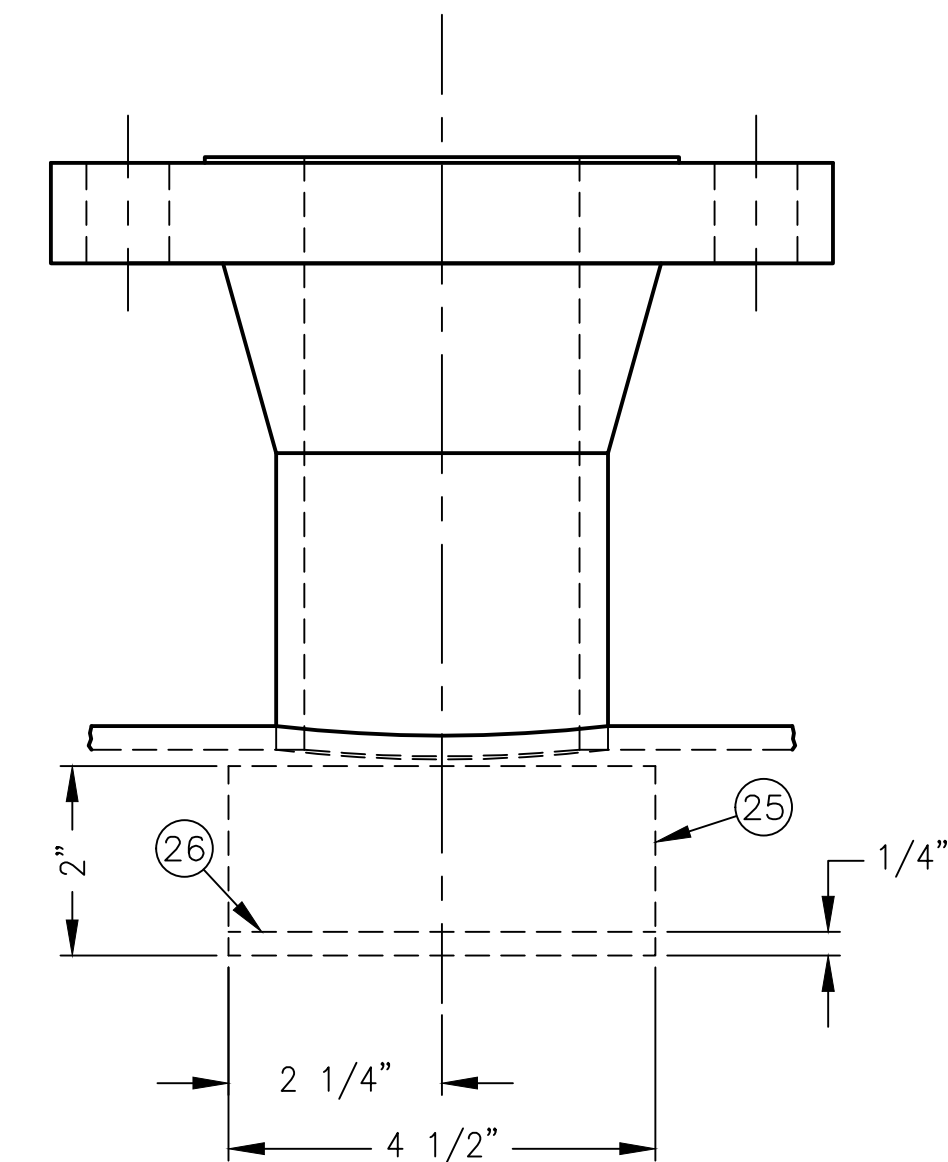
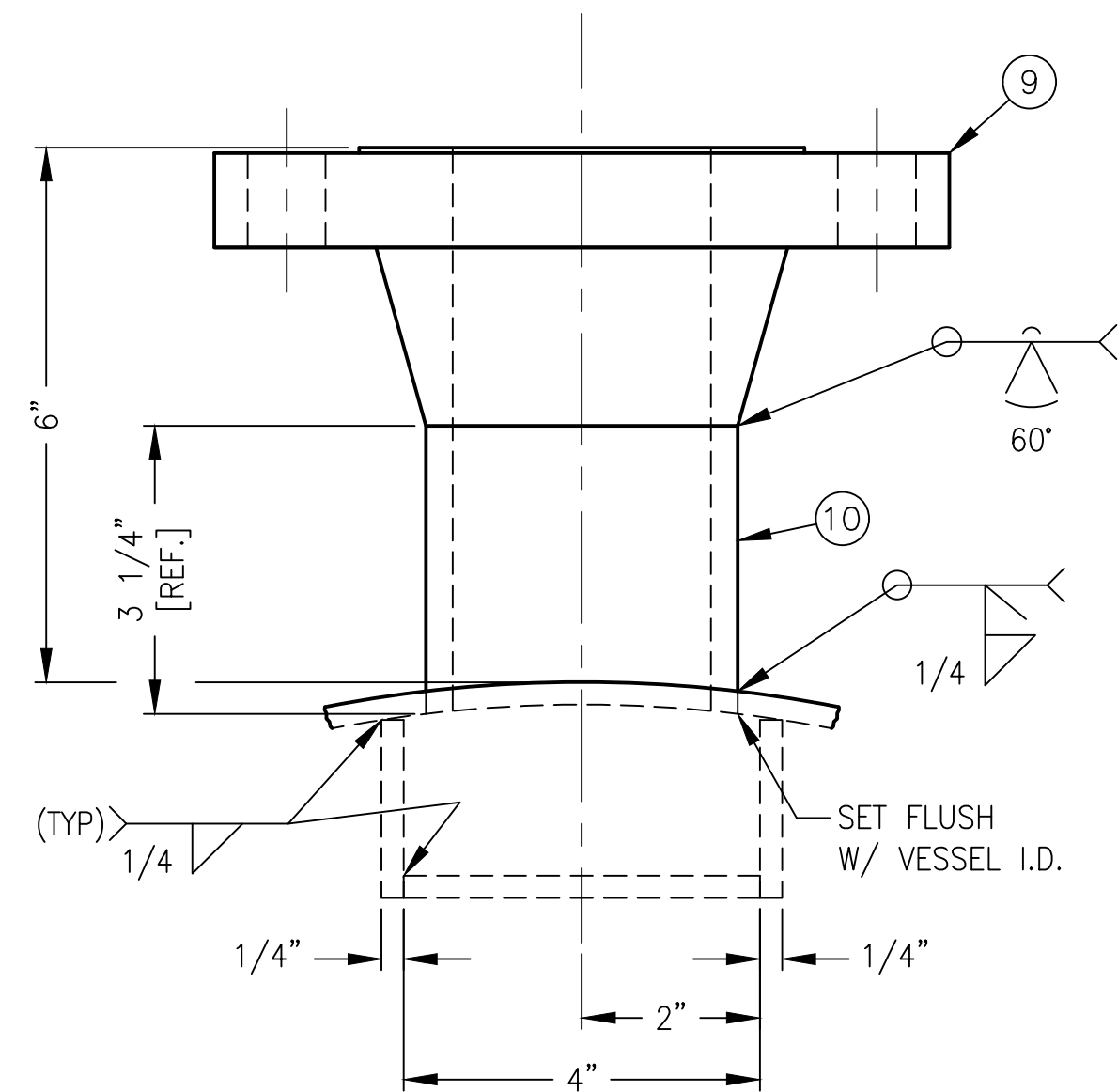
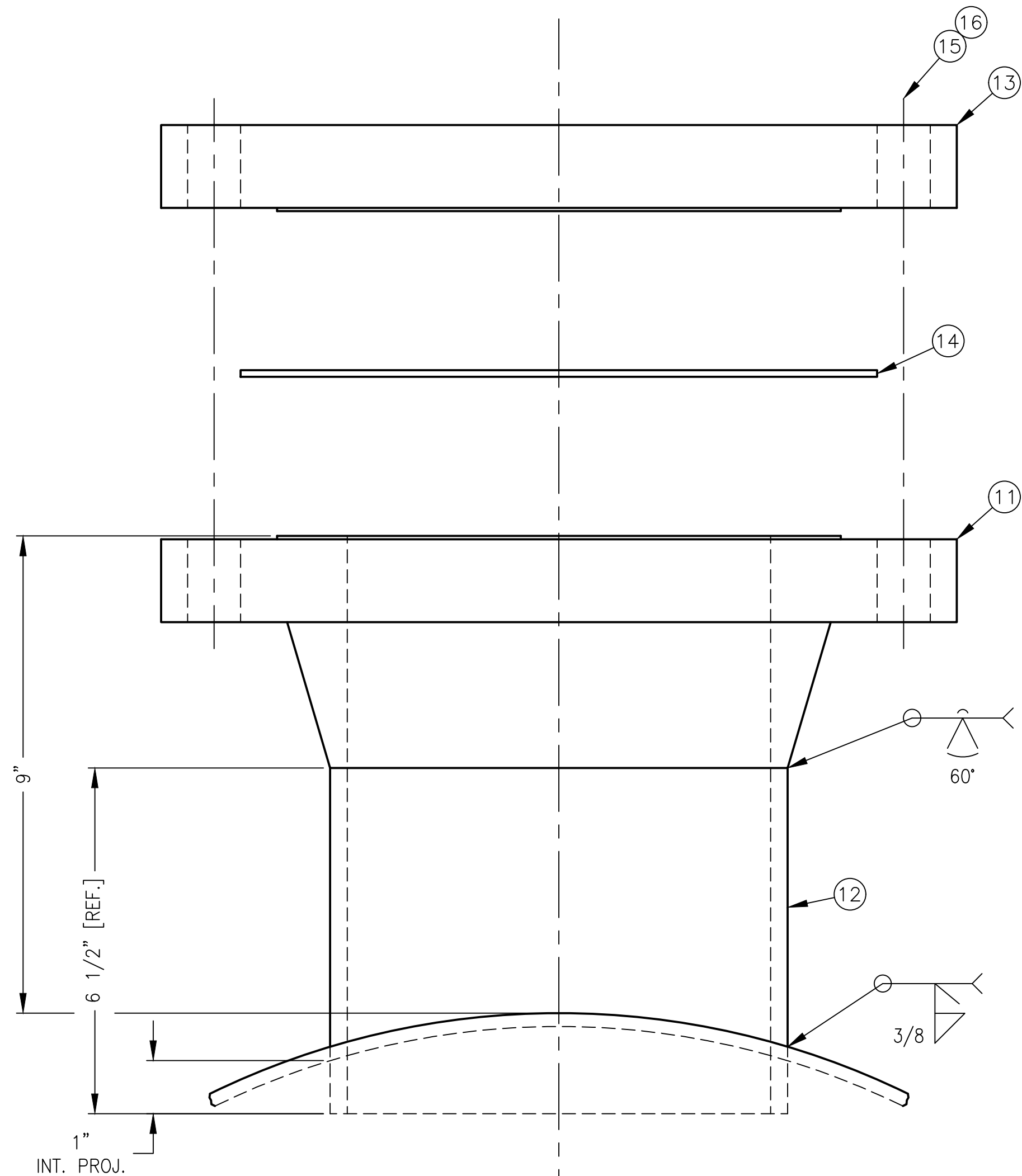
INSULATION: N/A

BILL OF MATERIAL PER VESSEL / (2) REQ'D						
ITEM	HVM P/N	QTY.	DESCRIPTION	DIMENSIONS	MATERIAL	REMARKS
1	CYL-30-0-D-56-SBAD	1	CYLINDER,30"ODX1/4"THKX56"LONG	56" SM/SM	SA240-316/L	SHELL; BBE, 1/16" LANDS
2	HE-30-0-D-SBAD	2	HEAD,ELLIP,30"ODX1/4"NOM	-	SA240-316/L	0.2064" MIN. W/ 2" S.F. (9 5/8" OAH)
