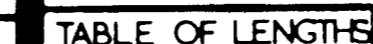


FINAL ASSEMBLY



WEIGHT TABLE			
UNIT TYPE	WEIGHT IN POUNDS	WEIGHT IN KILOGRAMS	TOTAL WEIGHT OF BARS
WH3605RR	285 lb	305 lb	
	130 KG	138 KG	
WH3610RR	405 lb	440 lb	
	184 KG	200 KG	
WH3615RR	535 lb	590 lb	
	242 KG	267 KG	
WH3620RR	665 lb	740 lb	
	301 KG	325 KG	
WH3625RR	795 lb	885 lb	1590 lb
	360 KG	401 KG	.720 KG

CERTIFIED FINAL STAMP

CODE, SPECIFICATION, CLASS ETC	1 BFT (GB) LTD	MFG STD	MID	2 ASME SECTION VIII	3 TEMA 'R'	
SERVICE CONDITIONS	SHELL	HEAVY GAS OIL	TUBE	C.T.W.		
INSPECTION AUTHORITY AND REQUIREMENTS	1	LLOYDS (FULL)			MATERIALS	TACK-UP
	2	PRITCHARD - RHODES (FULL)			FINAL DIML	HYDROSTATIC
	3	GKN BIRWELCO LTD.			MATERIALS	TACK-UP
					FINAL DIML	HYDROSTATIC
RADIOGRAPHY	GAMMA-RAY					
YES <input checked="" type="checkbox"/>	EXPOSED 'TACK-UP'	SPEE	###	100%	YES	SHELL & TUBE
WELDING PROCEDURE	1 BFT (GB) LTD	MFG STD	MID	2 ASME	IX	
FOR CARBON ON STEEL - STANDARD WELD- PROCEDURES MIDO-SMHO-QMHO APPLY	FOR OTHER MATERIALS STANDARD PROCEDURE AS DIRECTED BY THE WELDING ENG.			228 TPF	- TUBE WELDS	
				230 TPF	- SHELL WELDS.	
WELDERS QUALIFICATION	ASME IX		MATERIAL RECD.	YES		
SPECIAL TESTS	MECHANICAL		NO	CHARPY IMPACT	NO	
HYDROSTATIC TESTING	1 SHELL ENDS	NO	NO	2 WATER	YES.	
EXCHANGERS TO BE THOROUGHLY DRAINED AND DRIED OUT BEFORE DESPATCH						
FINISH	AS REFERENCE		A	BELOW		
A. HOME (1) ONE COAT OF RED OXIDE PRIMER SHELL EXTERNAL ONLY B. EXPORT (1) ONE COAT OF RED LEAD PRIMER SHELL EXTERNAL ONLY C. (1) ONE COAT OF ZINC CHROMATE PRIMER SHELL EXTERNAL ONLY D. DO NOT PAINT E. OTHER FINISH (SPECIFY)						
PRE-HEAT	YES <input checked="" type="checkbox"/>					
DETAILS	150°C SHELL & TUBE WELDS					
STRESS RELIEF	YES <input checked="" type="checkbox"/>	METHOD	ELECTRIC RESISTANCE	FURNACE	TEMP (MAX) AT TIME OF LOADING	300°C
SHELL ALL WELDS LOGICAL	SHELL - COMPLETE		INTERNALS - BUTT WELDS LOGICAL	INTERNALS - COMPLETE		
STRESS RELIEF TEMPERATURE	690°C		HEATING RATE	200°C PER HOUR MAX		
HOLDING TIME	1 HOUR	COOLING RATE	250°C PER HOUR ABOVE 300°C IN FURNACE BELOW 300°C PERMISSIBLE TO COOL IN STILL AIR			
REMARKS	FOR UK PORT					R6-2244J
SHELL ASSY & TUBE ASSY, 5% Cr 1/2% Mo						
SERVICE	CLARIFIED OIL COOLER		CORROSION ALLOW.	SHELL	1/8"	TUBE 1/8" EXCLUDING 1/16"

NAVY ORDER

MAX PRESS. 1000 MAX TEMP. 100 MND TEST ☒

SPEC. ALL 100 TUBE 100

SPEC. ZR 100 SPEC. SH 100

MAX PRESS. ORDER NO. 100 SURFACE NO. 100

SERIAL 100 YEAR BUILT 100

CULC. SYMBOLS 100 YEAR 100

PURCHASE ORDER 100

NOT

MC1556-2

MAX PRESS		MAX TEMP		HYD TEST	
SWELL	10.3	BARS	39.9 °C	17.5	BARS
TUBE	6.9	BARS	121 °C	10.4	BARS
YES		NO	YES		NO
MAKERS CODE: B72249/01		SURFACE		33	
SERIAL: 51-E220-825-24		YEAR BUILT		1972	
COOL CYCLES: ASME VIII		ITEM		04-E-12	
PURCHASE ORDER: 7-2233-2					

LETTER	REVISION	BY	DATE
A	WELD PREPS SHELL & TUBE ASSEMBLIES MODIFIED BUTT WELDS WERE LAP JOINTS	MM	7-8-78
B	EARTHING BOSS ADDED.	MM	7-8-78
C	DRG CHANGED TO SUIT CUSTOMER'S REQUIREMENTS ITEM 10 ADDED	MM	11-8-78
D	COOL Plate Joint now T&G 1/4" L&B WAS 26-3/8"	MM	21-7-78
E	SHELL HYD TEST PRESS WAS 15.5 BARS	MM	2-10-78

THESE DRAWINGS ARE THE DESIGN SHOWN HEREIN ARE THE PROPERTY OF
BROWN FINTUBE (GREAT BRITAIN) LTD.
 "THE DRAWING IS LENT WITHOUT CONSIDERATION EITHER THAN THE BORROWER HAS A FEE
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 OR INDIRECTLY NOR USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT IS
 SPECIALLY SPECIFIED."
 "THE APPARATUS IN THE DRAWING IS COVERED BY ONE OR MORE PATENTS IN
 PATENT APPLICATIONS."

F	1 CUT A TUBIST NOTE MODIFIED	MM	21-7-78
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DRAWN BY	AGGneaves	DATE	3.8.72
CHECKED BY	AmFeinley	DATE	4-8-72
APPROVED BY		DATE	

NEW DESIGNATION	51-1E220-825-24	NO OF LINES
ENGINEERING REF	1TH3625RR-24	Two

CUSTOMER:	PRITCHARD - RHODES LTD.
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DRAWING NUMBER	SHEET /	REV
B722420/01-1	OF	0