

Alternate Form - Single Chamber Completely Shop-Fabricated Vessels Only

#95530

1. Manufactured by Wyatt Industries, Inc. Dallas, Texas  
(Name and address of Manufacturer)

2. Manufactured for Celanese Chemical Company  
(Name and address of Purchaser)

3. Type Vert. Vessel No. (60-D-2476) ((Mfr. Serial)) ((State & State No.)) Natl. Bd. No. \_\_\_\_\_ Yr. Built 1960

4. SHELL: Matl. A-240 T-304 Mod. s. 75000 Nom. Thk. 3/16 Corrn. Allow. 1/16 In. Diam. 1 Ft. 8 In. Lgth. 20 Ft. 0 In.

5. SEAMS: Long Dbl. Butt s.R. No X.R. Spot Sectioned No Efficiency 85 %  
(Welded, Dbl., Single, Lap, Butt) (Yes or No) (Spot or Complete) (Yes or No)  
 Girth Dbl. Butts s.R. No X.R. Spot Sectioned No No. of Courses 2

If riveted or brazed describe seams fully under remarks.

6. HEADS: (a) Material A-240 T-304 Mod. s. 75000 (b) Material \_\_\_\_\_ T.S. \_\_\_\_\_

Location (Top, bottom, ends)	Thickness	Crown Radius	Knuckle Radius	Elliptical Ratio	Conical Apex angle	Hemispherical Radius	Flat Diameter	Side to Pressure (Convex or Concave)
(a) <u>Bottom</u>	<u>3/16</u>	<u>Min. 16"</u>	<u>1.2</u>					<u>Convex</u>
(b) _____								

If removable, bolts used \_\_\_\_\_ Other fastening \_\_\_\_\_  
(Material, Spec. No., T.S., Size, Number) (Describe or Attach Sketch)

7. Constructed for (Int.) pressure of 124 psi. Max. Temp. 400 °F. Subzero -20 °F. Hydrostatic Test 338 psi.

8. SAFETY OR RELIEF VALVE OUTLETS: Number \_\_\_\_\_ Size \_\_\_\_\_ Location \_\_\_\_\_

9. NOZZLES: See attached "Schedule of Openings"

Purpose (Inlet, Outlet, Drain)	Number	Diam. or Size	Type	Material	Thickness	Reinforcement Material	How Attached

10. INSPECTION MANHOLES, No. \_\_\_\_\_ Size \_\_\_\_\_ Location \_\_\_\_\_  
 OPENINGS Handholes, No. \_\_\_\_\_ Size \_\_\_\_\_ Location \_\_\_\_\_  
 Threaded, No. \_\_\_\_\_ Size \_\_\_\_\_ Location \_\_\_\_\_

11. SUPPORTS: Skirt Yes Lugs \_\_\_\_\_ Legs \_\_\_\_\_ Other \_\_\_\_\_ Attached Welded to Btm. Hd.  
(Yes or No) (Number) (Number) (Describe) (Where & How)

12. REMARKS: 1.8" OD x 20.0" Seam to Flange Face Higher Acrylate Unit Tower  
 Item No. T-72 Dwg. # E-11523

(Brief description of purpose of the vessel, as Air Tank, Water Tank, L.P.O., etc.—State Contents.)

We certify that the statements made in this report are correct and that all details of material, construction, and workmanship of this vessel conform to the ASME Code for Unfired Pressure Vessels.

Date August 9, 1960 Signed Wyatt Industries, Inc. By W. A. ...  
(Manufacturer)

Certificate of Authorization Expires December 31, 1961

**CERTIFICATE OF SHOP INSPECTION**

Inspection Agency's Serial No. 54666

VESSEL MADE BY Wyatt Industries, Inc. at Dallas, Texas

I, the undersigned, holding a Certificate of Competency as an Inspector of Boilers and Unfired Pressure Vessels in THE STATE OF Texas and employed by Hartford Steam Boiler I & I of Conn., inspected internally and externally, the vessel described in this report on \_\_\_\_\_ 19\_\_\_\_, and certify that the statements made in this report are correct and corresponding with mill test reports of materials furnished by the builders, and measurements made of the vessel and that this vessel is constructed in accordance with the ASME Code for Unfired Pressure Vessels.

