

FORM U-1A MANUFACTURERS' DATA REPORT FOR UNFIRED PRESSURE VESSELS
Alternate Form for Single Chamber Completely Shop-Fabricated Vessels Only

1. Manufactured by AMF BEAIRD, INC., SHREVEPORT, LOUISIANA
(Name and address of Manufacturer)
2. Manufactured for BROWN & ROOT, INC., HOUSTON, TEXAS
(Name and address of Purchaser)
3. Type Horiz. Vessel No. (161844) (Mfr. Serial) (State & State No.) Natl. Bd. No. Yr. Built 1969
(Horiz. or Vert.)
4. SHELL: Matl. SA-516-70-Fbx T.S. 70,000# Nom. 13/16 Corr. 1/16
(Kind and Spec. No.) (Fig. or F.B. & Spec. Min. T.S.) Thk. In. Allow In. Diam. 12 Ft. 0 In. Length 110 Ft. 3 In. heads 1/16
5. SEAMS: Long Dbl. Butt H.T. Yes R.T. Complete Sectioned No Efficiency 100 %
(Welded, Dbl., Single, Lap, Butt) (Yes or No) (Spot or Complete) (Yes or No)
Girth Dbl. Butt H.T. Yes R.T. Complete Sectioned No No. of Courses 16
6. HEADS: (a) Material SA-516-70-Fbx T.S. 70,000# (b) Material SA-516-70-Fbx T.S. 70,000#
(Top, bottom, ends) Thickness 7/16" Crown Radius 72.015" Conical Apex Angle 72.015" Hemispherical Radius 72.015" Flat Diameter 72.015" Side to Pressure (Convex or Concave) Concave
(a) Ends (b) Ends
- If removable, bolts used SA-516-70-Fbx (Material, Spec. No., T.S., Size, Number) Other fastening SA-516-70-Fbx (Describe or Attach Sketch)
7. Constructed for max. allowable working press. 180 psi at max. temp. 400 °F. Min. temp. (when in service) -20 °F. Hydrostatic Pneumatic or Combination Test Press. 294 psi.
8. SAFETY OR RELIEF VALVE OUTLETS: Number 1 Size 6" Location Top of tank in shell
9. NOZZLES:
- | Purpose (Inlet, Outlet, Drain) | Number | Diam. or Size | Type | Material | Thickness | Reinforcement Material | How Attached |
|--------------------------------|---------|---------------|------------------------|-----------|-----------|------------------------|--------------|
| (1) 2" | (2) 3" | 150# | Weld Neck Flanges | SA-105-II | SA-105-II | | Welded |
| (2) 6" | (1) 10" | (1) 12" | 150# Weld Neck Flanges | SA-105-II | SA-105-II | | Welded |
10. INSPECTION Manholes, No. 1 Size 18" Location Top of tank in shell
OPENINGS: Handholes, No. 1 Size 18" Location Top of tank in shell
Threaded, No. 1 Size 18" Location Top of tank in shell
11. SUPPORTS: Skirt (Yes or No) Lugs (Number) Legs (Number) Other (2) Saddles Attached Welded to tank shell
(Describe) (Where & How)
12. REMARKS: One 144" I.D. x 122' 0-7/8" O.A. Length 99,836 W.G. Raw Product Tank, per Beaird Dwg. Order 161844

(Brief description of purpose of the vessel as Air Tank, Water Tank, L.P.G., Etc.—State Contents.)

¹ If postweld heat-treated.

² List other internal or external pressure's with coincident temperature when applicable.

We certify that the statements made in this report are correct and that all details of design, material, construction, and workmanship of this vessel conform to the ASME Code for Unfired Pressure Vessels. 1968 Edition Div. 1

Date 3-27 19 69 Signed AMF BEAIRD, INC. By W.B. Thomas
(Manufacturer)

Certificate of Authorization Expires December 31, 1970

CERTIFICATE OF SHOP INSPECTION

VESSEL MADE BY AMF BEAIRD, INC. at SHREVEPORT, LOUISIANA

I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State or Province N. B. and employed by COMMERCIAL UNION INSURANCE COMPANY of AMERICA

have inspected the pressure vessel described in this manufacturer's data report on 3-27 19 69 and state that to the best of my knowledge and belief, the manufacturer has constructed this pressure vessel in accordance with the applicable sections of the ASME Boiler and Pressure Vessel Code.

By signing this certificate neither the Inspector nor his employer makes any warranty, expressed or implied, concerning the pressure vessel described in this manufacturer's data report. Furthermore, neither the Inspector nor his employer shall be liable in any manner for any personal injury or property damage or a loss of any kind arising from or connected with this inspection.

Date 3-27 19 69

W.B. Thomas
Inspector's Signature

Commission

Natl Board or State and No.

- U1610
- BEAIRD NAME PL (REF. DWG #6-9FA12C)
 - #14 GA X 5" X 23 1/4" (H.R.S. OR C.R.S)
 - #6 PARKER-KALON DRIVE SCREWS
TYPE U 3/8" LG.
- DRILL #31(.12") HOLES
IN BRACKET TO MATCH
NAME PLATE

③ ① ②



W
RT
HT



BEAIRD



RAW PRODUCT TANK

SERIAL NO. 161844

ITEM NO. V-1010

DATE

P.O. NO. 34-5012-13

MAX ALCH. NR. 180

P.S.G. TEMP. -29/400° F.

SHELL .8125

IN. O.D. 145 5/8

HEAD .4375

IN. D.R. HEMI IN.

C.A.L. 122 FT. 0 7/8"

IN. NB NO.

AMF BEAIRD INC.

SHREVEPORT, LOUISIANA

SUBSIDIARY OF AMERICAN MACHINE AND FOUNDRY COMPANY

1/4 I.R. MAX.

②

6 3/4"

1/8 I.R. MAX.

ALL LETTERS, EXCEPT SPECIAL STAMPS TO BE 5/32" UNLESS OTHERWISE SHOWN

AMF BEAIRD, INC.

SUBSIDIARY OF AMERICAN MACHINE & FOUNDRY COMPANY

SHREVEPORT, LOUISIANA

BEAIRD NAME PLATE BRACKET
FOR CONTRACT VESSELS

ITEM #2 WAS 14 GA X 5" X 10"		12/67	RAW	DRAWN	SER 7-6-67	ORDER NUMBER	DRAWING NUMBER
REDRAWN		7/67	SER	CHECKED	EN 7-6-67	161844	6-9AA15-D
REVISIONS		APPR.	APPROVED	JPD 7-6-67		SHEET 4 OF	SHEET OF