3	FWN-1-03-S40-SDAD	1	FLANGE,RFWN,1",300#,S40	-	SA182-F316/L	1.049" BORE
4	PIP-1-S40-W-SFAD	1	PIPE,1",S40	3 13/16" LG.	SA312-TP316/L WLD	0.133" WALL, BOE
5	FWN-2-03-S40-SDAD	8	FLANGE,RFWN,2",300#,S40	-	SA182-F316/L	2.067" BORE
6	PIP-2-S40-W-SFAD	3	PIPE,2",S40	3 9/16" LG.	SA312-TP316/L WLD	0.154" WALL, BOE
7	PIP-2-S40-W-SFAD	2	PIPE,2",S40	4 3/8" LG.	SA312-TP316/L WLD	0.154" WALL, BOE
8	PIP-2-S40-W-SFAD	2	PIPE,2",S40	6 9/16" LG.	SA312-TP316/L WLD	0.154" WALL, BOE
9	FWN-3-03-S80-SDAD	1	FLANGE,RFWN,3",300#,S80	-	SA182-F316/L	2.900" BORE
10	PIP-3-S80-W-SFAD	1	PIPE,3",S80	3 1/4" LG.	SA312-TP316/L WLD	0.300" WALL, BOE
11	FWN-8-03-S40-SDAD	1	FLANGE,RFWN,8",300#,S40	-	SA182-F316/L	7.981" BORE
12	PIP-8-S40-W-SFAD	1	PIPE,8",S40	6 1/2" LG.	SA312-TP316/L WLD	0.322" WALL, BOE
13	FB-8-03-SDAD	1	FLANGE,RFB,8",300#	-	SA182-F316/L	-
14	GSKT-SW-8-03-B-CG-316	1	GASKET,SPIRAL WOUND,8",300#,1/8"THK,CG	-	316SS/GRAPHITE	-
