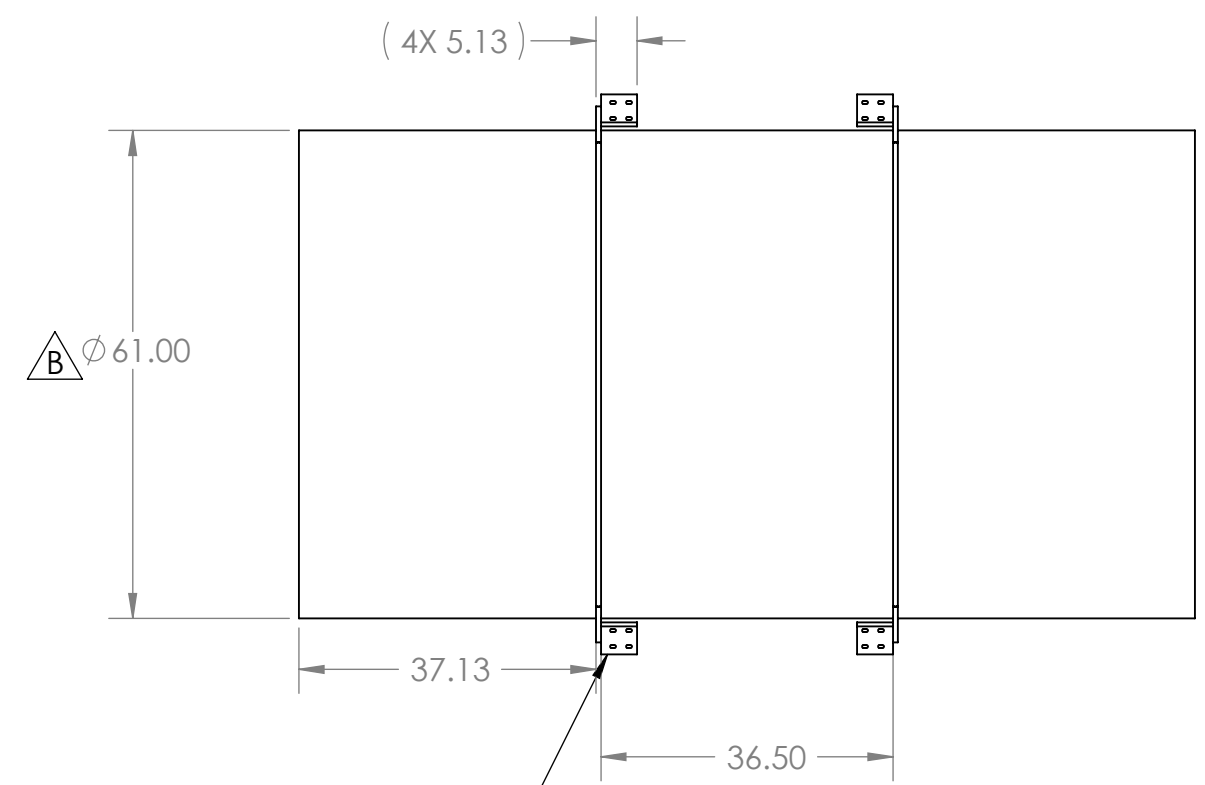
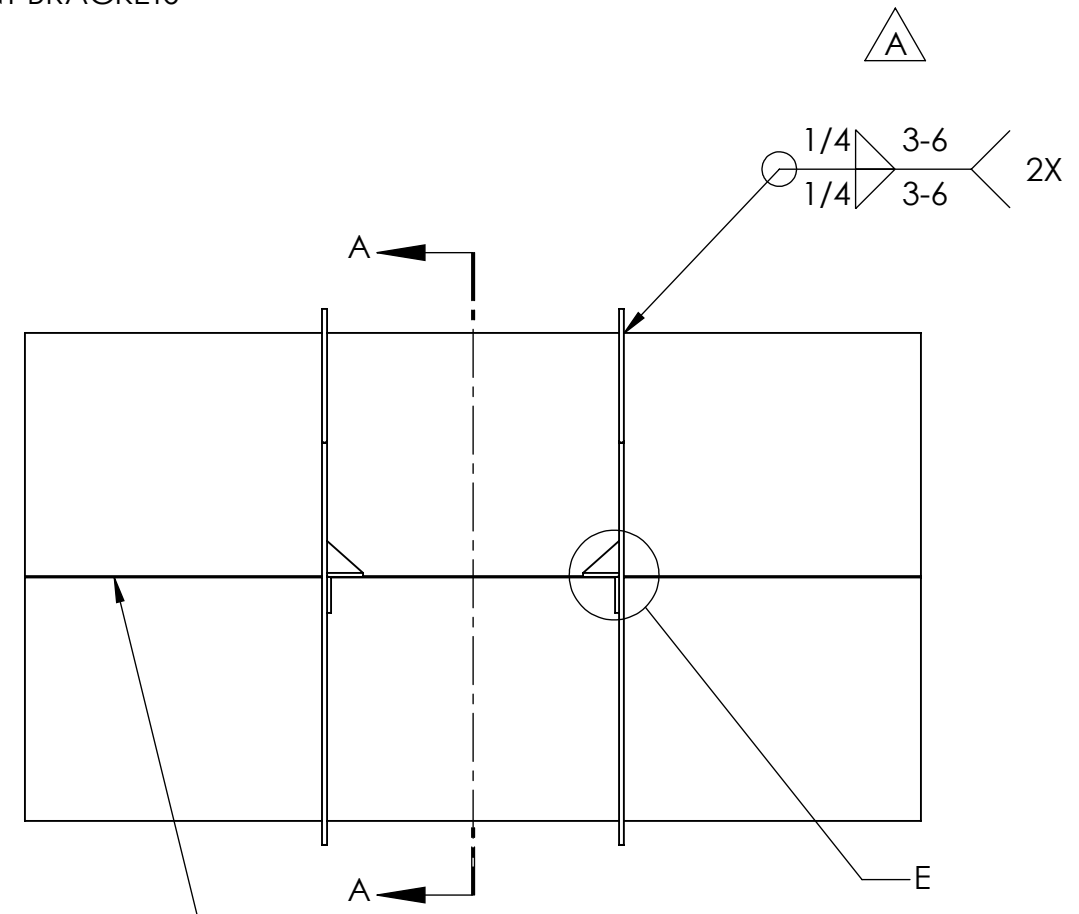
