

GENERAL NOTES

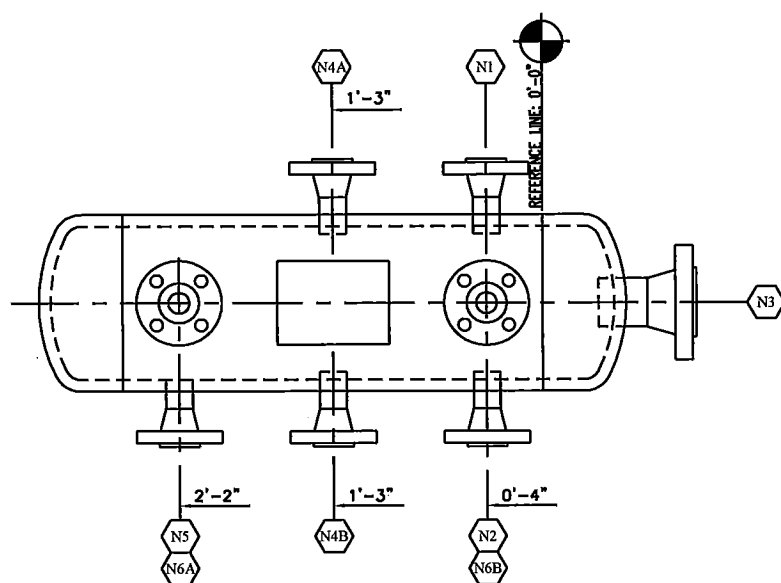
1. QUALITY CONTROL PROGRAM NUMBER: AQP-1317(S)
2. WELDING PROCEDURE REGISTRATION NUMBER: WP1970.2
3. ULTRASONIC TESTING: ALL CAT "D" WELDS PRIOR TO PWHT
4. MPI: INTERNAL CAT "D" FILLETS PRIOR TO PWHT ONLY
& EXTERNAL CAT "D" FILLETS BEFORE AND AFTER PWHT
5. RT: 100% BEFORE AND AFTER PWHT
6. HARDNESS TEST: 210 HV MAX
-5 POINT TRAVERSE ON LONG SEAM, (1) CIRC SEAM &
(1) TEST EACH ON 10% OF NOZZLE CAT "C" & "D" WELDS
7. PWHT: ACCORDING TO UCS-56
HEAT FROM AMBIENT TO 800°F AT A MODERATE RATE
HEAT FROM 800°F TO 1150°F AT 400°F/Hr MAX
SOAK AT 1150°F FOR 60 MIN
COOL TO 800°F AT 500°F/Hr MAX
FROM 800°F AIR COOL IN FURNACE
8. EXTERNAL SANDBLAST: SSPC-SP6 (COMMERCIAL)
9. EXTERNAL FINISH:
PRIME: ONE COAT OF PRIMER
FINISH: ONE COATS OF INDUSTRIAL ENAMEL (GREY)
-PAINT IN VISIBLE AREA 3" HIGH LETTERS "DO NOT WELD ON VESSEL - PWHT"
10. ALL BOLT HOLES TO STRADDLE CENTERLINE
11. ALL OPENINGS TO BE COVERED PRIOR TO SHIPPING
12. ALL OUTSIDE PROJECTIONS MEASURED ALONG CENTERLINE OF NOZZLE
13. FABRICATION TOLERANCE AS PER BWM DWG: TOL2002
14. VESSEL TO BE REGISTERED IN ALBERTA, SASKATCHEWAN, & BRITISH COLUMBIA
15. VESSEL TO BE SUPPLIED WITH U-STAMP
16. VESSEL SERIAL NUMBER: 15235

NOZZLE SCHEDULE

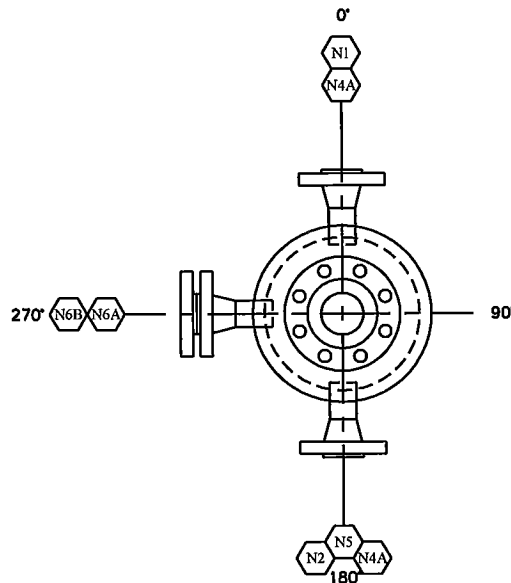
MARK	QTY	DESCRIPTION	NPS	CLASS	TYPE	PROJECTION		WELD	WELD		REPAD	BILL OF MATERIALS ITEM NUMBER
						INSIDE	OUTSIDE		A	B	C	
N1	1	VENT	1 1/2	600	RFWN	1/2"	4"	1,2	5/16	-	-	5,6
N2	1	LIQUID INLET	1 1/2	600	RFWN	1/2"	4"	1,2	5/16	-	-	5,6
N3	1	LC	3	600	RFWN	1"	5"	1,2	3/8	-	-	7,8
N4A/B	2	LG	1 1/2	600	RFWN	1/2"	4"	1,2	5/16	-	-	5,6
N5	1	LIQUID OUTLET	1 1/2	600	RFWN	FLUSH	4"	1,2	5/16	-	-	5,6
N6A/B	2	INSPECTION	1 1/2	600	RFWN	1/2"	4"	1,2	5/16	-	-	5,6,9,10,11,12

