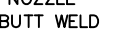

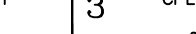
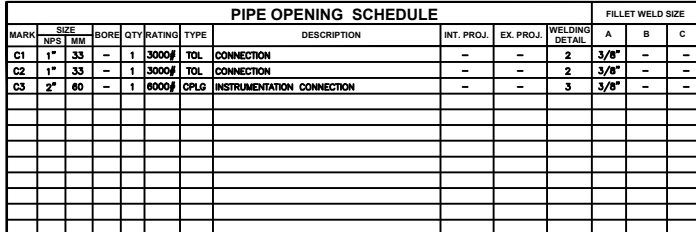


<p><b>1</b> NOZZLE BUTT WELD</p>  <p>PES-WPS-02</p>	<p><b>2</b> OLET</p>  <p>PES-WPS-02</p>	<p><b>3</b> CPLG</p>  <p>PES-WPS-04 SEE NOTE 10 &amp; 11</p>
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**NOTES:**

1. REGISTERED QUALITY CONTROL PROGRAM AQP 1084.
2. EXTERIOR & INTERIOR OF PIPE TO BE FREE OF WELD SLAG, SPATTER, GREASE, MOISTURE, ETC.
3. ALL DIMENSIONS ARE IN MILLIMETERS, UNLESS OTHERWISE NOTED.
4. ALL PIPING CUT LENGTHS ARE CALCULATED WITH A (3 mm) WELD GAP.
5. FOR TACK WELDS USE PES-WPS-02.
6. DESIGN PRESSURE EQUALS MAXIMUM ALLOWABLE WORKING PRESSURE.
7. WELD DETAIL #2 SHALL APPLY TO C1, C2.
8. ASCEP/ASME SUBSTITUTIONS: SA-333-6 FOR SA-106B, SA-350-F2 CL1 FOR SA-105N, SA-420-WPL6 FOR SA-234-WPB.
9. ALL BEVEL ANGLES +/- 15 DEGREES.
10. WELD DETAIL #3, AS PER B31.3 LATEST ADDENDA FIG 328.4.3(a) CIRCUMFENTIAL WELDING TO ALIGN PIPE FITTINGS TO A MAX OF 30" INTERNAL BEVEL.
11. 2" 6000# HALF CPLG TO HAVE 30" OUTSIDE BEVEL (ONE SIDE ONLY).
12. IMPACT TESTING EXEMPT PER MAT'L TABLE A-1 AND TABLE 323.2.2A
13. SANDBLAST SSPC-SP6
14. PRIME (1) ONE COAT DTM WARM GREY  
PAINT (1) ONE COAT DTM WARM GREY

[illegible]