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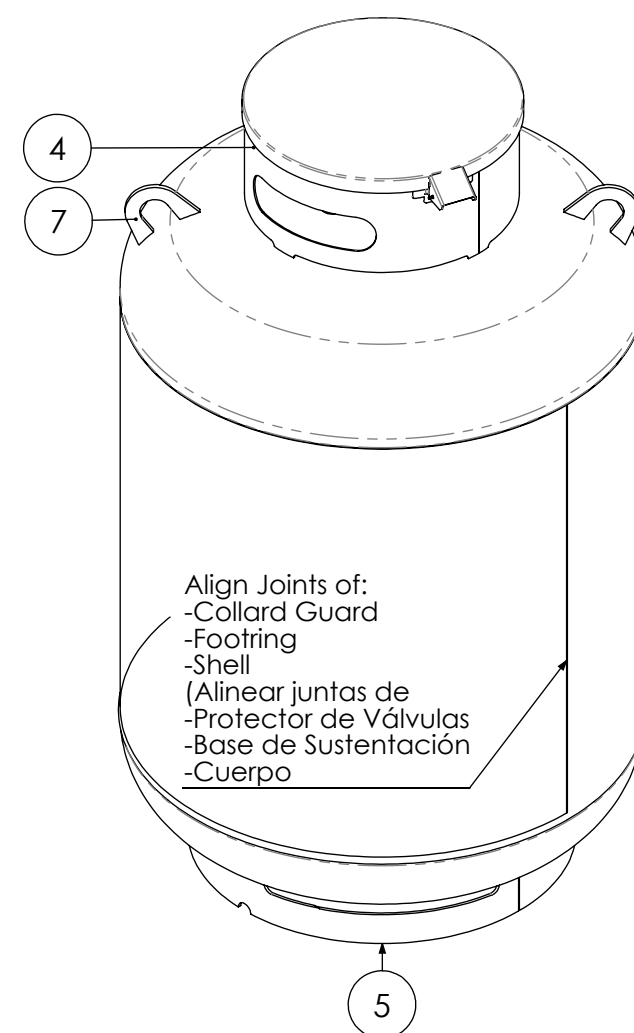
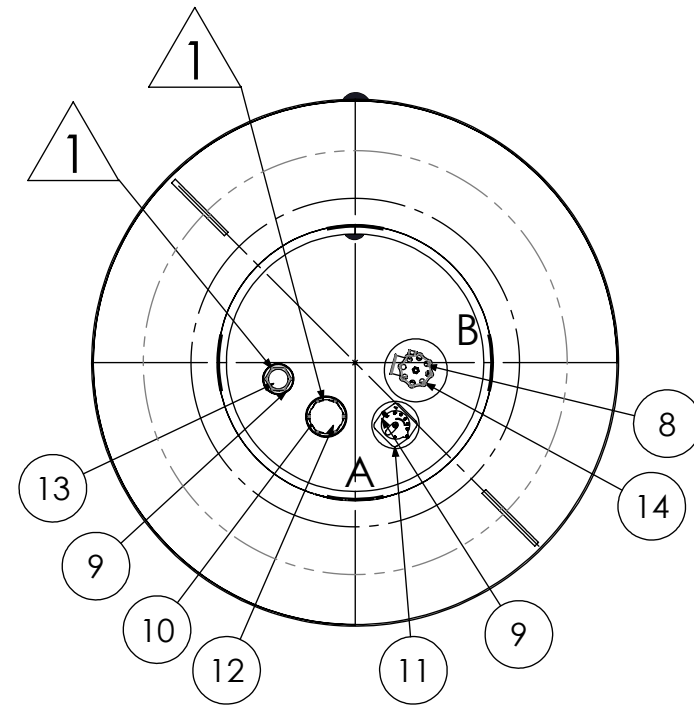
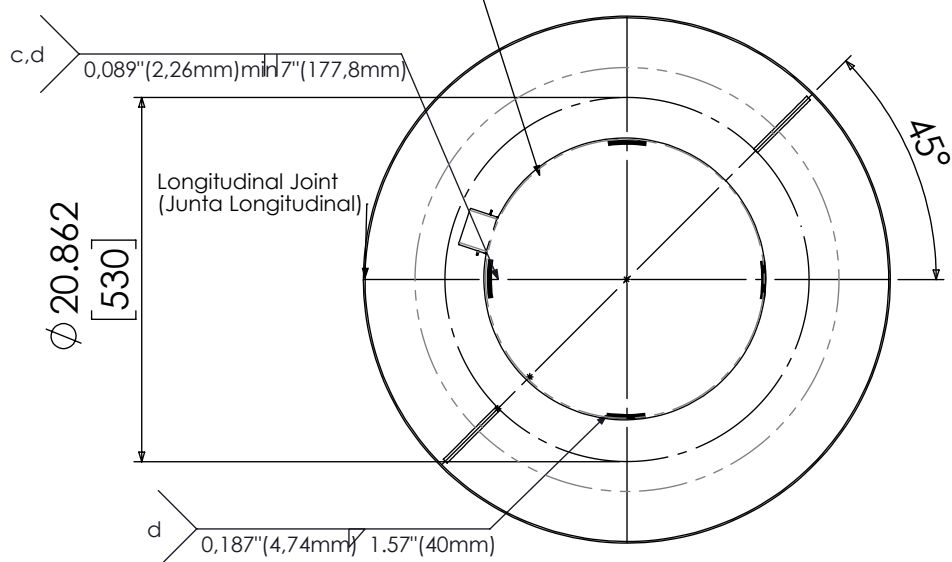
