

SPECFAB JOB # 2007116

WORKLINE
ALL DIMENSIONS ARE MEASURED FROM THIS LINE UNLESS NOTED OTHERWISE.

EST. WEIGHTS & CAPACITY

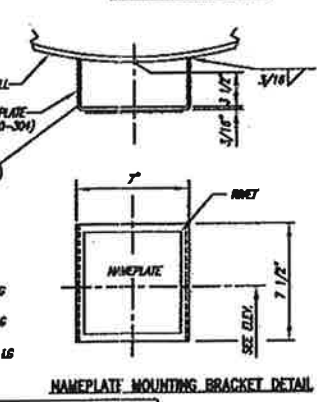
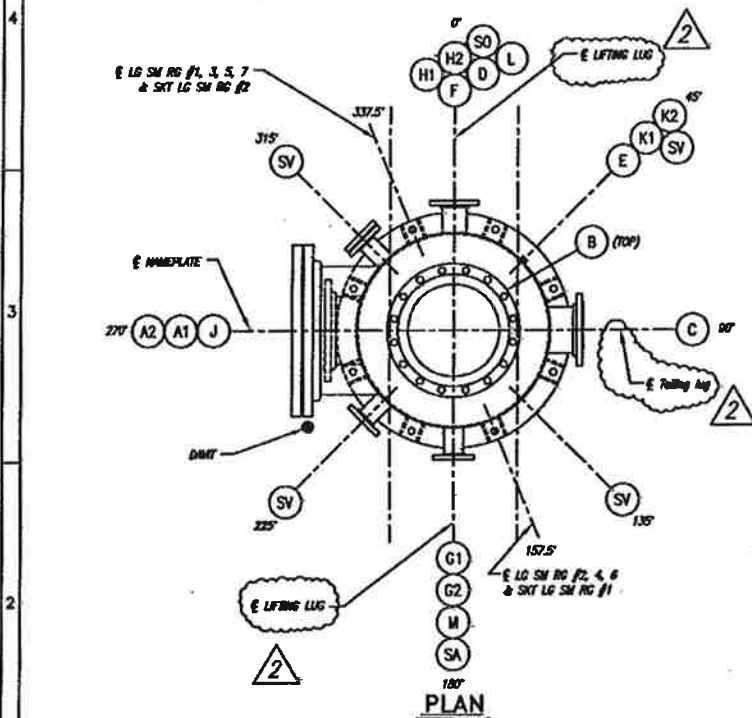
BARE VESSEL WEIGHT	7625	LBS.
LIFT WEIGHT	8838	LBS.
HYDRO WEIGHT	2350	LBS.
CAPACITY	1844	GALS.
INSULATION	1213	LBS.

ITEM # C4401 00 38 1/2"
PO# 01310-4500140683

SHELL THICKNESS	1/4" - 3/8"
HEAD THICKNESS	3/16" - 3/8"
VESSEL EMPTY WT	7800 LBS
MAX HYDRO PRESS	250

NOTE: VESSEL LIFT WT DOES NOT INCLUDE INTERNAL PACKING

- GENERAL NOTES:**
- FLANGE BOLT HOLES TO STANDARD VESSEL CENTERLINES UNLESS NOTED OTHERWISE.
 - NOZZLE & TOP 1/2" TELLER HOLE IN REINFORCING PAD.
 - OUTSIDE PROJECTION SHOWN IN THE NOZZLE SCHEDULE IS FROM VESSEL O.D. UNLESS NOTED OTHERWISE.
 - INSIDE PROJECTION SHOWN IN THE NOZZLE SCHEDULE IS MINIMUM ONLY.
 - ALL NOZZLES SHALL BE ADEQUATELY PROTECTED AND COVERED FOR SHIPMENT.
 - INSTALL 1/2" TYP. FLEEWOOD PROTECTIONS ON FLANGES WITHOUT BLIND FLANGES, A MINIMUM OF (4) 3/8" DIA BOLTS FOR 12" AND SMALLER AND (8) 3/8" DIA BOLTS FOR LARGER FLANGES.
 - VESSEL TO BE DRYER, DRYED AND CLEANED BEFORE SHIPMENT.
 - ALL FLANGE FACE FINISHES ARE TO BE 125-250 Ra.
 - PAINT OR STENCIL P.O. NUMBER & REV NO. WITH 3" HIGH LETTERS ON CH SIDE OF VESSEL.
 - BLENDED CONNECTIONS FURNISHED WITH BLIND FLANGE, STUDS, NUTS AND (2) GASKETS.
 - USE 308L ELECTRODES.
 - PT LIFTING LUGS.
 - ALL PRESSURE CONTAINING WELDS SHALL BE GRIND SMOOTH TO REMOVE DISCONTINUITIES SUCH AS UNDERCUTTING AND OVERLAPPING IN THE WELD GEOMETRY.
 - WMP LIMITED BY HEADS.
 - VESSEL LIFT WEIGHT DOES NOT INCLUDE INTERNAL PACKING.