15	STU-N-UNC-5L-HSH	12	STUD,7/8",UNC,5-3/4"LONG	-	SA193-B8M	-
16	NUT-HX-HVY-N-UNC-HSI	24	NUT,HEX,HVY,7/8",UNC	-	SA194-8M	-
17	PLT-D-SBAD	2	PLATE,1/4"THK	25 1/4" X 26" LG.	SA240-316/L	WEB PLATE
18	PLT-D-SBAD	4	PLATE,1/4"THK	3 3/4" X 25 1/4" LG.	SA240-316/L	RIB PLATE
19	PLT-D-SBAD	1	PLATE,1/4"THK	6" X 27 1/2" LG.	SA240-316/L	FIXED BASE PLATE
20	PLT-D-SBAD	1	PLATE,1/4"THK	6" X 27 1/2" LG.	SA240-316/L	SLIDING BASE PLATE
21	PLT-D-SBAD	1	PLATE,1/4"THK	2 1/2" X 3" LG.	SA240-316/L	GROUNDING LUG
22	V4-2000006	1	NAMEPLATE,ASME	-	316SS	-
23	FWN-6-03-S80-SDAD	1	FLANGE,RFWN,6",300#,S80	-	SA182-F316/L	5.761" BORE
24	PIP-6-S80-W-SFAD	1	PIPE,6",S80	2 3/4" LG.	SA312-TP316/L WLD	0.432" WALL, BOE
25	PLT-D-SBAD	2	PLATE,1/4"THK	2" X 4 1/2" LG.	SA240-316/L	INTERNAL PLATE
26	PLT-D-SBAD	1	PLATE,1/4"THK	4" X 4 1/2" LG.	SA240-316/L	INTERNAL PLATE
27	FWN-1H-03-S80-SDAD	1	FLANGE,RFWN,1-1/2",300#,S80	-	SA182-F316/L	1.500" BORE