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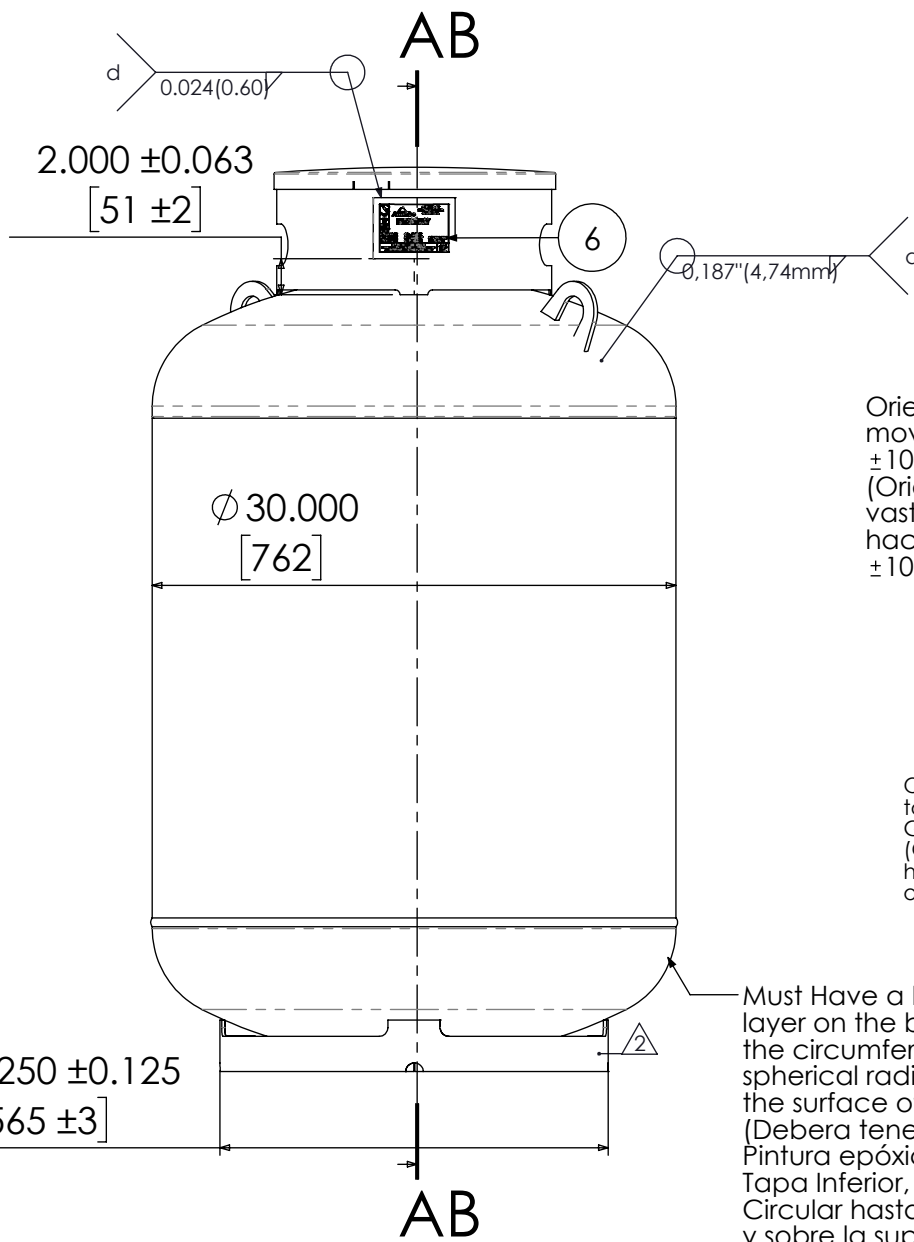
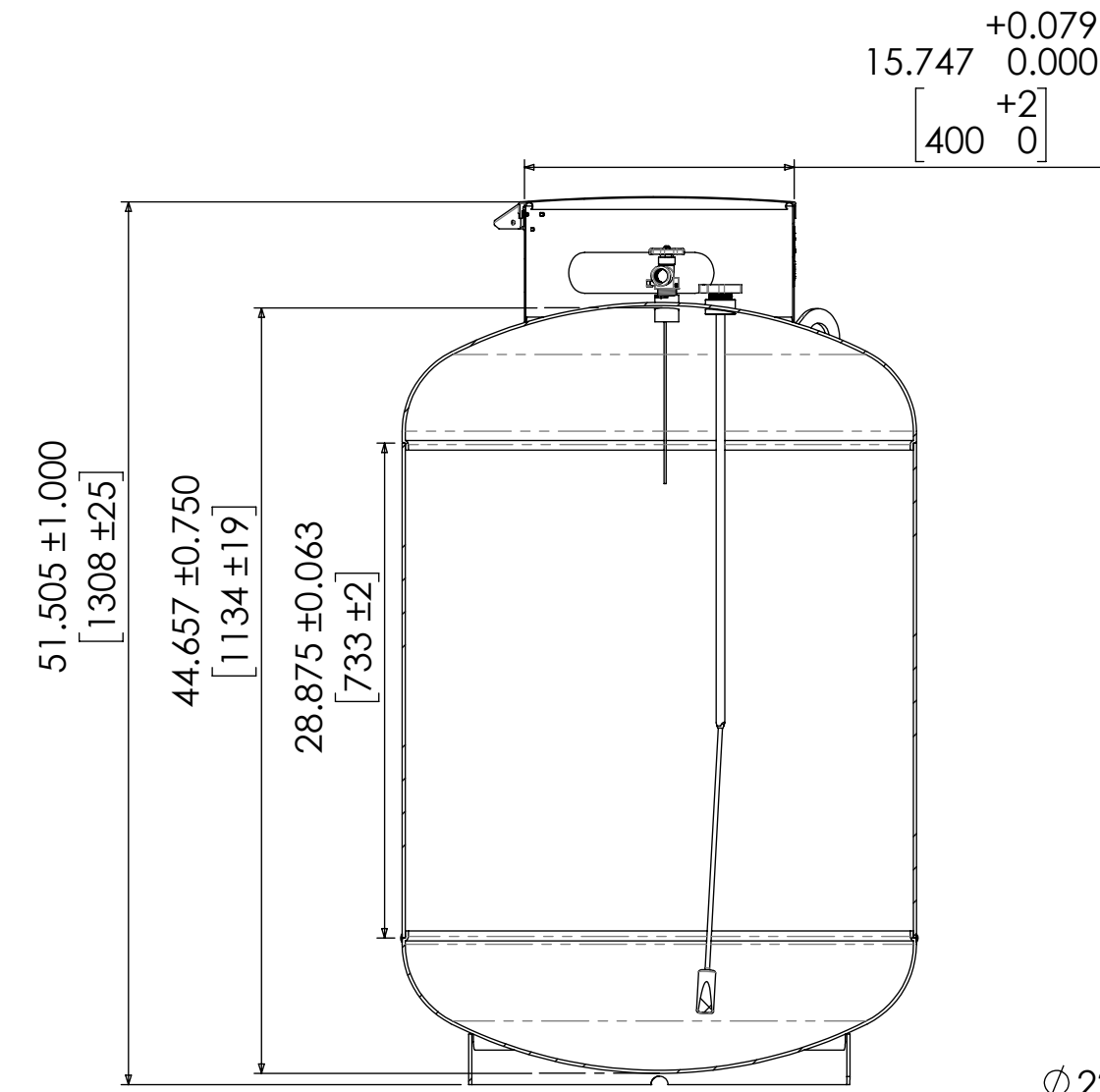
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Collard Guard Must be welded over Top Head, with 4 equidistant external seams
(El protector de válvulas sera soldado sobre la tapa superior con 4 cordones exteriores equidistantes)



