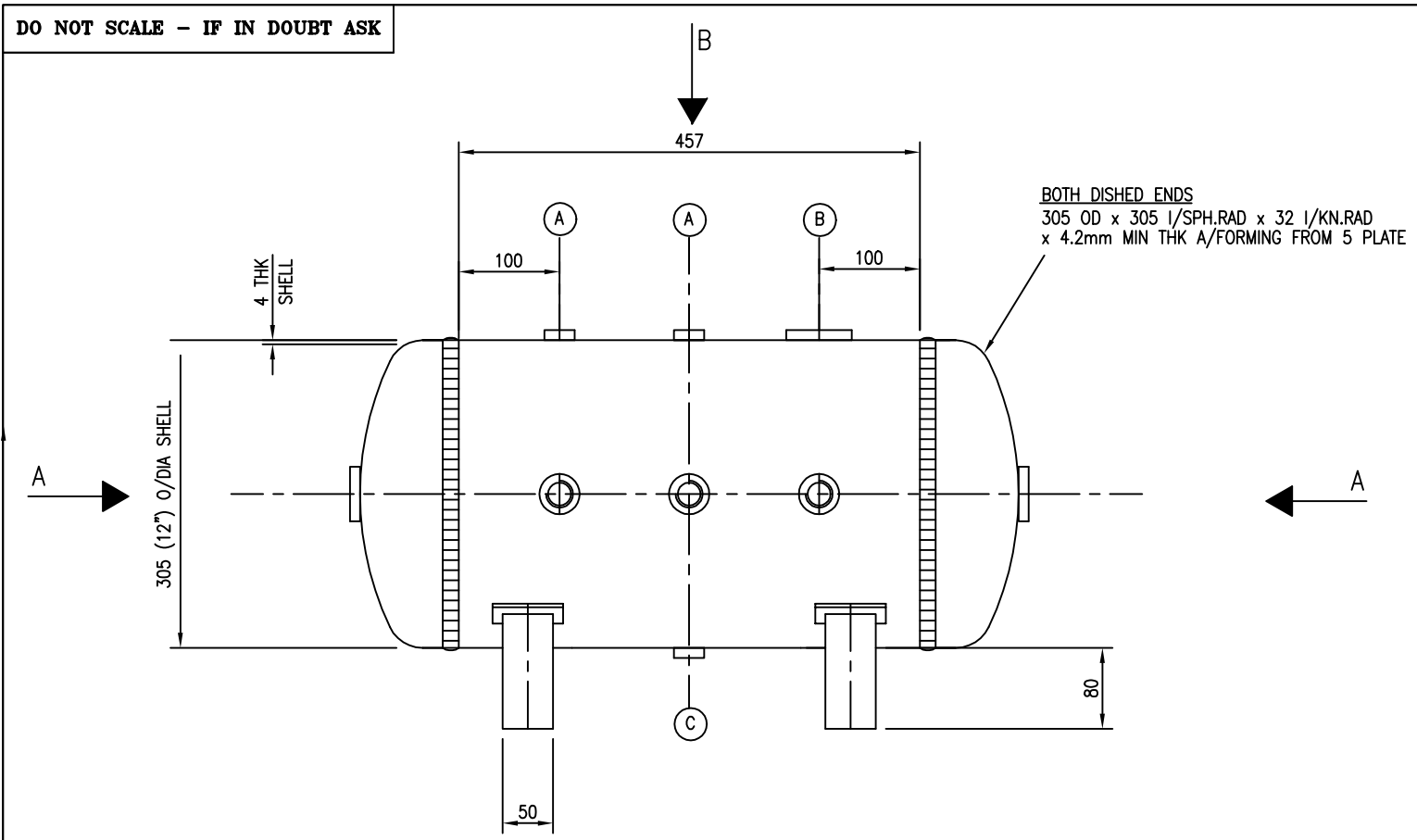
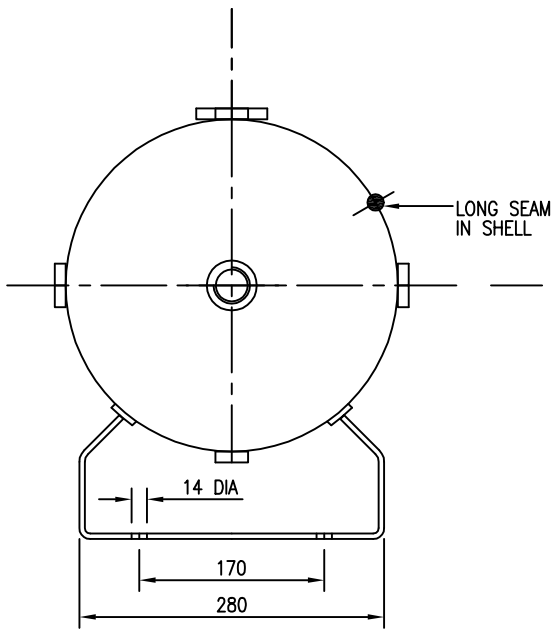
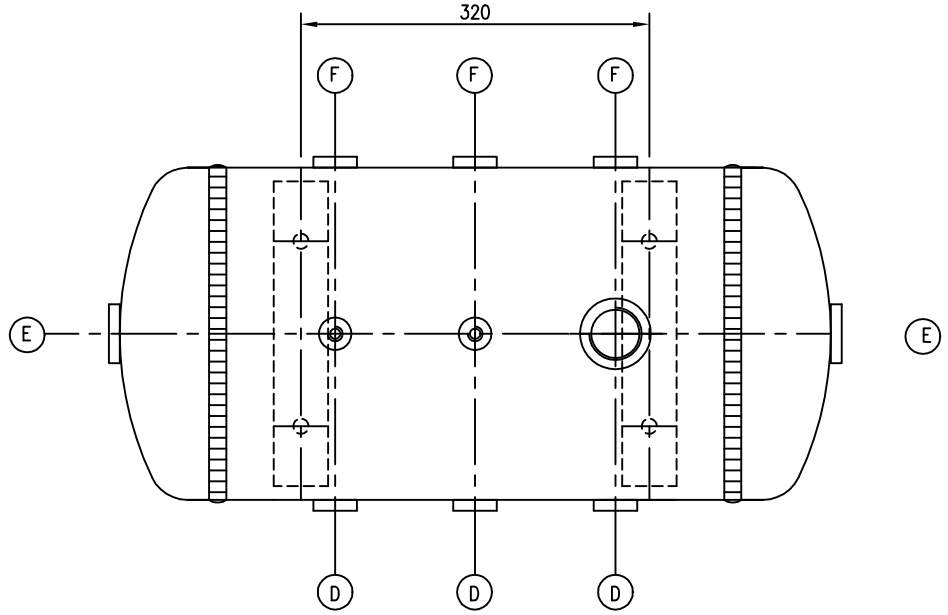
DO NOT SCALE – IF IN DOUBT ASK



