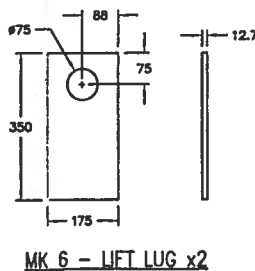
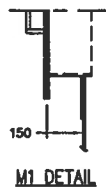


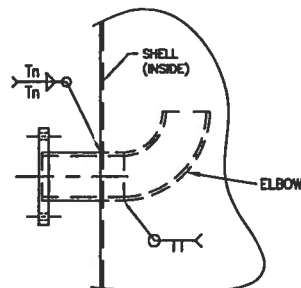
TYPICAL ROOF/SHELL NOZZLE DETAIL



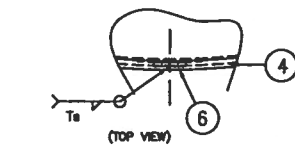
MK 6 - LIFT LUG x2



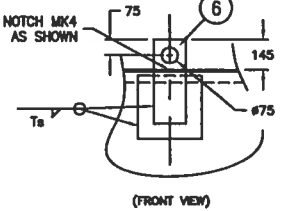
M1 DETAIL



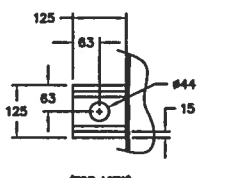
N6 DETAIL



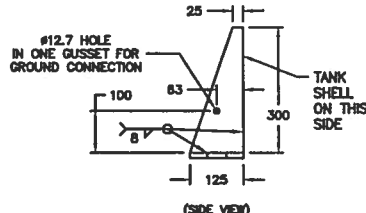
MK 6 - LIFT LUG DETAIL



MK 6 - LIFT LUG DETAIL



MK 6 - LIFT LUG DETAIL



MK 7 - ANCHOR CHAIR x4

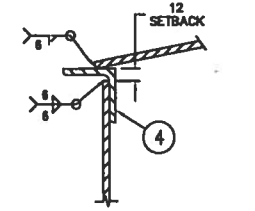
CONTENTS: SULFURIC ACID  
TANK CAPACITY: 106,800L

MK 8 DETAIL

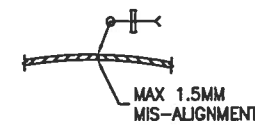
API STD 650			
APPENDIX	J	S	YEAR MFG.
EXTENSION & REV.	10	EXTENSION 1988	2007
DIAMETER	4000 MM	HEIGHT	8500 MM
CAPACITY	670 BBL	106,800 L	
MAX. SPEC. GRV.	1.83	DESIGN HT.	7750 MM
DES. PRESSURE	ATMOSPHERIC		
MAX. OP. TEMP.	40° C		
MFG. S.N.		TANK NO.	
SHELL COURSE	THICKNESS	MTL	
1	6.4 MM	316L	
2	6.4 MM	316L	
3	6.4 MM	316L	
4	6.4 MM	316L	
5	6.4 MM	316L	

MFG. BY WESTEEL REGINA SK.