Align Joints of:
- Collard Guard
- Footring
- Shell
(Alinear juntas de
- Protector de Válvulas
- Base de Sustentación
- Cuerpo



Orient level gauge stem movement to Lifting Lug (F) ± 10° of tolerance.
(Orientar Movimiento del vástago del indicador hacia la Oreja de lzaje (F) ± 10° de Tolerancia)

Orient Output Service Valve to opposite window of Collar Guard
(Orientar Salida de Válvula de Servicio hacia el centro de la ventana opuesta del Cuello Protector)

Must Have a Black Epoxic layer on the bottom head, below the circumferential seam to the spherical radius, and over the surface of Footring
(Debera tener Una capa de Pintura epóxica negra en la Tapa Inferior, debajo del cordon Circular hasta el radio de abombado, y sobre la superficie de la base de sustentación)

DETAIL A SCALE 1:2

DETAIL B SCALE 1:2

DESIGN DATA (DATOS DE DISEÑO)

ASME CODE SECTION VIII, DIV. 1, 2021 EDITION

Table with 4 columns: Parameter, Value, Unit, and Notes. Includes Vessel Use, ASME Code Stamp, Capacity, Weight, Pressure, Temperature, Test Pressure, MAWP, Heat Treatment, Impact Test, Corrosion, Radiographic Exam, etc.

NOZZLES TABLE (TABLA DE BOQUILLAS)

Table with 10 columns: NUMBER, QTY., SIZE, FLANGE TYPE, MATERIAL, REGARDS NOZZLES, TYPE, CORR., PURPOSE (USO), TORSION (TORQUE). Lists 15 nozzle specifications.

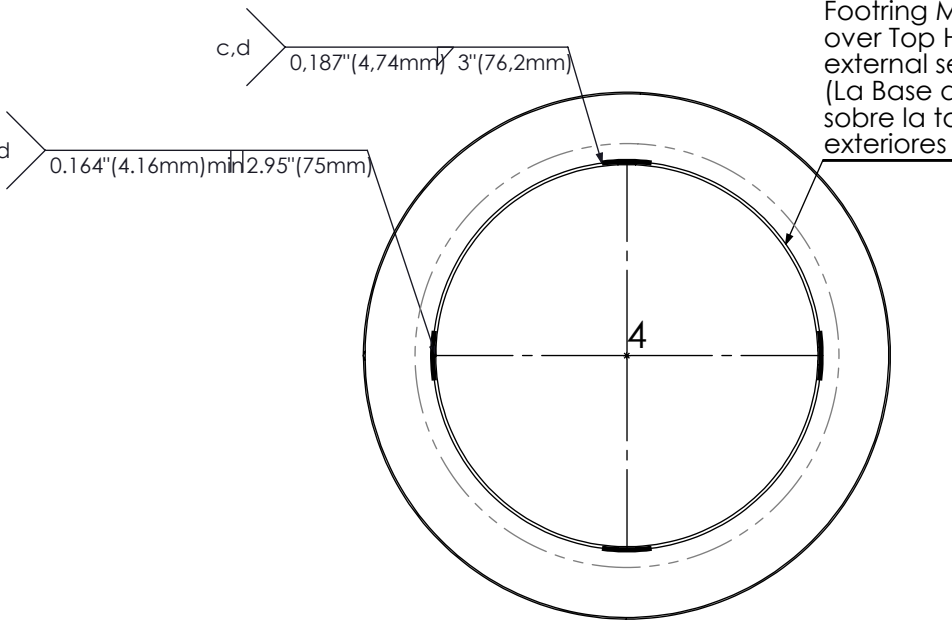
LISTA DE MATERIALES (BILL MATERIALS)