CERTIFIED BY
SPECIALTY PROCESS FABRICATORS, INC

SHELL MAWP PSIG AT °F
SHELL MAEP PSIG AT °F
SHELL MDMT °F AT PSIG

SERIAL YEAR BUILT

Specfab
SPECIALTY PROCESS FABRICATORS, INC.
VICKSBURG, MS 39183

MARK NO.	SERVICE	SIZE	RATING	TYPE	MATERIAL	LG.	MATL.	THICK. X WLD.	MATL.	O.S.	LS.	WELD DETAIL	WELD SIZE	NOTES	
SO 1	SHORT OPENING	8"			SEE DET.	SHK. #2									
SA 1	SHORT ACCESS	24"			SEE DET.	SHK. #2									
SY 4	SHORT MENUS	3"			SEE DET.	SHK. #2									
N 1	NOZZLE	3"	150#	RFSD	SA-182-F304	S/40a		6"	FLUSH	#	W	1/4	1/4		
L 1	SPARE	3"	150#	RFSD	SA-182-F304	S/40a		6"	FLUSH	#	W	1/4	3/8	W/ BLD. GASKET & BOLTING ***	
K1/K2	PT/P	1/2"	3000#	HLF OPLG.	SA-182-F304	S/40a		6"	FLUSH	#	W	1/4	1/4		
J 1	PACKING DUMP	12"	150#	RFSD	SA-182-F304	S/40a		1/8" x 2"	SA-240-304	6"	FLUSH	#	1/2	3/16	W/ BLD. GASKET & BOLTING **
M1/M2	LEVEL GAUGE	3/4"	3000#	HLF OPLG.	SA-182-F304	S/40a		6"	FLUSH	#	W	1/4	1/8		
O1/O2	LEVEL TRANSMITTER	3"	150#	RFSD	SA-182-F304	S/40a		6"	FLUSH	#	W	1/4	1/8		
P 1	LIQUID INLET	6"	150#	RFSD	SA-182-F304	S/40a		1/8" x 2"	SA-240-304	6"	FLUSH	#	1/4	1/4	
E 1	TI	3/4"	3000#	HLF OPLG.	SA-182-F304	S/40a									
D 1	LIQUID OUTLET	4"	150#	RFSD	SEE DET.	SHK. #2									
C 1	VAPOR INLET	8"	150#	RFSD	SA-182-F304	S/40a		1/8" x 2"	SA-240-304	6"	FLUSH	#	5/16	1/4	1/4
B 1	VAPOR OUTLET	18"	150#	RFSD	SA-182-F304	STR. WT.	SEE ELEV.	1/8" x 2 3/4"	SA-240-304	SEE ELEV.	FLUSH	#	3/8	3/8	1/4
A 1	MANWAY	24"	150#	RFSD	SA-182-F304	S/20		3/8" x 5"	SA-240-304	6"	FLUSH	#	3/8	1/2	3/8
A 2	MANWAY	24"	150#	RFSD	SA-182-F304	S/20		3/8" x 5"	SA-240-304	6"	FLUSH	#	3/8	1/2	3/8

REFERENCE DRAWINGS

NUMBER	DESCRIPTION	NO.	DATE	BY	CHK.	DATE
		0	ISSUED FOR APPROVAL	JSL	JSL	
		1	ISSUED FOR CONSTRUCTION	BFT	DM	5/2/07
		2	ADDED 4 FT TO COLUMN	BOO	DM	5/29/07
		2	REVISED AS NOTED	BFT	DM	7/12/07

NOTICE

THIS DRAWING IS THE PROPERTY OF ERCON, INC. OR ONE OF ITS AFFILIATED COMPANIES ("ERCON"). NO COPIES OR REPRODUCTION OF THIS DRAWING SHALL BE MADE, IN WHOLE OR IN PART, FOR ANY PURPOSE WITHOUT THE WRITTEN PERMISSION OF ERCON. ANY UNAUTHORIZED REPRODUCTION OR PUBLICATION OF THIS DRAWING SHALL BE AT THE USER'S SOLE RISK AND WITHOUT LIABILITY TO ERCON. ALL COPIES ARE TO BE RETURNED ON REQUEST OF ERCON.

SPECIFICATIONS

CONSTRUCTION CODE	ASME CODE SECTION VIII, DIV. 1 2001 EDITION, 2006 ADDENDA
YEAR BUILT	2007
SERIAL NO.	95
DESIGN PRESSURE INTERNAL	50
DESIGN PRESSURE EXTERNAL	15
HYDRO PRESSURE INTERNAL	251 PSIG
CORROSION ALLOWANCE	NONE
RADIOGRAPHY	NONE
SHELL MATL. SPEC.	SA-240-304
FLANGE MATL. SPEC.	SA-182-F304
PIPE MATL. SPEC.	SA-312-TP304
REPAIR MATL. SPEC.	SA-240-304
MDMT	-5 °F
NATIONAL B.O. NO.	LATER
PSIG @ TEMP.	-5/250 °F MIN/MAX
PSIG @ TEMP.	-5/250 °F MIN/MAX
J.E. SHELL	70#
J.E. HEADS	RSW (SMLS)
STRESS RELIEVE	NONE
HEAD MATL. SPEC.	SA-240-304
CPLG. MATL. SPEC.	SA-182-F304
BW FIT. MATL. SPEC.	SA-403 WP304
STRUC. MATL. SPEC.	SA-36
FLG. STUD SPEC.	SA-182-87
FLG. NUT SPEC.	SA-182-2H

GASKET DESC. OMLOCK 308L FITE DR EQUAL OR EPDM

INSULATION DESC. 3"

INSPECTION BY HSB CO. & CUSTOMER

SANDBLAST C.S. ONLY - PER SSPC-SP10 (COMMERCIAL BLAST)

