

Form No. 1 Manufacturers' Data Report on an Unfired Pressure Vessel
As Required by the Provisions of the API-ASME Code

242

For Vessels having parts built under different sections (W, EW, R, and F), use appropriate item headings for each part

1 Manufactured by Wyatt Metal & Boiler Works Dallas, Texas Mfrs. Shop Job No. 2719
(Name and address of the manufacturer)

2 Manufactured for O. L. Olson Co., Houston, Texas Purchaser's Order No. 24248
(Name and address of the Purchaser)

3 Type Horizontal Vessel No. 56D2719-2 To be installed in Texas Date built 7/56
(Horizontal or vertical—when in service) (Mfrs. Serial No.) (State and State No.) (Month and Year)

4 Have mill test reports been checked on all the plates or seamless vessel forgings entering this unfired pressure vessel? yes
Do the chemical and physical properties of all plates or seamless vessel forgings meet the requirements of the Code? yes
(See chemical and physical report)

5 Shell or Drums: No. 1 Diameter 9 ft. 0 in. Length over all 62 ft. 2 in.
(or width) Studs: _____ Nuts: _____

6 Stamp on Shell Plates or seamless Forgings 55,000 Rivets _____ Bolts _____
(Brand and lowest tensile strength) (ASTM or other specifications for carbon steel or alloy)

7 W¹-Shell Plates 1/4 in. Style of Seams: Longitudinal Sgl. V Dbl. Butt
EW-Shell Plates _____ in. (Riveted or fusion-welded, and type)
R-Shell Plates _____ in. Butt Strap Thickness: Inside _____ in. Outside _____ in.
F-Shell _____ in. (Thickness)

8 W-Joints Radiographed No Vessel Stress-Relieved No (Yes or No) Efficiency of Joint 80 per cent
R- Diameter of Rivet Holes _____ in. Pitch of Rivets X X Efficiency of Joint _____ per cent
(Vessel as built)

9 W-Girth Joints _____
R-Girth Joints _____ Diameter Rivet Holes _____ in. Pitch of Rivets _____ in. No. of Courses 7
(Riveted or fusion-welded, and type)

10 Outer Shell _____ in. Style of Seams: Longitudinal _____ Girth _____ Length of Section or Course _____ ft. _____ in.
(if jacketed, thickness) (Riveted or fusion-welded, and type)

11 Heads: (thickness) 3/8" Nom. in. Radius of dish _____ in. Radius of knuckle _____ in.
Ratio of ellipse axis _____
Included angle if conical _____ Side to pressure _____
If removable, head bolts used _____ or method of fastening _____
(Number and size) (Describe or sketch on separate sheet)

12 W-Radiographic Inspection All or Per Cent Thickness
a Longitudinal Joints _____ in.
b Circumferential Joints _____ in.
W-Stress-Relieving Heads Ring Nos. Controlling Thickness Temp of Vessel Time Temp Is Held
a If part of vessel only _____ in. _____ F _____ hr. _____ min.
b If entire vessel _____ in. _____ F _____ hr. _____ min.

13 Nozzle Outlets in Heads: No. _____ Size _____ Material of Nozzle or Reinforcement _____ How attached CW IS & OS _____
Nozzle Outlets in Shell: No. _____ Size _____ Material of Nozzle or Reinforcement _____ How attached CW IS & OS _____
(riveted, welded, etc.)

14 Handholes or Sight Holes _____
(Number, size, and location)

15 Manholes: In Heads _____ Reinforcement _____
In Shell 1- 16" 150# (Inspection) Reinforcement Pad CW IS & OS
(Number) (Size and location of each, distance off center of head) (Riveted, welded, etc., outside only or also inside)

16 Method of supporting vessel Saddles
(Lugs, skirt, or ring if on end; or saddles or lugs if horizontal)

17 a² Allowable working pressure at atmospheric temperature (See W-, R-, and F-525) 46 psi
b Hydrostatic test pressure 69 psi
c Hydrostatic test pressure when hammer test 58 psi
d Proof test pressure if applied _____ psi
c Location of yield if yielding occurred _____
f² Hydrostatic test stress in longitudinal joints (W vessels only) 11,870 psi
g Allowable operating stress (Two-thirds stress obtained in f) 9,918 psi

18 Constructed for pressure of 40 psi. With specified operating temperature of 450 F. With corrosion allowance of 0 in.

Remarks 9' 0" O.D. x 62' 2" S-S Isopentane Tank
Item No. TK-22 Dwg. No. E-9502

¹W-Welded, EW-Welded External Pressure, R-Riveted, F-Seamless Forged.
²When there are shell sections of different thicknesses, each section shall be treated separately.

WE CERTIFY the above data to be correct and that all details of material, construction, and workmanship on this unfired pressure vessel conform to the API-ASME Code for Unfired Pressure Vessels for Petroleum Liquids and Gases.

Date 7/26/1956 Signed Wyatt Metal & Boiler Works By W. A. Moore
(Manufacturer) Hartford Steam Boiler
7/26/1956 Checked by [Signature] For Insp. & Insurance Co.
(Inspector)

WYATT METAL & BOILER WORKS
DALLAS, TEXAS

Customer O. L. Olsen Company
Address Houston, Texas
Customer's P. O. 24218
Phone TX-22
Wyatt's Dept. E-9502
Serial No. 56-D-2719-2
Date August 24, 1956

S/O 2719-2

MILL TEST REPORT

121-K-2-12

MILL	HEAT	SLAB	SPECIFICATIONS	CHEMICAL					THICK.	PHYSICAL		
				C	MN	P	S	YIELD PT.		TEN. STR.	ELONG.	BEND.
U S S	730185	21	A-283C	17	46	012	021	3/8"	40680	60140	32.7	OK
U S S	660219	4	A-283C	17	55	010	030	3/8"	40630	61500	34.0	OK
U S S	730185	7	A-283C	17	46	012	021	3/8"	40680	60140	32.7	OK
U S S	730185	21	A-283C	17	46	012	021	3/8"	40680	60140	32.7	OK
U S S	660219	4	A-283C	17	55	010	030	3/8"	40630	61500	34.0	OK
U S S	660219	12	A-283C	17	55	010	030	3/8"	40630	61500	34.0	OK
U S S	730185	8	A-283C	17	46	012	021	3/8"	40680	60140	32.7	OK
U S S	730185	22	A-283C	17	46	012	021	3/8"	40680	60140	32.7	OK
U S S	520065	1	A-283C	16	17	012	032	3/8"	42660	62800	32.7	OK
U S S	660219	3	A-283C	17	55	010	030	3/8"	40630	61500	34.0	OK
Sheff	3379		A-283C	15	42	01	02	1/4"	43900	61400	25.0	OK
C F T	68005R	12	A-285C FB	16	43	022	027	3/8"	37200	58700	29.2	OK
Sheff	1576		A-283C	15	34	01	02	1/2"	45900	63300	25.5	OK

The Above Data Certified Correct:

WYATT METAL & BOILER WORKS

[Signature]