Date August 9, 1960

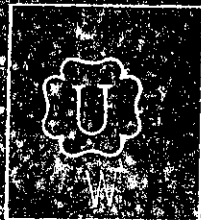
[Signature]  
Inspector's Signature

Commissions Texas Comm. # 248  
State or Natl. Bd. & Number

#95530

MANUFACTURED BY  
**WYATT INDUSTRIES, INC.**  
HOUSTON    CORPUS CHRISTI    DALLAS

*Wyatt's*



S P O T

X . R .

YEAR BUILT

1960

MAX. WORKING  
PRESSURE

124<sup>#</sup> P.S.I.

MAX. TEMP

400° F.

MANUFACTURER  
SERIAL NO

60-D-2476

HSB NO

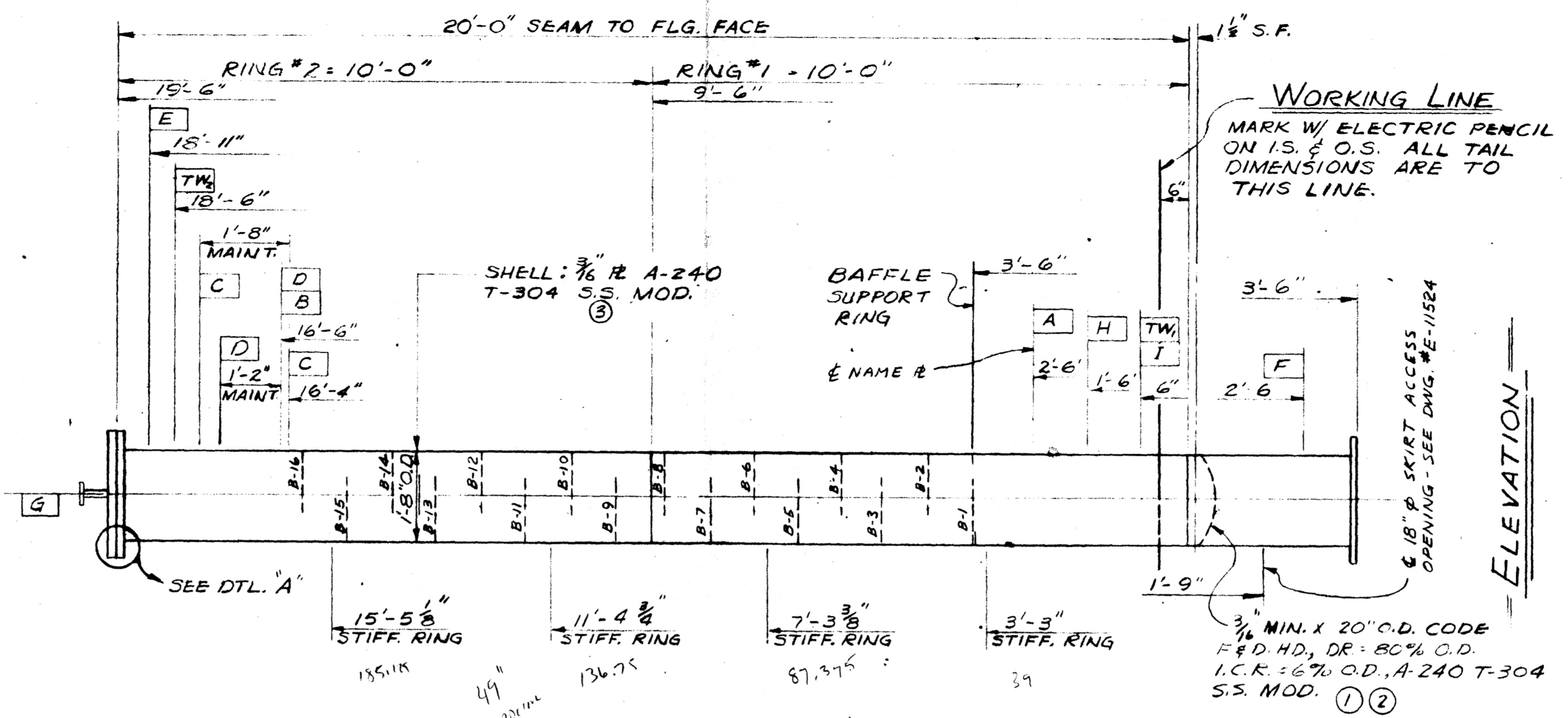
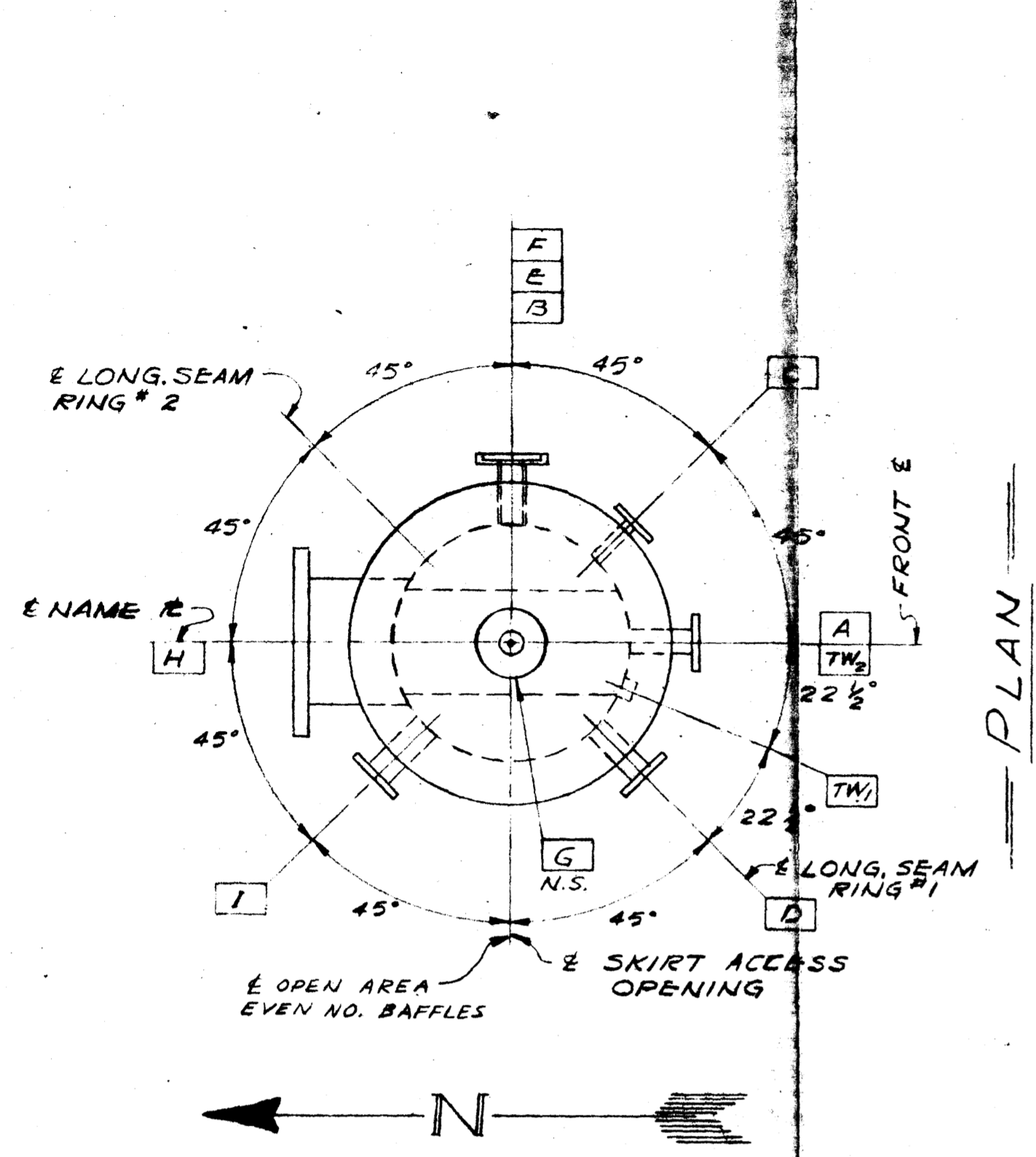
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P.O. # 21-329-0

