

FORM U-1A MANUFACTURER'S DATA REPORT FOR PRESSURE VESSELS
(Alternative Form for Single Chamber, Completely Shop-Fabricated Vessels Only)
As Required by the Provisions of the ASME Code Rules, Section VIII, Division 1

1-2

1. Manufactured and certified by WALKER STAINLESS EQUIP. CO., INC. 601 STATE ST., NEW LISBON, WI 53950
(Name and address of manufacturer)
2. Manufactured for DEDERT CORP. OLYMPIA FIELDS, IL
(Name and address of purchaser)
3. Location of installation CORN PRODUCTS CORP. STOCKTON, CA
(Name and address)
4. Type VERT. TANK 3564 SP-13391-D 987 1985
(Type or vessel) (Mfg. serial No.) (CRN) (Drawing No.) (Mfg. date) (Year built)
5. The chemical and physical properties of all parts meet the requirements of material specifications of the ASME BOILER AND PRESSURE VESSEL CODE. The design, construction, and workmanship conform to ASME Rules, Section VIII, Division 1. 1983
Year

to W-84 NONE NONE
(Addenda (Data)) (Code Case Nos) (Special Section per UG 1204d)
6. Shell: SA-240 T-316 SS .164" 0 3'-0" 9'-0"
(Matl (Spec. No., Grade)) (Nom. Thk. (in.)) (Corr. Allow. (in.)) (Usual I.D. (ft. & in.)) (Length (overall) (ft. & in.))
7. Seams: WLD DBL BUTT --- 70 --- --- WLD DBL BUTT --- 2
(Long. (Welded, Dbl., Sing. Lap, Butt)) (R.T. (Spot or Full)) (E.T. (%)) (H.T. Temp. (F)) (Time (hr)) (Circ. (Welded, Dbl., Sing. Lap, Butt)) (R.T. (Spot, Partial, or Full)) (No. of Courses)
8. Heads: (a) Matl. SA-240 T-316 SS (b) Matl. SA-240 T-316 SS
(Spec. No., Grade) (Spec. No., Grade)

	Location (Top, Bottom, Ends)	Minimum Thickness	Corrosion Allowance	Crown Radius	Knockle Radius	Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure (Convex or Concave)
(a)	TOP	.110"	0	36"	2.2"	---	---	---	---	CONCAVE
(b)	BOTTOM	.140"	0	60° CONE	---	---	---	---	---	CONCAVE

If removable, bolts used (describe other fastenings) 36 - 5/8" 11UNC x 4 1/2" LG. GR-2 C.S. BOLTS
(Matl., Spec. No., Gr., Size, No.)
9. MAWP FULL VACUUM & 15 psi at max. temp. 250 °F
Min. temp. (when less than -20°F) --- °F Hydro. --- test pressure 25 psi.

10. Nozzles, inspection and safety valve openings:

Purpose (Inlet, Outlet, Drain)	No.	diam or Size	Type	Matl.	Nom. Thk.	Reinforcement Matl.	How Attached	Location

11. Supports: Skirt NO Lugs 4 Legs --- Other --- Attached RING & SHELL - WELDED
(Yes or no) (No.) (No.) (Describe) (Where and how)

12. Remarks: Manufacturer's Partial Data Reports properly identified and signed by Commissioned Inspectors have been furnished for the following items of the report: NONE
(Name of part, item number, Mfg.'s name and identifying stamp)
36" T-316 FLASH COOLER (FC-2) #653693
APPROX. EMPTY WEIGHT 1600 LBS., BOLTING RINGS ARE SA-36 C.S., 1 1/2" THK. MATL., LUG RINGS ARE SA-36 C.S., 3/8" x 1 1/2" x 36" ID MATL.

