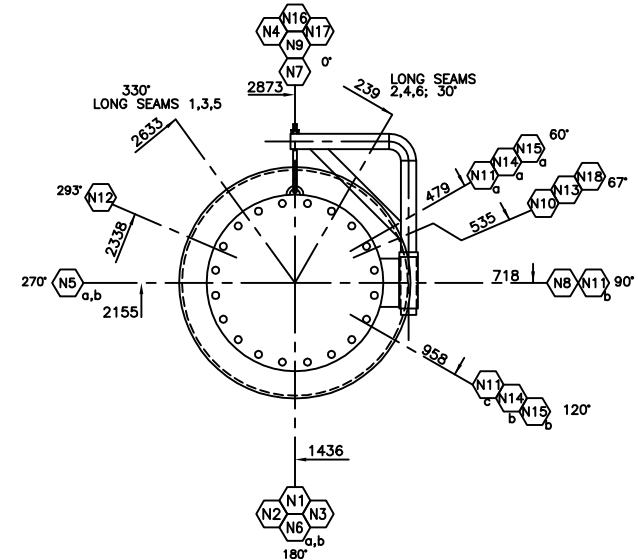
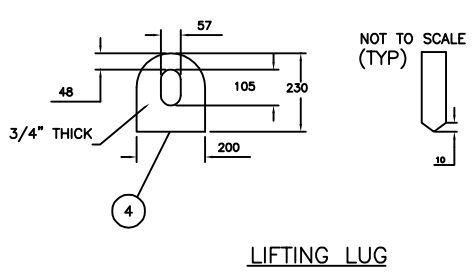


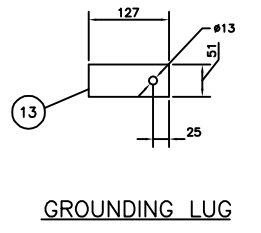
NOZZLE SHOP PROJECTION DETAIL				WELD DETAILS (n.t.s.)				NOZZLE SCHEDULE												MATERIAL LIST									
GENERAL NOTES				SLIP ON FLANGES*		TRANSITIONS		O'LETS		ALL NOZZLES		ALL NOZZLES																	
1. ALL DIMENSIONS ARE IN MILLIMETERS. 2. DRILL AND TAP 1/4" WEEPHOLE IN EXTERNAL REINFORCING PADS AS LOW AS POSSIBLE. 3. INSIDE EDGES OF NOZZLE NECKS SHALL BE ROUNDED TO 1/8" RADIUS MIN. OR ONE HALF PIPE WALL THICKNESS IF WALL THICKNESS IS LESS THAN 1/4" PER UW-16.3. 4. ALL FLANGE BOLT HOLES TO STRADDLE NATURAL CENTERLINES. 5. TOLERANCES AS PER STANDARD SHOP DWG.				COR-6		COR-6		COR-6,7		COR-6,7																			
				COR-6		COR-6		COR-6		COR-6																			
				COR-6		COR-6		COR-6		COR-6																			
				COR-6		COR-6		COR-6		COR-6																			
				COR-6		COR-6		COR-6		COR-6																			
ASME SECTION VIII, DIV. 1, 2004 EDITION				COATING/INSULATING																									
IMPACT TESTING NOT MANDATORY PER UG 20f (1-5)				REGISTERED WELD PROCEDURE : COR 6,7,20				EXTERNAL: CORLAC SPEC: 6000-001. SAND BLAST SPEC SSPC SP-6, SIL 7.																					
SERVICE: SWEET				VOLUME :10.95 cu m 387 cu ft				DEVOE 359, 3-5 mils. GLOSS BLACK																					
NDT: RADIOGRAPHY: 100% RT-1 AS PER UW-11(a)				MAWP: 100 psi @ 212°F (690 kPa @ +100°C/-29°C)				INTERNAL: CORLAC SPEC: 6000-002. SAND BLAST SPEC SSPC SP-5, 2-3 mils, SIL 7;																					
PWHT: 1150°F FOR 60 min				MDMT: -20°F @ 100 psi				2 COATS & DFT: DEVOE 253, 6-7 mils (TOTAL: 12-14 mils);																					
JOINT EFFICIENCY: LONG SEAMS = 1.00, CIRC. SEAMS = 1.00				HYDROTEST : 130 psi / 896 kPa																									
HEAD THK NOM. : 0.375" MIN. THK.: 0.3125"				VESSEL TYPE: INCLINED FREE WATER KNOCK OUT				ALL INTERNAL PIPING: CORLAC SPEC: 6000-002. SAND BLAST SPEC SSPC PS-6, SIL 7.																					
SHELL THK NOM.: 0.25" MIN. 0.20"				CRN: R8811.2				DEVOE 253, 8-12 mils.																					
CORR. ALLOW. : HEADS 0.0625" SHELL 0.0625"				INSULATION: NONE																									
NDE: UT: CAT. D WELDS ONLY																													



