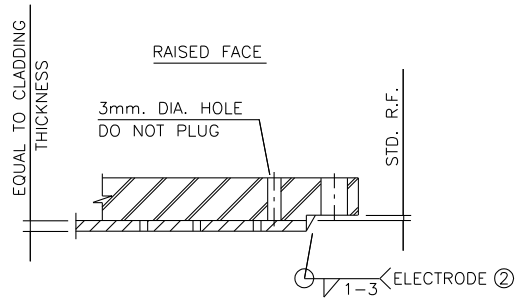
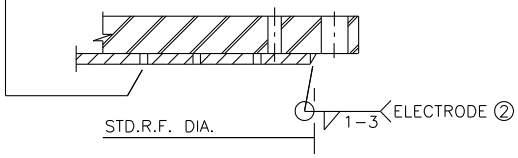
ALLOY SHEET ON CARBON STEEL
BLINDFLANGE "G"

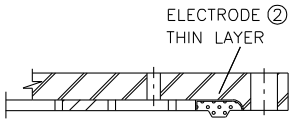


PLATE

PLUG WELDS INTERMEDIATE ALLOY WELD.
(ELECTRODE ②). FOR VACUUM SERVICE ONLY.
PITCH OFF PLUGS TO BE DETERMINED BY VENDOR.
UNLESS OTHERWISE NOTED ON VESSEL DRAWING.



TONGUE GROOVE OR RING JOINT
(SEE ALSO DETAIL "E")



ALLOY DEPOSIT

DESIGN NOTES:

D1.THESE DETAILS ARE DESIGNED FOR PRESSURE VESSEL STEEL PLATES. CLADDED WITH AUSTENITIC STAINLESS STEEL TYPES 304L.316L AND 347. FERRITIC STAINLESS STEEL. TYPES 405,410 AND ASME SB.127 (MONEL)

D2.MINIMUM DIAMETER OF CLAD VESSELS IS 610mm. AS FUL ACCESS MUST BE AVAILABLE FOR WELDING AT LEAST ONE MANWAY.

D3.WELDING PROCEDURE "B" MAY BE FOR PLATE THICKNESS OF 8mm. AND LESS, FOR VESSELS DESIGNED FOR 232 C ÅND LOWER TEMPERATURE. PROCEDURE "A" SHALL BE USED IN ALL OTHER CASES. DO NOT USE PROCEDURE "B" ON ASME SB.127 MONEL CLAD PLATES.

CONSTRUCTION NOTES:

C1.WELDING DETAILS ARE NOT INTENDED TO PROVIDE A COMPLETE WELDING PROCEDURE : ADDITIONAL DETAILS OF PROCEDURE AND EVIDENCE OF QUALIFICATION OF THE PROCEDURE IN ACCORDANCE WITH SECTION IX OF THE ASME BOILER AND PRESSURE VESSEL CODE SHALL BE FURNISHED BY THE VESSEL FABRICATOR.

C2.ELECTRODES SHALL BE SELECTED AS FOLLOWS

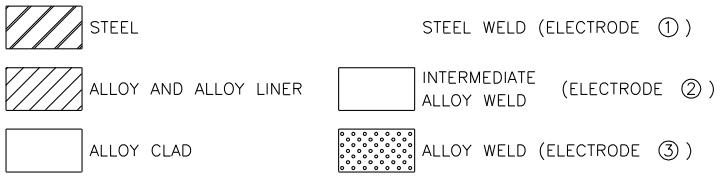
CLADDING ALLOY	① STEEL	② INTERMED ALLOY	③ ALLOY
ASME.SA.240 TYPES 405 and 410.	SAME AS USED FOR SHELL	ASME SA.298 E 309 or E 310	ASME SA.298 E 309 or E 310
ASME.SA.240 TYPES 304 and 304L.			ASME SA.298 E 308L
ASME.SA.240 TYPES 316 and 316L.		*	ASME SA.298 E 316L
ASME.SA.240 TYPE 321 and 347.			ASME SA.298 E 347
ASME.SB.127 (MONEL)		MONEL 140 or 190	MONEL 140 or 190
ALLOY 20 Cb. (CARPENTER 20 Cb)		ASME SA.298 E 310 Mo	ALLOY 20 Cb

* FOR STEP No.3 IN PROCEDURE "B" USE ASME SA.298 E310Mo ELECTRODES.

C3.TO MINIMIZE ALLOY DILUTION ALL ALLOY WELDS EXPOSED TO CORROSIVE FLUID SHALL BE MADE WITH TWO PASSES (MINIMUM) OF ALLOY. ③

C4.IN NOZZLE DETAILS "C","D" AND "E" THE DEPOSIT IS MADE IN A MACHINED GROOVE FOR WELDING, AND FINISHED FLANGE THICKNESS IS ANSI STANDARD.

LEGEND



STANDARD CONNECTIONS AND WELDING DETAILS FOR CLAD STEEL VESSELS

ISSUE	DATE		
4	1 DEC'00	2 OF 2	BN-DS-A 7