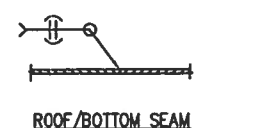
NAMEPLATE DETAIL



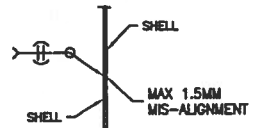
ROOF TO SHELL



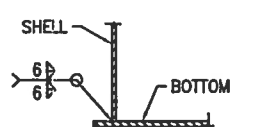
VERTICAL SEAMS



ROOF/BOTTOM SEAM



SHELL TO SHELL



ROOF TO SHELL SEAM

BILL OF MATERIALS					
MK.	QTY.	PART NO.	DESCRIPTION	MAT'L	REMARKS
1	1	533158	7.9 PLT. x 4015 O.D. CONED - FLAT $\phi$ = 4100	T316L SS	ROOF
			FLAT: 7.9 PLT. x 2438 W. x 4140 LG. (2 PCS REQ'D) - PER ROOF LAYOUT PAGE 2		
2A	8	533154	6.4 PLT. x 1829 W. x 6300 LG.	T316L SS	SHELL
			2 PCS. TO MAKE 1 COURSE - CUT TO 1829 W. x 12,586 LG. - PER SHELL LAYOUT PAGE 2		
2B	2	533155	6.4 PLT. x 1219 W. x 6300 LG.	T316L SS	SHELL
			2 PCS. TO MAKE 1 COURSE - CUT TO 1219 W. x 12,586 LG. - PER SHELL LAYOUT PAGE 2		
3	1	533157	12.7 PLT. x 4075 O.D. FLAT	T316L SS	BOTTOM
			FLAT: 12.7 PLT. x 2438 W. x 4140 LG. (2 PCS REQ'D) - PER FLOOR LAYOUT PAGE 2		
4	1	533159	ANGLE - [1/4"x2"x2"] x 13,220 LG.	T316L SS	TOP RING
			ROLL TO 3987 I.D. - LEG OUT		
5	1	530913	NAMEPLATE - API 650 - 18 GA. x 155 x 155	SS304	DWG: 20284-NP
			c/w NAMEPLATE BRACKET	T316L SS	DWG: 20284-PRT
			c/w RIVETS		
6	2	MAKE	LIFT LUG - PER DETAIL	T316L SS	DWG: 20284-PRT
			c/w 6.4 PLT. x 300 W. x 300 LG.	T316L SS	REPAD
7	4	MAKE	ANCHOR PLATE - PER DETAIL	T316L SS	DWG: 20284-PRT
			ANCHOR GUSSET - PER DETAIL	T316L SS	DWG: 20284-PRT
8	2	533185	DECAL - SULFURIC ACID	5 YR VINYL	DWG: 20284-DCL

NOZZLE SCHEDULE							
MK.	QTY.	PART NO.	SIZE	RATING	DESCRIPTION	MAT'L	REMARKS
M1	1	-	750# (30")	API	SHELL MANHOLE	T316L SS	DWG: 20284-MHS
	1	530171	6.4 PLT.		REPAD c/w TEST HOLE	T316L SS	DWG: 20284-PRT
	1	530945	6.4# (1/4")	150#	HALF COUPLING	A182-316L	TEST FTG.
	1	-	3.0 THK.		RING GASKET	VITON	DWG: 20284-GSK
M2	1	-	610# (24")	API	ROOF MANHOLE		DWG: 20284-MHR
	1	-	3.0 THK.		RING GASKET	VITON	DWG: 20284-GSK
N1	1	271425	203# (8")	150#	RFSO	A182-316L	ROOF N. VENT
	1	533186	203# (8")	SCH80S	SM'LESS PIPE x 170 LG.	A312-316L	150 EXT. PROJ.
	1	271433	203# (8")		FLANGE PROTECTOR	POLY.	FLUSH INT. PRJ.
N2	1	530130	51# (2")	150#	RFSO	A182-316L	FILL
	1	533183	51# (2")	SCH160	SM'LESS PIPE x 160 LG.	A312-316L	125 EXT. PROJ.
	1	271429	51# (2")		FLANGE PROTECTOR	POLY.	25 INT. PROJ.
N3	1	533188	76# (3")	150#	RFSO	A182-316L	FILL
	1	533187	76# (3")	SCH80S	SM'LESS PIPE x 160 LG.	A312-316L	125 EXT. PROJ.
	1	271430	76# (3")		FLANGE PROTECTOR	POLY.	25 INT. PROJ.
N4	1	530136	152# (6")	150#	RFSO	A182-316L	LEVEL
	1	533182	152# (6")	SCH80S	SM'LESS PIPE x 180 LG.	A312-316L	150 EXT. PROJ.
	1	271432	152# (6")		FLANGE PROTECTOR	POLY.	25 INT. PROJ.
N5	2	530130	51# (2")	150#	RFSO	A182-316L	SUCTION/DRAIN
	2	533183	51# (2")	SCH160	SM'LESS PIPE x 160 LG.	A312-316L	125 EXT. PROJ.
	2	530945	6.4# (1/4")		HALF COUPLING	A182-316L	25 INT. PROJ.
	2	271429	51# (2")		FLANGE PROTECTOR	POLY.	TEST FTG.
	2	MAKE	6.4 PLT.		REPAD	T316L	DWG: 20284-PRT
N6	1	533189	102# (4")	150#	RFSO	A182-316L	OVERFLOW
	1	533190	102# (4")	SCH80S	SM'LESS PIPE x 200 LG.	A312-316L	150 EXT. PROJ.
	1	533191	102# (4")	SCH80S	WELD ELBOW 90° - L.R.	A312-316L	50 INT. PROJ.
	1	530945	6.4# (1/4")		HALF COUPLING	A182-316L	TEST FTG.
	1	271431	102# (4")		FLANGE PROTECTOR	POLY.	
	1	MAKE	6.4 PLT.		REPAD	T316L	DWG: 20284-PRT
N7	1	530130	51# (2")	150#	RFSO	A182-316L	LEVEL
	1	533183	51# (2")	SCH160	SM'LESS PIPE x 160 LG.	A312-316L	125 EXT. PROJ.
	1	530945	6.4# (1/4")		HALF COUPLING	A182-316L	25 INT. PROJ.
	1	271429	51# (2")		FLANGE PROTECTOR	POLY.	TEST FTG.
	1	MAKE	6.4 PLT.		REPAD	T316L	DWG: 20284-PRT