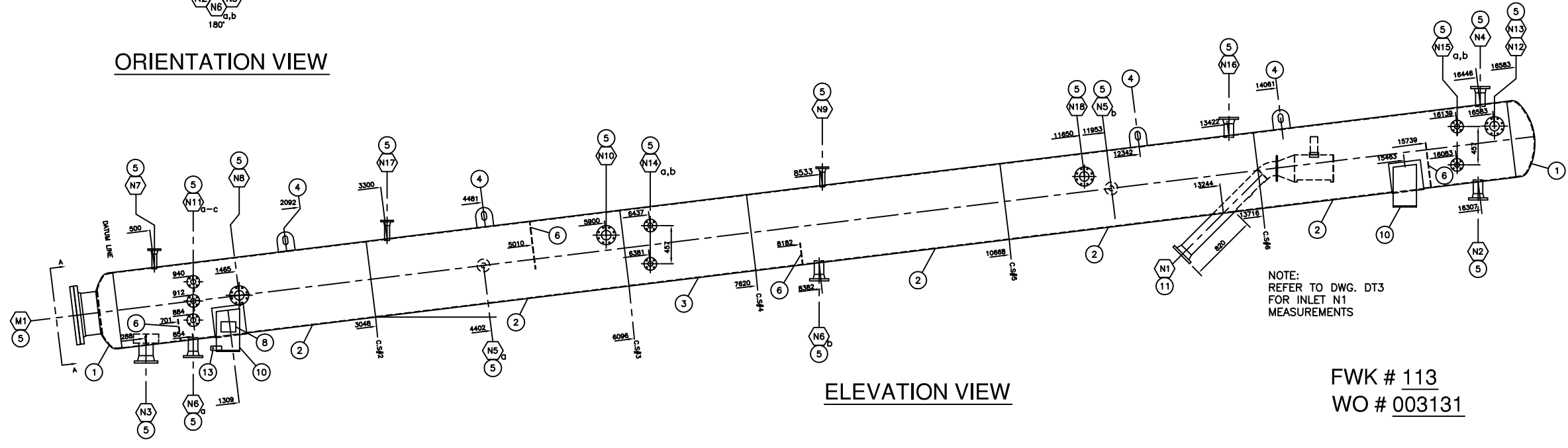
ORIENTATION VIEW



LIFTING LUG



GROUNDING LUG



ELEVATION VIEW

FWK # 113
WO # 003131

NO.	DATE(d/m/y)	DESCRIPTION	BY	INT.
15/12/05		ADDED RT TESTING, UPDATED TO ASME 2004 EDITION	KDN	
02/09/04		REVISED N5a,b	JHZ	AD
26/07/04		IFC	JHZ	AD
20/07/04		ISSUED FOR APPROVAL	JHZ	AD

CUSTOMER	FILE
NAVIGO ENERGY INCLINED FREE WATER KNOCK OUT	
TITLE	DATE
GENERAL ARRANGEMENT 914mm (36") O.D. x 16764mm (55'-0") LG. S/S INCLINED FREE WATER KNOCK OUT	04/07/20
SCALE	DRAWN
1:30	TRL
APPROVED	REV

APPROX. TOTAL 8687 lbs.
FULL WATER 32828 lbs.