

Technical drawing of a mechanical part, likely a bracket or support, showing dimensions and labels. The drawing includes the following features:

- Top Label:** CUT SURFACE PARALLEL TO 4.2° RADIAL LINE BOTH SIDES
- Top Left:** 22.0 NOM.
- Top Right:** 3 (in a hexagon)
- Center:** 4.2° (angle), B (label), 8 REF. (dimension), A (label), 3 (in a hexagon)
- Bottom Left:** 4.2° (angle), 2 (dimension), 1 (dimension)
- Bottom Center:** 3 (dimension)

1. REMOVE BURRS AND BREAK SHARP EDGES.
2. STEEL STAMP ID. NO. ON SURFACE INDICATED IN CHARACTERS $3/16$ MIN. HEIGHT.
3. SCRIBE CENTERLINES $.003$ TO $.005$ WIDE AND DEEP WHERE NOTED. STEEL STAMP OR MIL CUT AN INDEX MARK AT ENDS OF CENTERLINES AS SHOWN $1/32 \times 1/32 \times 1/4$ LONG.
4. MAKE FROM ASME SA-508 CL2
SWRI LOG NO. 1811B, HEAT NO. Q2Q106NQT
5. MAKE FROM FORGED STAINLESS STEEL SA336, GR. 316
SWRI LOG NO. 1318 HEAT NO. 78899
6. MAKE FROM CAST STAINLESS STEEL SA351 CF8
SWRI RIC NO. 124 HEAT NO. 153864
7. STAINLESS STEEL CLAD OVERLAY IN ACCORDANCE WITH SWRI WPS-900-2 REV. 2.
8. MACHINE NOTCH $3/16$ WIDE $\times$ $.238$ DEEP $\times$ $3/4$ LONG AND WELD IN ACCORDANCE WITH SWRI WELDING TECHNIQUE FOR CREATING WELDING CRACKS.
9. INCONEL OVERLAY IN ACCORDANCE WITH SWRI-WPS-900-3 REV. 0.
10. SHIELD METAL ARC WELDING OF DISSIMILAR METAL JOINT IN ACCORDANCE WITH SWRI-WPS-522
11. SHIELDED METAL ARC WELDING OF STAINLESS STEEL ACCORDANCE WITH SWRI-WPS-221-1.

7 1/4 REF.

3 1/4

.187

.500 TYP.

1 1/2

.187

.500 TYP.

7 1/4

6 1/4 TYP.

6 1/4 TYP.

SECTION B-B

SCALE: 1/2

AS-WELDED

AS-WELDED

3

4

5

6

D

F

C

C

E

E

18 1/2

9/16 CRACK LENGTH

3/4 CRACK LENGTH

500

500

1 1/2

6 REF.

1/2

1/2

6 REF.

237 REF.

.792

.062 DIA. ±.003 2G-HOLES

15°

15° TYP

WELD

INCONEL WELD

S.S. WELD

S.S. CLADDING

INCONEL BUTTERING

CAST S.S.

5

9

10

11

7

TI
APERTURE
CABD

WELDING: W-2

.238 REF (10%)

8

$\frac{3}{16}$

$\frac{2}{16}$

SECTION E-E

SECTION: 1/1

NO2-SE-PIPE-MOCKUP
4A-STP

2.375
NOM.

2

.500
.500
.187

1.500

WELDING

VIEW F-F
SCALE: 1/2

VIEW 1-1
SCALE: 1/2

WELDING HAZ

3/16 REF.
3/16 REF.

.238 REF. (10% T)

SECTION C-C
SCALE: 1/1

NOZ-SE-PIPE-MOCKUP-44-STP

TOLERANCES UNLESS NOTED		DASH NO		PART NAME		MATERIAL	
DECIMALS = .010		REV					
FRACTIONS = 1/16							
ANGLES = 0.5°							
FINISH 125		NEXT ASSEMBLIES		PARTS LIST			
APPROVED		DATE		SOUTHWEST RESEARCH INSTITUTE			
DESIGN		F.O.R. DATE: 10/25/45		QUALITY ASSURANCE SYSTEMS AND ENGINEERING DIVISION			
DRAWN BY		DESIGNED BY		SAN ANTONIO, TEXAS			
CHECKED BY		DATE		NOZZLE - TO - SAFE - END			
C.A.M.R.		DATE		WELDED MOCKUP			
10/25/45		10/25/45		SOUTH TEXAS PROJECT			
		10/25/45		SHEET OF			
		10/25/45		SCALE 1/2" = 1"			
		10/25/45		C D-5770-656			

PDR RIDS

8707060440