- NOTES:
- TANK DESIGNED AND CONSTRUCTED USING API 650 APPENDIX J & S  
C.A.: 3.2 mm MAX OPERATING TEMP 40° C  
CAPACITY: 106,800 L 617 BBL. MIN. DES METAL TEMP N/A  
MAX SPEC. GRAVITY 1.83 DESIGN PRESSURE: ATMOSPHERIC
  - X-RAY: FLOOR SEAMS: 100% VERTICAL SEAMS + T JOINTS: 100%  
HORZ. SEAMS: 2 x 432MM SPOT / SEAM
  - DYE PENETRANT: T- JOINT, ROOF/ SHELL JOINT.
  - AIR/SOAP TEST 14 kPa MIN. 21 kPa MAX.
  - HYDROTEST TANK WITNESSED BY TANK OWNERS REPRESENTATIVES  
PICKLE AND PASSIVATE WELDS ONLY
  - EXTERNAL FINISH: GRIND WELDS SMOOTH, PICKLE AND PASSIVATE WELDS ONLY
  - ESTIMATED SHIPPING WEIGHT: 10,330 KGS (22,770 LBS)
  - TANK INTERIOR TO BE PASSIVATED AFTER HYDRO TEST BY OTHERS.
  - QTY FOR THIS ORIENTATION: 1 TOTAL QTY: 2  
TANK TAG: S220A
  - ANCHOR BOLTS SUPPLIED BY OTHERS.

NO.	DATE	REVISION/APPROVALS	BY	CHK'D
B	07/01/11	ISSUED FOR PRODUCTION	MK	SB
D	07/01/11	1/4" REL. TO 900 FROM SHELL, ANCHOR BOLT WTS 22#	MK	SB
C	07/01/11	FLATE LAYOUT ON PAGE 2 COMPLETED	MK	SB
B	07/01/11	CONSTRUCT CORRECTIONS	MK	SB
A	07/01/11	TO CUSTOMER FOR APPROVAL	MK	SB

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ISSUED BY: MK	ISSUED TO: SB	CUSTOMER P.O. NO.: 026227	REVISION NO.: 0
DRAWING TITLE: 106,800 L API 650 S.V.S.W. TANK 4000 DIA. x 8500 SHELL HEIGHT	DATE: 07.07.11	DWG NO.: 20284A	REV: 0
CUSTOMER: COMSTOCK - CITY OF WINNIPEG	TANK NO: S220A	PAGE 1 OF 2	

