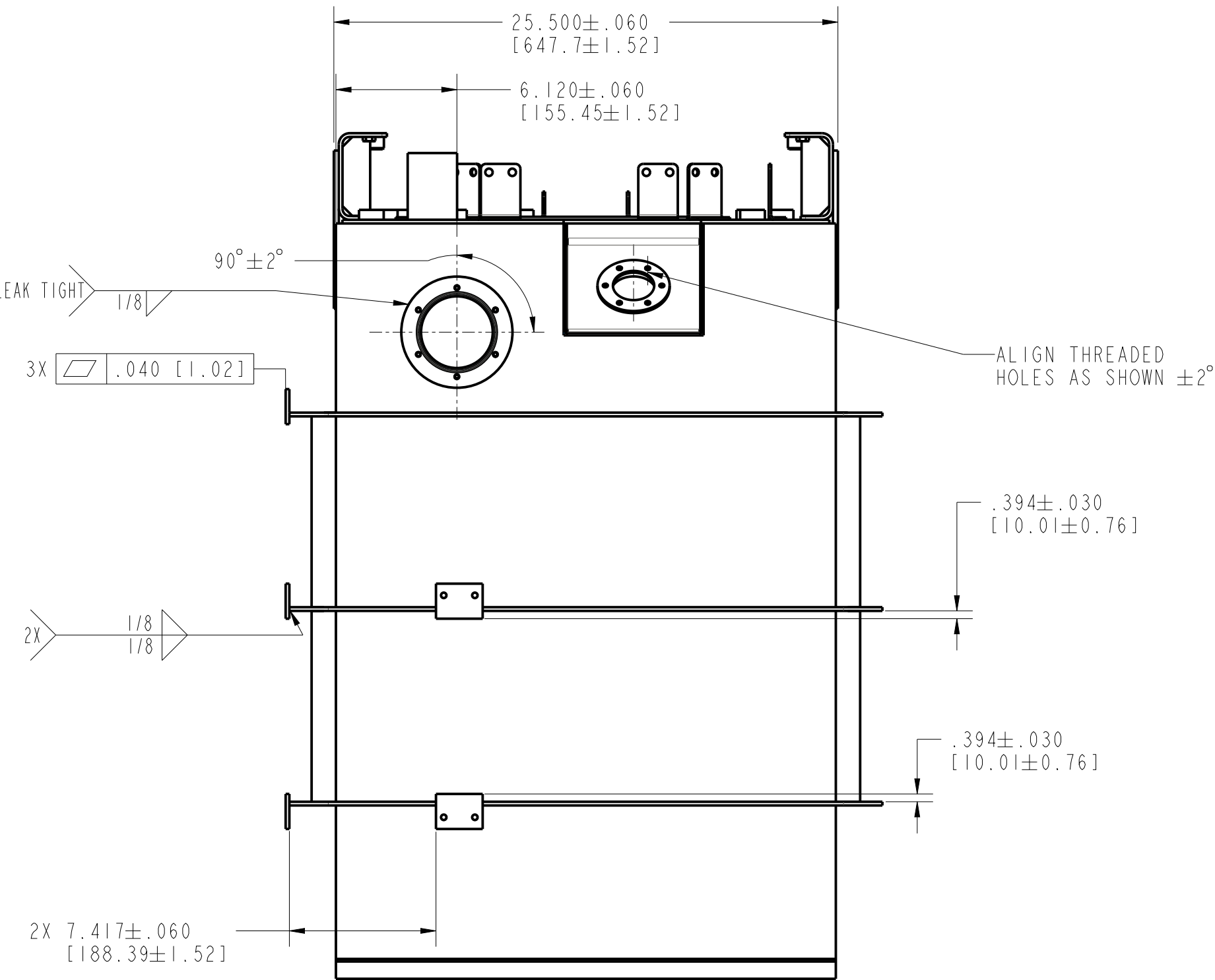
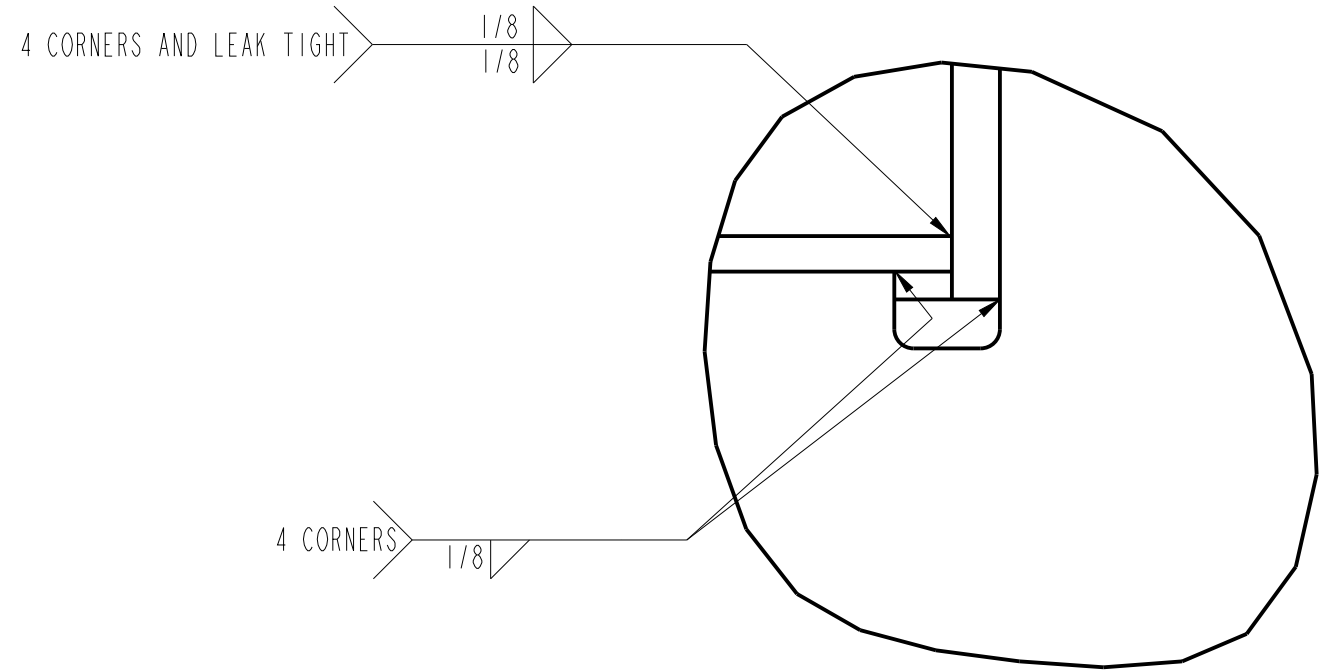
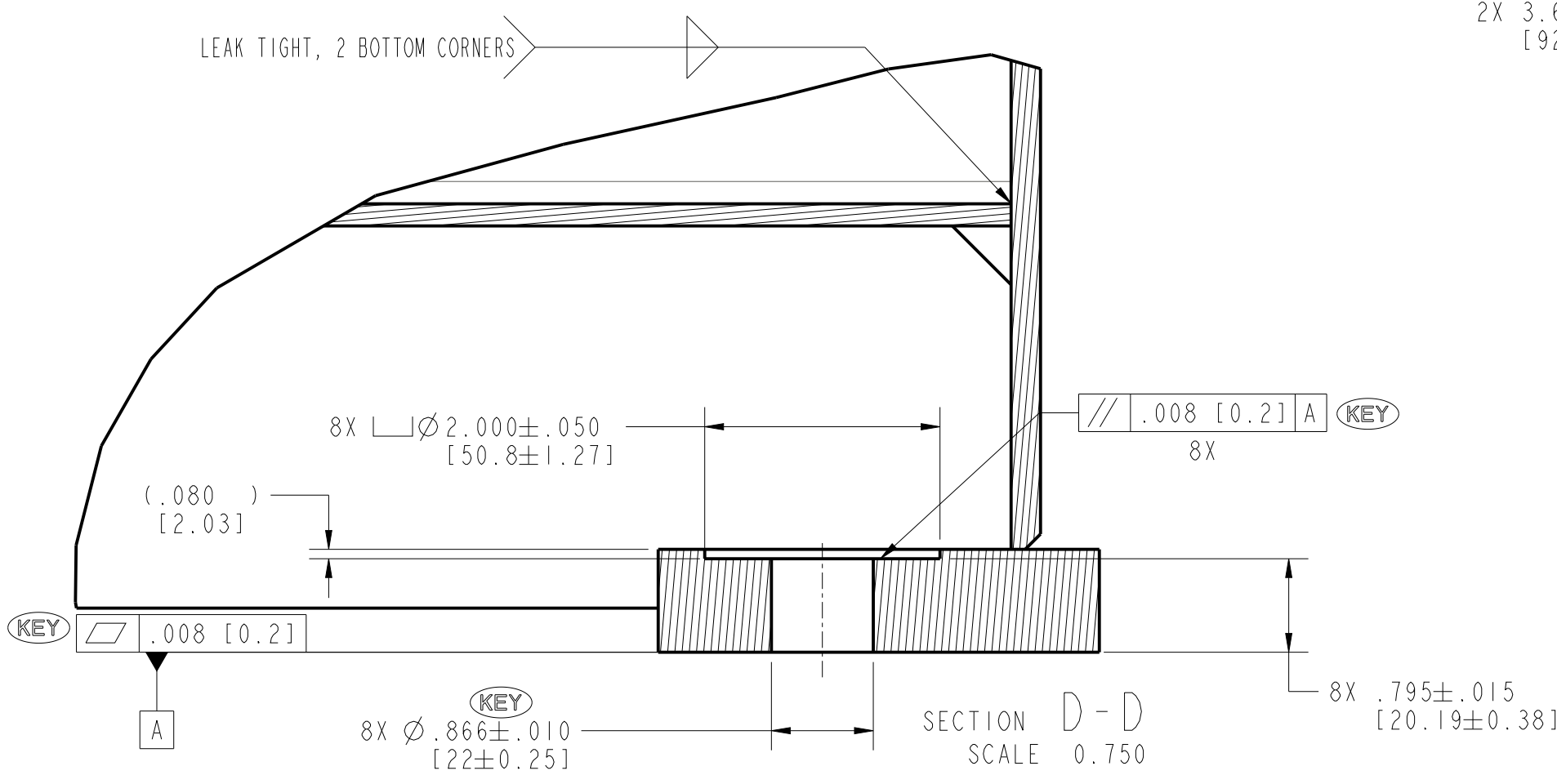