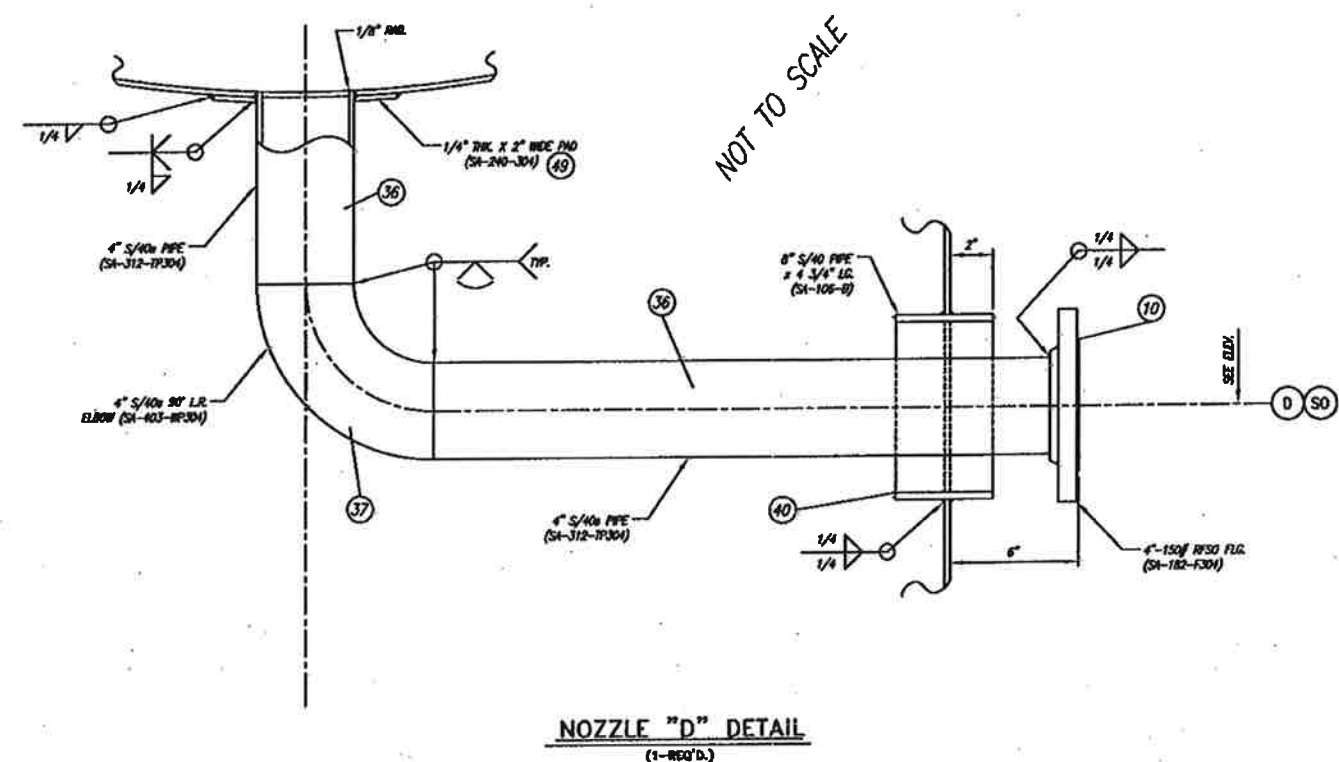
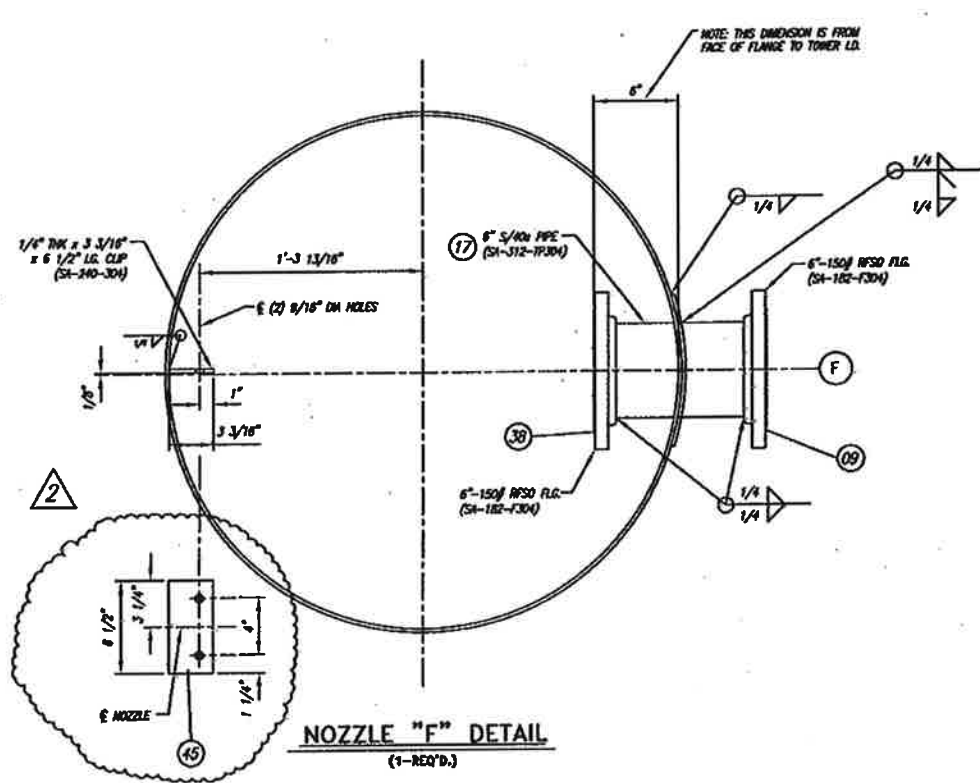
PAINT C.S. ONLY - PRIME COAT WITH AERON DIBECOTE B (3-5 MILS)

