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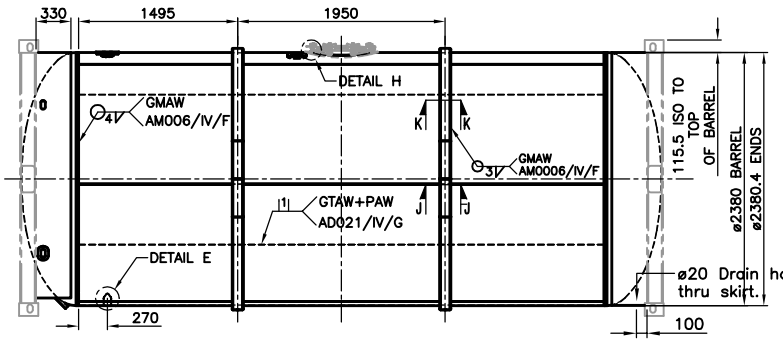
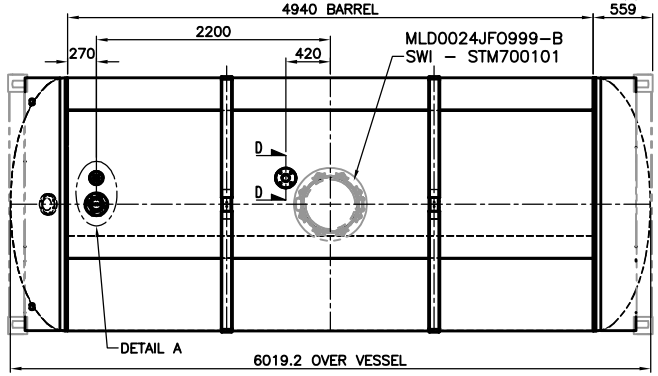
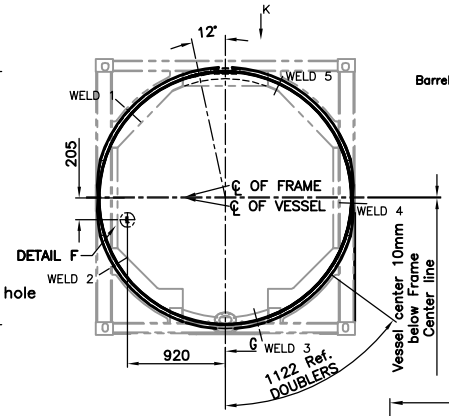
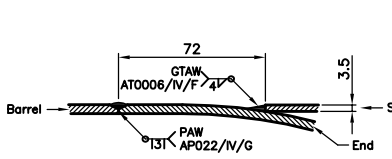
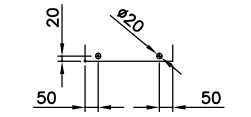