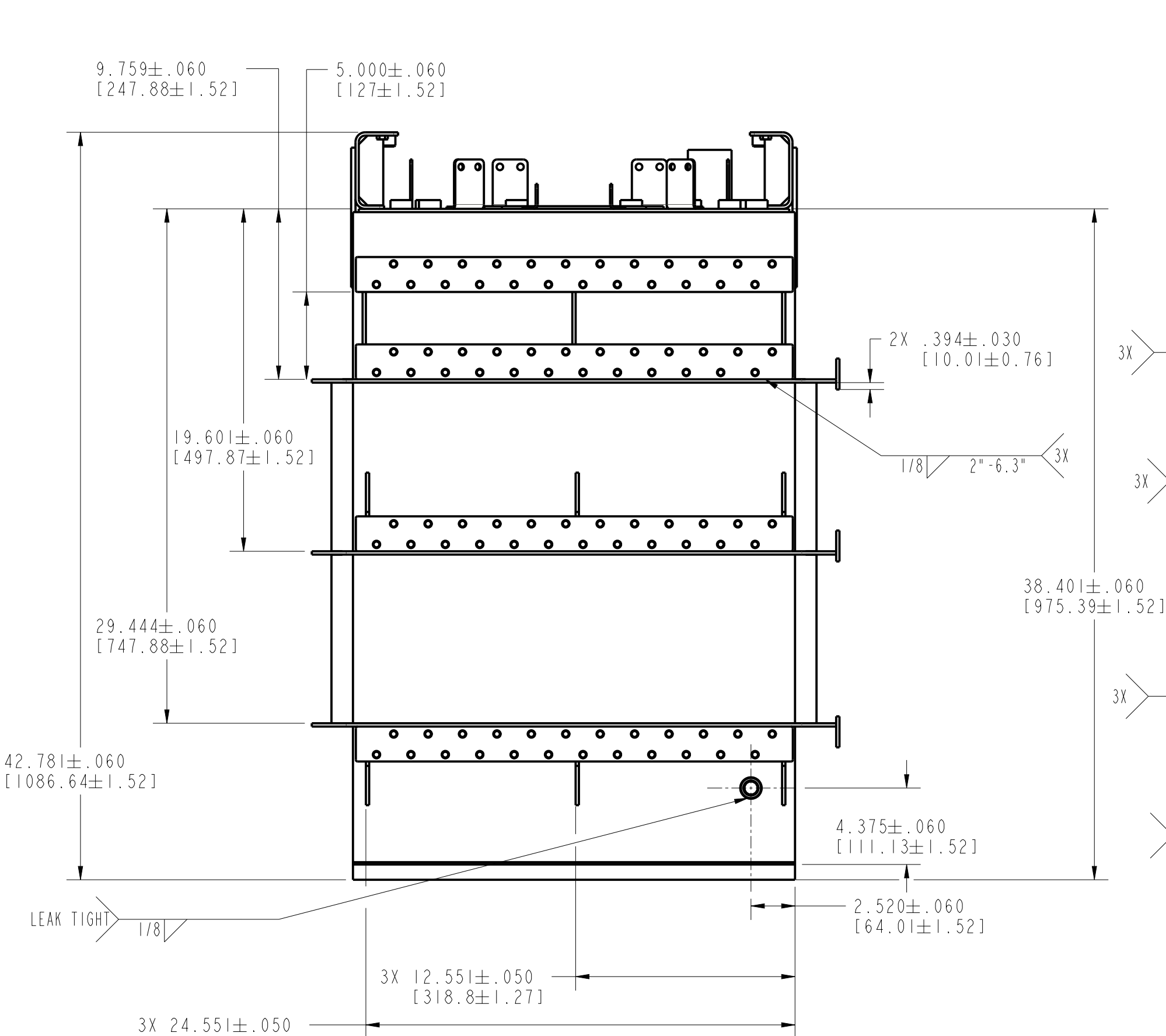
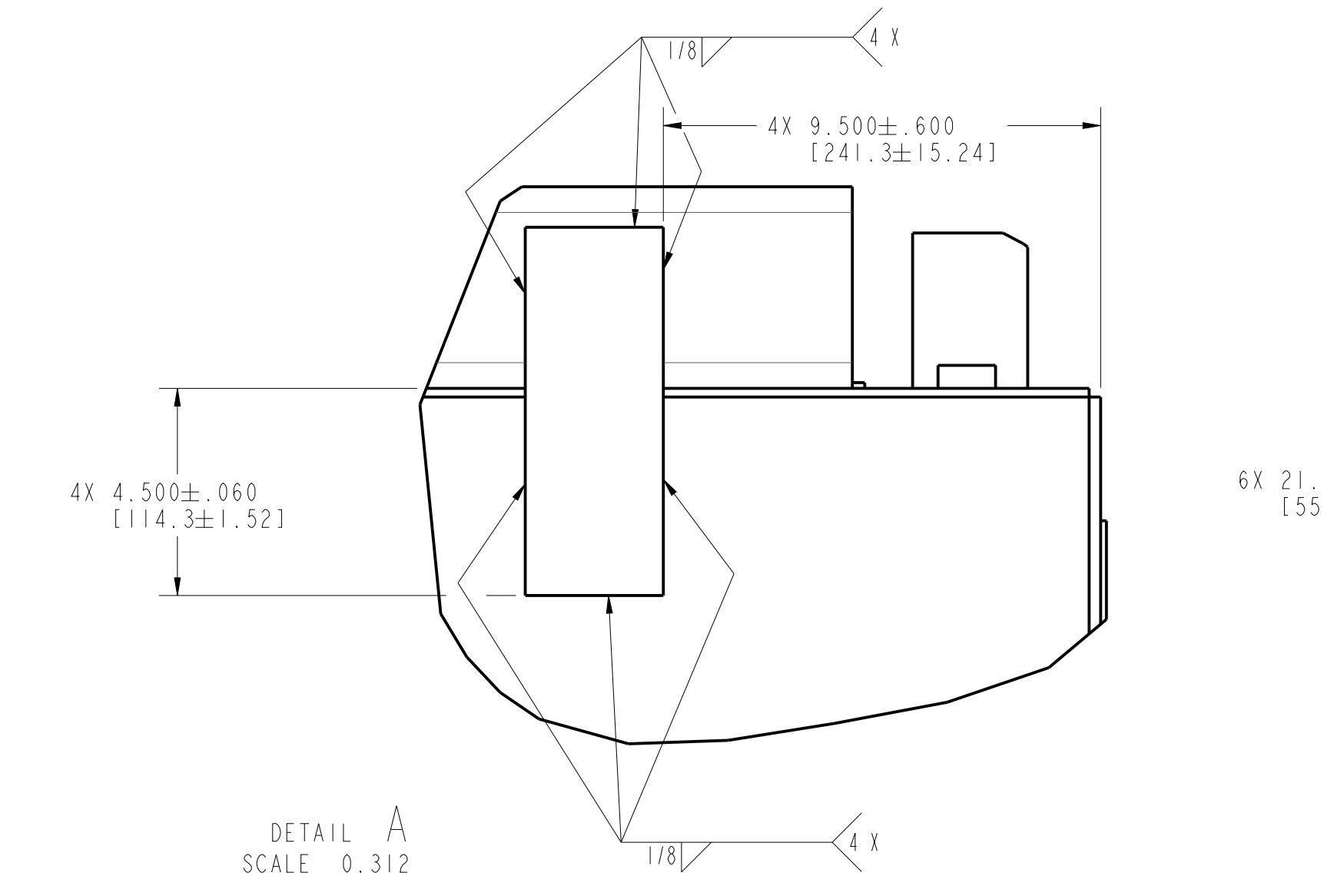
