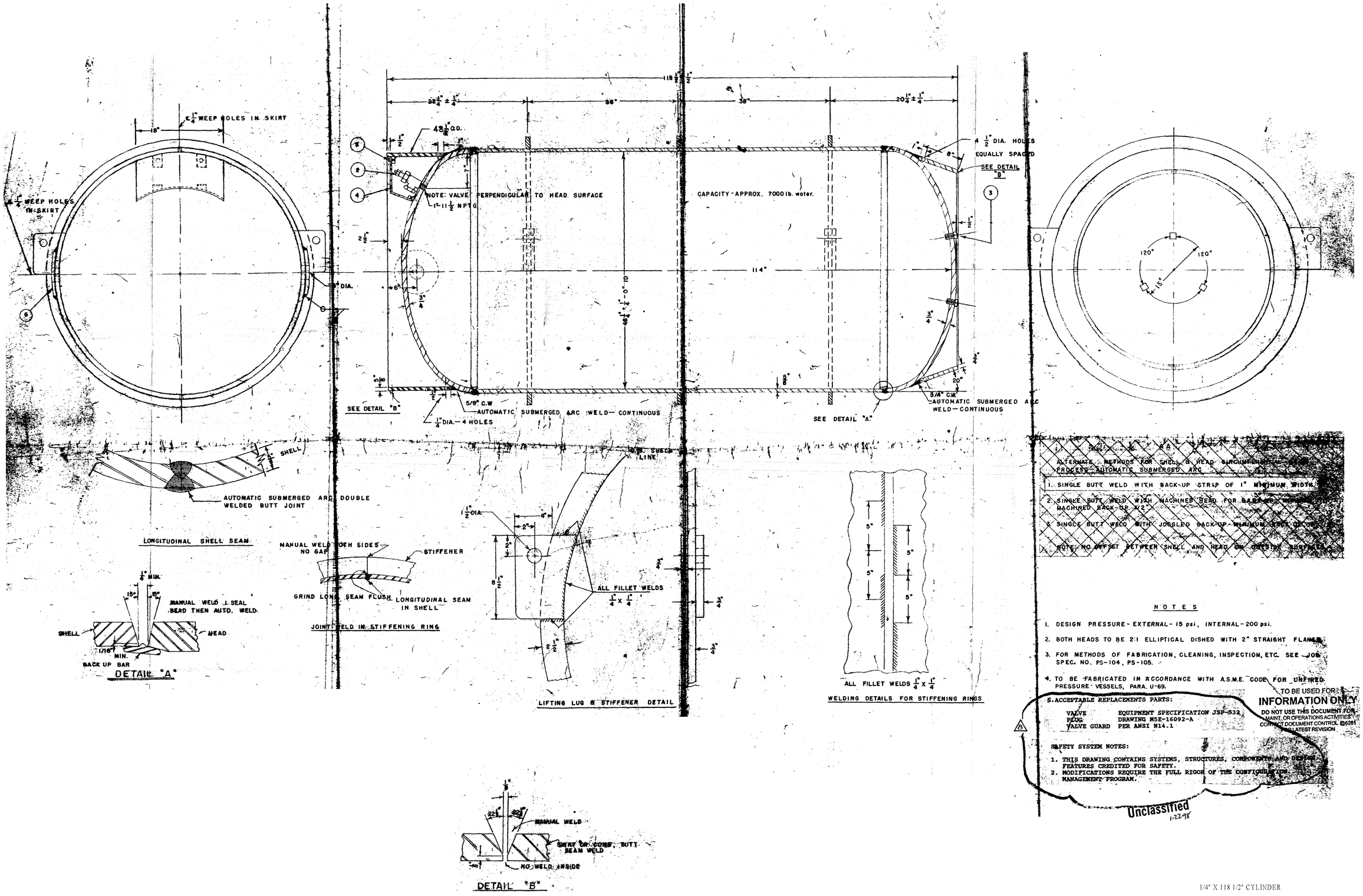

ALTERNATE METHODS FOR SHELL & HEAD CIRCUMFERENTIAL SEAM PROCESS - AUTOMATIC SUBMERGED ARC

1. SINGLE BUTT WELD WITH BACK-UP STRIP OF 1" MINIMUM WIDTH.
2. SINGLE BUTT WELD WITH MACHINED HEAD FOR BACK-UP MACHINED BACK-UP 1/2"
3. SINGLE BUTT WELD WITH JOGGLED BACK-UP MINIMUM STRIP OF 1"
4. NOTE: NO OFFSET BETWEEN SHELL AND HEAD ON OUTSIDE SURFACE

NOTES

1. DESIGN PRESSURE - EXTERNAL - 15 psi, INTERNAL - 200 psi.
2. BOTH HEADS TO BE 2:1 ELLIPTICAL DISHED WITH 2" STRAIGHT FLANGE.
3. FOR METHODS OF FABRICATION, CLEANING, INSPECTION, ETC. SEE JOB SPEC. NO. PS-104, PS-105.
4. TO BE FABRICATED IN ACCORDANCE WITH A.S.M.E. CODE FOR UNFIRED PRESSURE VESSELS, PARA. U-69.
5. ACCEPTABLE REPLACEMENTS PARTS:

VALVE	EQUIPMENT SPECIFICATION JSP-532
PLUG	DRAWING M5E-16092-A
VALVE GUARD	PER ANSI N14.1

SAFETY SYSTEM NOTES:

1. THIS DRAWING CONTAINS SYSTEMS, STRUCTURES, COMPONENTS AND DESIGN FEATURES CREDITED FOR SAFETY.
2. MODIFICATIONS REQUIRE THE FULL RIGOR OF THE CONFIGURATION MANAGEMENT PROGRAM.

TO BE USED FOR:
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DO NOT USE THIS DOCUMENT FOR MAINT. OR OPERATIONS ACTIVITIES. CONTACT DOCUMENT CONTROL @6281 FOR LATEST REVISION
Unclassified
1-22-98

1/4" X 118 1/2" CYLINDER