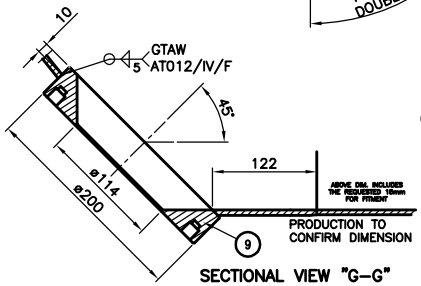




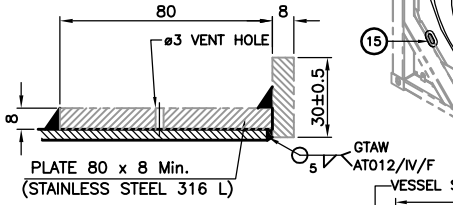
CIRCUMFERENTIAL WELD



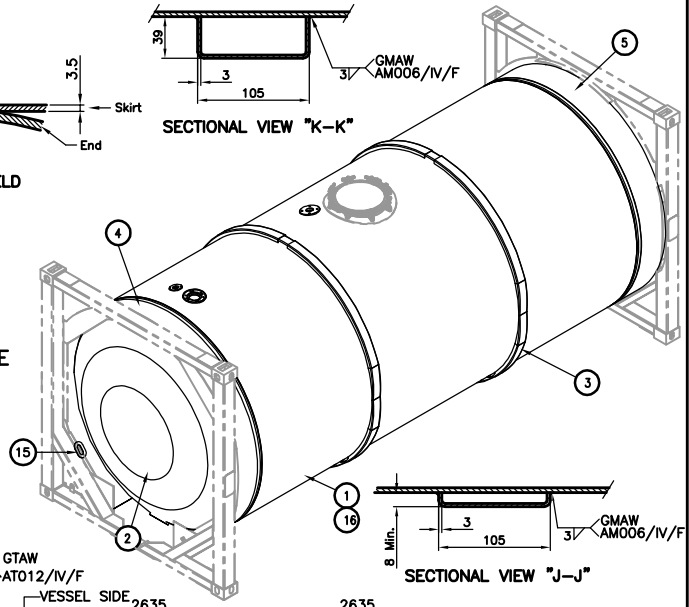
REAR SKIRT DRAINAGE
BOTH SIDES

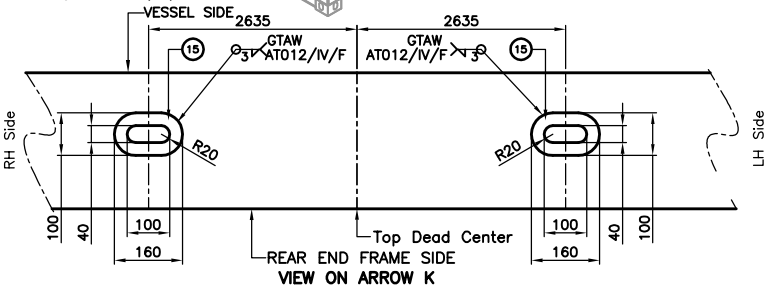


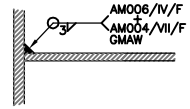
SECTIONAL VIEW "G-G"



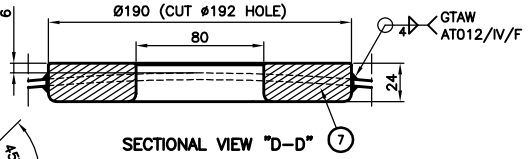
DETAIL "H"



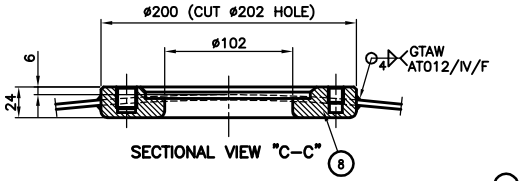




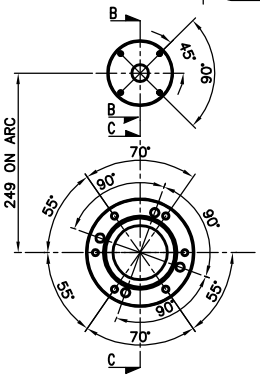
SKIRT to END FRAME **



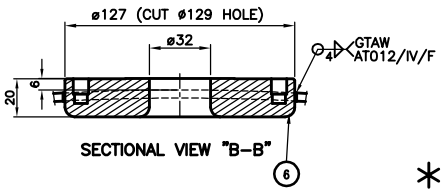
SECTIONAL VIEW "D-D" (7)



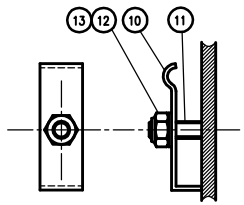
SECTIONAL VIEW "C-C" (8)



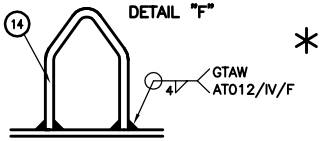
DETAIL A



SECTIONAL VIEW "B-B" (6)



DETAIL "F"



DETAIL "E"

* BUILD WITH FIRST 40 TANKS

** BUILD WITH LAST 60 TANKS

WELDING NOTE

1. WELDING PROCEDURES GENERALLY IN ACCORDANCE WITH ASME SECTION IX
2. INSPECTION AUTHORITY BUREAU VERITAS.
3. WELDING SYMBOLS IN ACCORDANCE WITH SABS 044 PART 2 1963.