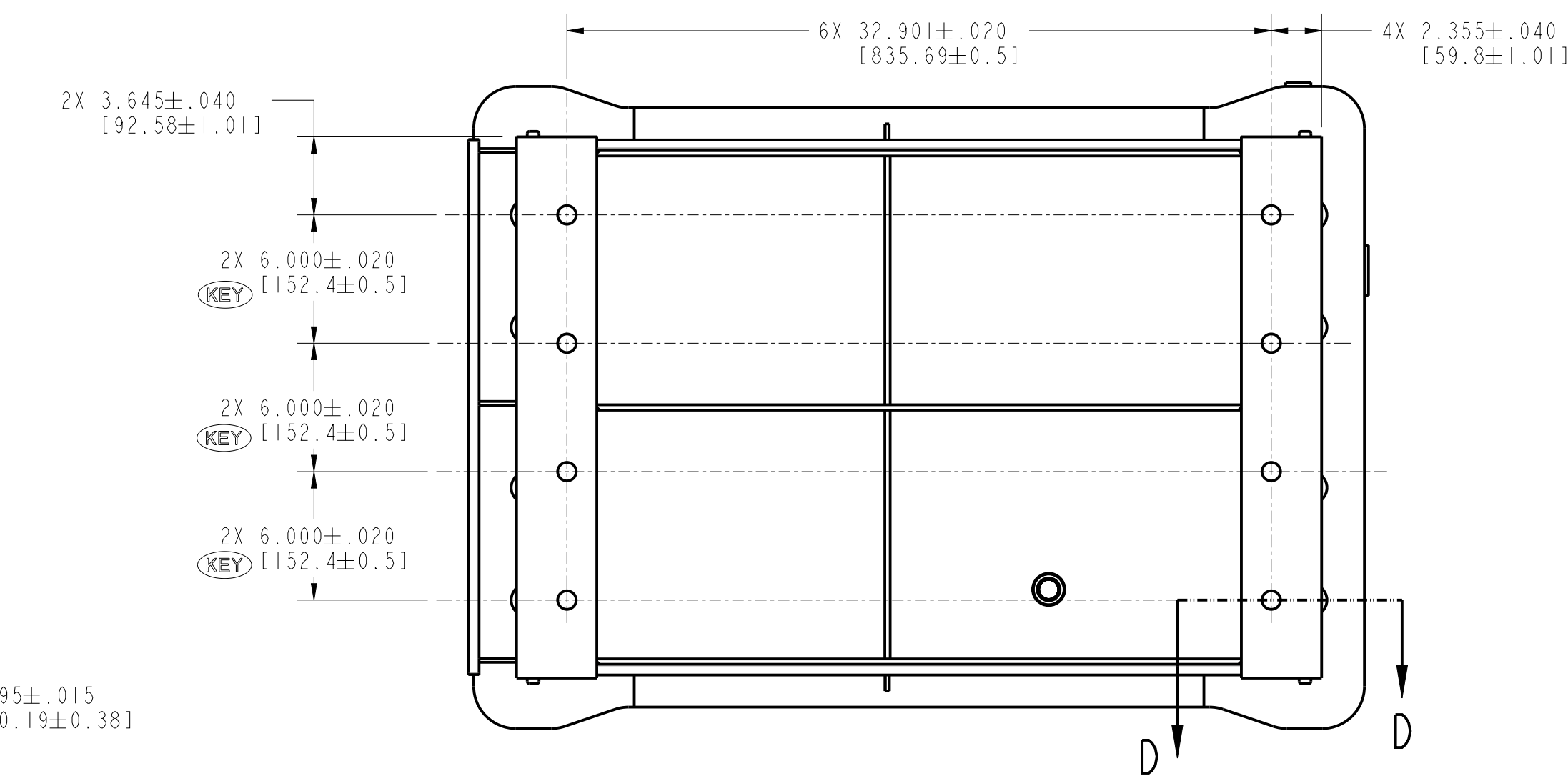
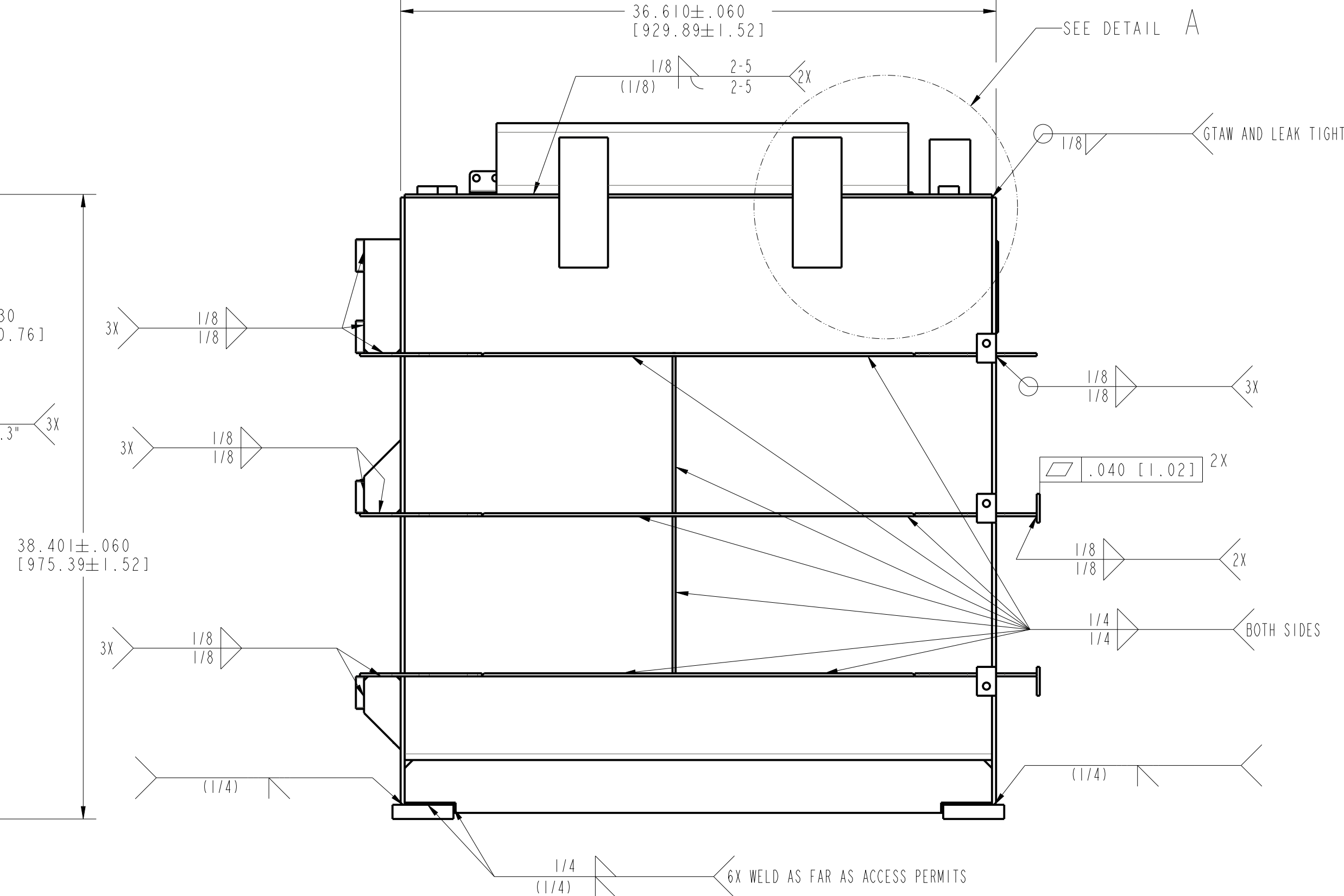
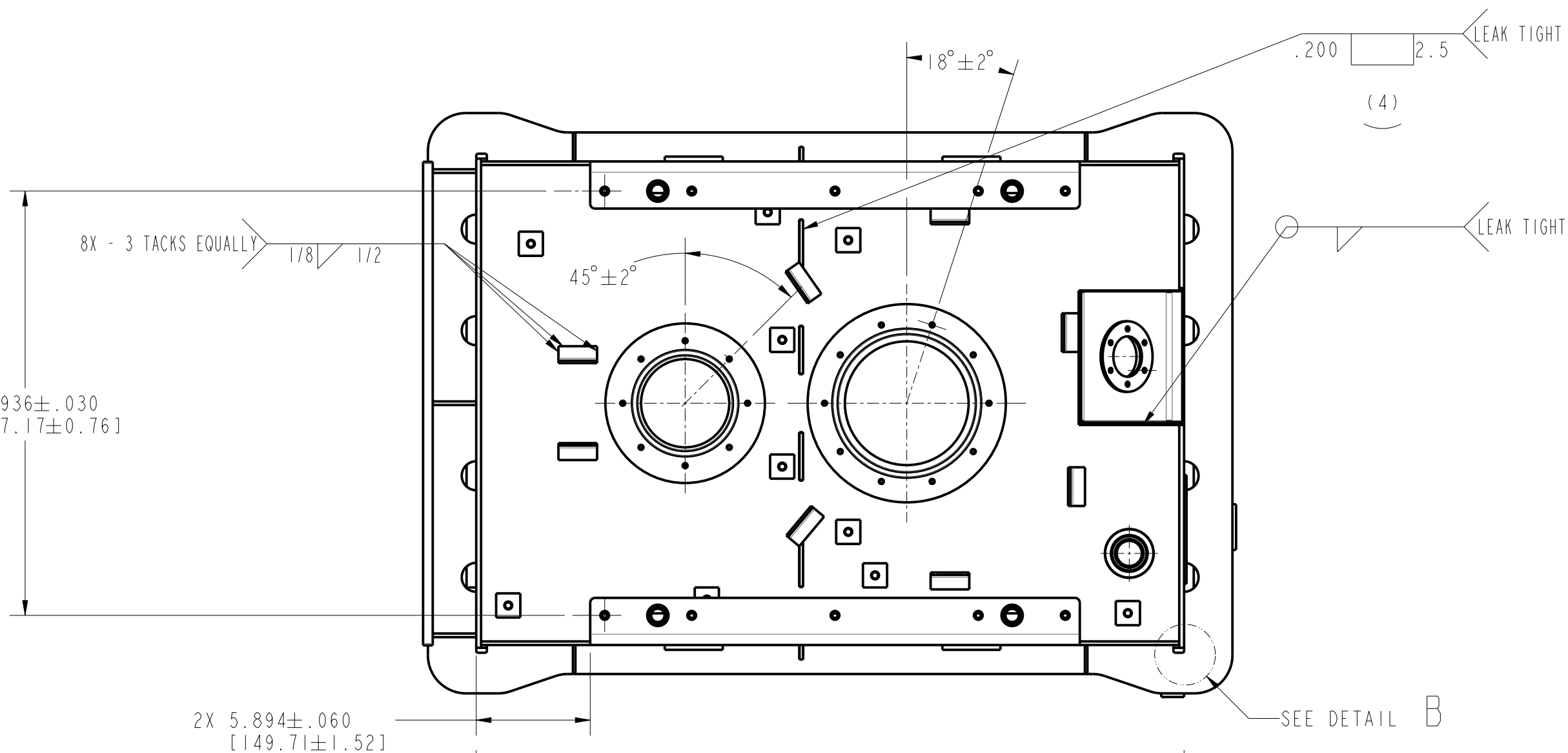


