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GENERAL NOTES

1. ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE NOTED.
2. ALL BOLT HOLES ARE TO STRADDLE THE NORTH/SOUTH AND VERTICAL CENTER LINES.
3. NOZZLE PROJECTIONS ARE FROM OUTSIDE OF VESSEL OR WELD SEAM LINE TO GASKET CONTACT SURFACE OF FLANGE.
4. ALL WELDS TO BE CONTINUOUS EXCEPT NOTED.
5. FLANGE SHALL BE AS PER ASME B16.5(2003) UNLESS OTHERWISE STATED.
6. FLANGES SURFACE FINISH SHALL BE Ra 3.2 TO 6.3 μ m (AARH 125 TO 250).
7. FOLLOWING DOCUMENTS ARE APPLIED TO FABRICATION & INSPECTION
 - 1) WPS AND PQR WITH WELDING MAP REFER TO D0644-COM-P-120
 - 2) ALL CUSTOMER SPEC. LISTED IN MATERIAL REQUISITION (MR).
8. ALL INTERNAL AND EXTERNAL ATTACHMENT WELDS SHALL BE WELDED WITH FULL PENETRATION ON THE BASE METAL OF THE PRESSURE ENVELOPE.
9. ALL MATERIALS AND WELDER IDENTIFICATION SHALL BE WITH LOW STRESS STAMPS.
10. NOZZLE REPADS 10" NPS AND SMALLER SHALL HAVE ONE 1/4" WEEP HOLE. NOZZLE REPADS, 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.
11. DIMENSIONED TOLERANCES SHALL CONFORM TO ASME CODE REQUIREMENTS AND MEG ENERGY STD. DRAWING 085354-3010-PV-24.
12. 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.
 - 1) 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.
 - 2) TEST SPECIMENS : AS PER ASTM A370 MINIMUM 3 SETS PER HEAT.
 - 3) IMPACT ENERGY : PER ASME SECTION VIII DIV.1 UG-84.
- 4) APPLICABLE MATERIALS :
 - A) 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)
 - B) 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)
 - C) 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)
13. WPS/PQR TO HAVE QUALIFICATION MATERIAL WITH SAME P NO.
14. DESIGN LIQUID LEVEL IS FULL WITH SG=1.
15. VESSEL SHALL BE "ASME" STAMPED AND NATIONAL BOARD REGISTRATION. ABSA REGISTRATION.
16. 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
17. UPON COMPLETION OF HYDROTEST, VESSEL SHALL BE COMPLETELY DRAINED OF ALL WATER, AIR DRIED, AND CLEANED
18. ALL WELDED ATTACHMENTS PROVIDE WITH WEEP HOLES, SHALL BE SOAP TESTED AT 175Kpa PRIOR TO HYDROSTATIC TEST.
19. VESSEL EXTERNAL SURFACE PREPARATION AND PAINTING SHALL BE AS PER SPEC. 085354-3010-PC-50 TABLE 3. SYSTEM A1
20. NDE INSPECTION REQUIREMENTS :
 - 1) SPOT RT PER VW-11(6) FOR ALL BUTT WELD IN ACCORDANCE WITH ASME SEC. V AND ASME SEC. VIII DIV.1 UW-51
 - 2) ALL SADDLE TO SHELL AND LIFTING LUG WELDS SHALL BE MPI EXAMINED ALL AROUND.

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FOR APPROVAL ASME-U

REV.	DATE	DESCRIPTIONS FOR REVISION	DRWN	CHK'D	CHK'D	REV'D	APP'D
◇	2014 03.13	FOR APPROVAL	S.K.KIM				
◇	2014 01.02	FOR APPROVAL	J.H.LIM				
◇	2013 11.12	FOR APPROVAL	J.H.LIM				
◇	2013 09.13	FOR APPROVAL	ADRAH				

PROJECT	
CUSTOMER	
CLIENT	SNC ♦ LAVALIN INC
TITLE	GTG GLYCOL AERIAL COOLER EXPANSION VESSEL 3A-V-3173 GENERAL ASSEMBLY (2/2)
OWNER JOB NO.	508298
P/O NO.	P-5120-01
SEWON JOB NO.	D-0644
SEWON DWG. NO.	D0644-3AV3173-D-01-1
WORKS	C