FRONT ELEVATION



END VIEW ON ARROW A



PLAN VIEW ON ARROW B

!! NOTE !! POSITION OF NOZZLES MAY BE MOVED TO MEET CLIENT REASONABLE REQUIREMENTS PROVIDING THERE IS A MINIMUM OF 6x THE CALCULATED THK OF SHELL / HEAD BETWEEN WELDS AND THAT ALL OTHER CODE REQUIREMENTS ARE MET.

DESIGN DATA

DESIGN CODE		EN286–1:1998	
DESIGN PRESSURE	Barg	12	
DESIGN TEMPERATURE	°C	–10 to +85	
MAX WORKING PRESSURE	Barg	12	
WORKING TEMPERATURE	°C	–10 to +85	
CORROSION ALLOWANCE	mm	0.5	
JOINT EFFICIENCY		N/A	N/A
HYDRO TEST PRESSURE	Barg	18	
CAPACITY	Litres	40	
WEIGHT – EMPTY	Kg	35	
WEIGHT – FULL OF WATER	Kg	75	
PSV	Bar.Litres	480	
ADDITIONAL LOADS (FATIGUE)		N/A	
FLUID GROUP		LIQUID : N/A GAS : GROUP 2	
RISK CATEGORY		N/A	
CONFORMITY ASSESSMENT MODULE		N/A	
RADIOGRAPHY		NONE	
PWHT		NO	
WELD TESTS (M/C WELDS ONLY)		EVERY 50M OF WELD	
INSPECTION		AJ METAL PRODUCTS LTD	