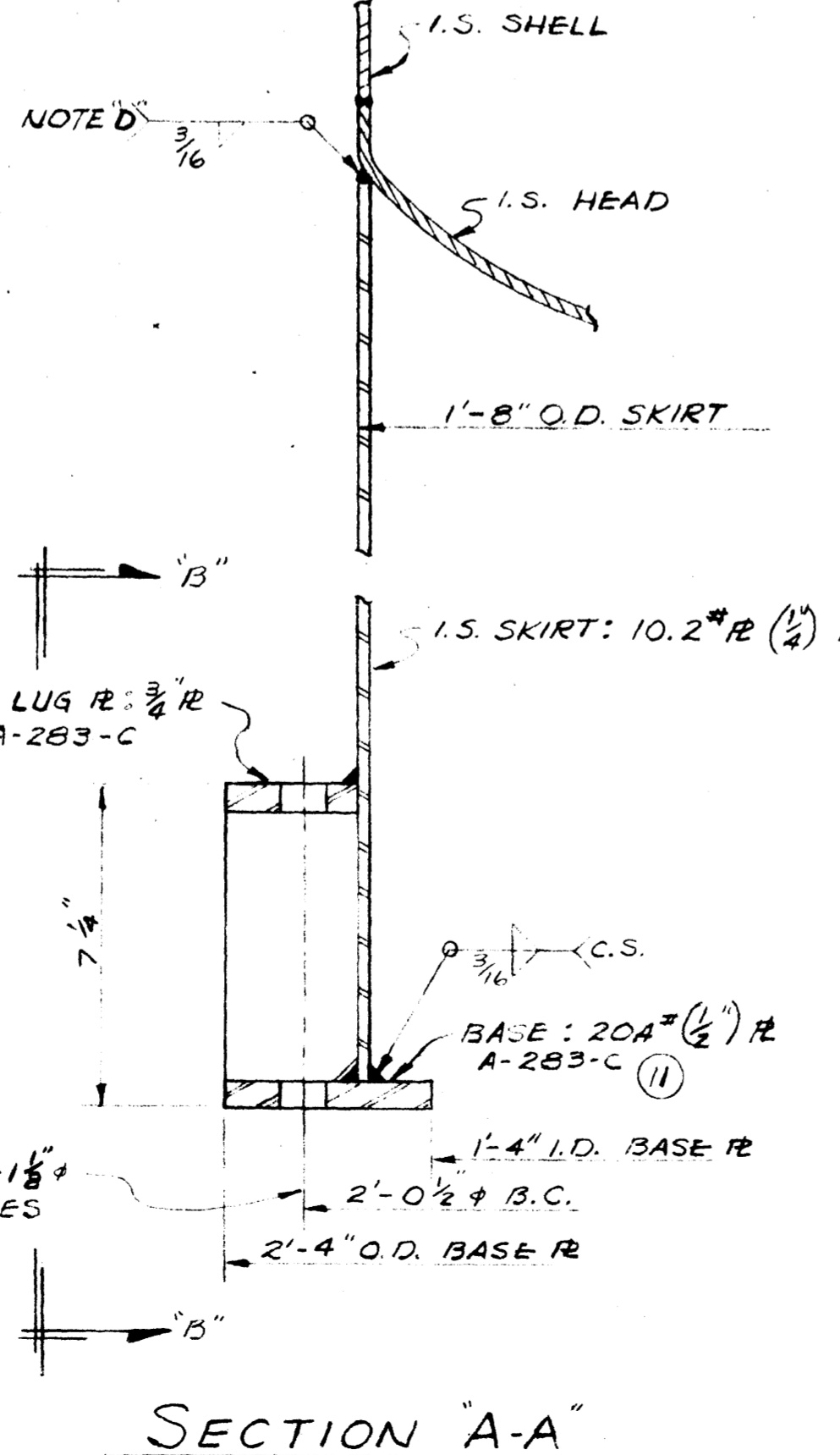