Table with 6 columns: ITEM NO., QTY., DESCRIPTION (DESCRIPCIÓN), FUNCTION (FUNCIÓN), MATERIAL (MATERIAL), DRAWING (DIBUJO), KEY PART (CLAVE). Lists 19 material items.

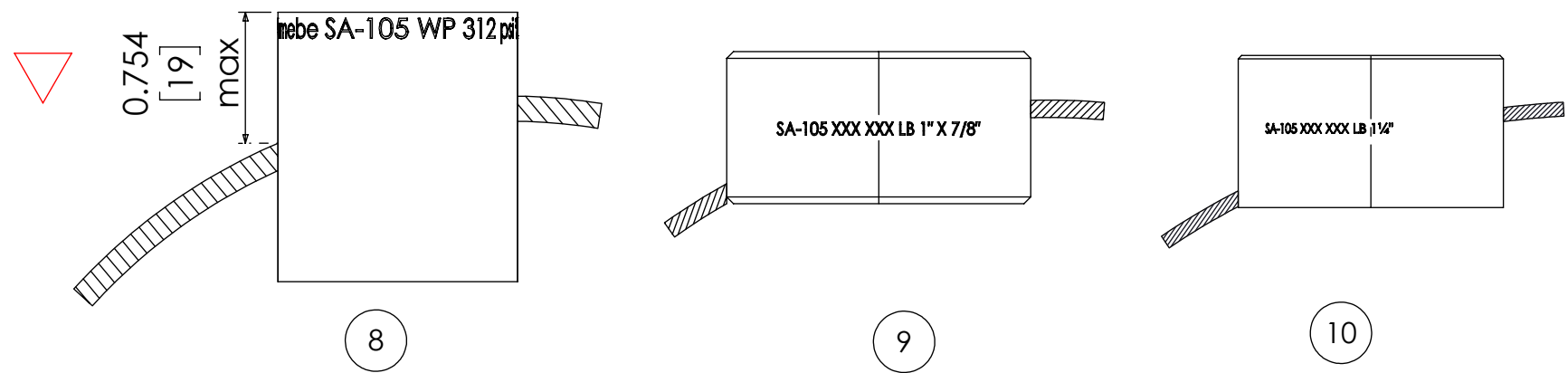
GENERAL NOTES (NOTAS GENERALES)

- 1- La variación del volumen debe mantenerse dentro de 22% (Volume variation must maintain within 22%)
2- Tolerancias en los Retes de soldadura +0.125 -0 (+3.175 -0) (Weld tolerances +0.125 -0 (+3.175 -0))
3- Las perforaciones para las boquillas deberán quedar fuera de los ejes principales (Flange holes shall straddle the center line of the vessel)
4- Las boquillas no deberán ser colocadas en cordones de soldadura (Nozzle openings shall not be placed on weld areas if visible)
5- Prueba final de hermeticidad neumática: 100 psi (7.0 kg/cm2) a 120 psi (8.4 kg/cm2) Final pneumatic leak test: 100 psi (7.0 kg/cm2) a 120 psi (8.4 kg/cm2)
6- Limpiar el exterior del recipiente antes de dar el acabado final, por medio de fosforizado (Clean the vessel surface before final appearance, with phosphat)
7- Las válvulas deben tener sellador Everseal-183 para cuerdas y no debe ser quebrado para evitar fugas posteriores al ensamble. (Valves must have seal and must not be fragile to prevent subsequent LP leak to assembly)
8- Acabado interior del recipiente libre de residuos del proceso de fabricación (Vessel's internal appearance shall be free of residues of fabrication process)
9- El recipiente deberá estar exento de basura, grasa y escoria de soldadura (Vessel shall be exempt of trash, grease and weld spatter)
10- Evitar filos cortantes (Free of cut edge)