VESSEL DESIGN

CAPACITY	25000 LITRES	6605 US GALLONS
Max. ALLOWABLE WORKING PRESSURE		4.0 bar
TEST PRESSURE		6.0 bar
Max. EXTERNAL PRESSURE		0.41bar
RID/ADR PRESSURE		N/A

BARREL MATERIAL

STAINLESS STEEL 316L
SANS 50028-7 TYPE 1.4402/1.4404

Min. Design thickness	4.2 mm
Corrosion Allowance	0.2 mm
Manufacturing thickness	4.4 mm

END MATERIAL

STAINLESS STEEL 316L
SANS 50028-7 TYPE 1.4402/1.4404

Min. Design thickness	4.4 mm
Corrosion Allowance	0.2 mm
Manufacturing thickness	4.6 mm

MIN. MECHANICAL PROPERTIES

	20°c		140°c	
	Shell	End	Shell	End
0.2% PROOF STRESS	290 MPa	290 MPa	240 MPa	240 MPa
1% PROOF STRESS	330 MPa	320 MPa	275 MPa	275 MPa
UTS	600 MPa	590 MPa	492 MPa	492 MPa
ELONGATION	50%	48%		
RADIOGRAPHY	TO ASME UW52			
SHELL	SPOT			
ENDS	100%			
FINISH	SEE SPECIFICATION			

ITEM	QTY	DESCRIPTION	L	B	MATERIAL	PART NUMBER	Kg
16	1	BRL,JFO-SCR,Ø2380,5PLT,4.4				BRL0020JFO250-A	0.0
15	2	SKIRT,DOUBLER	160	100	3MM, S/S 304L	SHT0297VSL-B	0.8
14	1	BRK,TUBE,SYPHON,3"	250	8	Ø8MM, S/S 316L	RDB0001VSL-B	0.0
13	1	WASHER,FLAT-M8X1.6MM	1.6		S/S	M08016WSF-S	0.0
12	1	NUT,NYLOC-M8			S/S	M08000NTL-S	0.0
11	1	STUD,PROJECTION,WELD-M8X20MM	20		S/S 304L	M08020STP-S	0.0
10	1	PRO,CLAMP,ø8.5	70	20	2MM, S/S 304L	SHT0001THM-A	0.0
9	1	BDC,3",45°	35	200	34.8MM, S/S 316L	FLN0032VSL-A	0.0
8	1	TDC,RECESSED,3"	24	200	24MM, S/S 316L	FLN0016VSL-A	3.8
7	1	PRV,3",DN80	24	190	24MM, S/S 316L	FLN0028VSL-A	4.4
6	1	AIN,DN32,M10	20	127	Ø130MM, S/S 316L	FLN0138VSL-B	0.0
5	1	RAW,SCR-COIL,330X3.5MM	7570	330	3.5MM,S/S 304L	RAW03512SCR-S	70.6
4	1	RAW,SCR-COIL,330X3.5MM	6754	330	3.5MM,S/S 304L	RAW03512SCR-S	63.0
3	2	RING-ø2380,10E,200CNTR			3MM, S/S 304L	ROF0009GEN250-A	0.0
2	2	END,JFO-SHR,Ø2380,4.6	4804	1380	5.0MM,SANS 50028 - 7	END7878JFO250-A	0.0
1	1	BRL,JFO-SCR,ø2380,5PLT,4.4mm	7464	4980		BRL7878JFO250-A	1315

TOLERANCE UNLESS OTHERWISE STATED

LINEAR	0 to 20	21 to 200	201 to 1000	1001 to 3000	3001 to 13000	ANGLES
	±0.5	±1.0	±1.5	±2.0	±3.0	±1°

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PROJECTION | DRAWN: WMARKIE | DATE: 05/09/2007
SCALE: 1:35 | CHECK: | Vers. 0
ECR No: 7878 | APPRV: | Ver. 0

DESCRIPTION:
VESSEL-25000L,4.4CR,4.6CR
ø2380x6019,2

REV	DATE.	REVISIONS	BY
-3	30/7/07	Manlid note added	BV
-2	02/07/07	Center dims changed on Arrow K was 2605. Dims on front view was 980	WM
-1	27/06/07	Dims added for rings	WM

Welfit Oddy

DRAWING NR: VSL7878JFO250-A
FORMAT: A2H