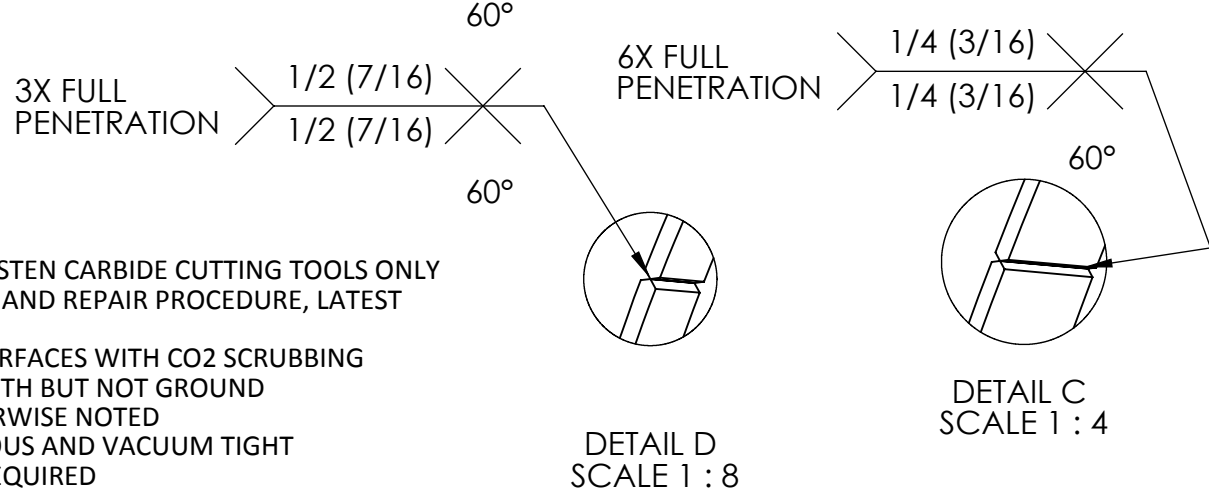
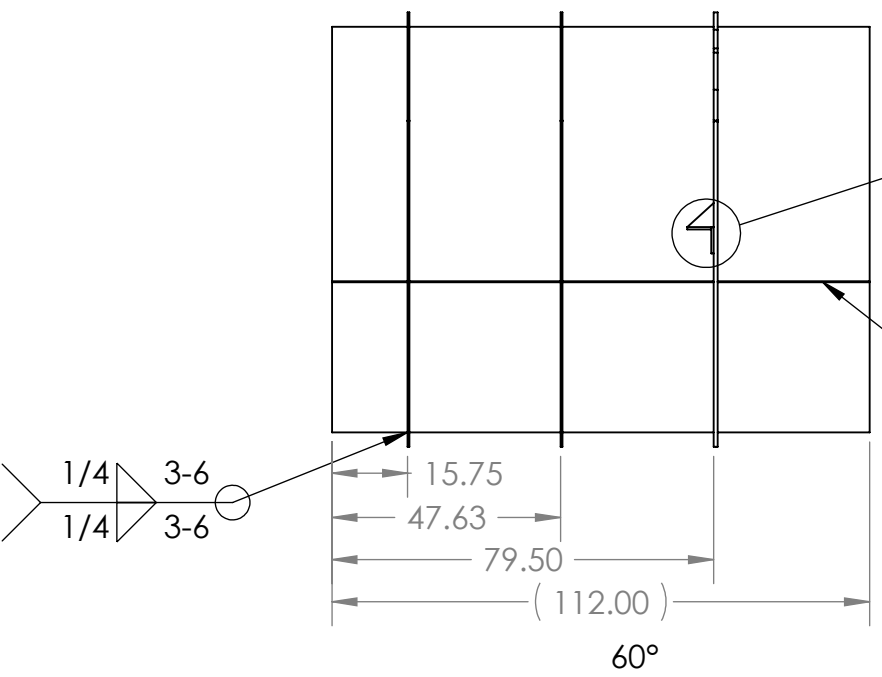
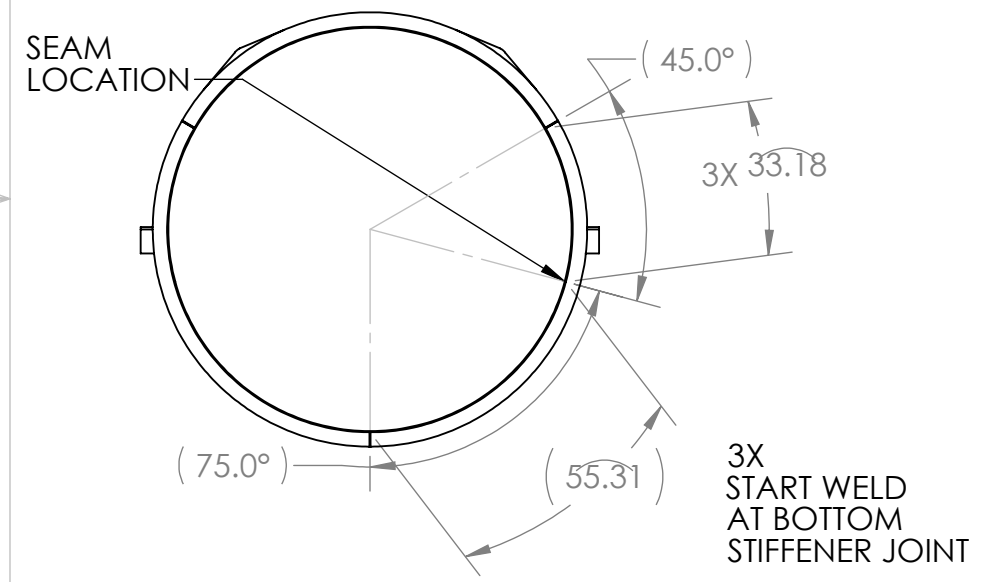
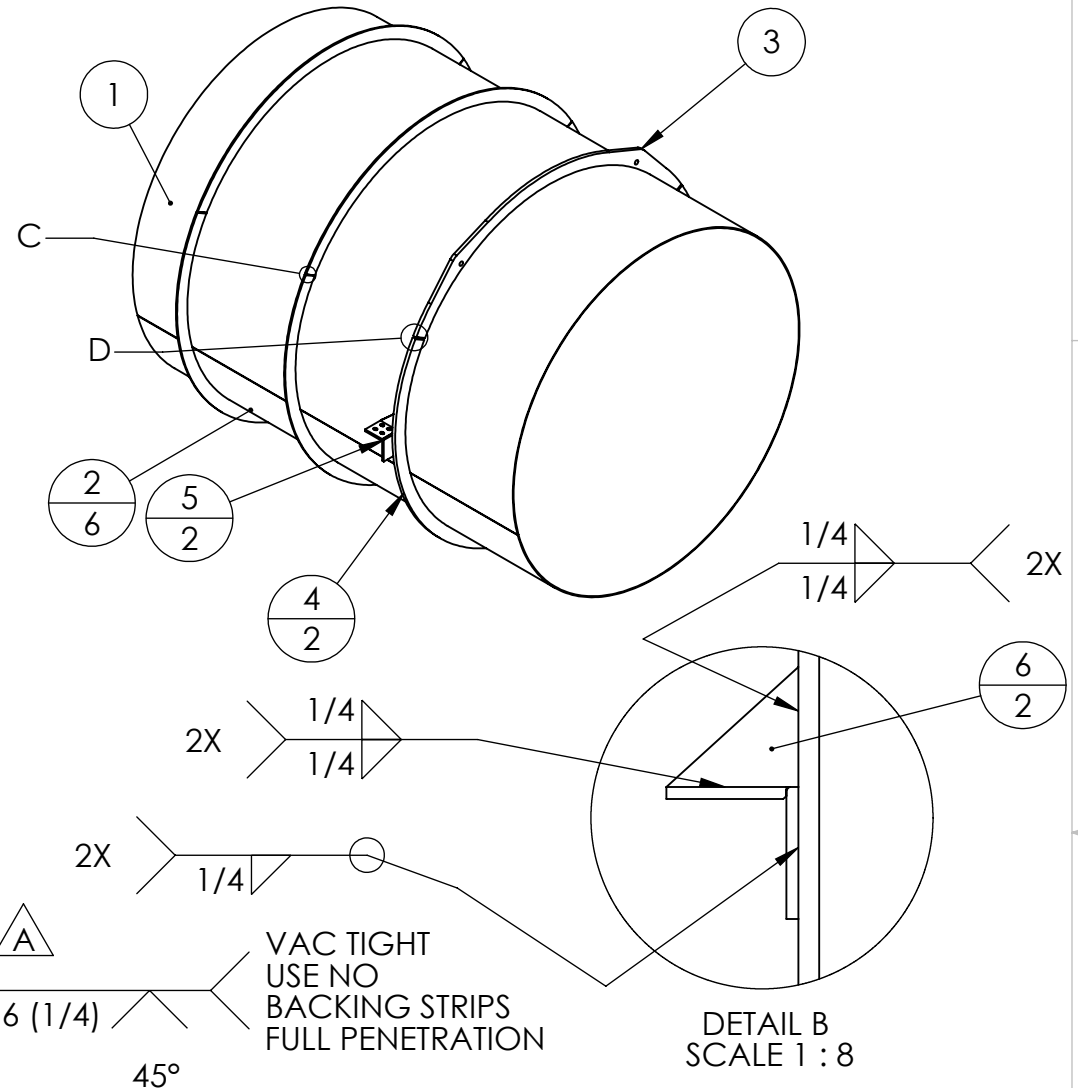
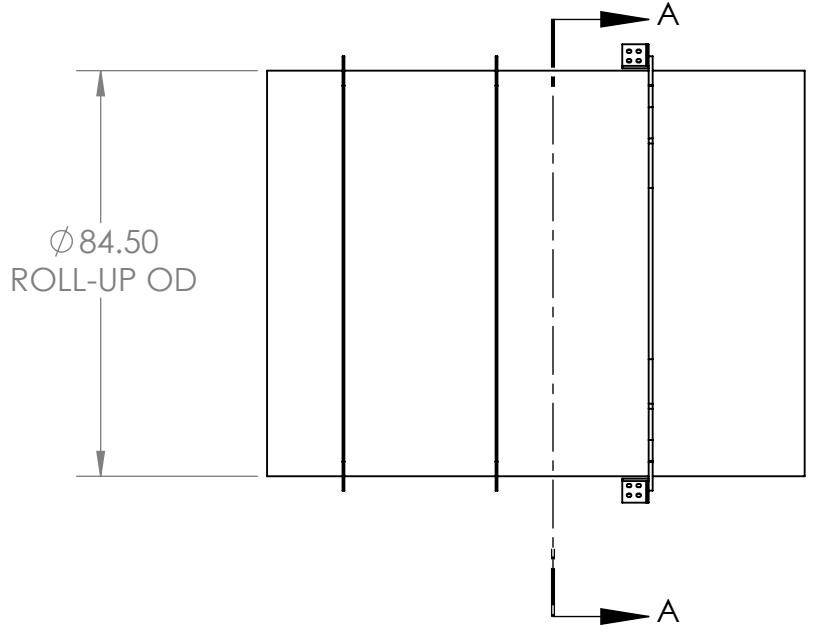
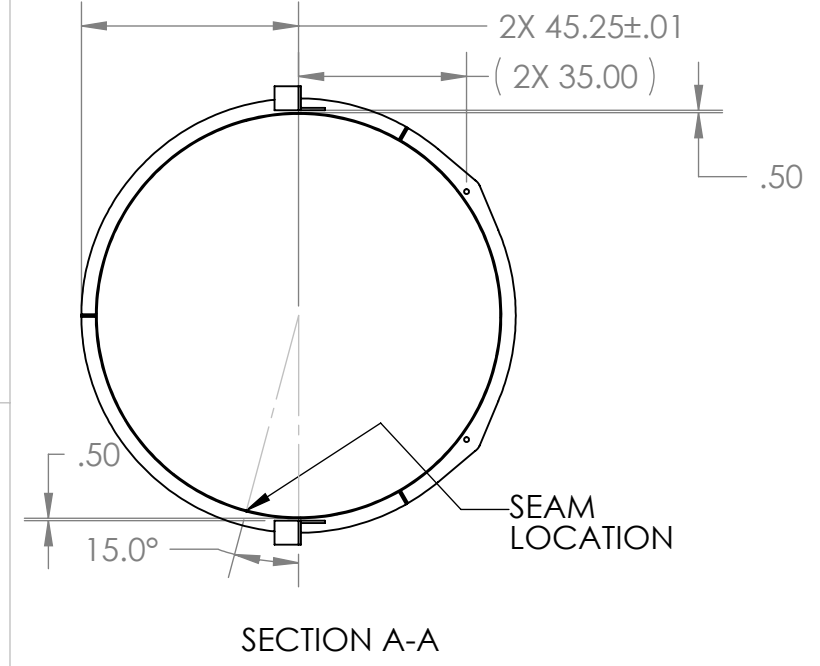


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REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	REVISED WELD CALL-OUT	8/11/2010	MKM2
	B	RELEASED TO PRODUCTION	8/25/2010	MKM2
	C	REVISED STIFFENER WELDS	8/25/2010	MKM2



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	114203-00S	ROLL-UP, MC-B TUBES	1
2	114204-00S	STIFFENER, 1/3, PLAIN, MC TUBE	6
3	114205-00S	STIFFENER, LIFTING, MC TUBES	1
4	114206-00S	STIFFENER, THICK, MC TUBES	2
5	114207-00WS	WELDMENT, BRACKET, MC TUBE	2
6	114427-00S	PLATE, BRACKET, BRACE	2

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

MATERIAL: AISI 304/AISI 304L DUAL CERT PER SA240

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

WEIGHT: 2550.84#

APPROVALS	DATE
DRAFTER MKM2	7/9/10
CHECKER RW	7/22/10
ENGINEER MKM2	7/9/10

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 www.gnbvalves.com

TITLE: WELDMENT, TUBE, LEFT, MCB

DO NOT SCALE DRAWING

DWG. NO. 114202-00WS  
 SCALE: 1:40 SHEET 1 OF 1

REV C