REVISIONS table with columns: ZONE, REV., DATE, DESCRIPTION, APPROVED. Shows 3 revisions.



Footring Must be welded over Top Head, with 4 equidistant external seams
(La Base de sustentación sera soldada sobre la tapa superior con 4 cordones exteriores equidistantes)



LONGITUDINAL JOINT

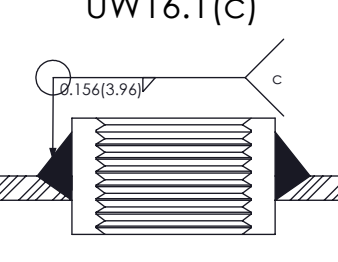
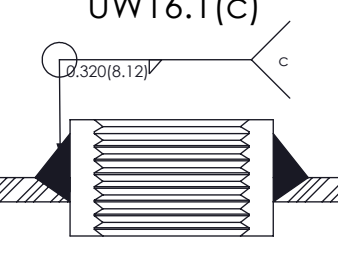
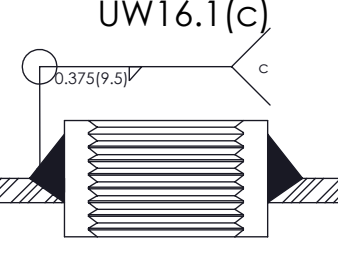
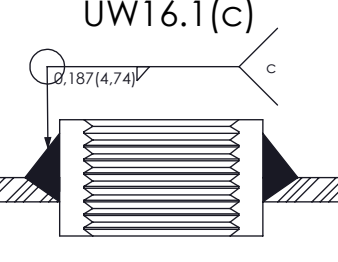
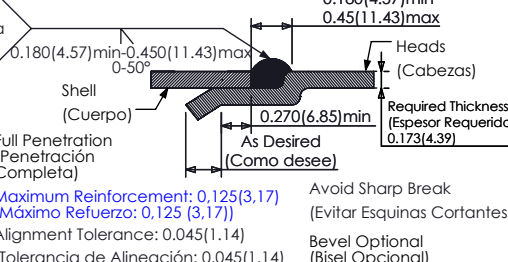
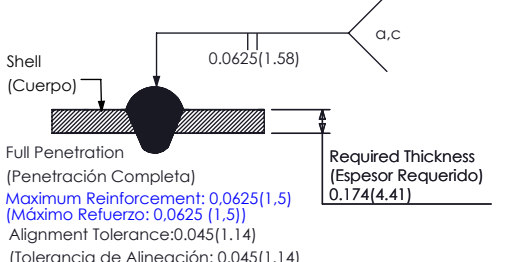
CIRCUMFERENTIAL JOINT

W1 SERVICE VALVE

W2 RELIEF VALVE

W3 LEVEL GAUGE

W4 FILLER VALVE



WELDING PROCEDURE SPECIFICATION (ESPECIFICACIÓN DE PROCESO DE SOLDADURA) table with columns: Item, WPS No., Rev., Process, etc.

FINISH (ACABADO) table with columns: Item, Description, etc.

Table with columns: DATE, NAME, SIGN, etc. for drawing approval.

Company information: TANQUES MENHER, S.A DE C.V. COLOSO DE RODAS NO. 46 COL. 7 MARAVILLAS DEL GUSTAVO A. MADERO C.P. 07700 MÉXICO D.F. Includes Arambe logo and drawing title: 120 GALLONS VERTICAL STATIONARY TANK WITH STANDARD VALVE.

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