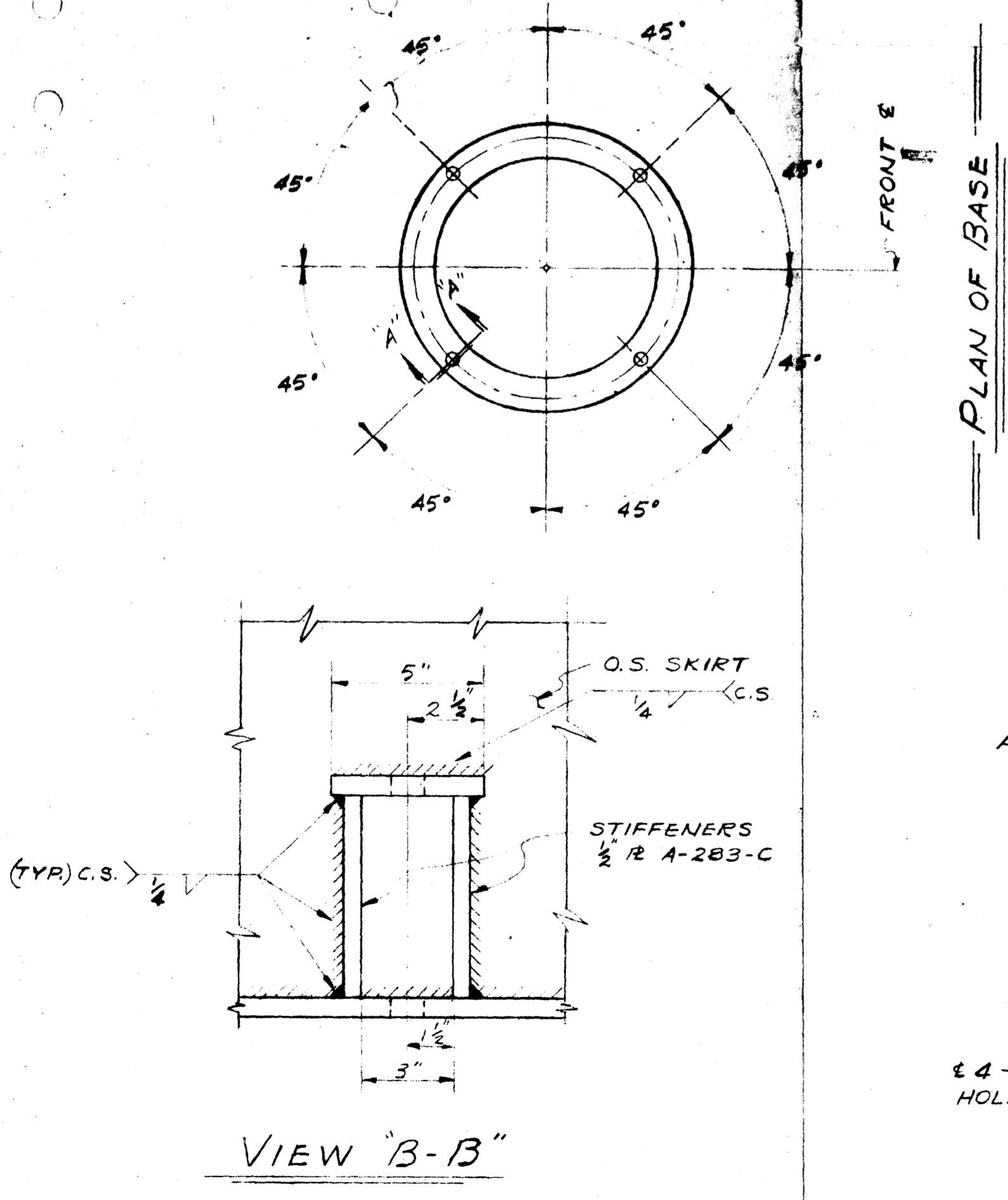
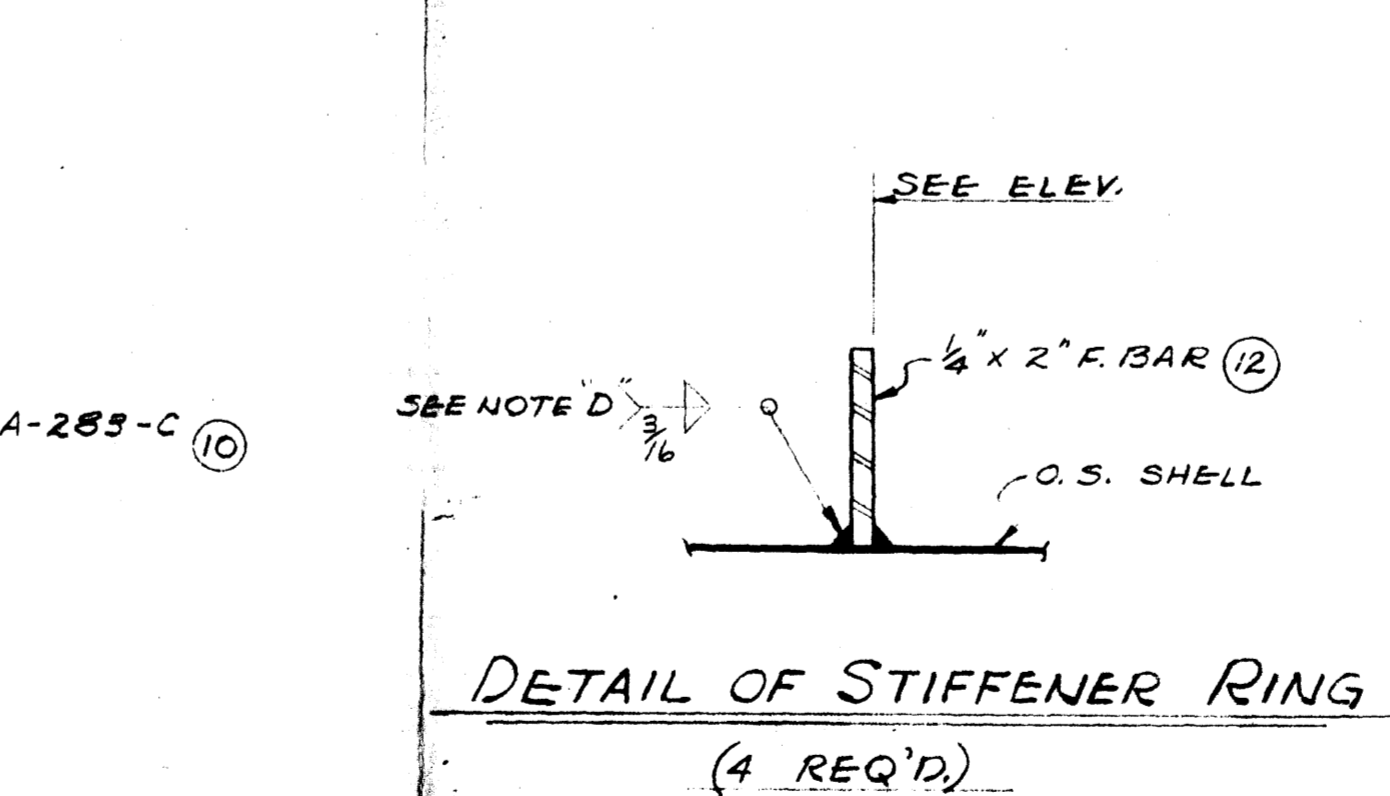