Specfab
SPECIALTY PROCESS FABRICATORS, INC.
2353 Haining Road
Vicksburg, MS 39183
601-636-6888
www.specprofab.com

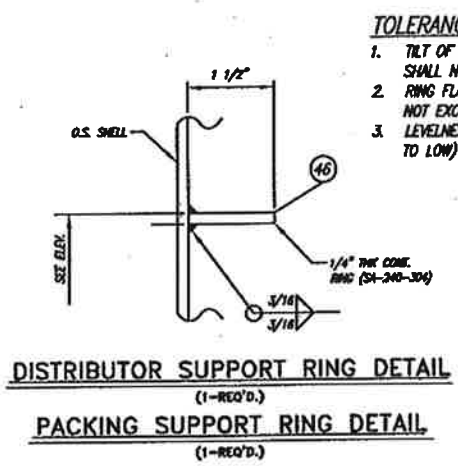
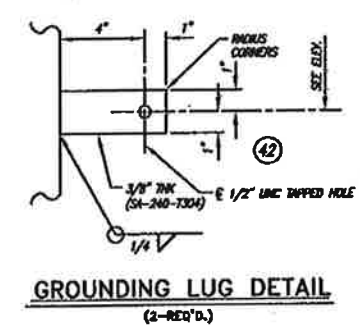
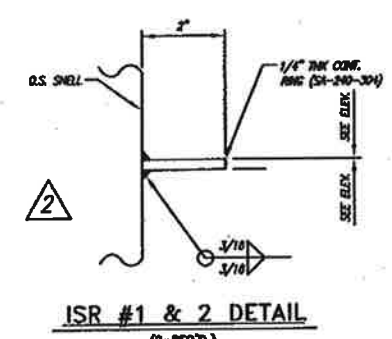
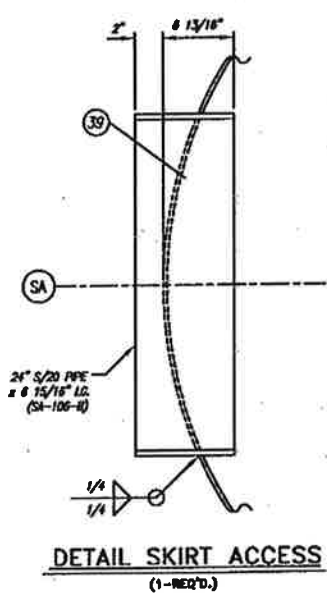
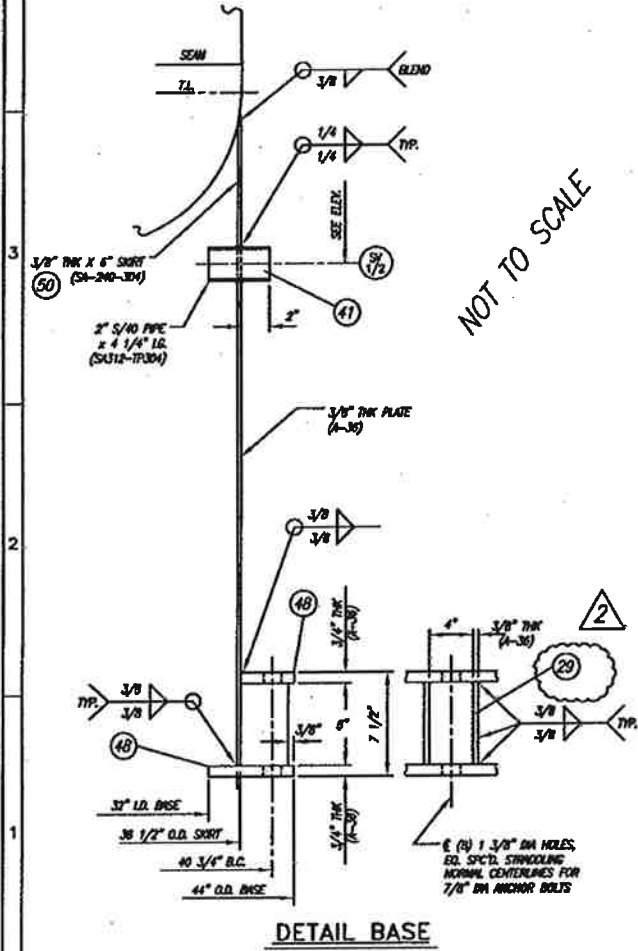
DESCRIPTION: **36" I.D. x 29'-7" SEAM / SEAM ACID REDUCTION COLUMN**
ITEM NO.: C4401
JOB # 2007116

CUSTOMER: **BUNGE-ERCON VICKSBURG, MS.**

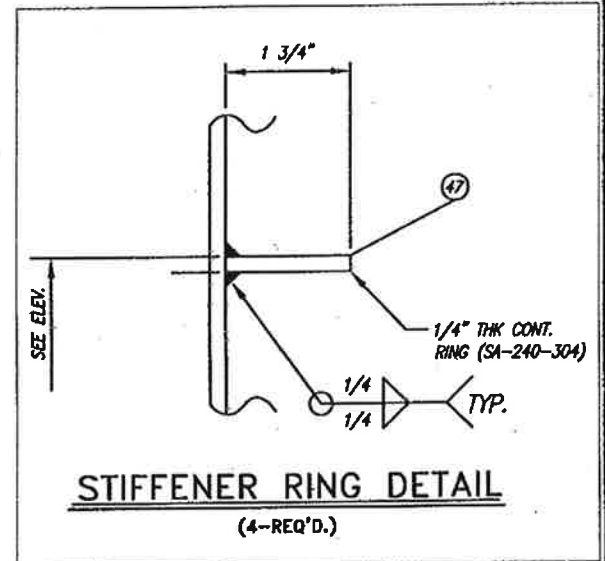
SCALE: N.T.S. DATE: 5/2/07 P.O. No.: 61310-4500140663
DRAWN BY: JSL FILE No.: 2007116
CHECK BY: JSL DWG. NO.: V-074-107 SHEET NO. REV. 1 OF 4 2
APVD BY: DM 5/2/07



