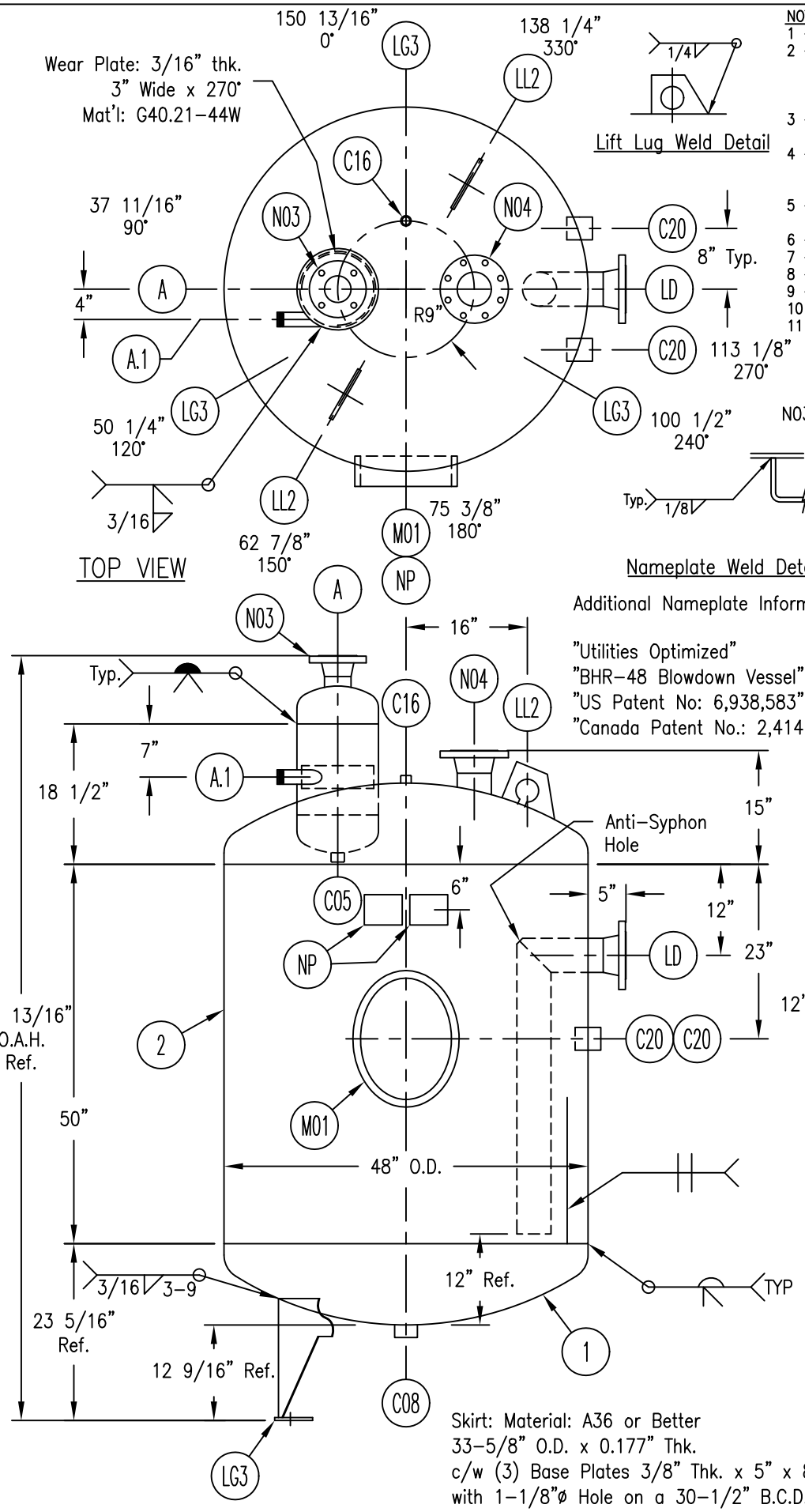


Skirt: Material: A36 or Better
33-5/8" O.D. x 0.177" Thk.
c/w (3) Base Plates 3/8" Thk. x 5" x 8"
with 1-1/8"ø Hole on a 30-1/2" B.C.D.

