

FORM U-1A MANUFACTURERS' DATA REPORT FOR UNFIRED PRESSURE VESSELS

Alternate Form for Single Chamber Completely Shop-Fabricated Vessels Only

CUST. ORDER NO. 2-089941-7083 3/21/61

1. Manufactured by U.S. STEEL CORP., NATIONAL TUBE DIVISION, CHRISTY PARK WORKS, McKEESPORT, PA.

2. Manufactured for BOEING AIRPLANE CO., SEATTLE, WASHINGTON

3. Type Horizontal Vessel No. (7113) (Mfrs. Serial) (State & State No.) Natl. Bd. No. 7113 Yr. Built 1961

4. SHELL: Mat. A372 Cl IV T.S. 120,000 2mm 2.478 Corr. In. Diam. Fr 20 In. Lgth. 10 Ft. 44 In.

5. SEAMS: Long Seamless S.R. (Yes or No) X.R. Sectioned Efficiency 100 %
 Girth S.R. (Yes or No) X.R. Sectioned No. of Courses 1

If riveted or brazed describe seams fully under remarks.

6. HEADS: (a) Material T.S. (b) Material T.S.

Location (Top, bottom, ends)	Thickness	Crown Radius	Knuckle Radius	Elliptical Ratio	Conical Apex angle	Hemispherical Radius	Flat Diameter	Side to Pressure (Convex or Concave)
(a)								
(b)	<u>Integrally forged head & neck</u>						<u>10"</u>	<u>Concave</u>

If removable, bolts used _____ Other fastening _____ (Describe or Attach Sketch)

7. Constructed for 1st pressure of 8250 psi. Max. Temp. 200 °F. Subzero -20 °F. Hydrostatic Test 12375 psi.

8. SAFETY OR RELIEF VALVE OUTLETS: Number _____ Size _____ Location _____

9. NOZZLES:

Purpose (Inlet, Outlet, Drain)	Number	Diam. or Size	Type	Material	Thickness	Reinforcement Material	How Attached
<u>Inlet-outlet</u>	<u>1</u>	<u>3/32 Amisco</u>	<u>Threaded & seal welded</u>				
<u>Bottom vent</u>	<u>1</u>	<u>3/16" Amisco</u>	<u>Threaded & seal welded</u>				

10. INSPECTION Manholes, No. _____ Size _____ Location _____

OPENINGS Handholes, No. _____ Size _____ Location _____

Threaded, No. _____ Size _____ Location _____

11. SUPPORTS: Skirt (Yes or No) _____ Lugs (Number) _____ Legs 2 (Number) _____ Other _____ Attached Welded to pads on vessel (Where & How)

12. REMARKS: High pressure helium service

(Brief description of purpose of the vessel, as Air Tank, Water Tank, L.P.G., Etc.—State Contents.)

We certify that the statements made in this report are correct and that all details of material, construction, and workmanship of this vessel conform to the ASME Code for Unfired Pressure Vessels.

Date 5-18 19 61 Signed Nat. Tube Div., Christy Park Wks. By J. J. McKeen (Manufacturer) CHIEF INSPECTOR

Certificate of Authorization Expires December 31, 1961

RECEIVED

CERTIFICATE OF SHOP INSPECTION

JUN 28 1961

Inspector Agency's Serial No. 7113
 VESSEL MADE BY National Tube Div., Christy Park Works, McKeesport, Pa.

I, the undersigned, holding a Certificate of Competency as an Inspector of Boilers and Unfired Pressure Vessels in THE STATE OF Pa. and employed Warford Steam Boiler Insp. Assn. Co., Warford, Pa. inspected internally and externally, the vessel described in this report on 5-21 1961, and certify that the statements made in this report are correct corresponding with mill test reports of materials furnished by the builders, and measurements made of the vessel and that this vessel is constructed in accordance with the ASME Code for Unfired Pressure Vessels.

Date 5-18 19 61 Inspector's Signature W. G. [Signature] Commission No. 2421 State of Pa. 1275 Ohio 1401