



MARK	DESCRIPTION	QUANTITY	REMARKS
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GENERAL NOTES	INSTRUCTIONS FOR STRESS RELIEF	MATERIAL SPECIFICATIONS	DESIGN DATA	REG. DESIGN NO.
<p>1. ALL EXTENDED DIMENSIONS FROM 2. ALL FLANGE LATE HOLES TO STRADOLE CENTRE LINES. 3. ALL MACHINED SURFACES TO BE GRADED WITH HEAVY GRADE. 4. TEST HOLES SHALL BE TAP 1/4" NPT. LOCATED 90° TO THE LONG TORSION AXIS. FILL WITH GRADE AFTER TEST. 5. SCREWED OR BORED TO BE RUGGED. 6. VESSEL TO BE CLEAN INSIDE.</p>	<p>PART SEEL SHALL BE STRESS RELIEVED IN FURNACE AT TEMPERATURE 800 F. MAXIMUM WHEN LOADING. COOLING RATE SHOULD NOT EXCEED 22° F. PER HOUR. STRESS RELIEVING TIME SHALL BE 2.5 H. HOLD FOR 2.5 HOURS. COOLING RATE MUST NOT EXCEED 100° F. PER HOUR. BELOW 400° F. PART MAY BE COOLED IN STILL AIR. LOCAL STRESSING AS ALLOWED. ONLY IN CASE OF SPECIAL ORDER. ADDITIONAL INSTRUCTIONS.</p>	<p>ASTM A-102-B 1/2" CARBON STEEL 30,000 TENSILE 105,000 YIELD ASTM A-105 5/8" CARBON STEEL 30,000 TENSILE 105,000 YIELD ASTM A-106-B 1 1/2" CARBON STEEL 30,000 TENSILE 105,000 YIELD ASTM A-107 2" CARBON STEEL 30,000 TENSILE 105,000 YIELD ASTM A-108 2 1/2" CARBON STEEL 30,000 TENSILE 105,000 YIELD ASTM A-109 3" CARBON STEEL 30,000 TENSILE 105,000 YIELD ASTM A-109-1 4" CARBON STEEL 30,000 TENSILE 105,000 YIELD ASTM A-109-2 6" CARBON STEEL 30,000 TENSILE 105,000 YIELD ASTM A-109-3 8" CARBON STEEL 30,000 TENSILE 105,000 YIELD ASTM A-109-4 10" CARBON STEEL 30,000 TENSILE 105,000 YIELD</p>	<p>FABRICATE IN ACCORDANCE WITH ASME CODE FOR PRESSURE-RETAINING EQUIPMENT DIVISION I SECTION VIII DIVISION 1 UNDESIGNED OR UNSTANDARD COMPONENTS. DESIGN PRESSURE: 150 PSI WORKING PRESSURE: 100 PSI DESIGN TEMPERATURE: 500 F WORKING TEMPERATURE: 400 F DESIGN SPEED: 1000 RPM DESIGN VIBRATION: AS PER SPECIFICATION DESIGN SEISMIC: AS PER SPECIFICATION CORROSION ALLOWANCE: 0.03125 IN CONSTRUCTION ALLOWANCE: 0.03125 IN THICKNESS OF HEAD: 0.5 IN STRESS RELIEF: AS PER SPECIFICATION</p>	<p>6700-1507</p>

CRN: A-5154

VICTORIA MACHINERY DEPOT CO. LTD.
 VICTORIA, B.C. CANADA
 PROPRIETOR: SIMPLOT CHEMICAL CO. LTD. (Simpson, Manitoba)
 PURCHASER: CHEMICAL CONSTRUCTION CORP.
64" I.D. AMMONIA CONVERTER 6700-1507
 ENGINE: 2" DIA. 1500 RPM 10 HP
 100715 AMMONIA CONVERTER 393 5616
 6700 NO. 1 AMMONIA PLANT