SPECFAB JOB # 2007116



- TOLERANCES FOR SUPPORT RINGS**
1. TILT OF TRAY SUPPORT RING OVER ITS WIDTH SHALL NOT EXCEED +/- 1"
 2. RING FLATNESS OVER ANY 12" CHORD SHALL NOT EXCEED 1/16"
 3. LEVELNESS SHALL NOT EXCEED 5/64" (HIGH TO LOW)



REFERENCE DRAWINGS		REVISIONS			
NUMBER	DESCRIPTION	BY	CHK.	DATE	
A	ISSUED FOR APPROVAL	JSL	JSL		
0	ISSUED FOR CONSTRUCTION	BFT	DM	5/2/07	
1	SHORTENED SHORT BY 4 FT	BOD	DM	5/29/07	
2	REVISED AS NOTED	BFT	DM	7/12/07	

NOTICE
THIS DRAWING IS THE PROPERTY OF EROCOL, INC. OR ONE OF ITS AFFILIATED COMPANIES ("EROCOL"). NO COPIES OR REPRODUCTION OF THIS DRAWING SHALL BE MADE, IN WHOLE OR IN PART, NOR INFORMATION THEREON PUBLISHED OR USED OTHER THAN AS SPECIFICALLY AUTHORIZED BY EROCOL. IN WRITING, ALL COPIES ARE TO BE RETURNED ON REQUEST OF EROCOL.

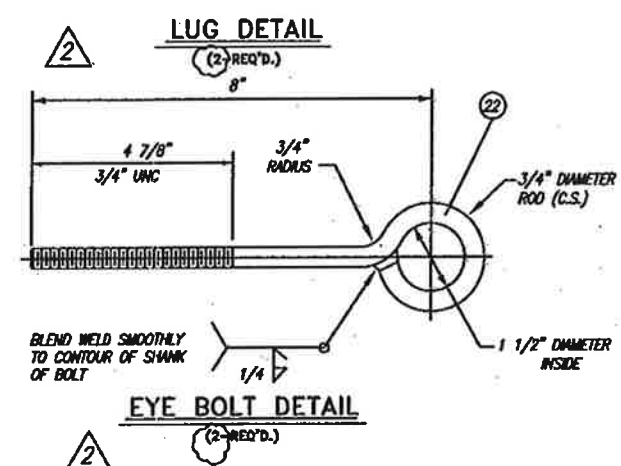
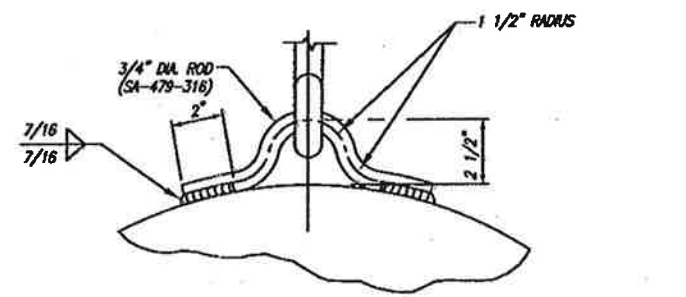
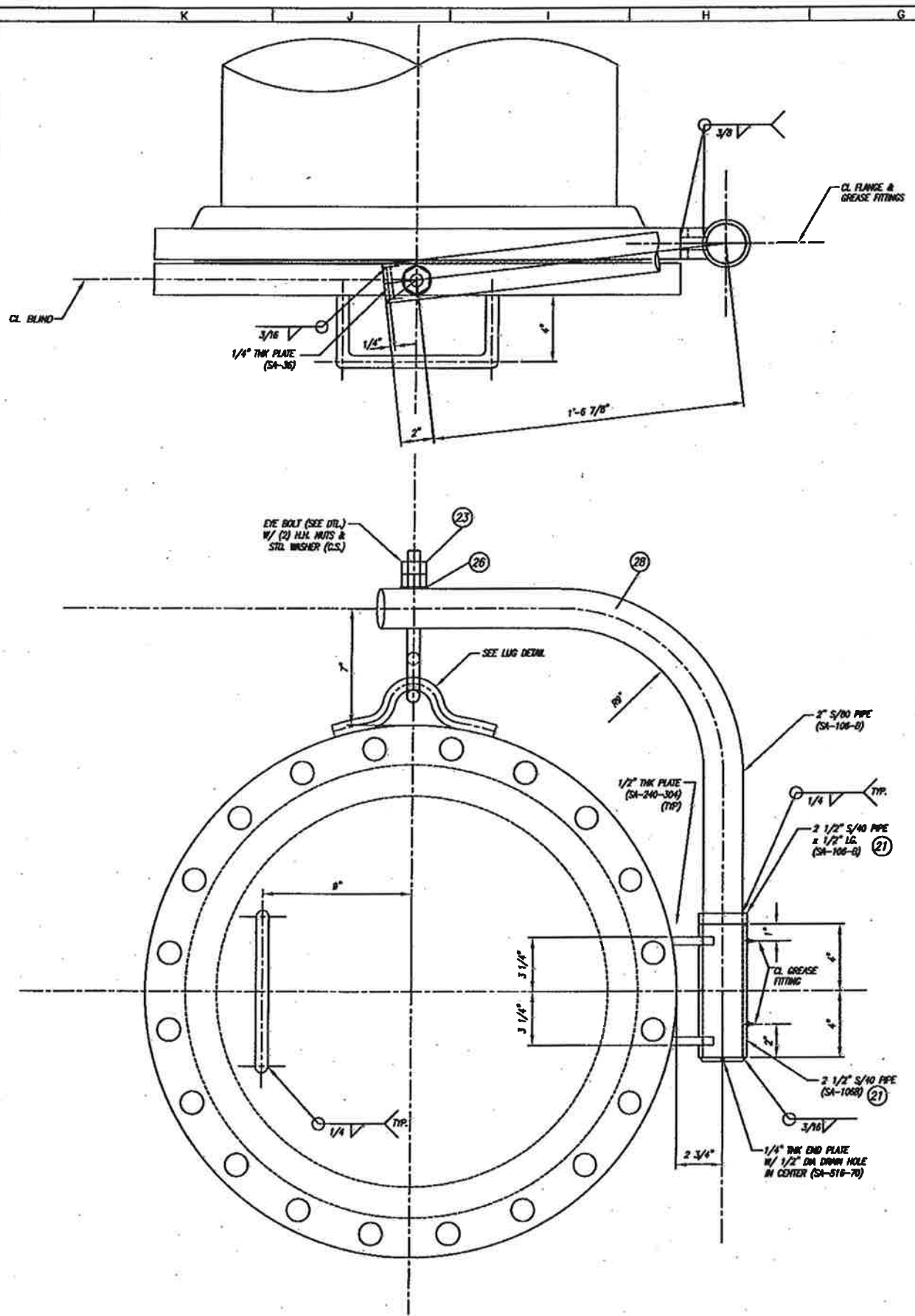
5/2 2007116 ITB# C 4401 OMC REV'D

