

S/N 4589

10P 1004

173265
8/01/1966

Form No. 1 for Manufacturer's Report on an Unfired Pressure Vessel as Required by the Provisions of the API-ASME Code

MANUFACTURER'S NAME: **AMERICAN STEEL FABRICATORS** South San Francisco, Calif. Mfg. Shop Job No. **40481**
PURCHASER'S NAME: **ALLIANCE OIL CO. OF CALIFORNIA** Purchaser's Order No. **112-0-112**

Orientation: **Horizontal** Vessel to be installed in: **California** Date built: **May 1966**
(State and State No.) (Month and Year)

Have sufficient reports been filed in all the places of receipt of this unfired pressure vessel? **Yes**
Do the technical drawings of all parts of all plates of seamless vessel fittings meet the requirements of the Code? **Yes**

Shell of Drum: No. **1** Diameter: **9'-0"** Length over all: **12'-0"**
Rivets: **A-112, 3/16" P.S. See mechanical drawing for more info. See A.I.D. H.T.**

Welded Shell Plates: **Yes** Rivets: **None** Style of joints: **Double V-groove, D.P. 10**
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Welded Shell: **Yes** Vessel Stress Relieved: **None** Yes or No? Efficiency of joint: **90%** per cent
Efficiency of joint: **90%** per cent (Based on butt)

Welded Girth Joints: **Yes (6)** Diameter (Rivet) holes: **1/8"** Width of Rivets: **1/2"** No. of Courses: **Two (2)**

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Heads: **Flat** Radius of dish: **17'-0"** Radius of knuckle: **None**

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Welded Radiographic Inspection: **All of the Circumferential Joints** All of the Circumferential Joints

Welded Stress Relieving: **None** Ring No. Controlling Thickness: **None** Time Temp. in Hr. **None**

Welded Nozzle Outlet: **None** Material of Nozzle or Reinforcement: **None**

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Welded Method of supporting vessel: **None**

Welded Atmospheric working pressure of unfired vessel: **None**

BEST
TAINA
IMAGE
ROM
WISH
PLATE

S/N 4589
A#473865

4589 Date Installed: 10/1/58 State and Date: 10/1/58 (State and Date No.) (Month and Year)

1 Have all vessels, pipes, etc. constructed of plates or seamless vessel fittings entering this unfired pressure vessel? **Yes**

2 Do the vessels or fittings of all plates or seamless vessel fittings meet the requirements of the Code? **Yes**

3 Shell or Drum No. **2** Diameter **9** ft. **6-3/4** in. Length over all **5** ft. **7-1/2** in.

6 Stamps on Shell Plates or seamless fittings **A-202, 70,000 P.S.I., See attached sheet for heat treat, max 650 H.T.** Rivets **None** (A. S. T. M. or Other Specifications Carbon Steel or Alloy)

7 W—Shell Plates **1.00** in. min. R—Shell Plates **1.00** in. min. E—Shell Plates **1.00** in. min. Butt Joint Thickness Style of Seam: Longitudinal **Partial welded butt, see** (Rivets, or Fusion-Welded and Type)

8 W—Joints Radiographed **Yes** Vessel Surfs Radiographed **None** Yes (or No) Efficiency of Joint **95%** (per cent) (Vessel or Joint)

9 W—Girth Joints **Six (6)** R—Girth Joints **Six (6)** Diameter Box: Heiber Pitch of Rivets **Five (5)** in. No. of Courses **Five (5)**

10 Outer Shell Style of Seam: Longitudinal Girth (Rivets or Fusion-Welded and Type) Length of Section or Course **None**

11 Heads: (thickness) **17/32** in. Ratio of ellipse axis **1.00** Side to pressure { Top or one end **Convex** (Bottom or opposite end **Concave** Included angle of conical **None** If reproducible, head bolts used: (Number and size) (Describe or sketch on separate sheet, show)

12 W—Radiographic Inspection All or Part Thickness All or Part Thickness W—Longitudinal Joints **All** in. Circumferential Joints **All** in. W—Stress Relieving Heat Ring Nos. Controlling Thickness Temp. of Vessel Time Temp. is held 6 If part of vessel **None** Hr. 6 If entire vessel **Yes** **2** Hr. **1100** **1** Hr.

13 Nozzle Outlet in Heads No. **1** Size **2-1/2** Material of Nozzle or Reinforcement **Steel** How attached **Welded**

14 Nozzle Outlet in Shell No. **1** Size **2-1/2** Material of Nozzle or Reinforcement **Steel** How attached **Welded**

15 Handholes in Heads **2** in Shell **2** in Shell Reinforcement **Welded**

16 Method of supporting vessel **Welded**

17 4" Allowable working pressure at atmospheric temperature (See W, R, and P-21) **200** per sq. in. Location of field if yielding occurred (1) Hydraulic test shown in longitudinal joints (2) Hydraulic test shown in circumferential joints

18 Hydraulic test pressure **200** per sq. in. (W—Working pressure) **200** per sq. in. (R—Hydraulic test pressure) **200** per sq. in. (P—Hydraulic test pressure when hinged tested) **200** per sq. in. Allowable stress when tested (W—Working stress) **200** per sq. in. (R—Hydraulic test stress) **200** per sq. in. (P—Hydraulic test stress when hinged tested) **200** per sq. in.

Volume = 126.2 17³ 8.9/1/56