BILL OF MATERIALS

ITEM	QTY	REF.	PART No.	DESCRIPTION	MATERIAL	WEIGHT
1	2	HEAD	1-008800	12" x SCH 100 (0.739" MIN) BW PIPE CAP	SA-234-WPB	76#
2	1	SHELL	1-008801	12" PIPE SCH 100 x 2'-6" LG (BBE)	SA-106-B	268#
3	1	NAMEPLATE	2-000219	6" x 8" NAMEPLATE BRACKET	SA-36	2#
4	1	NAMEPLATE	1-001701	6" x 8" ALUMINUM NAMEPLATE	ALUMINUM	-
5	7	N1,2,4,5,6	1-008628	1 1/2" x CLASS 600 RFWN FLG SCH XXH	SA-105-N	45#
6	7	N1,2,4,5,6	1-003355	1 1/2" PIPE SCH XXH x 2 1/2" LG (BOE,ROE)	SA-106-B	10#
7	1	N3	1-000910	3" x CLASS 600 RFWN FLG SCH XXH	SA-105-N	12#
8	1	N3	1-003366	3" PIPE SCH XXH x 3 1/2" LG (BOE,ROE)	SA-106-B	2#
9	2	N6A/B	1-008802	1 1/2" x CLASS 600 RF B16.20 "CG STYLE" GRAPHITE FILLED FLEX GASKET	316SS	-
10	8	N6A/B	1-002643	3/4" DIA x 4 1/4" LG STUDS	SA-193-B7M	-
11	16	N6A/B	1-001872	3/4" DIA NUTS	SA-194-2HM	-
12	2	N6A/B	1-008803	1 1/2" x CLASS 600 RF BLIND FLG	SA-105-N	8#



ELEVATION VIEW



ORIENTATION VIEW

WELD DETAIL NUMBER	REGISTERED WELDING PROCEDURE NUMBER			BACKWELD/GOUGE
	ROOT	HOT PASS	FILL & CAP	
1,2,4	BWM-5 (GMAW)	BWM-14 (SAW)	BWM-14 (SAW)	N/A
3	BWM-5 (GMAW)	BWM-6 (SAW)	BWM-6 (SAW)	N/A

1	WELD NECK FLANGE	2	NOZZLE NECK	3	CIRC SEAM	4	ATTACHMENTS

REV. NO.	DATE	REVISION	BY	APP'D
A	06/25/09	ISSUED FOR APPROVAL	JAH	
B	07/02/09	REVISED AS PER CLIENT MARK-UPS	JAH	
0	07/08/09	ISSUED FOR FABRICATION	JAH	JAM
1	09/23/09	AS BUILT	JAH	

BILTON
Welding & Manufacturing Ltd.

BOX 6106
5815 37 Street
INNISFAIR, AB
CANADA
403-227-7799
1-888-227-4923
FAX 227-7796

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DESIGN SPECIFICATIONS

DESIGN & FABRICATE TO: 2007 ASME BOILER & PRESSURE VESSEL
CODE, SEC VIII, DIV 1
DESIGN PRESSURE & TEMPERATURE: 1440 PSI [9928 kPa] @ 130°F [54°C]
MINIMUM DESIGN METAL TEMP: -20°F [-29°C] @ 1440 PSI [9928 kPa]
IMPACT TESTS: EXEMPT AS PER UG-20(1)(1-5)
RADIOGRAPHY: 100% AS PER UW-11(e)
POST WELD HEAT TREATMENT: YES AS PER UCS-56
HYDROSTATIC TEST PRESSURE: 1440 PSI [9928 kPa] PREHEAT: 50°F [10°C]
CORROSION ALLOWANCE: 1/8" [3.2mm] MAWP: 1440 PSI [9928 kPa] @ 130°F [54°C]
HEAD THK. MIN.: 0.739" [18.7mm] VOLUME: 2.2 F13 [0.062 m3]
WEIGHT EMPTY: 440 LBS [200kg] WEIGHT FULL: 590 LBS [268kg]

HUSKY OIL OPERATIONS

LEVEL CONTROL POT - V-350
12.75" OD x 2'-6" S/S - 1440 PSI MAWP
DATE: 06/02/09
SHEET: 1 OF 1
DRAWN BY: JAH
PURCHASE ORDER: 08146-007
LOCATION: b-49-C/93-P-12
CRN DWG: BWM-275-09 RO
CRN NUMBER: U9463.21
SALE ORDER: 001488
JOB ORDER:
D1035
DRAWING NO.:
C842-1
REV. 1

CERTIFIED
AS BUILT