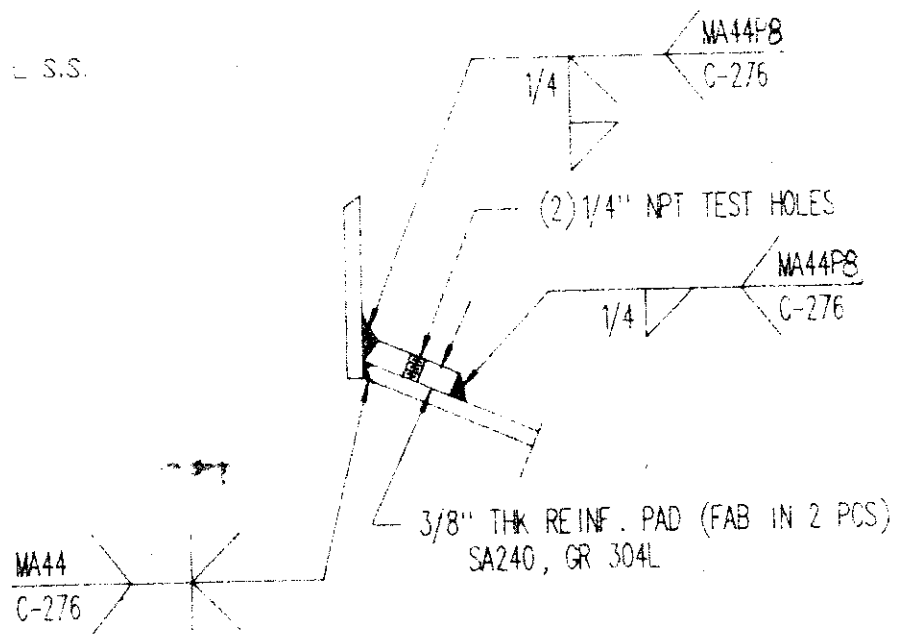
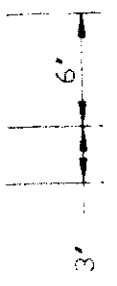


1/16" THK. X 18" X 34" LG. 304 L.S.S.  
 CK-UP PLATE (TYP.)



MIG302  
 E-309L

(2) 7/8" DIA. HOLES  
 PER BASE PLATE



DETAIL "F"  
 NOZZLE REINFORCING PAD DETAIL

2'D

		D	ADDED REINFORCING PADS TO NOZZLE A,B,C,D,E,F, & J. ADDED DETAIL "F" NOZZLE REINFORCING PADS. ADDED WELDING NOTES. DELETED GMAW (PULSE) IN NOTE 2. ADDED FULL PENETRATION NOZZLE WELD IN NOTE 2. ADDED NATIONAL BOARD STAMP NOTE IN NOTE 7. CHANGED DESIGN PRESSURE FROM 15 TO 24. CHANGED HYDRO PRESS. FROM 35 TO 36. CHANGED RADIOGRAPHY FROM NONE TO SPOT (5) SHOTS. ADDED SEAM LOCATIONS.	DG	4/15/96	
		C	CHANGED NOZZLE J IN PLAN • 330° TO NOZZLE E	DG	3/14/96	
		B	ADDED NOZZLE L & M, NOZZLES C,D,E, & F WERE 2" ARE NOW 4", SET FINAL ORIENTATIONS, CHANGED FLANGES FROM CARBON TO STAINLESS.	DG	3/7/96	
		A	CHANGED NOZZ HEIGHTS	DG	2/12/96	
		REV.	DESCRIPTION	DWN.	DATE	
SPARE	25°	 <p style="text-align: center;"><b>Casale Industries Inc.</b>          METAL FABRICATION AND ERECTION          GARWOOD, N.J. 07027</p>  <p style="text-align: center;"><b>MERCK</b>          Manufacturing Division          95-034 FLINT RIVER          10,000 GAL VERTICAL CSA BULK STORAGE TANK</p>				
SPARE	210°					
NITROGEN	45°					
LEVEL	135°					
OUTLET	BOTTOM					
MANHOLE SEE DETAIL B	270°					
VENT	TOP					
INLET	330°					
RECYCLE	90°					
VENT BACK	300°					
LEVEL	0°					
RELIEF	180°					
SERVICE	REMARKS	DRAWN BY: <i>D. Barbera</i>	SCALE	DRAWING NO.	REV.	
JLE		CHECKED BY:	NONE	8711-10	D	

## GENERAL NOTES

1. ALL FLANGE BOLT HOLES TO STRADDLE MAIN CENTERLINES, UNLESS OTHERWISE NOTED. FLANGE FACE FINISH TO CON-NOZZLE NECKS TO BE FLUSH INSIDE AND BACK WELDED.
2. WELDING TO BE SHIELDED ARC PROCESS. MAIN LOGITUDINAL AND GIRTH SEAMS TO BE FULL PENETRATION DOUBLE BUTT WELDS WITHOUT BACKING, PER ASME CODE, TABLE UW-12 TYPE NO.1. ALL NOZZ. WELDS TO BE FULL PENETRATION.
3. INTERNAL WELDS TO BE CLEANED AND WIRE BRUSHED FREE OF SLAG OR SPATTER. CHIP OR GRIND INSIDE WELDS SMOOTH, BUT NOT NECESSARILY FLUSH, NO SAND OR GRIT BLASTING PERMITTED. INTERIOR TO BE COMPLETELY CLEANED PRIOR TO SHIPMENT.
4. ALL EXTERNAL WELDS TO BE CLEANED AND WIRE BRUSHED FREE OF SLAG AND SPATTER. NO SAND OR GRIT BLASTING PERMITTED.
5. EXTERNAL CARBON STEEL SURFACES TO BE PAINTED ONE COAT OF CARBOLINE CARBOMASTIC #15 PRIMER.
6. FOR SHIPPING ALL NOZZLE AND FLANGE OPENINGS ARE TO BE PROTECTED WITH WOOD OR PLASTIC COVERS, AND ALL THREADED CONNECTIONS TO HAVE PLUGS. TAG VESSEL WITH NUMBER SPECIFIED.
7. VESSEL TO BE FABRICATED IN ACCORDANCE WITH ASME CODE SECTION VIII, DIV. 1, LATEST EDITION, STAMPED AND NATIONAL BOARD REGISTERED.

## MATERIAL SPECIFICATIONS

SHELL, HEADS & MISC. PLATE:	SB-575 N10276
BACK-UP FLANGES:	SA-240 GR 304 S/S
PLATE FLANGES:	SA 240 GR. 304 SS WITH HAST 'C' FACING
NOZZLE NECKS:	SB-575 N10276 & SB-366N10276
BOLTING:	SA 193-BB CL. 1
GASKETS:	TEFLON ENVELOPE PER STD. SU-3
SUPPORT LEGS:	SA-36

## DESIGN DATA

DESIGN PRESSURE	24 PSI (INTERNAL) & 1.2 PSI (EXTERNAL)
DESIGN TEMPERATURE	300°F/-20°F
HYDROSTATIC TEST PRESSURE	36 PSIG
SPECIFIC GRAVITY	1.75
CORROSION ALLOWANCE	0
RADIOGRAPHY	SPOT (5) SHOTS

## ESTIMATED WEIGHTS AND VOLUME

GROSS VOLUME:	11,300 GALS.
WEIGHT EMPTY:	8300 LBS.

## REFERENCE DRAWINGS & STANDARDS (GUIDES)

NAMEPLATE:	G-106
GASKETS:	SU-3
LIFTING LUGS:	G-135
GROUNDING LUG:	G-152