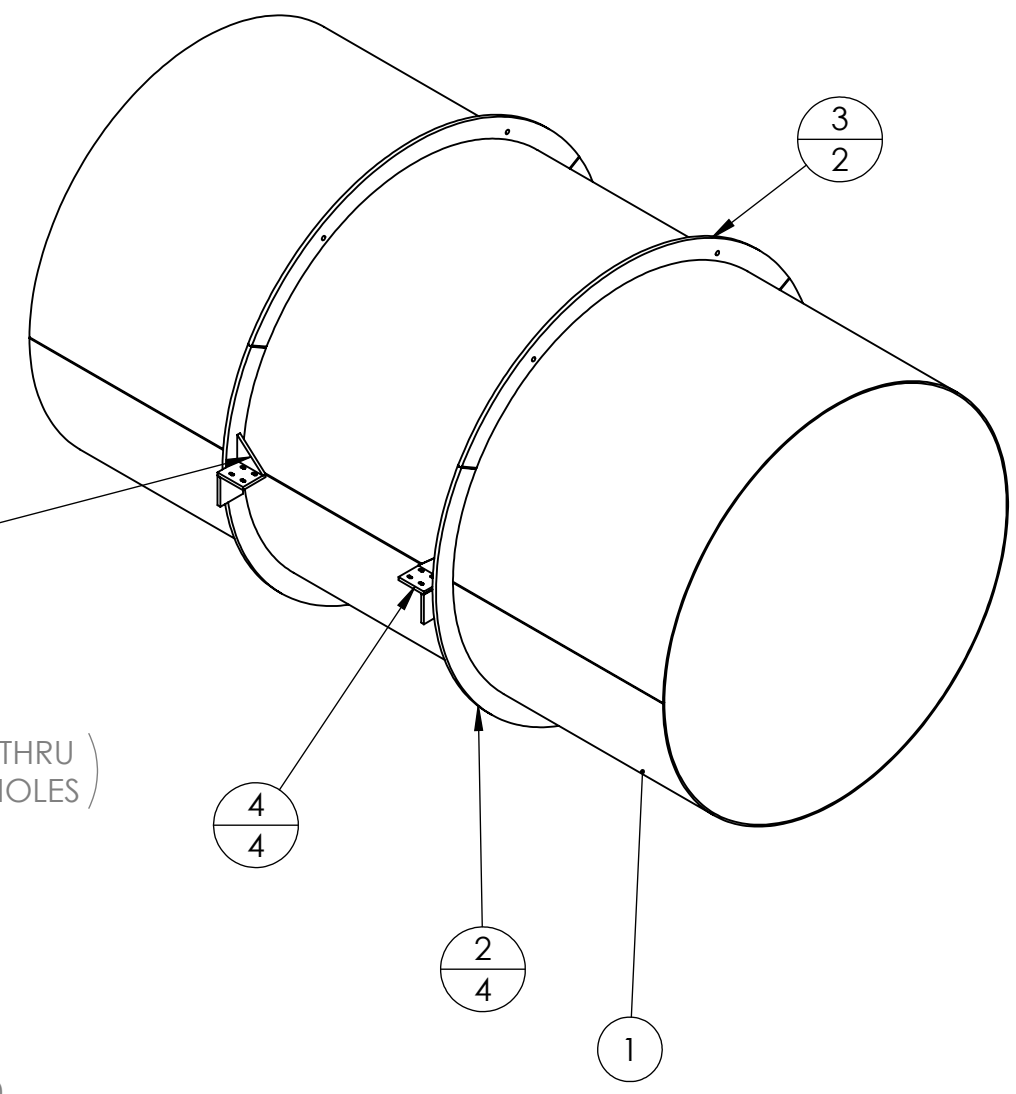
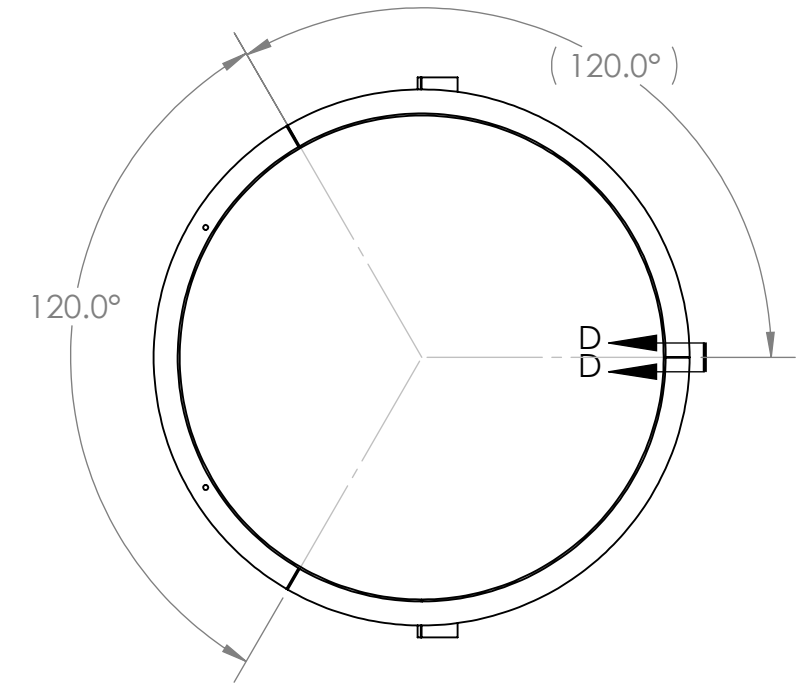


