

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

HTK-243

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 Mrs. Shop Job No. 2719
(Name and address of the manufacturer)

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

3. Type Horizontal Vessel No. 56D2719-3 To be installed in Texas Date built 7/56
(Horizontal or vertical—when in service) (City, State and County) (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)

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

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 ce
R- Diameter of Rivet Holes _____ in. Pitch of Rivets X X Efficiency of Joint _____ per ce
(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 _____
Ratio of ellipse axis _____ Top or one end Concave
Included angle if conical _____ Side to pressure _____ Bottom or opposite end _____
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 Ho.
a If part of vessel only _____ in. _____ F _____ hr. _____ min.
b If entire vessel _____ in. _____ F _____ hr. _____ min.

13. SEE ATTACHED SCHEDULE OF OPENINGS
18. 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 c Location of yield if yielding occurred _____
b Hydrostatic test pressure 69 psi f² Hydrostatic test stress in longitudinal joints _____ psi
c Hydrostatic test pressure when hammer test 58 psi (W vessels only) 11,870 psi
d Proof test pressure if applied _____ 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

¹ W-Welded, EW-Welded External Pressure, R-Riveted, F-Seamless Forged.
² When 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 [Signature]
(Manufacturer) Hartford Steam Boiler
7/26/1956 Checked by [Signature] For Insp. & Insurance Co.
(Inspector)

RTK 2-13

Customer O. L. Olsen Company
Address Houston, Texas
Customer's P. O. 24218
Item TK-23
Wyatt's Dwg. E-9502
Serial No. 56-D-2719-3
Date August 24, 1956

S/O 2719-3

MILL TEST REPORT

MILL	HEAT	SLAB	SPECIFICATIONS	CHEMICAL					THICK.	PHYSICAL			
				C	MN	P	S	YIELD FT.		TEN. STR.	ELONG.	BEND.	
U S S	66U219	19	A-283C	.17	.55	.010	.030	3/8"	40630	61500	34.0	OK	
U S S	66U219	12	A-283C	.17	.55	.010	.030	3/8"	40630	61500	34.0	OK	
U S S	73U185	5	A-283C	.17	.46	.012	.024	3/8"	40680	60140	32.7	OK	
U S S	67U219	10	A-283C	.17	.55	.010	.030	3/8"	40630	61500	34.0	OK	
U S S	53U065	4	A-283C	.16	.17	.012	.032	3/8"	42660	62800	22.7	OK	
U S S	66U219	20	A-283C	.17	.55	.010	.030	3/8"	40630	61500	34.0	OK	
U S S	66U219	9	A-283C	.17	.55	.010	.030	3/8"	40630	61500	34.0	OK	
U S S	66U219	11	A-283C	.17	.55	.010	.030	3/8"	40630	61500	34.0	OK	
U S S	73U185	6	A-283C	.17	.46	.012	.024	3/8"	40680	60140	32.7	OK	
Sheet	3379		A-283C	.15	.42	.01	.02	1/4"	43900	62400	25.0	OK	
C F I	58005R	12	A-285C RB	.16	.43	.022	.027	3/8"	37200	58700	29.2	OK	
Sheet	1576		A-283C	.15	.34	.01	.02	1/2"	45900	63300	25.5	OK	

The Above Data Certified Correct:

WYATT METAL & BOILER WORKS

By *[Signature]*