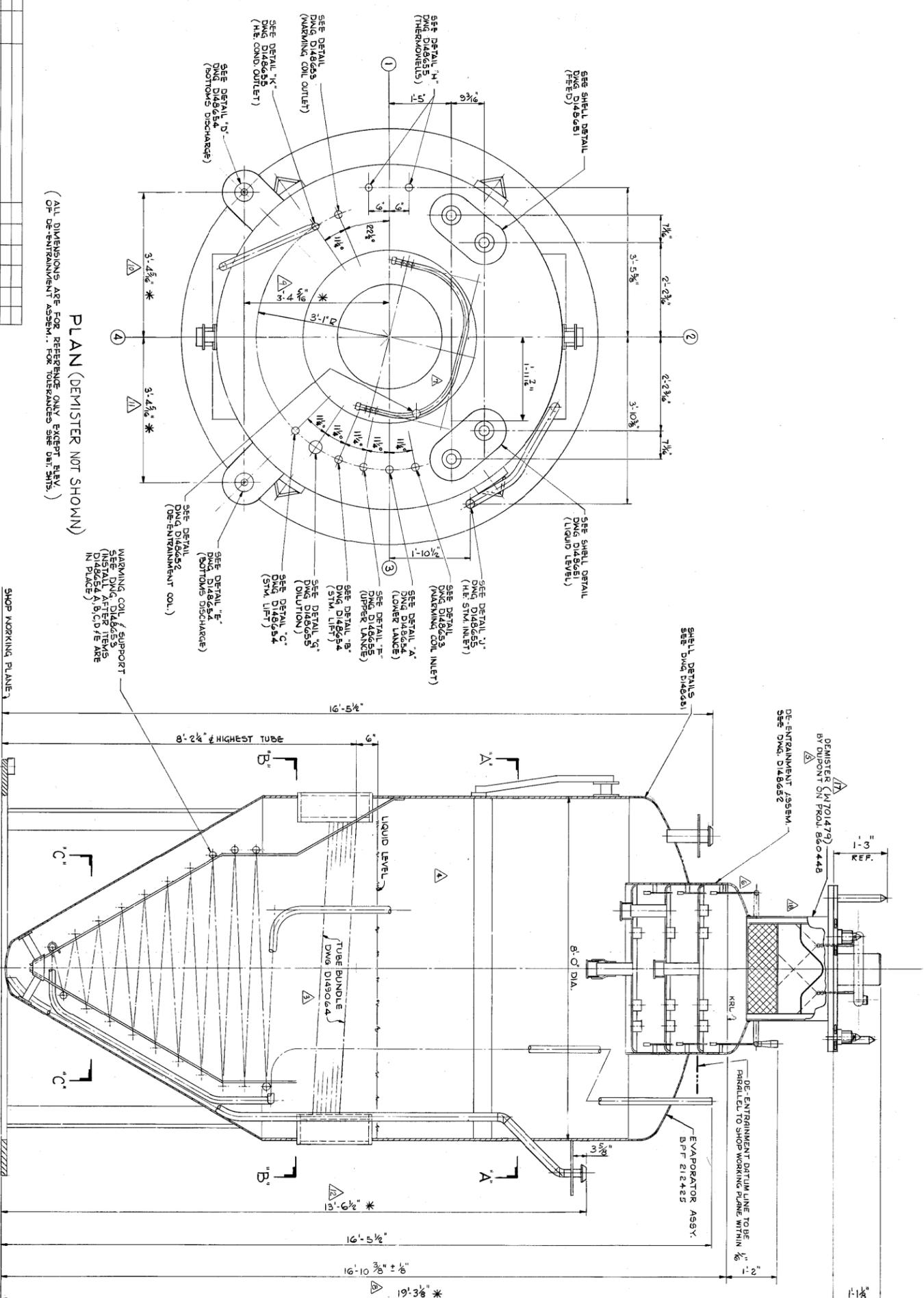


ANALYZE FOR SAFETY, ECOLOGY AND MINIMUM ESSENTIAL DESIGN



PLAN (DEMISTER NOT SHOWN)
(ALL DIMENSIONS ARE FOR REFERENCE ONLY EXCEPT FLUVE
OF DE-ENTRAINMENT ASSEMBLY. FOR TOLERANCES SEE DET. SHTS.)