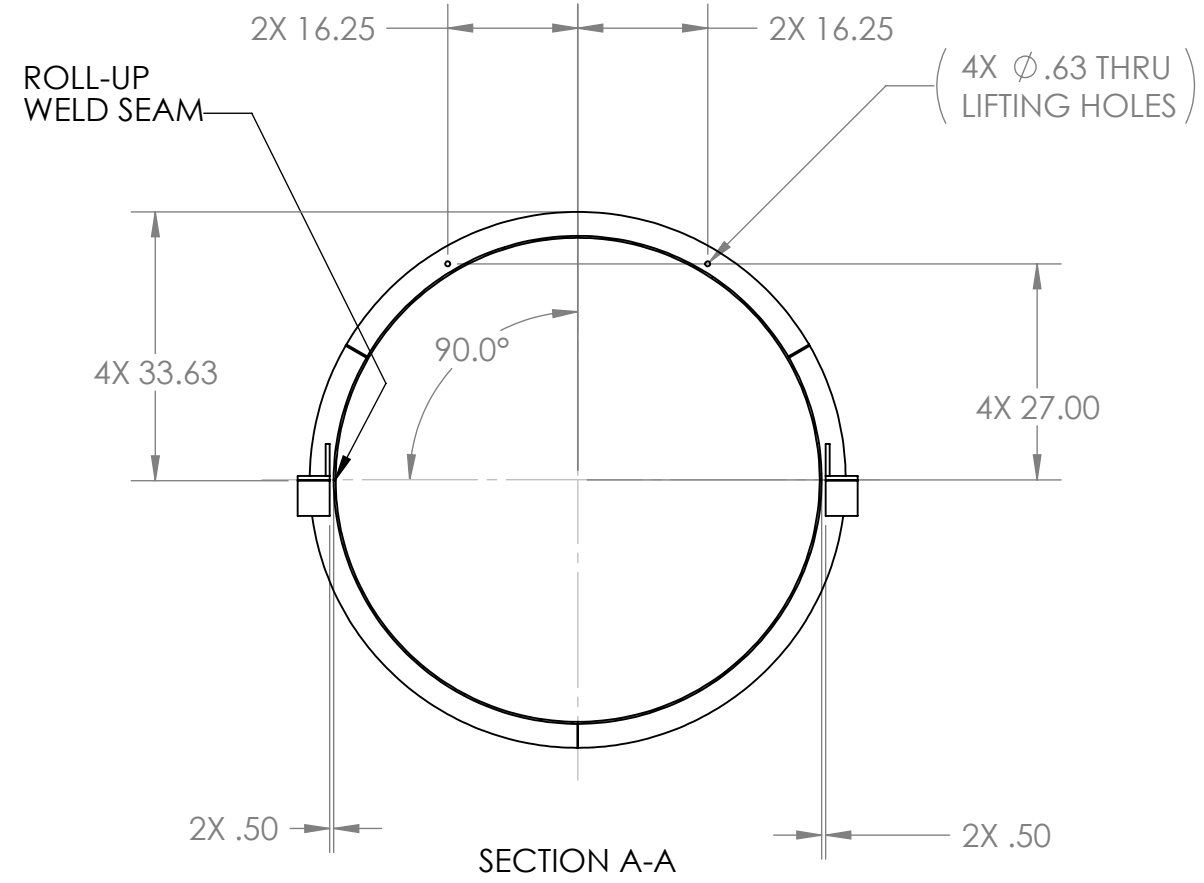
REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	REVISED WELD SIZE	8/11/2010	MKM2
	B	ADDED ROLL-UP OD CALLOUT, REVISED STIFFENER WELD TYPE, RELEASED TO PRODUCTION	8/23/2010	MKM2



