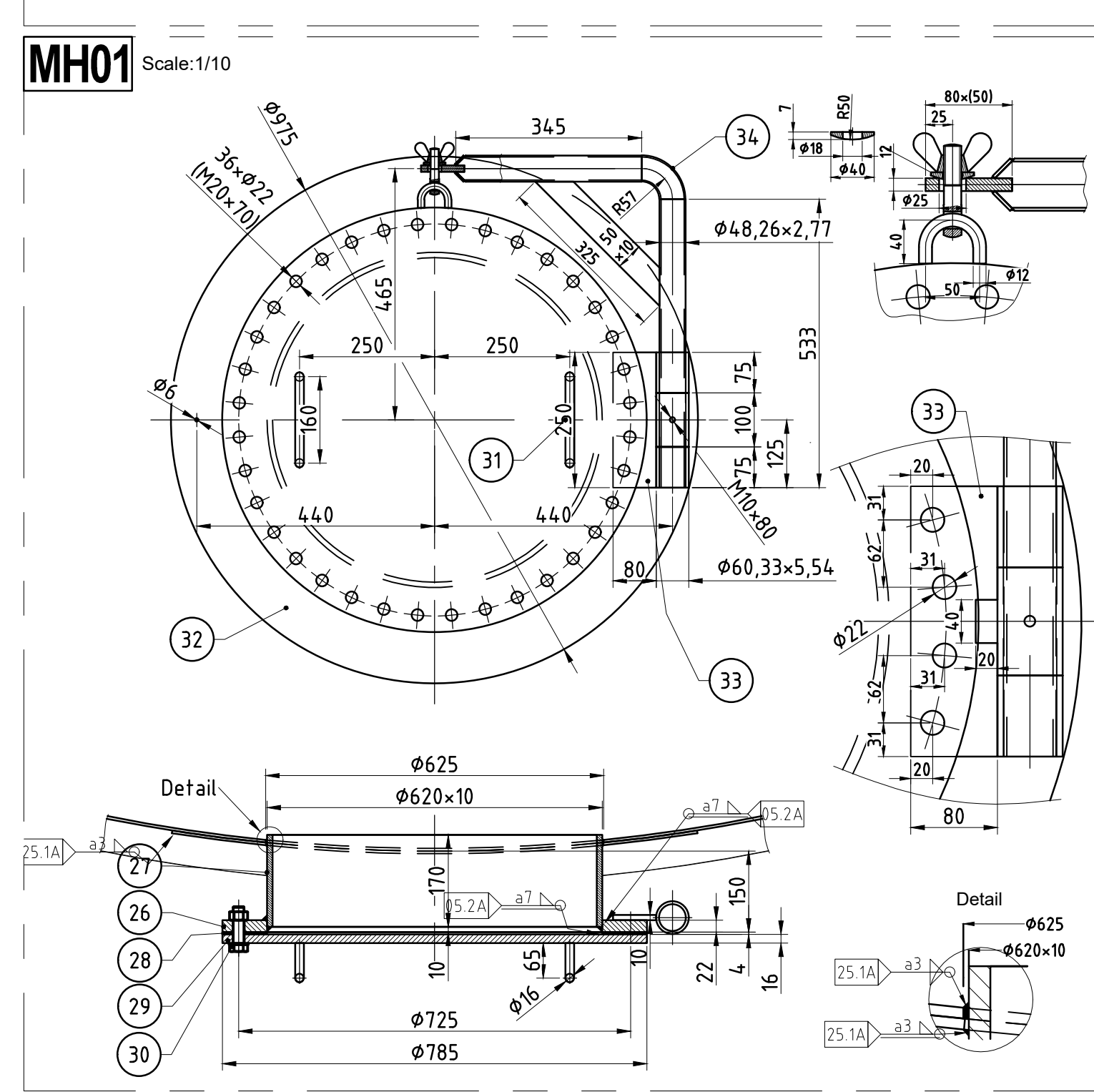
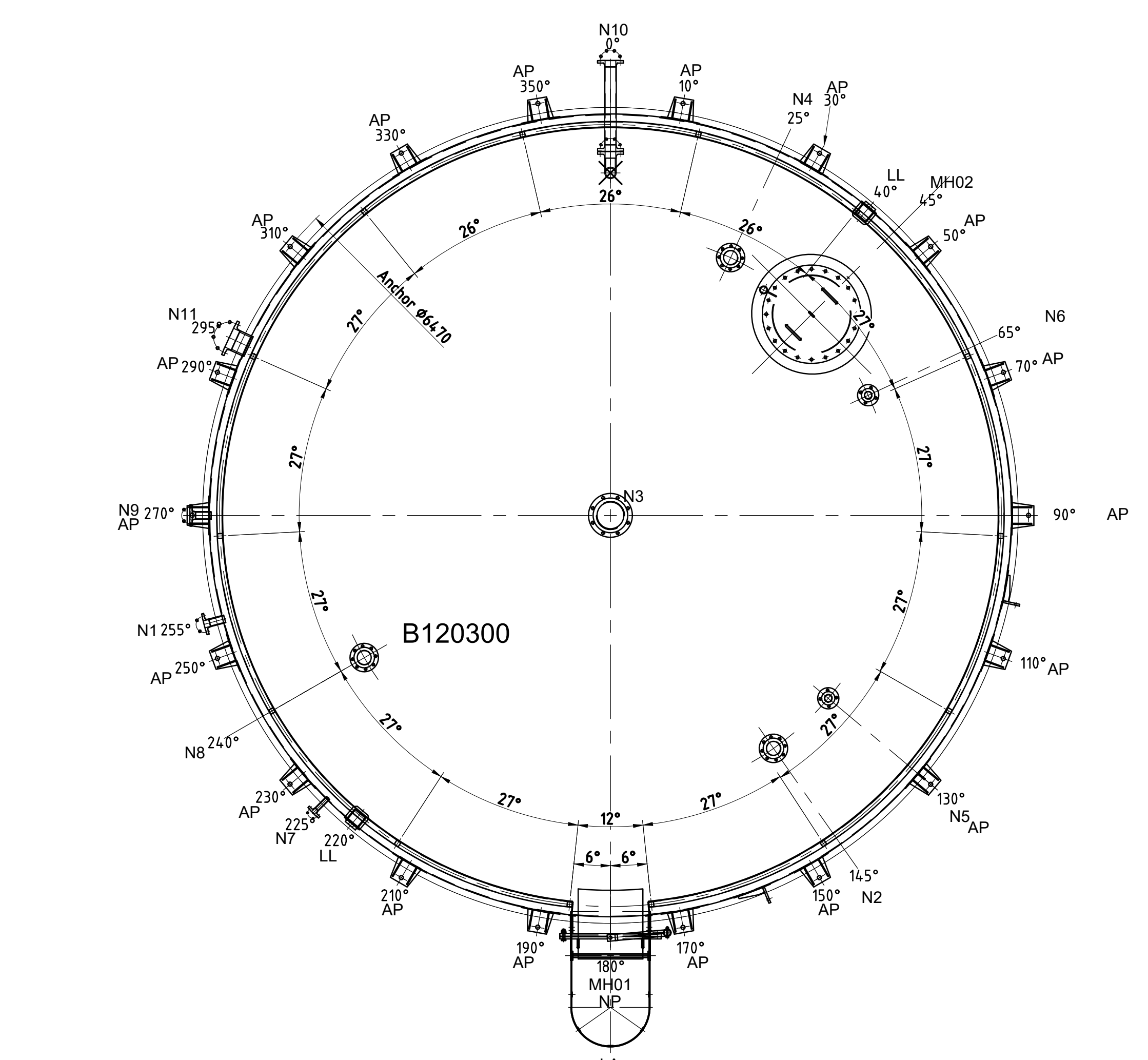
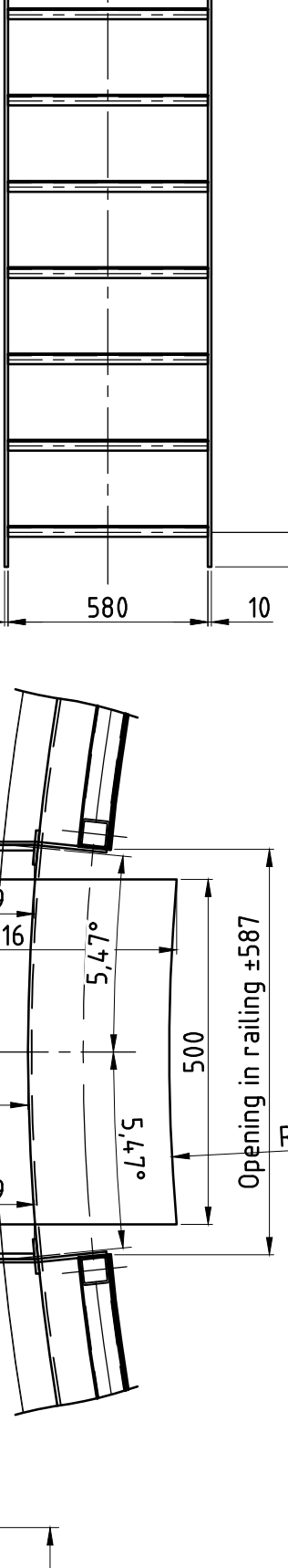
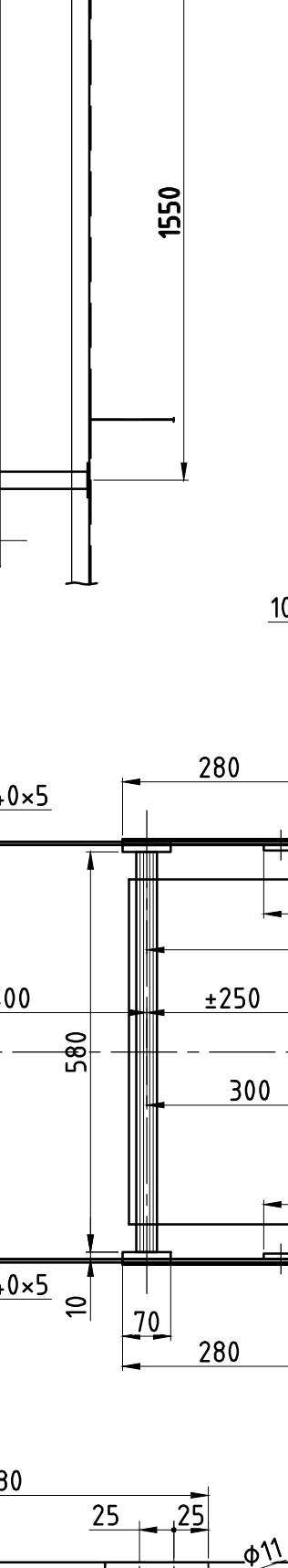
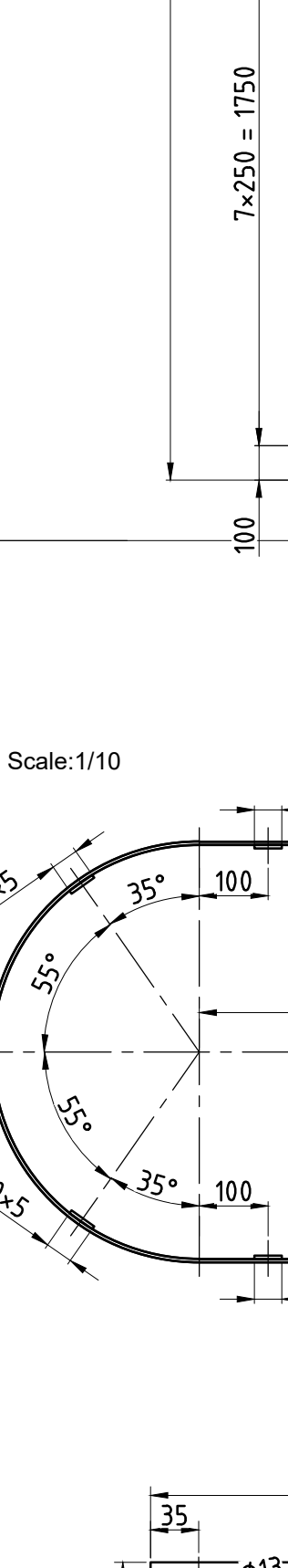
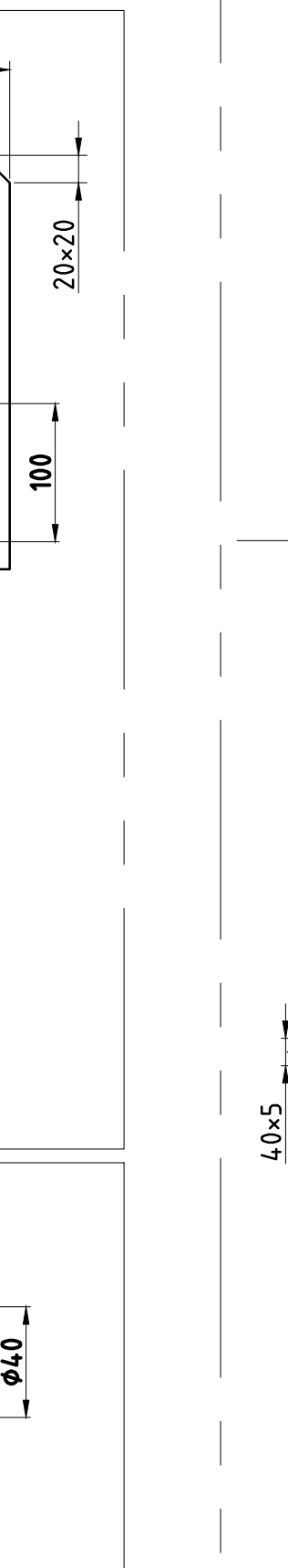
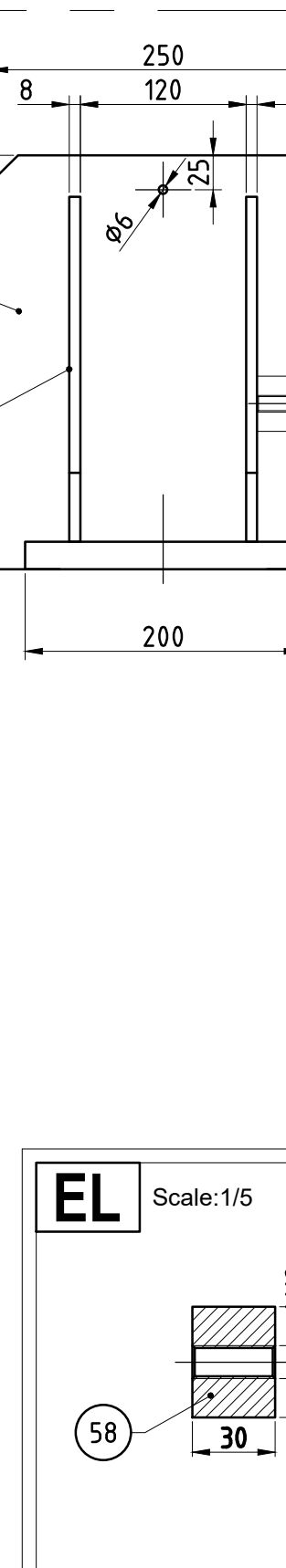
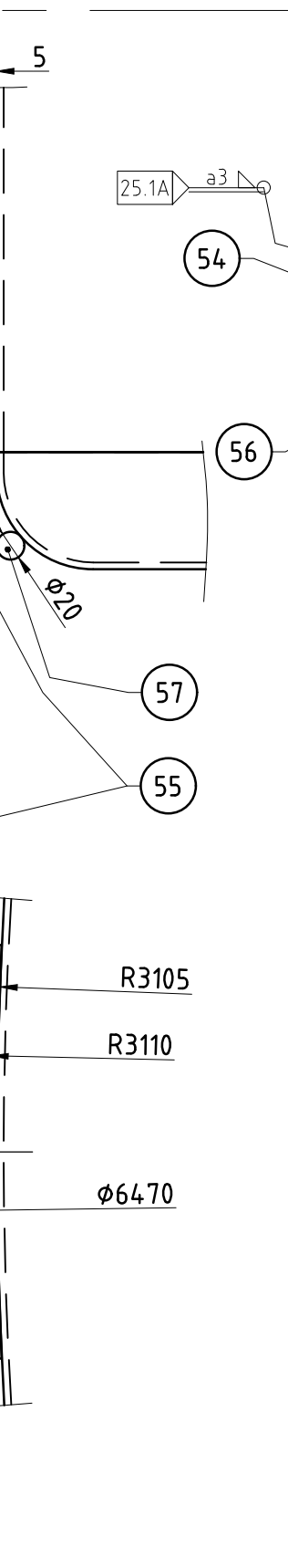
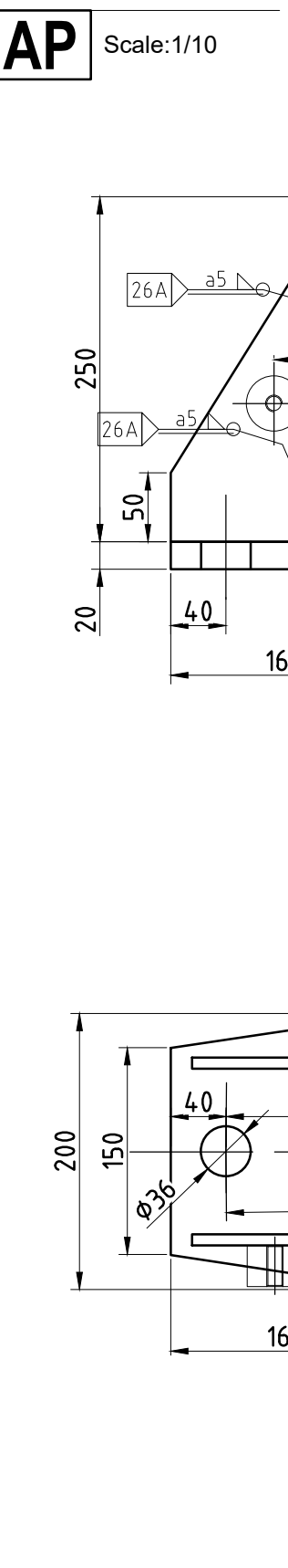




POS. NUMBER	DN	PN	DESCRIPTIONS
N2	1	50	Spare
N2	1	100	10 Connection to Z020200