REVISIONS					
RELEASE	LTR	DESCRIPTION	DRAWN/REV. BY	ENGINEER	DATE
EC1282	C	908-0405-14 REV 'D' WAS REV 'C' 908-0405-15 REV 'D' WAS REV 'C' (SH3 A3)	F.MOHAMMED	S.MILETTE	03-Feb-2023
APPROVALS ON FILE					

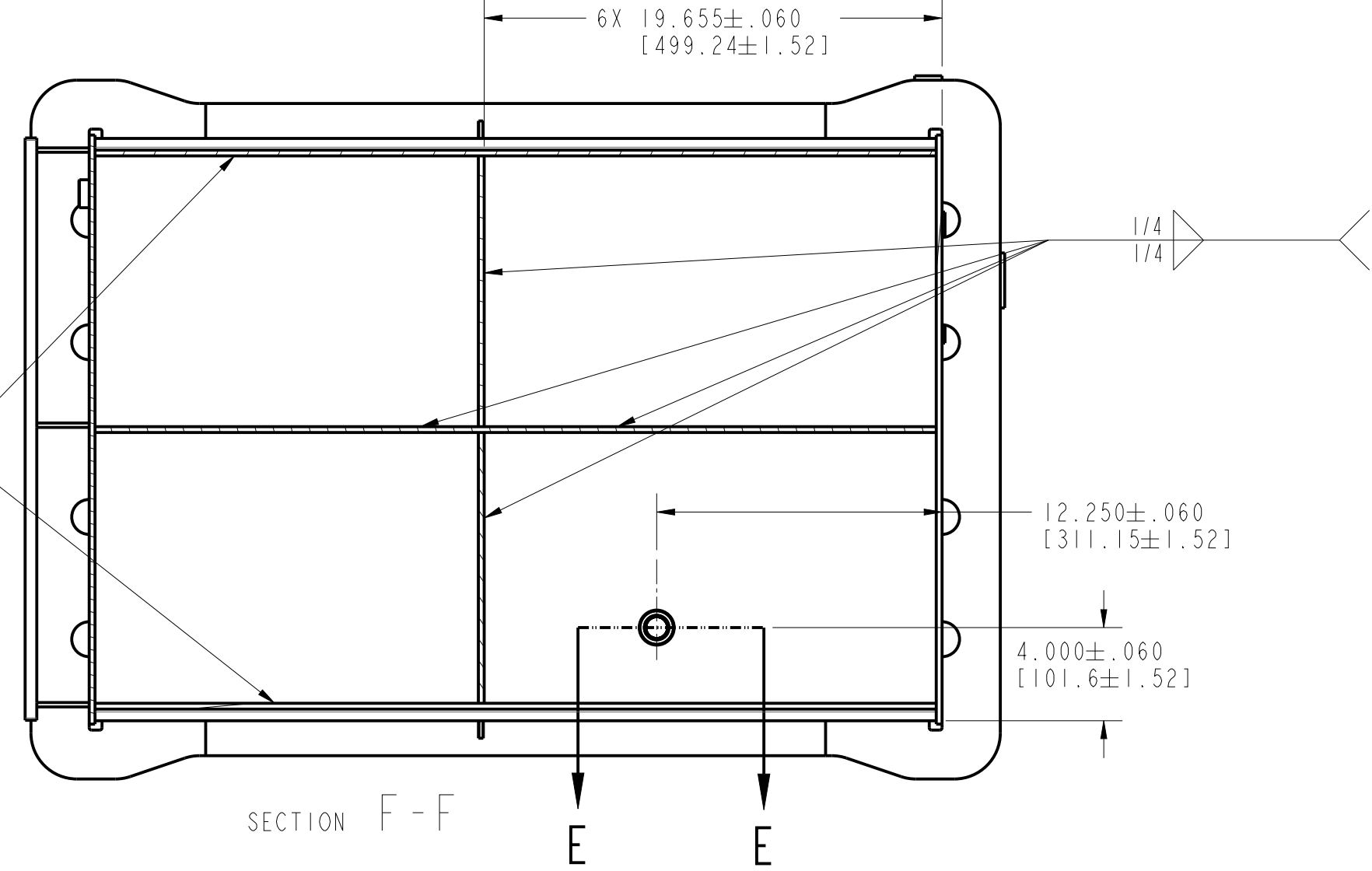
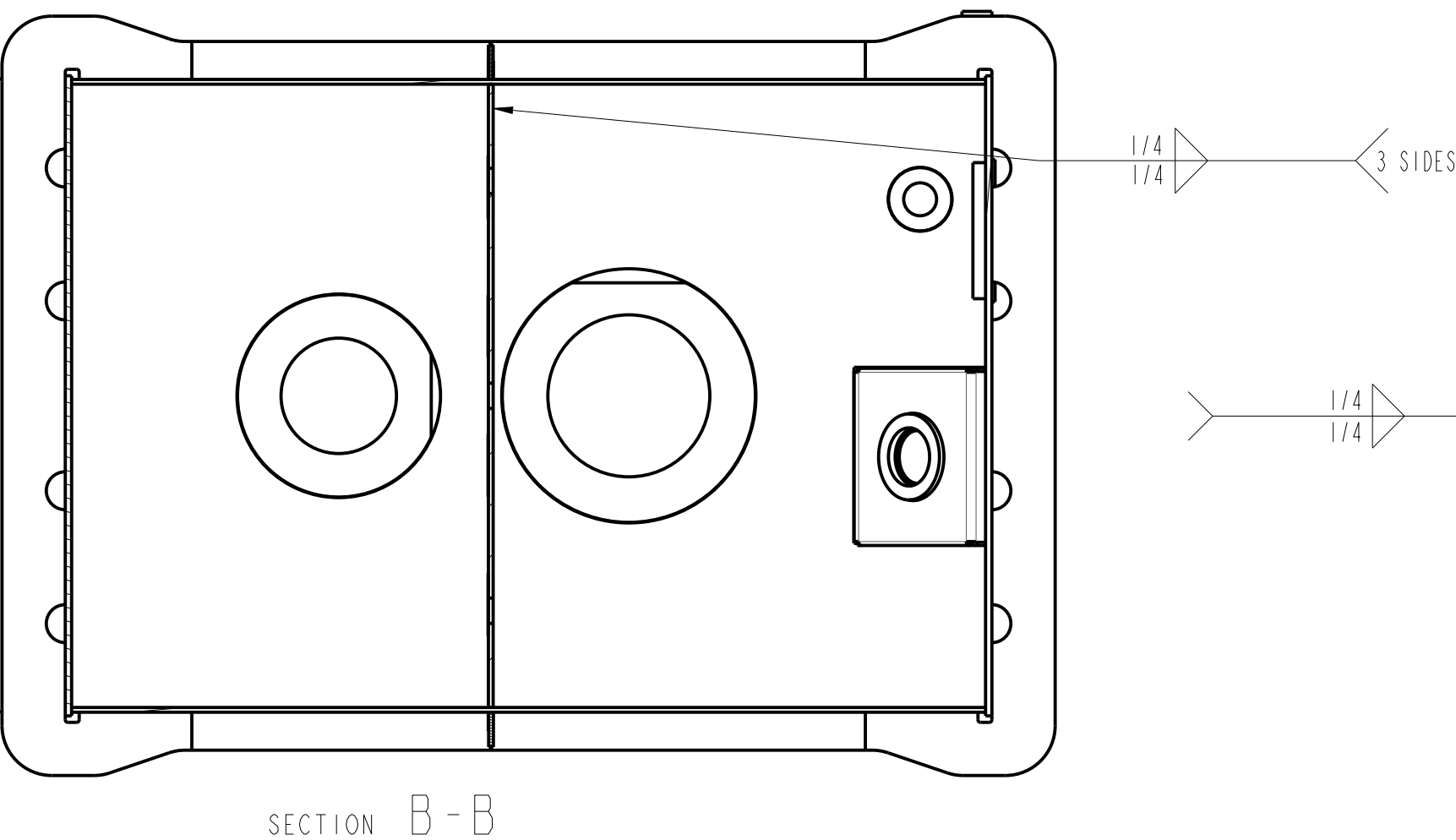
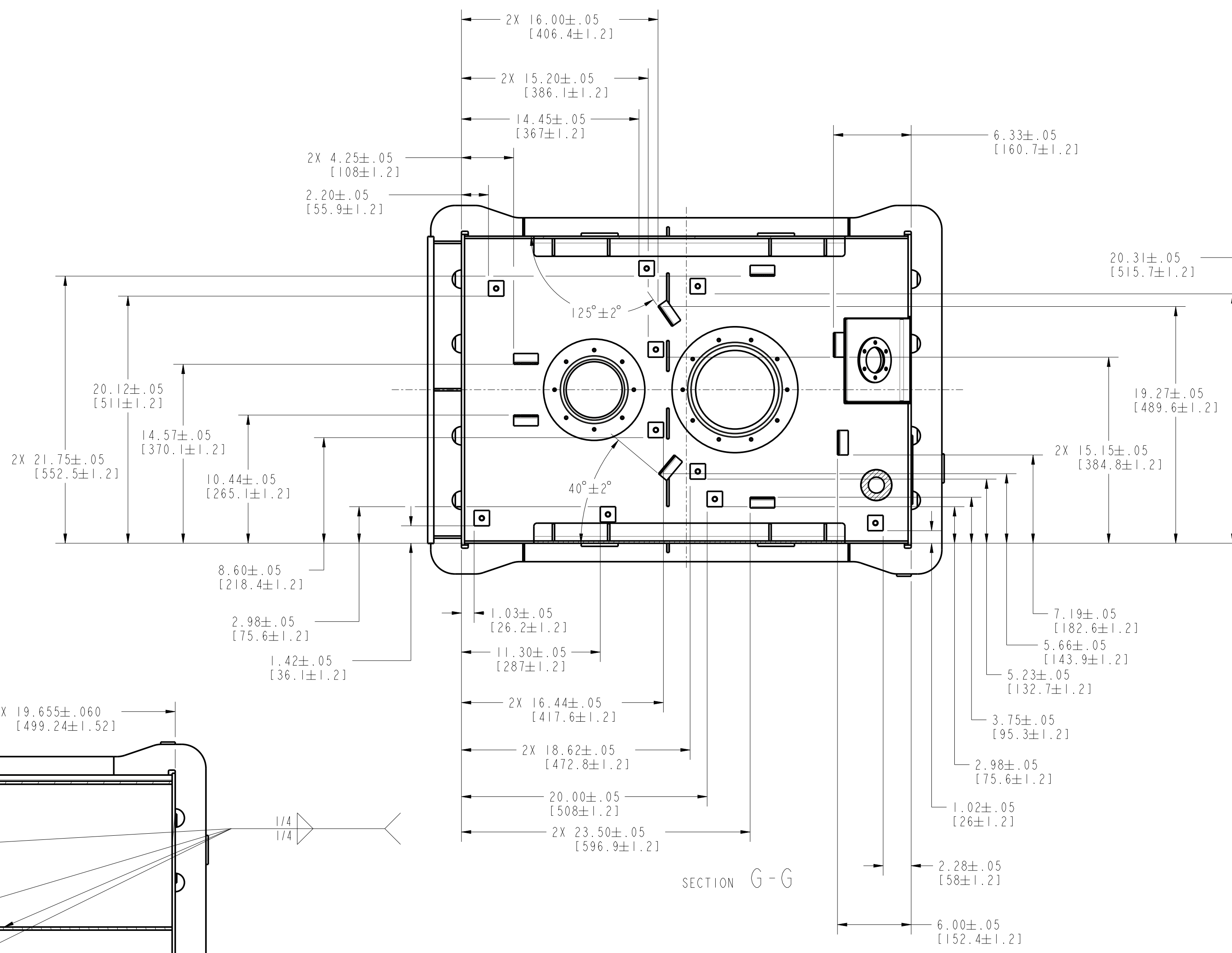
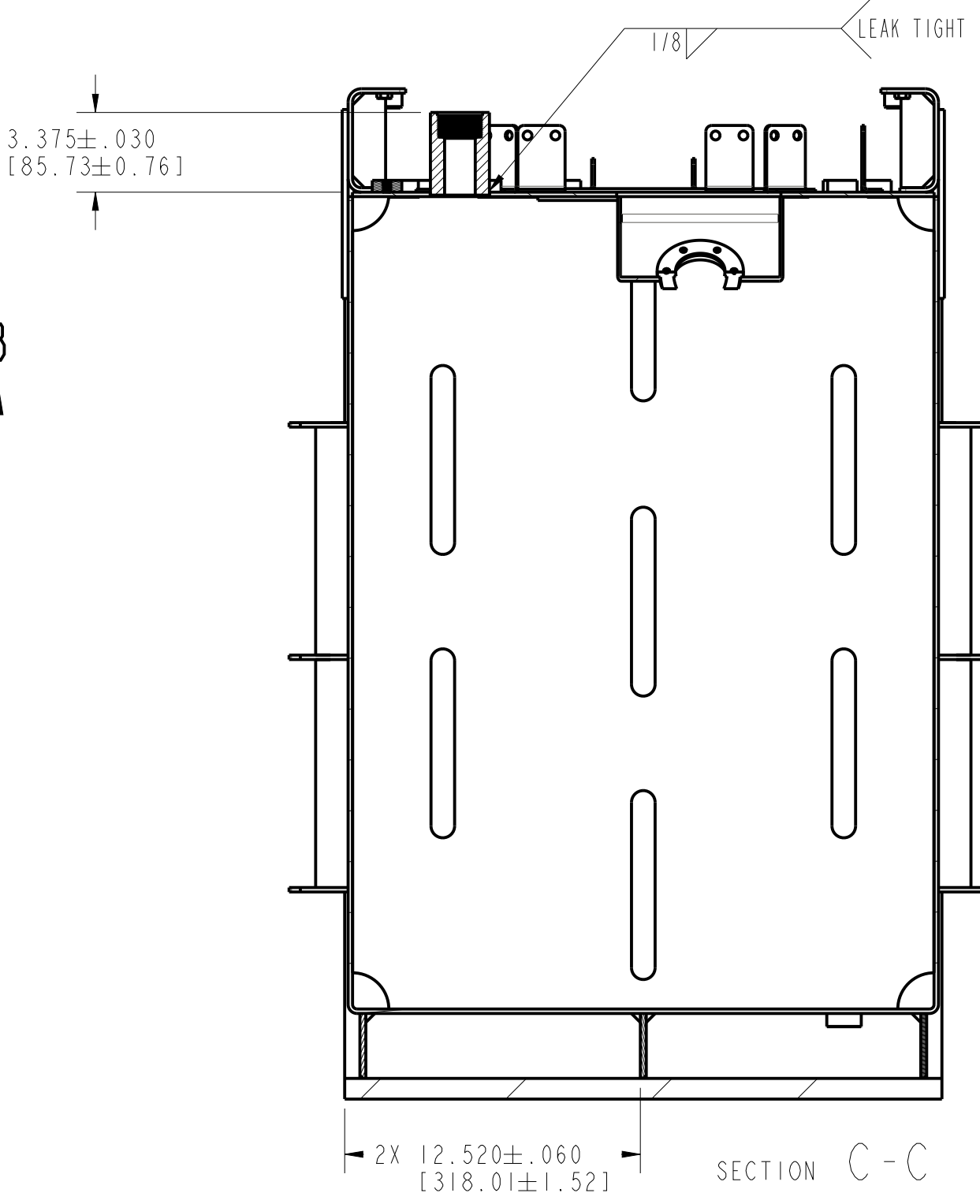