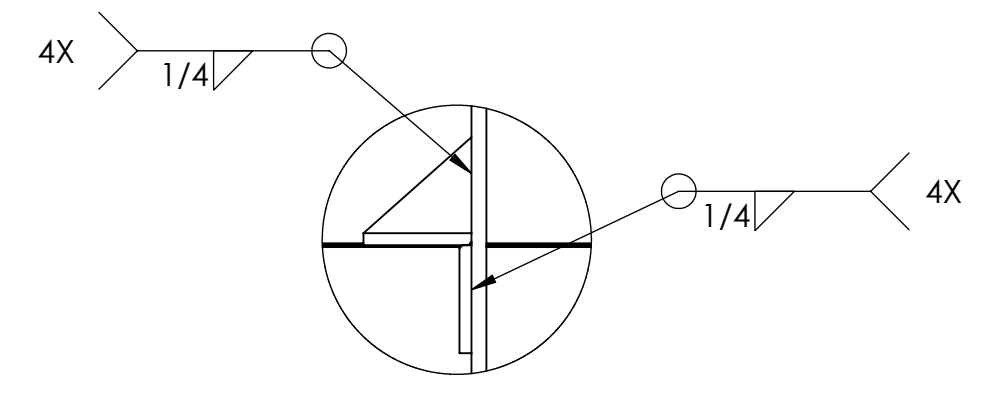
NOTE ORIENTATION OF STAND MOUNT BRACKETS



