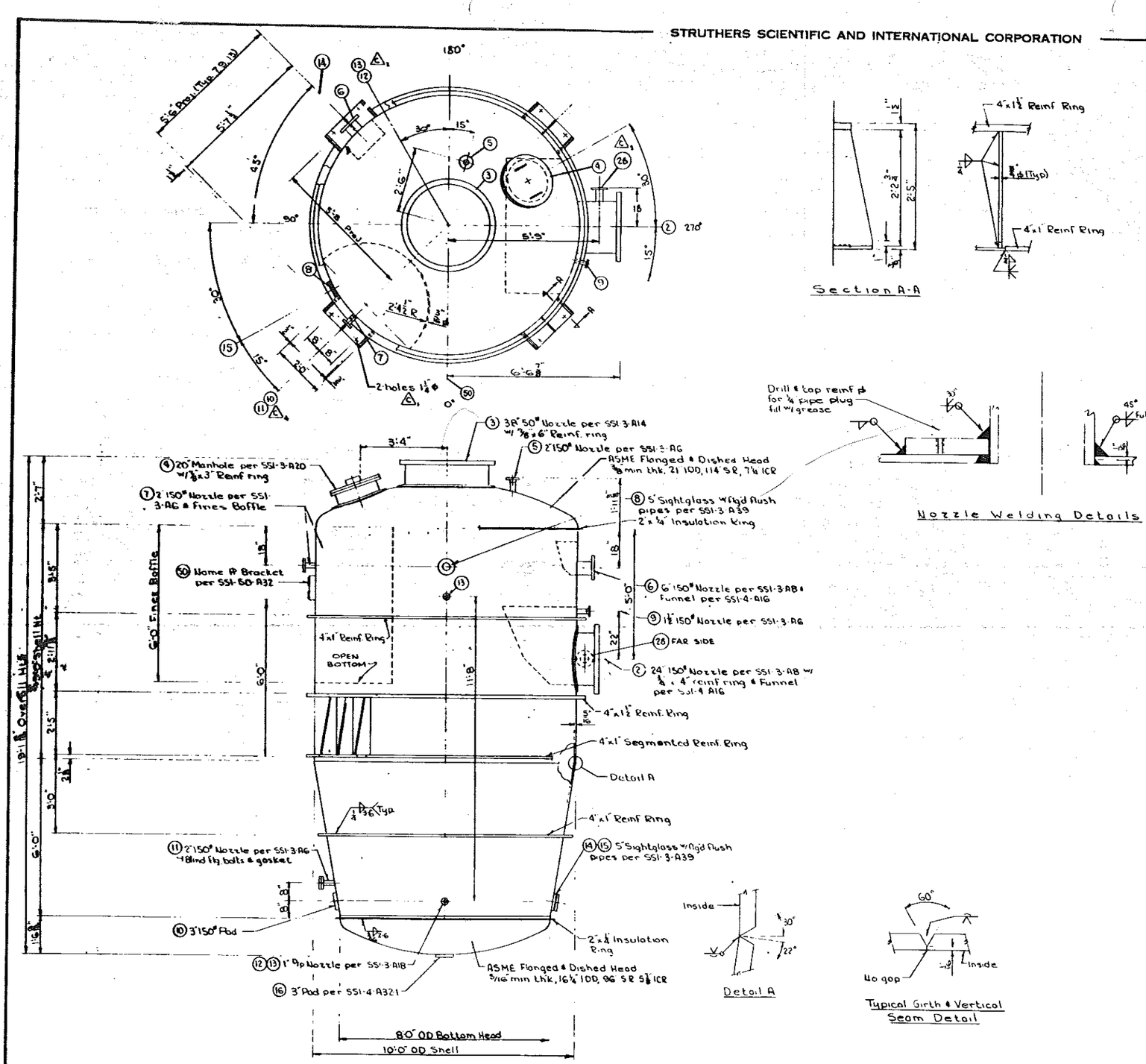
STRUTHERS SCIENTIFIC AND INTERNATIONAL CORPORATION



Section A-A

Nozzle Welding Details

General Notes

Construction to be in accordance with Section VIII 1965 ASME Code (latest revision) Code stamp reqd on body.

Spot x-ray reqd

Design Pressure- 15 psi external @ 250°F. (full vacuum) & 20 psig internal @ 250°F.

Test Pressure- 30 psig hydro.

Working Pressure- Atmospheric & hydrostatic

Working Temperature- 70°F.

Welding per ASME Code by code qualified welders. Joining of carbon steel to stainless steel to be done with E-309-15 or E-310-15 electrodes.

Weld Finish- Interior welds below top seam to be ground flush & polished to at least original ϕ finish. No ledges or crevices permitted. Inside fillet welds to be ground smooth. All outside welds to be normal.

Inspection- by SSIC, Customer & Insurance

Paint- per Customer Engineering Spec sheet B19

Material-

Body- SA 240 Type 316 ELC St'nl's St'l

Supports, Reinf. Rings, Back-up Flanges- Carbon steel - "CODE MTL. WITH MILL TEST REPORTS."

Nozzle Reinforcing- SA 240 Type 316 ELC St'nls Steel

REVIEWED, W.F. BRASHER EQUIP NO V-1404 BY KPB DATE 4/20/67
SATISFACTORY AS LISTED
SATISFACTORY AS NOTED
NOT SATISFACTORY AS NOTED (SEE BRG. REQD)
Fabrication shall conform with all specifications and requirements of Purchase Order
SEE TRANSMITTAL SUPPLEMENT TO ORDER FOR FURTHER INSTRUCTIONS

SSI CERTIFIED
FOR: Crosfield Chemical
ORDER: KPC-2055 KE6-0591
DATE: MAR 30 67 BY: [signature]
STRUTHERS SCIENTIFIC & INTERNATIONAL CORP.
WARREN, PA.

FKD-C2055-8-1
FKD-C2055-8-0
PE-3039-5-0
PE-3039-5-1

ENGINEERING DEPT
RECORD COPY
THIS COPY MUST NOT BE REMOVED FROM THE SERVICES SECTION

V-1404

REVISION		
A	TEW 1-18-65	WAS 285 GR C MTL.
B	TEW 1-28-65	REVISE NOZZLE REINFORCING PADS WAS 12.15, 12.11 UNIT
C	TEW 1-17-67	REVISED PER CUST. MKD DRWG 1-10-67
D	TEW 1-30-67	REVISED LOCATION OF #14, #15
E		
F		
G		

Struthers Scientific & International Corp.
Warren Division Warren, Penna.

Crystallizer Body Details

DRAWN J. Weber 11-8-64
CHECKED 11-18-64
SCALE ½" = 1'-0"

DRAWING NUMBER
KE6-0591-D-5

V-1404