



- General Notes:**
- 1.) Remove the rear head.
 - 2.) Prep the head and girth seam of the existing shell for welding.
 - 3.) Provide 1/2" SA-516-70 shell material. Roll an 84 in. long shell can to match the I.D. of existing autoclave.
 - 4.) Weld long seam of new shell can, install new shell can, install existing head and weld two girth seams.
 - 5.) Provide & install 1 each 4 in, S/120, RFWN (A-105), with a 6" projection.
 - 6.) Provide & install 4 each 2 in, 3000#, Half couplings (A-105).
 - 7.) Provide & install stiffener rings as required.
 - 8.) Provide & install new tram rails (A-36 angle) through the length of the new shell can
 - 9.) Provide & install hold down rail.
 - 10.) Provide spot radiography, maximum of three shots
 - 11.) Hydrotest per ASME @ 1.3 X MAWP
 - 12.) Provide transportation to the paint yard and a 2 coat paint system for the new shell can and girth welds.

DRAWN	mirailia	5/4/2013	TITLE
CHECKED			
QA			
MFG			
APPROVED			
SCALE	C	SIZE	2923 General Sketch
		DWG NO	REV