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GENERAL NOTES

- ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE NOTED.
- ALL BOLT HOLES ARE TO STRADDLE THE NORTH/SOUTH AND VERTICAL CENTER LINES.
- NOZZLE PROJECTIONS ARE FROM OUTSIDE OF VESSEL OR WELD SEAM LINE TO GASKET CONTACT SURFACE OF FLANGE.
- ALL WELDS TO BE CONTINUOUS EXCEPT NOTED.
- FLANGE SHALL BE AS PER ASME B16.5(2003) UNLESS OTHERWISE STATED.
- FLANGES SURFACE FINISH SHALL BE Ra 3.2 TO 6.3 μ m (AARH 125 TO 250).
- FOLLOWING DOCUMENTS ARE APPLIED TO FABRICATION & INSPECTION
 - WPS AND PQR WITH WELDING MAP REFER TO D0644-COM-P-120
 - ALL CUSTOMER SPEC. LISTED IN MATERIAL REQUISITION (MR).
- ALL INTERNAL AND EXTERNAL ATTACHMENT WELDS SHALL BE WELDED WITH FULL PENETRATION ON THE BASE METAL OF THE PRESSURE ENVELOPE.
- ALL MATERIALS AND WELDER IDENTIFICATION SHALL BE WITH LOW STRESS STAMPS.
- NOZZLE REPAIRS 10" NPS AND SMALLER SHALL HAVE ONE 1/4" WEEP HOLE. NOZZLE REPAIRS, GREATER THAN 10" NPS SHALL HAVE TWO 1/4" WEEP HOLES, 180° APART. ALL WEEP HOLES SHALL BE EQUIPPED WITH 1/4" NIPPLES THAT PROTRUDE 1" BEYOND THE INSULATION.
- DIMENSIONED TOLERANCES SHALL CONFORM TO ASME CODE REQUIREMENTS AND MED ENERGY STD. DRAWING 085354-3010-PV-24.
- THE REQUIREMENTS OF IMPACT TEST FOR MATERIALS SHALL BE FOLLOWED IN ACCORDANCE WITH SPEC. 085354-3010-EW-20. TEST SPECIMENS SHALL BE PROVIDED IN COMPLETE HEAT-TREATED CONDITION.
 - TEST TEMPERATURE : a) -49°F [-45°C] FOR VESSEL BODY
b) -49°F [-45°C] FOR SKIRT, LIFTING LUG
c) -49°F [-45°C] FOR EXTERNAL SUPPORT CLIPS SUCH AS PLATFORM & LADDER, PIPING.
 - TEST SPECIMENS : AS PER ASTM A370 MINIMUM 3 SETS PER HEAT.
 - IMPACT ENERGY : PER ASME SECTION VIII DIV.1 UG-84.
 - APPLICABLE MATERIALS :
 - FOR SHELL & HEADS, SA516-70N : THE MATERIAL SHALL BE USED WITH NORMALIZED SA516-70 MARKED AS "N" TO EXEMPT FROM IMPACT TEST (NORMALIZED SA516-70 PLATES CLASSIFIED AS CURVE D ARE EXEMPTED AS PER FIG UCS-66)
 - FOR SADDLE, LIFTING LUGS, SA516-70N : THE MATERIAL SHALL BE USED WITH NORMALIZED SA516-70 MARKED AS "N" TO EXEMPT FROM IMPACT TEST (NORMALIZED SA516-70 PLATES CLASSIFIED AS CURVE D ARE EXEMPTED AS PER FIG UCS-66 IF THK < 15MM)
 - FOR EXTERNAL SUPPORT CLIPS SUCH AS PLATFORM & LADDERS PIPING, SA516-70N : THE MATERIAL SHALL BE USED WITH NORMALIZED SA516-70 MARKED AS "N" TO EXEMPT FROM IMPACT TEST (NORMALIZED SA516-70 PLATES CLASSIFIED AS CURVE D ARE EXEMPTED AS PER FIG UCS-66 IF THK < 15MM)
- WPS/PQR TO HAVE QUALIFICATION MATERIAL WITH SAME P NO.
- DESIGN LIQUID LEVEL IS FULL WITH SG=1.
- VESSEL SHALL BE "ASME" STAMPED AND NATIONAL BOARD REGISTRATION. ABSA REGISTRATION.
- HYDROTEST WATER SHALL BE CLEAN WATER WITH LESS THAN 250ppm CHLORIDE CONTENT. HYDROTEST PRESSURE SHALL BE MAINTAINED FOR A MINIMUM OF 60MINUTES A/W CHART AT A MINIMUM OF 5°C
- UPON COMPLETION OF HYDROTEST, VESSEL SHALL BE COMPLETELY DRAINED OF ALL WATER, AIR DRIED, AND CLEANED
- ALL WELDED ATTACHMENTS PROVIDE WITH WEEP HOLES, SHALL BE SOAP TESTED AT 175Kpsig PRIOR TO HYDROSTATIC TEST.
- VESSEL EXTERNAL SURFACE PREPARATION AND PAINTING SHALL BE AS PER SPEC. 085354-3010-PC-50. TABLE 3. SYSTEM A1
- WDE INSPECTION REQUIREMENTS
 - SPOT RT PER VW-11(6) FOR ALL BUTT WELD IN ACCORDANCE WITH ASME SEC. V AND ASME SEC. VIII DIV.1 UW-51
 - ALL SADDLE TO SHELL AND LIFTING LUG WELDS SHALL BE MPI EXAMINED ALL AROUND.

FOR APPROVAL ASME-U

REV.	DATE	DESCRIPTIONS FOR REVISION	DRWN	CHK'D	CHK'D	REV'D	APP'D
1	2014 03.13	FOR APPROVAL	S.K.KIM				
2	2014 01.02	FOR APPROVAL	J.H.LIM	G.S.KIM	B.J.KIM		H.H.CHO
3	2013 11.12	FOR APPROVAL	J.H.LIM	G.S.KIM	B.J.KIM		H.H.CHO
4	2013 09.13	FOR APPROVAL	ADRAH	G.S.KIM	B.J.KIM		H.H.CHO

CUSTOMER	
CLIENT	SNC • LAVALIN INC.
TITLE	GTG GLYCOL AERIAL COOLER EXPANSION VESSEL
3A-V-3173	GENERAL ASSEMBLY (2/2)
SEWON CELLONTECH CO., LTD. CHANGWON, KOREA	
OWNER JOB NO.	508298
P/O NO.	P-5120-01
SEWON JOB NO.	D-0644
PROJECTION METHOD	THIRD ANGLE PROJECTION
SCALE	SEE DWG.
OWNER DWS. NO.	-
SEWON DWS. NO.	D0644-3AV3173-D-01-1
WORKS	C