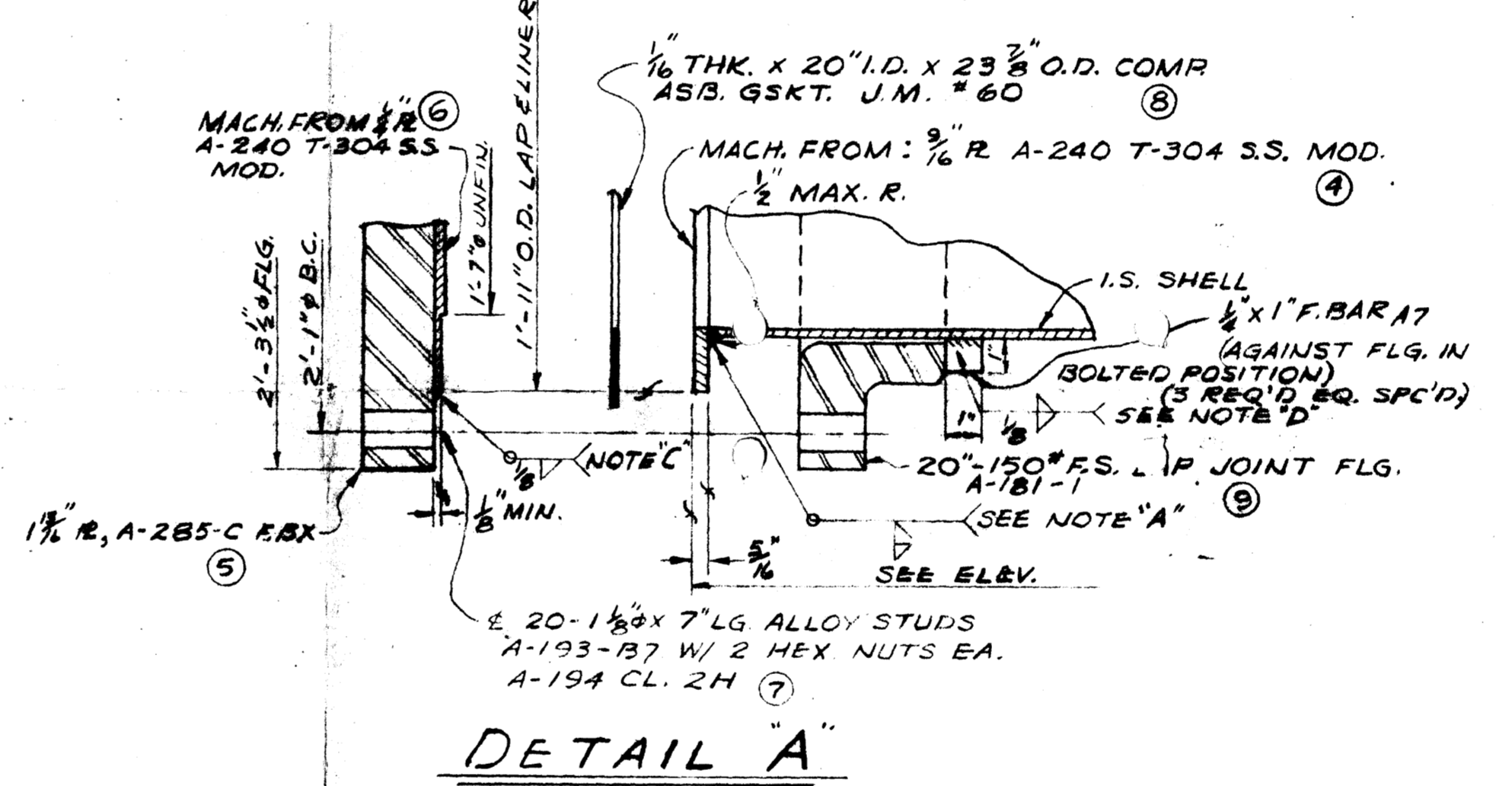
ITEM # T-72