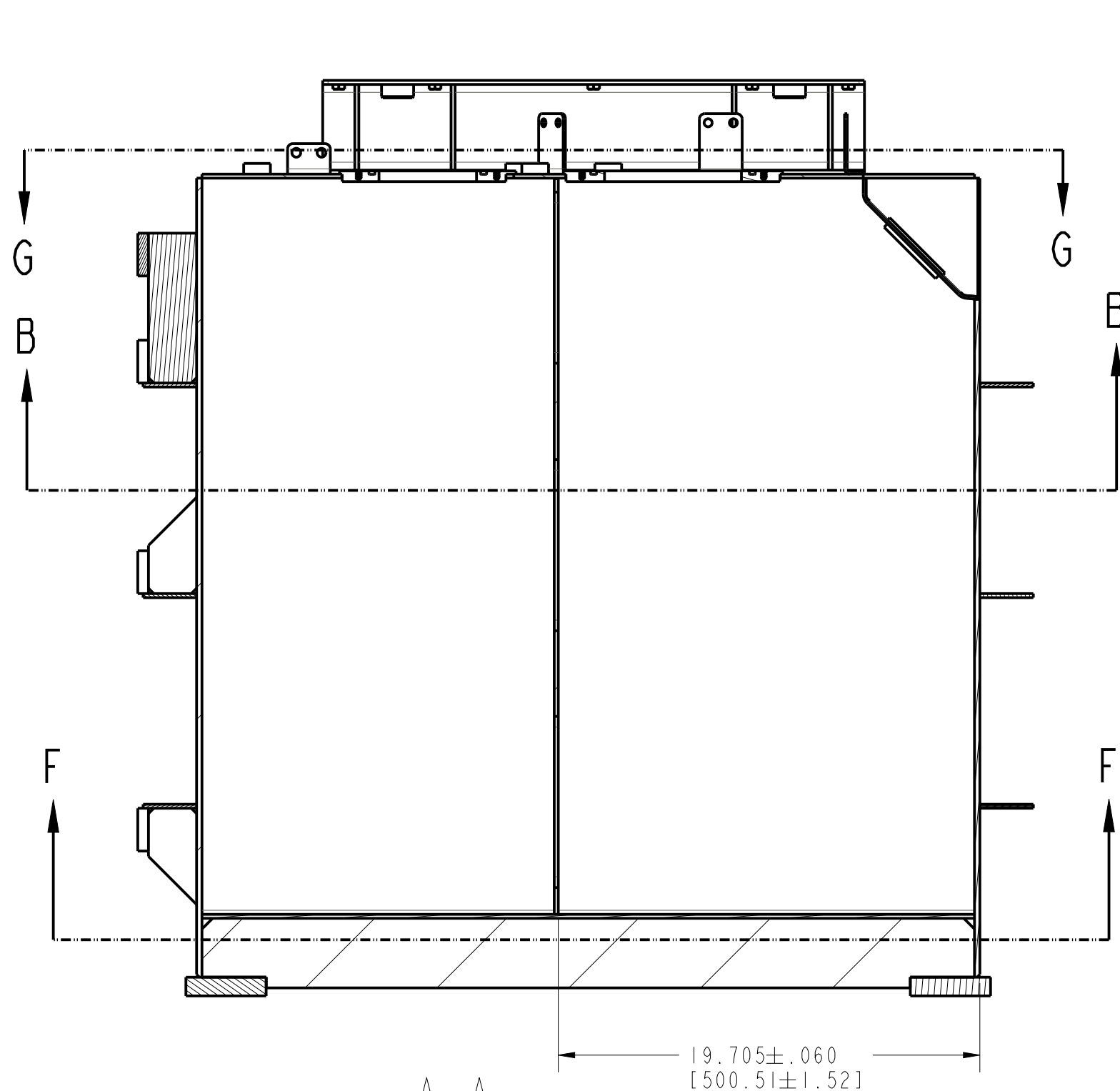
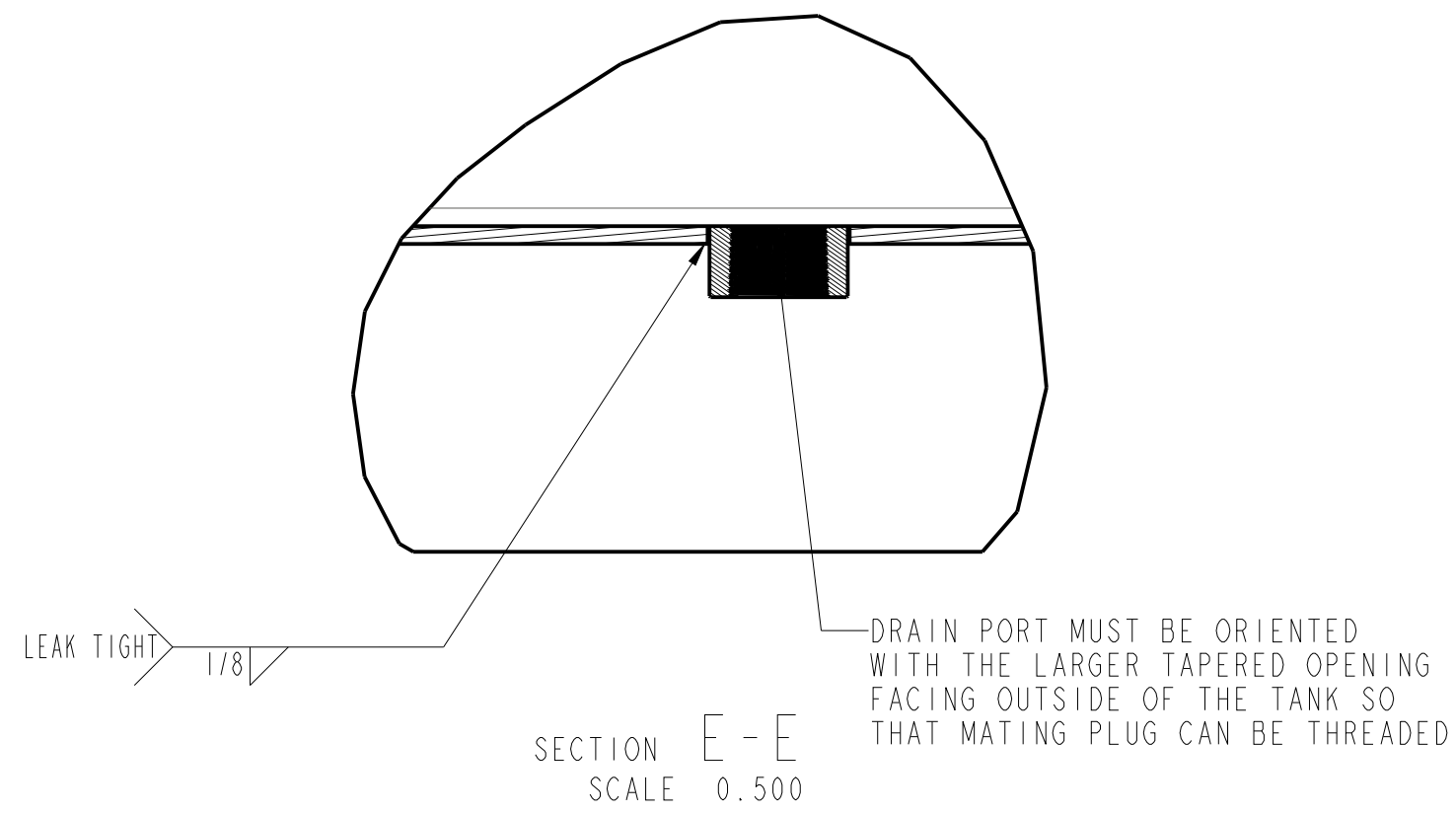
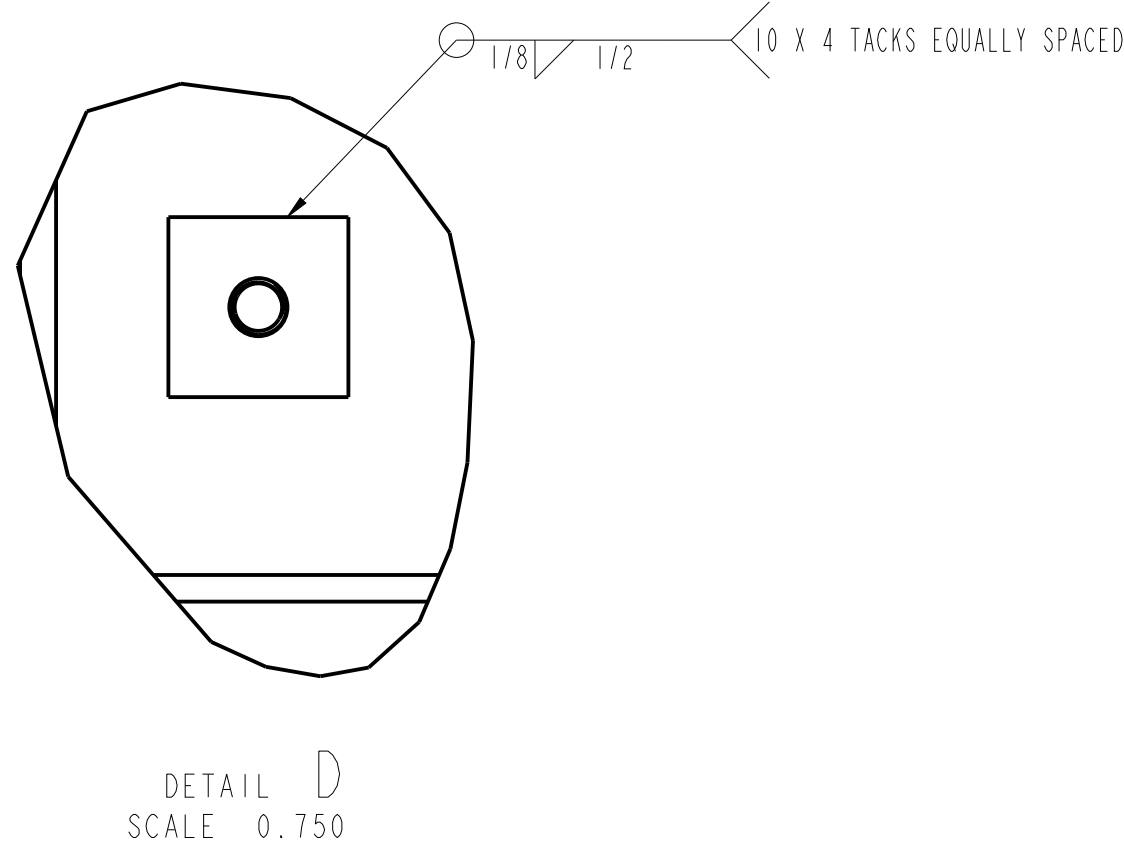
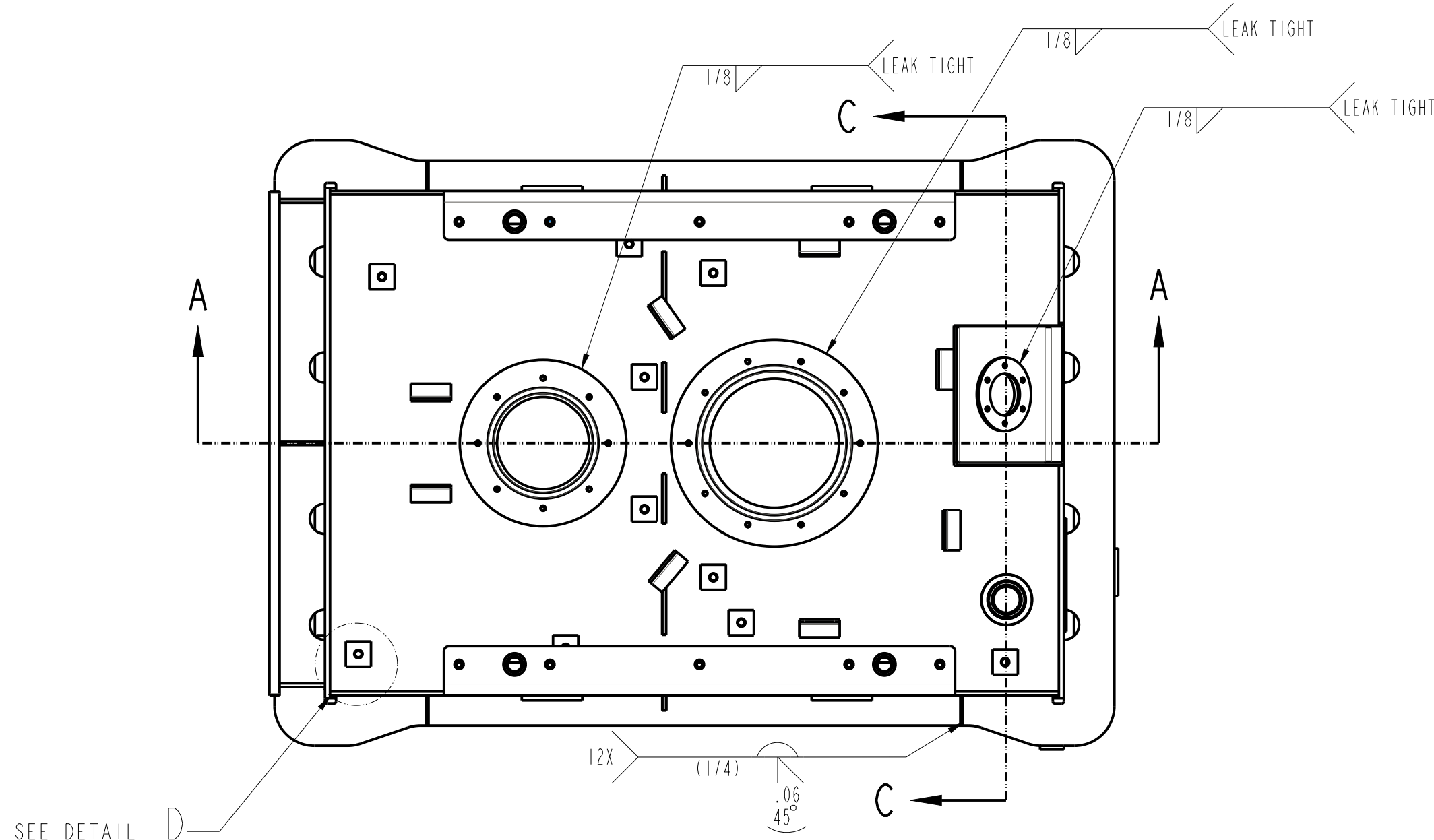