CERTIFICATE OF SHOP COMPLIANCE

We certify that the statements made in this report are correct and that all details of design, material, construction, and workmanship of this vessel conform to the ASME Code for Pressure Vessels, Section VIII, Division 1. "U" Certificate of Authorization No. 5842 expires JUNE 30, 1988.
Date 10/15/85 Co. name WALKER STAINLESS EQUIP. CO. Signed Stephen D. Day
(Manufacturer) (Representative)

CERTIFICATE OF SHOP INSPECTION

Vessel constructed by WALKER STAINLESS EQUIP. CO. at NEW LISBON, WI
I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State or Province of WISCONSIN and employed by D.I.L.H.R. - MADISON, WI
have inspected the component described in this Manufacturer's Data Report on 10-17, 19 85, and state that, to the best of my knowledge and belief, the Manufacturer has constructed this pressure vessel in accordance with ASME Code, Section VIII, Division 1. By signing this certificate neither the Inspector nor his employer makes any warranty, expressed or implied, concerning the pressure vessel described in this Manufacturer's Data Report. Furthermore, neither the Inspector nor his employer shall be liable in any manner for any personal injury or property damage or a loss of any kind arising from or connected with this inspection.
Date 10-17-1985 Signed Ungel Kanab Commissions NB6883 WIS
(Authorized Inspector) (National Board (incl. endorsements), State, Prov. and No.)

2-2

This form (E00118) is available from the Order Dept., ASME, 345 E. 47 St., New York, N.Y. 10017

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This form (E00117) may be obtained from the Order Dept., ASME, 345 E. 47th St., New York, N.Y. 10017

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4. Type	VERT. TANK (HORIZ., vert. tank, etc.)	3565 (Mfg's. serial No.)	---	SP-13404-D (Draw)	988 (Nat'l. Id. No.)	1985 (Year built)
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Remark 1

CUSTOMER TO SUPPLY & INSTALL PROPER SAFETY VALVE.

Date 10/15/85 Co. name WALKER STAINLESS EQUIP. CO. Signed Stephen D. Day
(Manufacturer) (Representative)
Date 10-17-1985 Signed Virgil Kannek Commissions NB 6893 Wis
(Authorized Representative) (Not Good (incl. endorsements), State, Price, and No.)

13 988

FORM U-2A MANUFACTURER'S PARTIAL DATA REPORT (ALTERNATIVE FORM)
A Part of a Pressure Vessel Fabricated by One Manufacturer for Another Manufacturer
As Required by the Provisions of the ASME Code Rules, Section VIII, Division 1 3-3

Manufactured and certified by Betts Industries, Inc., 1602 Penna. Ave. W., Warren, PA 16365
(Name and address of manufacturer)

2. Manufactured for Stock
(Name and address of purchaser)

3. Location of installation Unknown
(Name and address)

4. Type 6556(1 thru 15) 8171-4 1985
(Material or part, tank) (Ship's serial No. of Part) (CRRR) (Drawing No.) (Part 1, 2, 3, 4) (Year made)

5. The chemical and physical properties of all parts meet the requirements of material specifications of the ASME Boiler and Pressure Vessel Code. The construction and workmanship conform to ASME Rules, Section VIII, Division 1 1983
December 1984
(Addenda listed) (Code Case No.) (Special Service per UG-120(d))

6. (a) Drawing prepared by Betts Industries, Inc. (b) Description of part inspected Manway & Closure

7. Postweld heat treatment: Temp. SA-240-316 .177 1' 8" 10"
(Temp. in °F) (Time in min.) (Length in ft. & in.) (No. of Courses)

8. Shell: SA-240-316 .177 1' 8" 10"
(Matl.) (Nom. Thk. in.) (Corr. Allow. in.) (Dim. I.D. in & in.) (Length Overall in & in.) (No. of Courses)

9. Seams: Butt 70%
(Type) (RT) (RT, PM) (Grd) (RT)

10. Heads: (a) Matl. SA-240-316 (b) Matl. SA-240-316
(Spec. No., Grade) (Spec. No., Grade)

	Location (Top, Bottom, Ends)	Minimum Thickness	Corrosion Allowance	Crown Radius	Knuckle Radius	Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure (Concave or Convex)
(a)	TOP	.177		21"	1-3/8"					concave
(b)										

If removable, bolts used (describe other fastenings) SA-479-304-75M-5/8-8
(Matl., Spec. No., Gr., Size, No.)

11. MAWP 50 & F.V. psi at max. temp. 250 °F. min. temp. (when less than -20° F) 250 °F.
Hydro., pneu., or comb. test press. 250 psi in the vertical position.