SpecFab
Specialty Process Fabricators, Inc.
2353 Haining Road
Vicksburg, Ms 39183
601-636-6888
www.specprofab.com

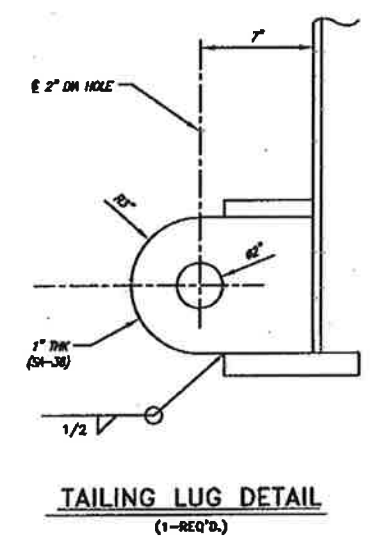
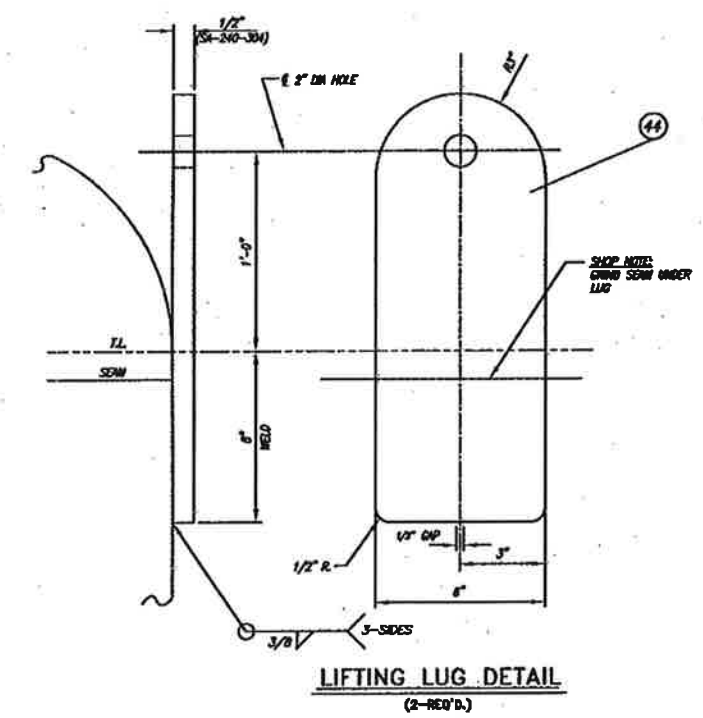
DESCRIPTION: 36" I.D. x 29'-7" SEAM / SEAM ACID REDUCTION COLUMN
C4401
JOB # 2007116

CUSTOMER: BUNGE-ERGON
VICKSBURG, MS.