28	PIP-1H-S80-W-SFAD	1	PIPE,2",S80	3 11/16" LG.	SA312-TP316/L WLD	0.200" WALL, BOE
29	PIP-1-S40-W-SFAD	1	PIPE,1",S40	23" LG.	SA312-TP316/L WLD	0.133" WALL, BOE

SHEET 2 OF 4

P.O. NO.: P0110862/63

[illegible]

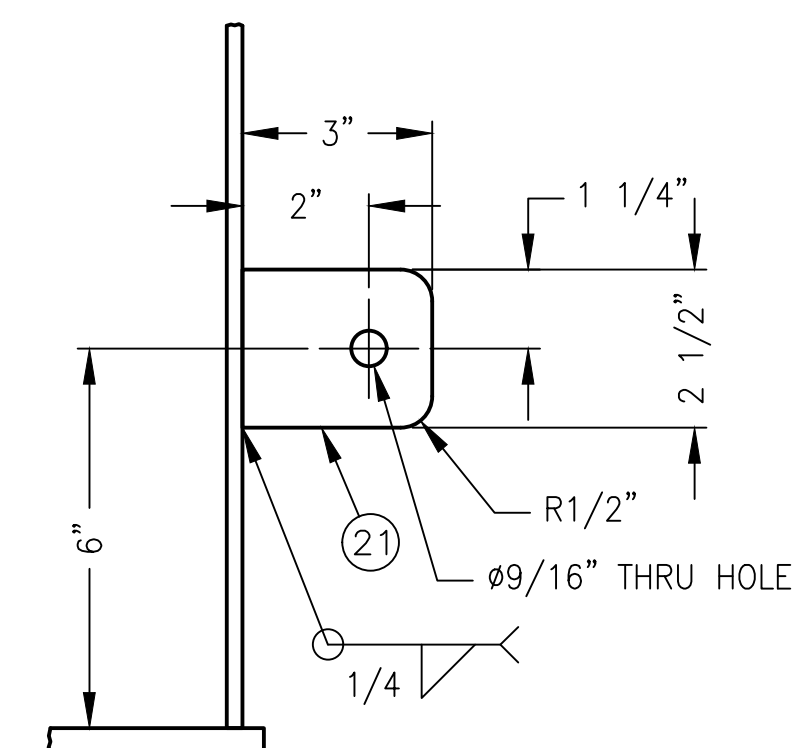
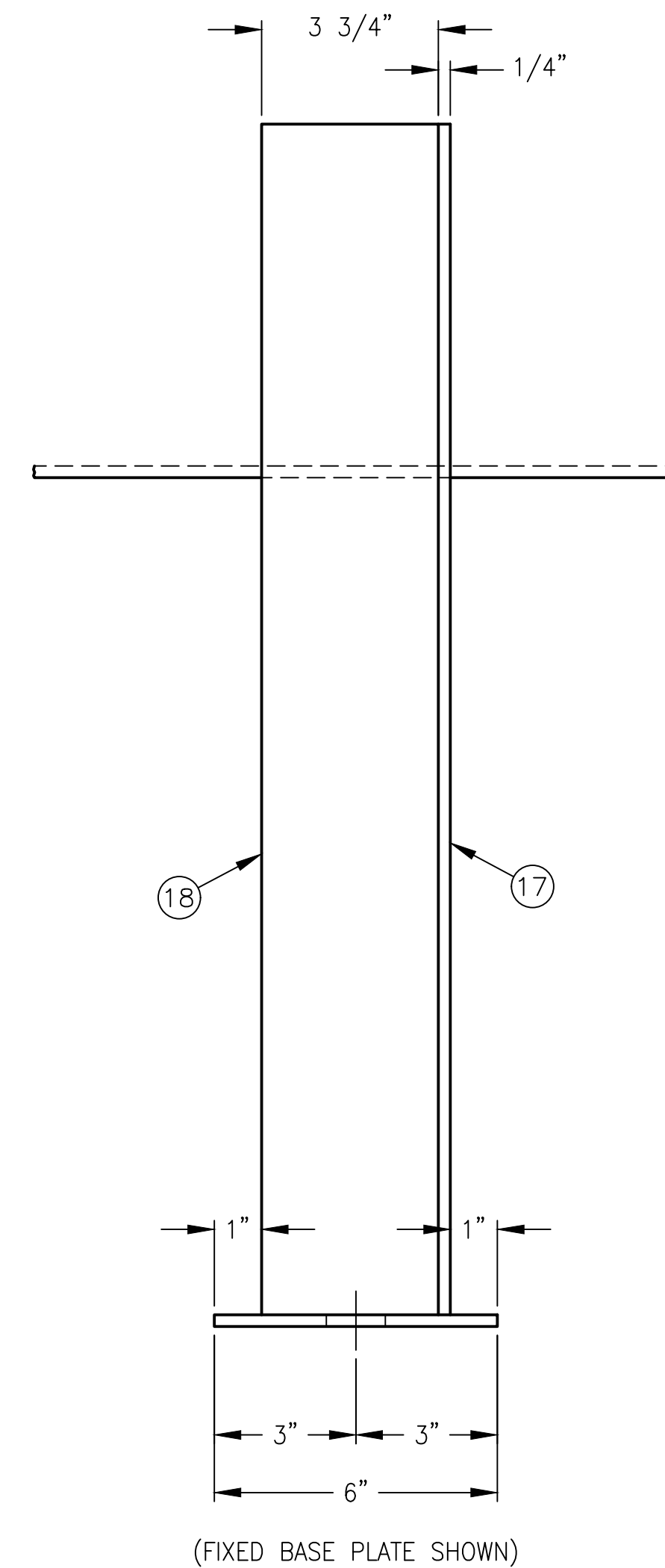
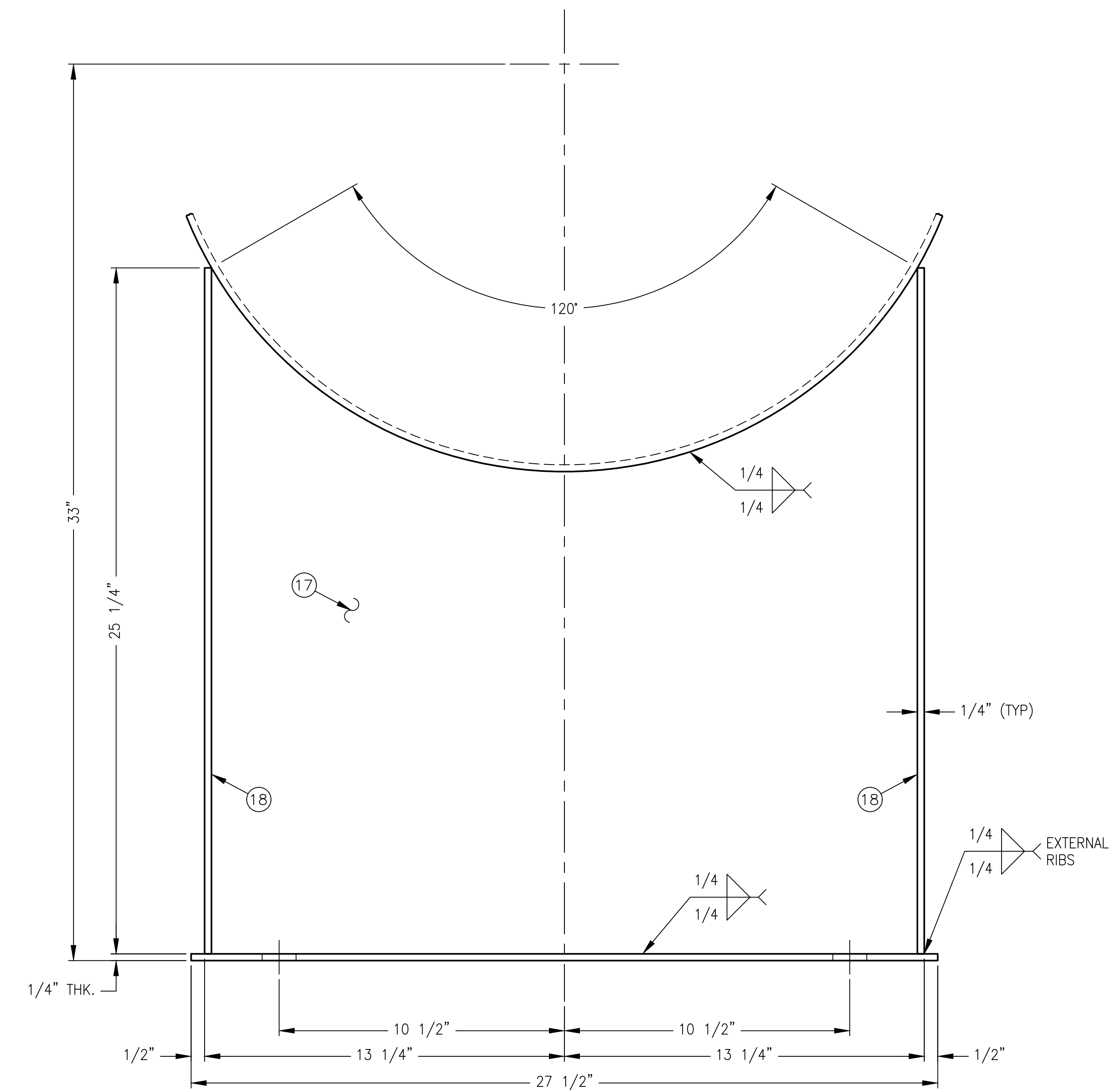


NOZZLE 'A' DETAIL
TYPE II NOZZLE
(1 REQ'D.)

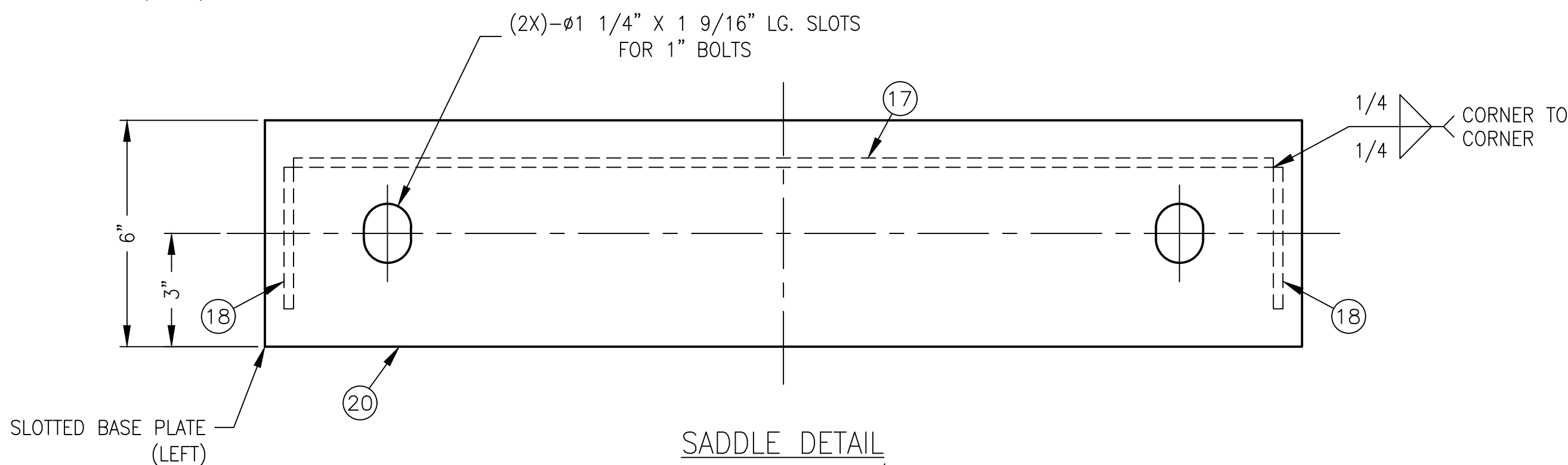
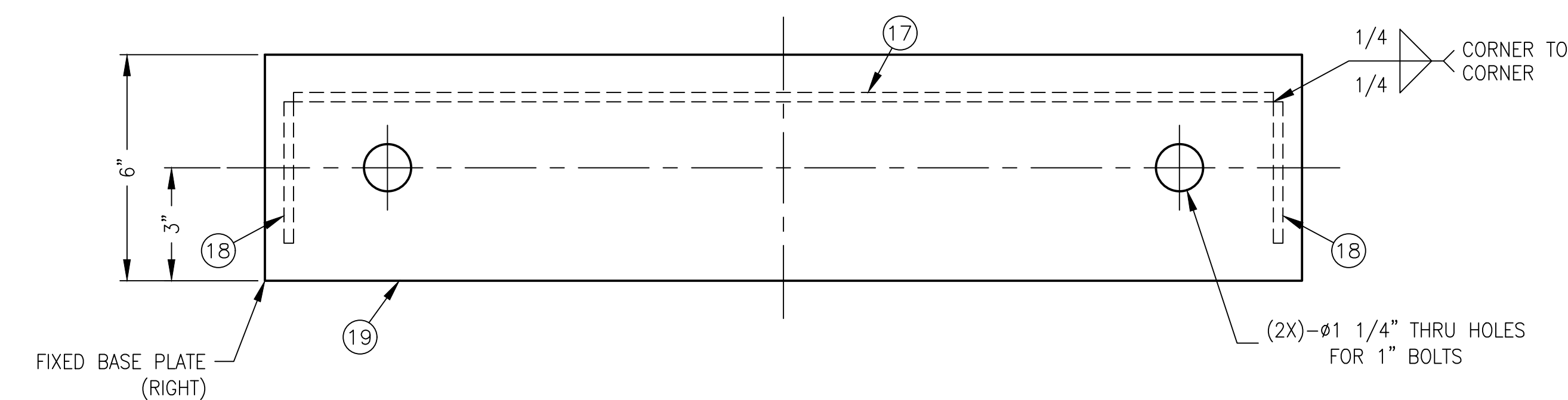