SCHEDULE OF OPENINGS									
MARK	QUAN.	SIZE	FLANGE	TYP. OPERATING MAT'L	NOZZLE	SCH. MAT'L	SERVICE	REMARKS	
A	1	1 1/2"	WNFF 150"	S.S.	160	S.S.	ORG. IN		
B	1	1 1/2"	WNFF 150"	S.S.	160	S.S.	WATER IN		
C	2	3/4"	WNFF 150"	S.S.	160	S.S.	LEVEL		
D	2	1 1/2"	WNFF 150"	S.S.	160	S.S.	L.I.C.		
E	1	1 1/2"	WNFF 150"	S.S.	160	S.S.	ORG. OUT		
F	1	2"	WNFF 150"	S.S.	80	S.S.	WATER OUT		
G	1	2"	WNFF 150"	S.S.	80	S.S.	SAFETY VAL.		
H	1	10"	L.J. 150"	C.S.	3/4"	S.S.	INSPECTION		
I	1	2"	WNFF 150"	S.S.	80	S.S.	STEAM OUT		
TW-1	1	1 1/2"	WELD IN TYPE			S.S.	T.W.		FW 774 ELEV. BY COLANESI
TW-2	1	1 1/2"	WNFF 150"	S.S.	160	S.S.	T.W.		FW 774 ELEV. BY COLANESI