SCALE: NONE DATE: 5/2/07 P.O. No.: 61310-4500140663
DRAWN: JSL FILE No.: 2007116
CHECK: JSL DWG. NO.: V-074-107 SHEET NO.: 2 OF 4
APVD: DM 5/27/07 REV.: 2



SPECFAB JOB # 2007116



2 DETAIL DAVIT (2-REQ'D.)

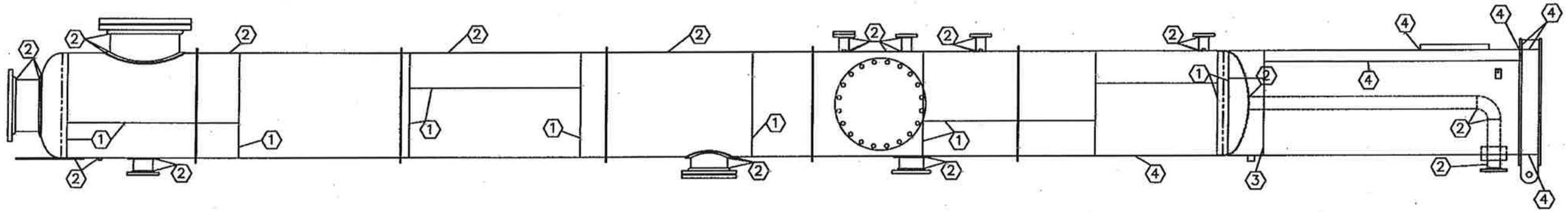
REFERENCE DRAWINGS		REVISIONS			
NUMBER	DESCRIPTION	NO.	DESCRIPTION	BY	DATE
A	ISSUED FOR APPROVAL	JSL	JSL		
0	ISSUED FOR CONSTRUCTION	BFT	BM		5/2/07
1	SHORTEN SHORT BY 4 FEET	BGD	BM		5/29/07
2	REVISED AS NOTED	BFT	BM		7/12/07

NOTICE
THIS DRAWING IS THE PROPERTY OF ERGON, INC. OR ONE OF ITS AFFILIATED COMPANIES (ERGON). NO COPIES OR REPRODUCTION OF THIS DRAWING SHALL BE MADE, IN WHOLE OR IN PART, NOR INFORMATION THEREON PUBLISHED OR USED OTHER THAN AS SPECIFICALLY AUTHORIZED BY ERGON IN WRITING. ALL COPIES ARE TO BE RETURNED ON REQUEST OF ERGON.

S/O: 2007116	ITEM: C 4401	ONE	REQ'D.
		Specialty Process Fabricators, Inc. 2353 Helming Road Vicksburg, Ms 39183 601-636-6888 www.specfab.com	
DESCRIPTION: 36" I.D. x 29'-7" SEAM / SEAM ACID REDUCTION COLUMN ITEM: C4401 JOB # 2007116			
CUSTOMER: BUNGE-ERGON VICKSBURG, MS.			
SCALE: NONE	DATE: 5/04/07	P.O. No.:	
DRAWN: JSL	5/04/07	FILE No.:	2007116
CHECK: JSL	5/29/07	DWG. NO.:	V-074-107
APVD: DVA	6/21/07	SHEET NO.:	3 OF 4
		REV.:	2