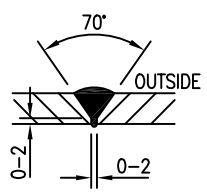
MATERIAL SPECIFICATIONS

SHELL / DISHED ENDS AND MISC BACKING PLATES	BSEN 10207 SPH265 (ALT) BS.1501–151–430A
COUPLINGS & PLUGS (SCREWED)	070M20
NOZZLE NECKS (PIPE)	N/A
PIPE FITTINGS	N/A
FLANGES	N/A
SUPPORT LEGS	BSEN.10025–S275JR (OR EQUAL)
ELECTRODES	SEE WELD PROCEDURES
MAXIMUM CARBON CONTENT OF ALL ASTM MATERIALS TO BE 0.25%	

GENERAL NOTES

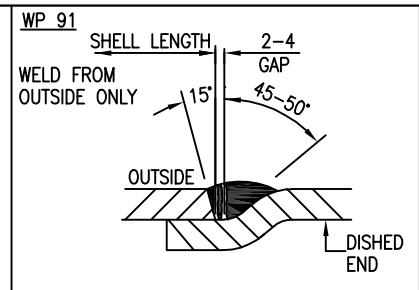
1. ALL DIMENSIONS ARE IN MILLIMETRES UNLESS STATED OTHERWISE
2. FOR TRUE ORIENTATION OF FITTINGS SEE END & PLAN VIEWS
3. TEMPERATURE OF TEST WATER AMBIENT.
4. THK OF PRESSURE COMPONENTS ARE JUSTIFIED USING EN286–1 1998
5. THIS PRESSURE VESSEL MUST BE PROTECTED AGAINST OVER PRESSURISATION BY MEANS OF A RELIEF VALVE.
6. NOZZLE OPENINGS TO BE PLUGGED / BLANKED FOR TRANSIT PROT'N.
7. DESIGN CALCULATIONS REFERENCE DOCUMENT No. 50–11/CALC.

WP 107
1st SIDE WELD INSIDE
GRIND BACK FROM OUTSIDE
2nd SIDE WELD OUTSIDE



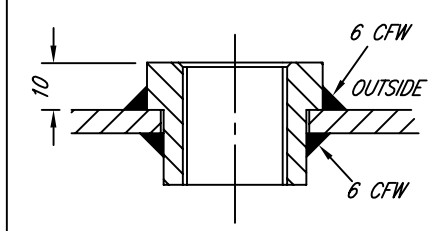
DETAILS OF SHELL LONG SEAM

WP 91



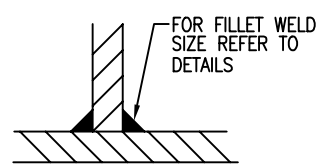
DETAILS OF D/END TO SHELL CIRC SEAMS

WELD PROCEDURE WPS 82A/103B



WELD DETAIL FOR NOZZLES A, B, C, D, & E

WP 82/108



WELD DETAIL MISCELLANEOUS FILLET WELDS

NOZZLE SCHEDULE

REF	SIZE	QTY	THREAD	SERVICE	COMMENTS
A	1/4"	1	BSPP	PRV/GAUGE	
B	1.1/2"	1	BSPP	INLET	
C	3/8"	1	BSPP	DRAIN	HALF COUPLING
D	3/4"	3	NPT	OUTLETS	
E	1.1/4"	2	BSPP	INSPECTION	COMP WITH PLUGS
F	3/4"	3	NPT	OUTLETS	

REV			REV										
1	18/08/08	GLH	2	07/10/13	FAS								
FIRST ISSUE FOR REVIEW			INLET CHANGED TO 1.1/2" AS PER PAUL AND IAN										

RECEIVER FINISH	REFERENCE DRAWINGS
INSIDE : CLEAN & DRY – LEFT SELF COLOUR OUTSIDE : PAINT ONE COAT OF GREY PRIMER	

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CLIENT: AJ METAL PRODUCTS LIMITED

TITLE: GENERAL ARRANGEMENT & DETAILS OF STANDARD 40 LITRE NOMINAL CAPACITY HORIZONTAL AIR PIG

CLIENTS ORDER/ CONTRACT No.		VESSEL REF. No.	
DRAWN: GLH	CHKD: DAG	DATE: 18/08/08	SCALE: 1:5
DRG No. 152		ISSUE: 1	REV: 1

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