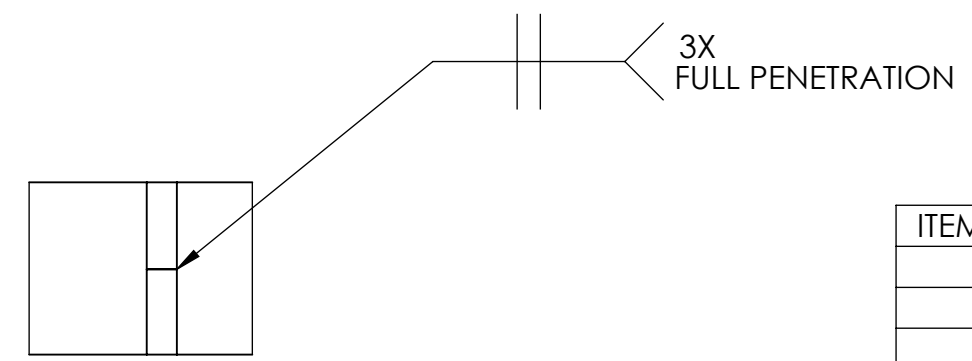
VAC TIGHT FULL PENETRATION USE NO BACKING STRIPS



SECTION A-A



DETAIL E SCALE 1 : 8



SECTION D-D SCALE 1 : 4

- NOTES:
1. ALL WELD PREPS TO BE DONE BY TUNGSTEN CARBIDE CUTTING TOOLS ONLY
  2. WELD PER QP1750-W2, LIGO WELDING AND REPAIR PROCEDURE LATEST REVISION
  3. CLEAN WELD WIRE AND ALL WELDED SURFACES WITH CO2 SCRUBBING
  4. INTERNAL WELD SURFACE TO BE SMOOTH BUT NOT GROUND
  5. ALL WELDS TO BE GTAW UNLESS OTHERWISE NOTED
  6. ALL INTERNAL WELDS TO BE CONTINUOUS AND VACUUM TIGHT
  7. NO POST WELD HEAT TREATMENT IS REQUIRED

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	114264-00S	ROLL-UP, MIDSTATION SPOOL	1
2	114266-00S	STIFFENER, BASE,	4
3	114265-00S	STIFFENER, LIFTING,	2
4	114273-00WS	WELDMENT, BRACKET,	4
5	114439-00S	PLATE, BRACKET, BRACE	4

MATERIAL: AISI 304/AISI 304L DUAL CERT PER SA-240  
 WEIGHT: 1786.93#

APPROVALS	DATE
DRAFTER MKM2	7/2/10
CHECKER RW	7/9/10
ENGINEER MKM2	7/2/10

UNLESS OTHERWISE SPECIFIED:  
 DIMENSIONS ARE IN INCHES  
 TOLERANCES: FINISH 125  
 ANGULAR: ± 0°30'  
 .XX ±.03  
 .XXX ±.005  
 UNSPECIFIED FILLETS: R.015  
 BREAK EDGES .010x45°  
 REMOVE ALL BURRS  
 // □ ⊥ WITHIN .03

THIRD ANGLE PROJECTION

DO NOT SCALE DRAWING

SCALE: 1:24

DWG. NO. 114267-00WS

REV B

SHEET 1 OF 1

TITLE: WELDMENT, TUBE, MIDSTATION SPOOL

**GNB CORPORATION**  
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