WELD PROCEDURES

- ① E-154;E-137
- ③ E-138
- ⑤
- ⑦
- ⑨
- ⑪
- ⑬
- ② E-137;E-102;E-148
- ④ E-141;E-142;E-139
- ⑥
- ⑧
- ⑩
- ⑫
- ⑭



ELEVATION
SEE PLAN FOR TRUE ORIENTATION

BILL OF MATERIAL

Bubble #	COMMODITY	QTY.	UM	SIZE	MATL.	DESCRIPTION
1	HEAD	2	EA	36" O.D. X .15" MIN THK	SA-240-304	HEAD, 36" O.D. X .15" MIN THK, 2:1 DIA W/2 3"
2	PLATE	6	EA	1/4" X 60" X 117"	SA-240-T304	PLATE
3	FLANGE	2	EA	24"	SA-182-F304	24" FLANGE, 150# RFSD
4	BLIND FLANGE	2	EA	24"	SA-182-F304	24" BLIND FLANGE, 150# RF
5	FLANGE	1	EA	18"	SA-182-F304	18" FLANGE, 150# RFSD
6	FLANGE	1	EA	12"	SA-182-F304	12" FLANGE, 150# RFSD
7	BLIND FLANGE	1	EA	12"	SA-182-F304	12" BLIND FLANGE, 150# RF
8	FLANGE	1	EA	8"	SA-182-F304	8" FLANGE, 150# RFSD
9	FLANGE	1	EA	6"	SA-182-F304	6" FLANGE, 150# RFSD
10	FLANGE	1	EA	4"	SA-182-F304	4" FLANGE, 150# RFSD
11	FLANGE	4	EA	3"	SA-182-F304	3" FLANGE, 150# RFSD
12	BLIND FLANGE	1	EA	3"	SA-182-F304	3" BLIND FLANGE, 150# RF
13	PPE	2.5	FT	24"	SA-312-T304	PPE, SSTD, SMLS
14	PPE	1	FT	18"	SA-312-T304	PPE, SSTD, SMLS
15	PPE	1	FT	12"	SA-312-T304	PPE, SSTD, SMLS
16	PPE	1	FT	8"	SA-312-T304	PPE, SSTD, SMLS
17	PPE	1	FT	6"	SA-312-T304	PPE, SSTD, SMLS
18	PPE	3.5	FT	3"	SA-312-T304	PPE, SSTD, SMLS
19	HALF COUPLING	3	EA	3/4"	SA-182-F304	3/4" HALF COUPLING, 3000#
20	HALF COUPLING	2	EA	1/2"	SA-182-F304	1/2" HALF COUPLING, 3000#
21	PPE	2	FT	2 1/2"	SA-108-B	PPE, SSTD, SMLS
22	EYEBOLT	2	EA	3/4" DIA.	CS	EYEBOLT, 1 1/2" DIA. EYE
23	NUT	4	EA	3/4" DIA.	CS	NUT, 3/4" DIA.
24	STUD	40	EA	1 1/4" DIA. X 7 1/2" LG	SA-193-B7	STUD
25	NUT	80	EA	1 1/4" DIA.	SA-194-2H	NUT
26	FLATWASHER	2	EA	3/4" DIA.	CS	FLATWASHER
27	GASKET	6	EA	34"		24" GASKET, GARLOCK 3000, 150# 6# THK
28	DAVIT ARM	2	EA	3"	SA-108-B	DAVIT ARM, 2" DIA, SMLS
29	PLATE	1	EA	3/8" X 60" X 240"	A-36	PLATE
30	PLATE	1	EA	3/8" X 72" X 240"	A-36	PLATE
31	STUD	12	EA	7/8" DIA. X 5 1/4" LG	SA-193-B7	STUD
32	NUT	24	EA	7/8" DIA.	SA-194-2H	NUT
33	STUD	4	EA	5/8" DIA. X 4 1/4" LG	SA-193-B7	STUD
34	NUT	8	EA	5/8" DIA.	SA-194-2H	NUT
35	NUMERPLATE BRKT	1	EA	3/16" THK.	SA-240-304	NUMERPLATE BRKT
36	PPE	20	FT	4"	SA-312-T304	4" PPE, SSTD, SMLS
37	ELBOW	1	EA	4"	SA-403-WF304	4" ELBOW, SMLS, 90 DEG LR
38	FLANGE	1	EA	8"	SA-182-F304	8" FLANGE, 150# RFSD
39	PPE	1	FT	24"	SA-108-B	24" PPE, SSTD, SMLS
40	PPE	1	FT	8"	SA-108-B	8" PPE, SSTD, SMLS
41	PPE	2	FT	2"	SA-312-T304	2" PPE, SSTD, SMLS
42	GROUND LUG	2	EA	3/8" X 2" X 5"	SA-240-T304	PLATE
43	TALKING LUG	1	EA	1" X 6" X 10"	A-36	PLATE
44	LIFTING LUG	2	EA	1/2" X 6" X 23"	SA-240-304	PLATE
45	CLIP	1	EA	1/4" X 3 3/16" X 6 3/16"	SA-240-304	PLATE
46	FLATBAR	3	EA	1/4" X 1 1/2"	SA-240-304	FLATBAR, ROLLED PER DWG SK-1
47	FLATBAR	5	EA	1/4" X 1 3/4"	SA-240-304	FLATBAR, ROLLED PER DWG SK-2
48	PLATE	1	EA	3/4" X 4 1/2" X 9"	A-36	PLATE
49	PLATE	1	EA	1/4" X 2 1/2" X 36"	SA-240-304	PLATE
50	PLATE	1	EA	3/8" X 60" X 240"	SA-240-304	PLATE
51	GASKET	1	EA	18"		18" GASKET, GARLOCK 3000, 150# 1/8" THK
52	GASKET	2	EA	12"		12" GASKET, GARLOCK 3000, 150# 1/8" THK
53	GASKET	1	EA	8"		8" GASKET, GARLOCK 3000, 150# 1/8" THK
54	GASKET	1	EA	6"		6" GASKET, GARLOCK 3000, 150# 1/8" THK
55	GASKET	1	EA	4"		4" GASKET, GARLOCK 3000, 150# 1/8" THK
56	GASKET	5	EA	3"		3" GASKET, GARLOCK 3000, 150# 1/8" THK

SPECFAB JOB # 2007116

ORIGINATION: BRAD THOMAS
 DATE: _____ REV: 0
 S/O NUMBER: _____

CUSTOMER: _____
 PO NUMBER: 61310-4500140663
 ITEM NUMBER: C 4401

REFERENCE DRAWINGS		REVISIONS			
NUMBER	DESCRIPTION	NO.	DESCRIPTION	BY	DATE
0	ISSUED FOR CONSTRUCTION	BFT	DM		5/2/07
1	REVISED BOM	BCD	DM		5/29/07
2	REVISED AS NOTED	BFT			6/4/07

NOTICE
 THIS DRAWING IS THE PROPERTY OF EROGON, INC. OR ONE OF ITS AFFILIATED COMPANIES ("EROGON"). NO COPIES OF OR REPRODUCTION OF THIS DRAWING SHALL BE MADE, IN WHOLE OR IN PART, NOR INFORMATION THEREON PUBLISHED OR USED OTHER THAN AS SPECIFICALLY AUTHORIZED BY EROGON IN WRITING. ALL COPIES ARE TO BE RETURNED ON REQUEST OF EROGON.

FOR CUSTOMER USE

5/a: 2007116 I/E: C-4401 ONE REV'D.

Specfab
 Specialty Process Fabricators, Inc.
 2353 Haining Road
 Vicksburg, Ms 39183
 601-636-6888
 www.specfab.com

DESCRIPTION: **36" I.D. X 29'-7" SEAM / SEAM ACID REDUCTION COLUMN**
 ITEM: C4401
 WELD MAP

CUSTOMER: **BUNGE-ERGON VICKSBURG VICKSBURG, MS.**

SCALE: N.T.S.	DATE: 5/27/07	P.O. No.: 61310-4500140663
DRAWN: DFF	FILE No.: 2007116	
CHECK: DM	DWG. NO. V-074-107	SHEET NO. 2
APVD: DM	REV. 4 OF 4	