ELEVATION
(FOR TRUE ORIENTATION OF PARTS, SEE PLAN & SECTIONS)

AXC - 554 W
BPF 212425
(SUPERIOR WELDING CO.)

NOTES:

- DESIGN, FABRICATION, & INSPECTION PER ASME PRESSURE VESSEL CODE, SECTION VIII DIVISION 1 AND DUPONT STANDARDS & SPECIFICATIONS.
- VESSEL TO BE STAMPED - NATIONAL BOARD.
- THERE SHOULD BE NO CREVICES ON INTERIOR OR EXTERIOR SURFACES THAT WOULD PROHIBIT CLEANING BY WASHING OR FLUSHING.
- HEADS TO BE GROUND SMOOTH.
- INSTALL HEAT EXCHANGER AFTER ALL INTERNALS ARE IN PLACE.
- TESTING:
 - AFTER TUBES ARE INSTALLED & BEFORE WELDING HEADS TO TUBE SHEETS (HEAT EXCHANGER):
 - HYDROSTATIC TEST FOR ONE HOUR - FRESH 5 PSI WATER TEST THE SPRAY DISTRIBUTOR LINE ON THE DE-ENTRAINER WHILE FILLING THE SHELL FOR HYDROTEST. THE WATER SHOULD BE ADDED THRU THE SPRAY LINE NOZZLE TO BUILD A BACKPRESSURE OF 40 PSI FOR 10 MINUTES. AFTER THE TEST, FILLING THE SHELL MAY PROCEED THRU OTHER NOZZLES AS DESIRED TO REDUCE THE FILLING TIME.
 - AFTER H.E. HEADS ARE WELDED TO TUBE SHEET, THE TUBES, HEADS & CONNECTING PIPING ARE TO BE TESTED AT:
 - HYDROSTATIC 250 PSI FOR ONE HOUR - FRESH 15 PSI SLING WITH SPREADER BAR, DURING & AFTER FABRICATION.
 - ALL OPENINGS SHALL BE COVERED FOR SHIPMENT WITH TAPE & EXTERIOR GRADE PLYWOOD.
 - WEIGHT:
 - ESTIMATED DRY WEIGHT: 15,100 LBS
 - ESTIMATED FULL OF WATER: 32,400 LBS
 10. AFTER DELIVERY FROM FABRICATOR VESSEL IS TO BE PICKLED, PIPED & INSULATED PER DRAWING N-449815.
 11. CUT & SHEARED SURFACES INSIDE EVAPORATOR & DE-ENTRAINER ARE TO BE OVERLAIN WITH WELD METAL.
 12. OR SEALED BY TUNGSTEN ARC FUSING.
 - * DENOTES CHANGES TO BE MADE BY DUPONT CONSTRUCTION AFTER RECEIVING EVAPORATOR FROM FABRICATOR.
 - FOR ON PLANT MOVING IN EMPTY CONDITION, USE LIFTING YOKES NO. 9A-95 (ON CAPACITY, SEE PLAN).

THIS EVAPORATOR FOR USE IN BUILDING'S 242 F AND 242-16 F H ADD PIPING PER THESE ARRANGEMENTS W-449813 FOR 242-16 F W-703793 FOR 242 F

SAVANNAH RIVER PLANT
BLDG 242
EVAPORATOR ASSEMBLY

THIS DOCUMENT CONTAINS INFORMATION RELATING TO ACTIVITIES OF THE ATOMIC ENERGY COMMISSION WHICH ARE UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE

REV	DATE	DESCRIPTION
1	10/1/74	ISSUED FOR FABRICATION
2	11/1/74	REVISED PER COMMENTS
3	12/1/74	REVISED PER COMMENTS
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100	1/1/83	REVISED PER COMMENTS

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