- NOTES:
1. ALL WELDING IS TO BE IN ACCORDANCE WITH AWS D 1.6 STANDARDS USING 308L SS FILLER ROD/WIRE ONLY.
 2. OUTSIDE SEAMS TO BE BACK-WELDED 100% OR OUTSIDE CORNER-FILLET WELDED WITH 100% WELD PENETRATION.
 3. ALL WELDS TO BE VISUALLY INSPECTED.
 4. ALL WELDS ARE GMAW EXCEPT AS NOTICE
 5. FINISH: BARE MILL.
 6. ALL WELDS DESIGNATED "LEAK TIGHT" SHALL BE INSPECTED WITH PRESSURIZED WATER TEST PER QCP-1162. THE MAXIMUM TEST PRESSURE IN THE TANK, Pmax, IS 4 PSI. ALL LEAKS FOUND MUST BE REPAIRED AND RETESTED.
 7. UNLESS OTHERWISE SPECIFIED, BLOCK TOLERANCES DO NOT APPLY TO REFERENCE DIMENSIONS.
 8. WELDING PROCESS: GMAW WITH WELD SIZE MAXIMUM OF 3/16 UNLESS OTHERWISE SPECIFIED.
 9. MIG (GMAW) WELD SPATTER PARTICLES TO BE SCRAPPED/GROUND LOOSE FROM INNER TANK WALLS, BAFFLES AND BOTTOM AND REMOVED PRIOR TO SHIPPING.
 - 9.1 TOOLS USED TO SCRAP AND GRIND SPATTER MUST BE FREE/CLEANED OF ALL NOT STAINLESS METAL TO PREVENT EMBEDDED NON-STAINLESS STEEL METAL FROM BEING LEFT IN THE TANK THAT COULD CORRODE.
 10. THE INSIDE OF THE TANK ASSEMBLY MUST BE FREE OF ALL DEBRIS VISIBLE TO THE UNAIDED EYE. COVERS SHOULD BE USED ON OPENINGS TO PRESERVE CLEANLINESS THROUGH THE PROCESS TO THE NEXT LEVEL ASSEMBLY.
 11. (KEY) DENOTES KEY CHARACTERISTICS.