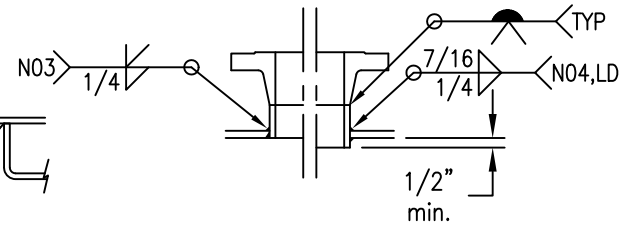
Lift Lug Weld Detail

NOTES
1 - 1° ON CIRC. = 0.4189"
2 - ALL DIMENSIONS ARE IN INCHES [MILLIMETRES IN BRACKETS]
TOLERANCE: COUPLING LOCATION +/- 1/16"
FLANGE LOCATION +/- 1/8"
HOLD DIMENSION +/- 1/16"
3 - M.D.M.T. -20°F. @ 100 PSI IMPACT TESTING IS EXEMPT PER UG-20(f).
4 - THIS VESSEL IS DESIGNED WITH SUPERIMPOSED STATIC, DYNAMIC, OR CYCLIC REACTIONS DUE TO EQUIPMENT OR MECHANICAL LOADING, OR PRESSURE OR THERMAL VARIATIONS = 0 LBS.
5 - THIS VESSEL IS DESIGNED WITH THERMAL, MECHANICAL, CYCLICAL, PRESSURE, OR FLUID SHOCK LOADINGS = 0 LBS.
6 - LUGS/SUPPORT MATERIAL: G40.21-44W.
7 - WELDING PROCEDURE: CIL-WP-1.
8 - MANWAY C.R.N.: #0H7379.5C
9 - PIPE CAP MATERIAL: SA-234-WPB TO B16.9
10 - COUPLING MATERIAL FOR "C20" TO BE SA-182-F304 to B16.11
11 - THIS VESSEL IS DESIGNED TO CONTAIN A NON-LETHAL GAS VAPOUR OR A NON-LETHAL LIQUID

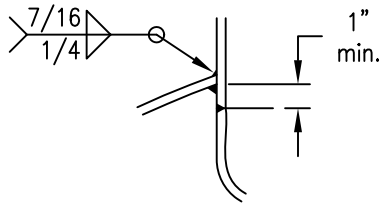
Nameplate Weld Detail

Additional Nameplate Information:

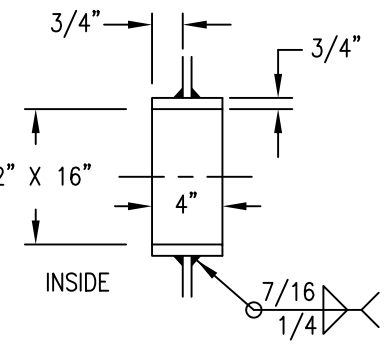
"Utilities Optimized"
"BHR-48 Blowdown Vessel"
"US Patent No: 6,938,583"
"Canada Patent No.: 2,414,611"



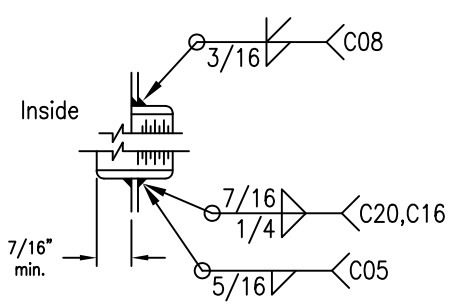
NOZZLE DETAIL



Chamber "A" Weld Detail



MANWAY DETAIL



COUPLING DETAIL

DESIGN SPECIFICATIONS

PRESSURE:	100 psi 689 kPa
TEMPERATURE:	650°F 343°C
PRESSURE (EXTERNAL):	0.0 psi
HYDROTEST PRESSURE:	130 psi 896 kPa

SHELL:

MATERIAL:	SA-516-70
ALLOW. STRESS:	18800 psi
JOINT EFF.:	0.70
CRSN. ALLOW.:	0.125"
NOM. THKS.:	0.375"

HEAD:

TYPE:	F&D
DISH. RAD:	42"
I.K.R.:	2-7/8"
MATERIAL:	SA-516-70
ALLOW. STRESS:	18800 psi
HEAD EFF.:	0.85
CRSN. ALLOW.:	0.125"
NOM. THKS.:	7/16"
MIN. THKS.:	0.375"

RADIOGRAPH:	NO
P.W.H.T.:	NO
AUTH. INSPECTOR:	YES
ASME SEC. VIII, DIV.1:	2007
HEAT No. REQ'D:	YES

O.I./SER. No.:

C.R.N.:

MATERIAL SPECIFICATIONS

MANHOLE COVER:	SA-516-70
MANHOLE COLLAR:	SA-106-C
PIPE:	SA-106-B
COUPLING:	SA-105
FLANGE:	SA-105
REINF. PLATE:	N/A
BOLT:	N/A
STUD:	N/A
NUT:	N/A
GASKET:	RED RUBBER

CAPACITIES

VOLUME:	400 I.G. 1816 ltrs.
WEIGHT:	1600 lbs. Empty 727 kg. Empty

FINISH

INTERIOR: AS WELDED
EXTERIOR: RED PRIMER

TOLERANCES U.N.O.	
X"	± 1/2"
X 1/2"	± 1/4"
X 1/4"	± 1/8"
X 1/8"	± 1/16"
X 1/16"	± 1/16"

U

BILL OF MATERIALS

KEY	ITEM NO.	QTY	DESCRIPTION		DWG. NO.
1		2	Head: 48" O.D. Flanged & Dished		
2		1	Shell: 48" O.D. x 49-3/4" Wide		
A		1	Pipe: 10" Std. c/w (2) 10" Std. Pipe Cap		See Note 9
A.1		1	Pipe: 1-1/2" Sch.160 c/w M.N.P.T.		
C05	CPHT100300XU	1	Coupling: 1" F.N.P.T. 3000# Half		
C08	CPHT200300XU	1	Coupling: 2" F.N.P.T. 3000# Half		
C16	CPFT075600XU	1	Coupling: 3/4" F.N.P.T. 6000# Full		
C20	CPFT200300XS	2	Coupling: 2" F.N.P.T. 3000# Full (S.S.)		See Note 10
N03		1	Pipe: 3" Sch.80 c/w 150# R.F.W.N. Flange		
N04		1	Pipe: 4" Sch.120 c/w 150# R.F.W.N. Flg.		Vent
LD		1	Pipe: 4" Sch.80 c/w 150# R.F.W.N. Flange		Loop Drain
LL2	LLTV050075QC	2	Lift Lug: 1/2" Thk.		
LG3	SKTA336250XC	1	Skirt c/w Qty. 3, Base Plates		
M01		1	Manway c/w 600# Cover, Gasket & Yoke		
NP	NMPN300463XB	2	Nameplate		
	BKPL300055XC	2	Nameplate Bracket		

Reference:
This drawing supersedes drawing PB4693
See drawing PA4820 for Base Layout

MK	DESCRIPTION	BY	DATE

REVISIONS

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Clemmer PV
Pressure Vessel
A DIVISION of CLEMMER STEELCRAFT TECHNOLOGIES INC., WATERLOO , ONTARIO

DESCRIPTION: 48" O.D. Vert. Blowdown Vessel			
CUSTOMER: Utilities Optimized			
PROJECT:			
ITEM NO.: BHR-48HM	DRN.: RG Dec 04/07	SCALE: 1:20	0
JOB NO.:	DWG. NO.: PB4819		