- DESIGN DATA
- ASME Code for Unfired Pressure Vessels, Section VIII, Division 1, Edition 1959
  - Additional specifications: see drawing notes
  - Code Symbol to be Applied per Part III
  - Design Pressure 124 PSIG (plus necessary stiffening rings for full vacuum at 200' of head)
  - Design Temperature 400 °F.
  - Corrosion Allowance 1/8" inches.
  - Type of Heads: TOP-FLANGED (C.S. FLG. & S.S. LAP), BOTTOM-F&L (ASME)
  - Stress Relief Required N/A
  - Radiograph Required SPOT PER CODE
  - Joint Efficiency: Head 100% Shell Longitudinal 85%
  - Maximum allowable Working Pressure (no corrosion allowance) Limited by HEAD 22.5 psig @ 1000' F. Limited by HEAD 185 psig @ 400 °F.
  - Hydrostatic Test Pressure 338 psig
  - Weight Empty 2817 lbs.
  - Weight full of Water 3345 lbs.
  - Design Wind Velocity 100 mph
  - Shipping Weight 2817 lbs.
  - Inspection by Hartford S.B.I. & I. & Customer
  - H.S.B. # 54666 Reg. Serial # 60-D-2476
- MATERIAL SPECIFICATIONS
- Shell ASTM A-240 T-304 S.S. MOD.
  - Head ASTM A-240 T-304 S.S. MOD.
  - Flanges ASTM A-182 F-304 S.S. MOD.
  - Nozzle Necks ASTM A-312 TP-30 MOD
  - Nozzle Reinforcing ASTM A-285-C F. BX. Nuts A-194-2H
  - Stiffeners 1/2" R A-283-C
  - Skirt and Base ASTM A-283-C
  - Stiffener Rings ASTM A-7
  - Gaskets 1/4" THK J.M. #60, UNGR. PHITED
  - Paint C.S. PARTS ONLY ONE 1/2" J.B. #983 RED METAL PRIMER
  - Weld Rod ASTM A-298 CL E-308 or E-310 MO, MANUAL ELECTRODES
- GENERAL NOTES
- All bolt holes shall straddle center lines, BESEL CENTER LINES.
  - Protect all machined surfaces and threaded connections with rust preventive immediately after machining.
  - All nozzle flanges shall be ASIA standard except for manhole flanges.
  - Sandblast all CS surfaces only, before painting.
  - Item No. T-72 P.O. No. 21-829-0
  - To be stamped on Name Plate
  - Tolerances per Colanese Spec. 1924 P 13
  - Name plate to be placed on a 4" bracket that extends 2-1/2" from high point of shell.
- For additional general notes see Dwg. #A-2060 (FABRICATION ONLY)