N3	1	200	10 Vent connection
N4	1	100	16 Level transmitter radar
N5	1	50	16 Catalyst connection
N6	1	50	16 Level switch HH
N7	1	25	40 Sample connection
N8	1	100	16 Crude bioreactor (in off spec)
N9	1	50	16 Level switch LL
N10	1	80	16 Drainage
N11	1	150	16 Outlet product
MH01	1	600	... Manhole bolted with davit
MH02	1	600	... Manhole on top
LL	4		Lifting lug
NP	1		Nameplate
AP	18		Anchors
EL	1		Earth ring lug
TL	1		Tailring lug



Welding Details			
Tank Construction	Plate - Tank	Pipe - Tank/Flange	Pipe - Pipe
TIG - Simultaneous nozzle 1/8" 2.5 - 6.5" Horizontal ① TIG with filler metal ② TIG without filler metal Vertical ① TIG with filler metal ② TIG without filler metal Plasma 1/8" 2.5 - 8" Carrousel ③ Plasma Weld Rig ④ Plasma ③ 39" (Thick. = 6 mm) ⑤ TIG with filler metal ⑥ TIG without filler metal	t_{plate} t_{tank} Horizontal ⑥ $t_{plate} = 0.7 \times t_{tank} \sqrt{\text{Strength}}$ ⑦ Covered Electrode Cool Spurt ⑧ $t_{plate} = 0.7 \times t_{tank} \sqrt{\text{Strength}}$ Vacuuming ⑨ Multi-run TIG, non-TIG ⑩ TIG Weld Rig ⑪ $t_{plate} = 0.5 \times t_{tank}$ Every other ⑫ ALL elements of the cooling circuit must be welded with cooling metal must be welded with filler metal	$t_{pipe} = 0.5 \times t_{tank} \sqrt{\text{Strength}}$ t_{pipe} t_{tank} t_{flange} ⑬ gasbacking 2 separated Fillet Welds ⑭ $t_{pipe} = 0.7 \times t_{tank} \sqrt{\text{Strength}}$ ⑮ 17 25 16(2 x) ⑯ Built Weld t_{pipe} t_{tank} ⑰ 22 24 30 16(2 x) REMARK: Last weld always runs in the product side	$t_5 = t_{pipe} \times 3$ t_{pipe} t_{pipe} ⑱ gasbacking ⑲ 8 9 ⑳ Multi-run 2 runs @ 1/8" non-TIG TIG runs = 1/8" TIG $t_{pipe} = 3$ t_{pipe} t_{pipe} ㉑ gasbacking ㉒ runs 1.2 - 1.5 ㉓ 10 12 ㉔ non-TIG TIG runs = 1/8" Covered Electrode

[illegible]