SHEET 3 OF 4
P.O. NO.: P0110862/63

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CUSTOMER: BAYOTECH					
DRAWING TITLE:					
30" O.D. x 56" SM/SM STEAM DRUM NOZZLE DETAILS					
DRAWN BY:	I. TORRES	DATE:	01/15/22	JOB NO.	HV-2112003
CHECKED BY:	K. GRIFFITH	DATE:		SCALE:	1" = 2"
APPROVED BY:	G. CASCO	DATE:		DRAWING	HV-2112003CA-03
					REVISION 0





GROUNDING LUG DETAIL
MATERIAL: 1/4" THK. SA240-316/L
(1 REQ'D.)



SADDLE DETAIL
MATERIAL: SA240-316/L
(2 REQ'D.)

SHEET 4 OF 4
P.O. NO.: P0110862/63

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CUSTOMER: BAYOTECH						
DRAWING TITLE:			 Houston Vessel Manufacturing LLC			
30" O.D. x 56" SM/SM						
STEAM DRUM						
SADDLE & LUG DETAILS						
DRAWN BY:	I. TORRES	DATE:	01/15/22	JOB NO.	HV-2112003	
CHECKED BY:	K. GRIFFITH	DATE:		SCALE:	1" = 3"	
APPROVED BY:	G. CASCO	DATE:		DRAWING	HV-2112003CA-04	
				REVISION	0	