**SHOP NOTE**  
CLEAN BLIND FLG. BEFORE ATTACHING LINER.



- WELDROD:
- NOTE "A": 3/32" ASTM A-298 CL E-308-15 OR 16 COATED MANUAL ELECTRODES (35)
  - NOTE "B": 1/8" ASTM A-298 CL E-308-15 OR 16 COATED MANUAL ELECTRODES (36)
  - NOTE "C": 1/8" ASTM A-298 CL E-310 MO-15 OR 16 COATED MANUAL ELECTRODES (37)
  - NOTE "D": 3/32" A-298 CL E-310 MO-15 OR 16 COATED MANUAL ELECTRODES (38)

REFERENCE DWGS.

MISC. DTLs.	*WT. 6811 (E-11524)
BAFFLE ASS'Y.	*WT. 6812 (ET-2509)
GENERAL NOTES CONT. (FABRICATION ONLY) *A-2060	

SHIPPING LIST

QUAN.	DESCRIPTION	WT.	REMARKS
ONE	1'-8" O.D. X 23'-8" APPROX. O.A. LGTH. VESL	2817	TOTAL

Colanese CHEMICAL COMPANY  
A DIVISION OF COLANESI CORPORATION OF AMERICA

ENGINEERING DEPT.  
AREA VIII HIGHER ACRYLATE UNIT  
TOWER  
1'-8" O.D. X 20'-0" S. TO F.F.  
T-72 PLAN & ELEVATION

DR. BY: JH DATE: 3/1/60  
CR. BY: DM DATE: 6-7-60  
APP. BY: ONK DATE: 4/16/60

SCALE: DRAWING NO. WT. 6810

#95530