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REMOVE ALL BURRS AND SHARP EDGES TO .010 R MAX.		MACHINED SURFACES SHALL HAVE A 125 MICRO-FINISH OR BETTER.		CUSTOMER REFERENCE	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES DIMENSIONS DESIGNATED (XX) ARE IN MILLIMETERS		DRAWING SCALE: 0.156 SHOWN FOR REFERENCE ONLY DO NOT SCALE DRAWING		THIS DRAWING CONFORMS TO ASME Y14.5-2009 AND SHAW DEVELOPMENT ES-2030	
THIRD ANGLE PROJECTION		DRAWING NO. 918-1320-01		REVISION C	
DRAWING STATE: Released		SHEET 1 of 3			



REVISIONS					
RELEASE	LTR	DESCRIPTION	DRAWN/REV. BY	ENGINEER	DATE
		SEE SHEET 1			
				APPROVALS	ON FILE



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DECIMALS ANGLES MM
XX ±.030 ±1/2° X ±.76
.XXX ±.010 .XX ±.254

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MANUFACTURING DRAWING

CUSTOMER REFERENCE

ORIGINAL RELEASE DATE 21-JUN-2019

THIS DRAWING CONFORMS TO ASME Y14.5-2009 AND SHAW DEVELOPMENT ES-2030

THIRD ANGLE PROJECTION

SHAW DEVELOPMENT

25190 Bernwood Dr., Bonita Springs, Florida 34135 WWW.SHAWDEV.COM

TITLE TANK WELDMENT, DEF

CODE IDENT NO. 59647 SIZE D DRAWING NO. 918-1320-01 REVISION C

DRAWING STATE Released SHEET 2 of 3

D

C

B

A

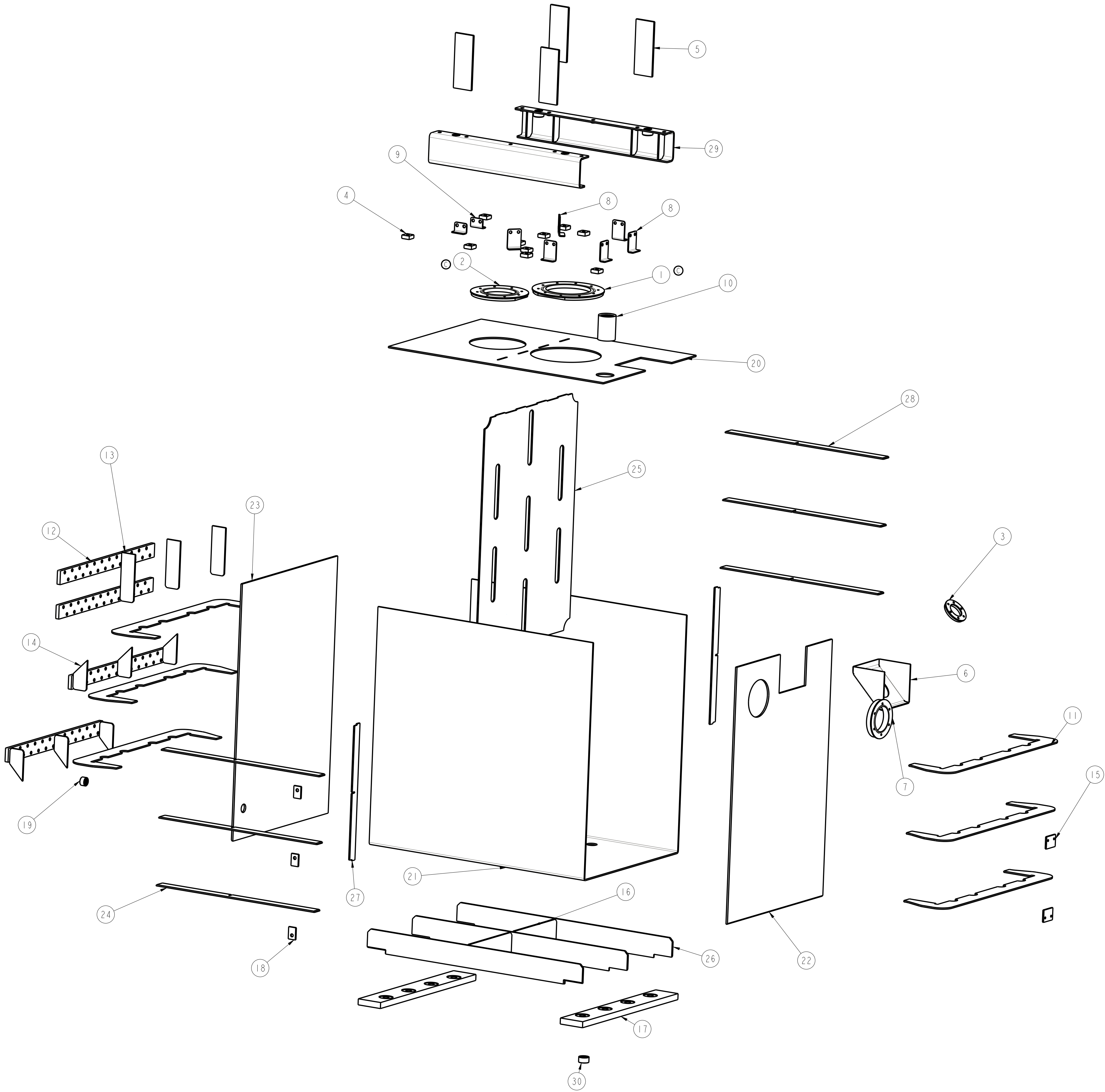
D

C

B

A

REVISIONS					
RELEASE	LTR	DESCRIPTION	DRAWN/REV. BY	ENGINEER	DATE
		SEE SHEET 1			
				APPROVALS	ON FILE



30	1	999-0847-01	3/4 NPT HALF COUPLING	STAINLESS-STEEL-316L	A
29	2	918-1322-01	BRACKET WELDMENT	-	A
28	3	918-1320-11	EXTERNAL STIFFENER	STAINLESS-STEEL-316L	A
27	2	918-1320-10	VERTICAL EXTERNAL STIFFENER	STAINLESS-STEEL-316L	A
26	3	918-1320-08	GUSSET, PLATE	STAINLESS-STEEL-316L	A
25	1	918-1320-07	BAFFLE	STAINLESS-STEEL-316L	A
24	3	918-1320-06	EXTERNAL STIFFENER	STAINLESS-STEEL-316L	B
23	1	918-1320-05	BACK PANEL	STAINLESS-STEEL-316L	A
22	1	918-1320-04	END PANEL	STAINLESS-STEEL-316L	A
21	1	918-1320-03	BOTTOM PANEL	STAINLESS-STEEL-316L	A
20	1	918-1320-02	TOP PANEL	STAINLESS-STEEL-316L	A
19	1	918-0475-02	G1/2" PORT	STAINLESS-STEEL-316L	A
18	3	908-1869-18	PLATE	STAINLESS-STEEL-316	A
17	2	908-1869-16	MOUNTING PAD	STAINLESS-STEEL-316L	A
16	2	908-1869-15	BOTTOM SUPPORT	STAINLESS-STEEL-316	A
15	2	908-1869-14	PLATE	STAINLESS-STEEL-316L	A
14	6	908-1869-13	ANGLED STIFFENER BLOCK	STAINLESS-STEEL-316L	A
13	3	908-1869-12	STIFFENER BLOCK	STAINLESS-STEEL-316L	A
12	4	908-1869-11	THREADED BAR	STAINLESS-STEEL-316L	A
11	6	908-1869-08	HORIZONTAL EXTERNAL STIFFENER	STAINLESS-STEEL-316L	A
10	1	908-1774-01	BOSS, SAE -24	STAINLESS-STEEL-304L	A
9	2	908-1404-23	BRACKET	STAINLESS-STEEL-316L	A
8	6	908-1404-21	BRACKET	STAINLESS-STEEL-316L	A
7	1	908-1404-19	FLANGE, FF	STAINLESS-STEEL-316L	A
6	1	908-1404-18	PANEL, FILLER	STAINLESS-STEEL-316L	A
5	4	908-1404-17	LUG, LIFTING	STAINLESS-STEEL-304L	A
4	10	908-1404-10	TAB, WELDMENT	STAINLESS-STEEL-316L	A
3	1	908-0405-16	BOLT FLANGE	STAINLESS-STEEL-304L	B
2	1	908-0405-15	BOLT FLANGE	STAINLESS-STEEL-304L	D
1	1	908-0405-14	BOLT FLANGE	STAINLESS-STEEL-304L	D
ITEM NO.	QTY. REQD.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	REV.

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DECIMALS	ANGLES	MM
.XX ± .030	± 1/2°	.X ± .76
.XXX ± .010		.XX ± .254

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NEXT ASSY 918-1320-01P

REV 4832

MANUFACTURING DRAWING

CUSTOMER REFERENCE

ORIGINAL RELEASE DATE 21-JUN-2019

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THIRD ANGLE PROJECTION

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TITLE TANK WELDMENT, DEF

CODE IDENT NO. 59647	SIZE D	DRAWING NO. 918-1320-01	REVISION C
DRAWING STATE Released			SHEET 3 of 3

8

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3

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