12. Nozzles and Inspection Openings:

Purpose (Heat, Order, Drain, etc.)	No.	Dim. or Size	Type	Matl.	Nom. Thk.	Reinforcement Matl.	How Attached	Location

13. Supports: Skirt Legs Other Attached

14. Remarks: Betts Industries is responsible for all the design of these pressure vessel parts.

CERTIFICATE OF SHOP COMPLIANCE

We certify that the statements made in this report are correct and that all details of material, construction, and workmanship of this vessel part conform to the ASME Code for Pressure Vessels, Section VIII, Division 1.

"U" Certificate of Authorization No. 10,776 expires February 17, 1986

Date June 24, 1985 Co. name Betts Industries, Inc. Signed [Signature]

CERTIFICATE OF SHOP INSPECTION

I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State or Province of Pennsylvania and employed by The Hartford Steam Boiler Inspection & Insurance Co. have inspected the pressure vessel part described in this Manufacturer's Data Report on June 24, 1985 and state that, to the best of my knowledge and belief, the Manufacturer has constructed this part of a pressure vessel in accordance with the ASME Code, Section VIII, Division 1. By signing this certificate neither the Inspector nor his employer makes any warranty, expressed or implied, concerning the pressure vessel part described in the Manufacturer's Data Report. Furthermore, neither the Inspector nor his employer shall be liable in any manner for any personal injury or property damage or a loss of any kind arising from or connected with this inspection.

Date June 24, 1985 Signed [Signature] Commissions Pa 2202

FORM U-1 MANUFACTURER'S DATA REPORT FOR PRESSURE VESSELS
As Required by the Provisions of the ASME Code Rules, Section VIII, Division 1

1. Manufactured and certified by WALKER STAINLESS EQUIP. CO., INC. 601 STATE ST., NEW LISBON, WI 53950
(Name and address of manufacturer)
2. Manufactured for DEDERT CORP. OLYMPIA FIELDS, IL
(Name and address of purchaser)
3. Location of installation CORN PRODUCTS CORP. STOCKTON, CA
(Name and address)
4. Type VERT. FLASH COOLER 3563 --- SP-13413-D 990 1985
(Name or vert. tank) (Ref's serial No.) (CNR) (Drawing) (Mat'l Bd No.) (Year built)
5. The chemical and physical properties of all parts meet the requirements of material specifications of the ASME Boiler and Pressure Vessel Code. The design, construction, and workmanship conform to ASME Rules, Section VIII, Division 1 1983
Year

W-84

NONE

NONE

(Addenda letter)

(Code Case No.)

(Special service per UG 120(d))

Items 6-11 incl. to be completed for single wall vessels, jackets of jacketed vessels, or sheets of heat exchangers

6. Shell: SA-240 T-304 SS .134" 0 1'-4" 12'-0"
(Mat'l Spec. No., Grade) (Nom. Thk. (in)) (Corr. Allow. (in)) (Diam. I.D. (ft & in)) (Length Overall (ft & in))
7. Seams: WLD DBL BUTT --- 70 ---
(Long (Dbl. Sngl.)) (H.T. (Spot or Full)) (EH (%)) (H.T. Temp. (F))
- WLD DBL BUTT --- 3
(Type) (Girth (Dbl. Sngl.)) (H.T. (Spot, Partial, or Full)) (No. of Courses)

8. Heads: (a) Mat'l. --- (Spec No., Grade) (b) Mat'l. --- (Spec No., Grade)

	Location (Top, Bottom, Ends)	Minimum Thickness	Corrosion Allowance	Crown Radius	Knuckle Radius	Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure (Convex or Concave)
(a)	---	---	---	---	---	---	---	---	---	---
(b)	---	---	---	---	---	---	---	---	---	---

If removable, bolts used (describe other fastenings) ---

(Mat'l. Spec. No., Gr., Size No.)

9. Type of Jacket SHELL OF HEAT EXCHANGE Proof Test ---
10. Jacket Closure --- If bar, give dimensions --- If bolted, describe or sketch.
(Describe as ogee & weld, bar, etc.)
11. MAWP FULL VAC. & 75 psi at max. temp. 250 °F. Min. temp. (when less than -20°F) --- °F.
Hydro., pneum., or comb. test press. 120 psi.

Items 12 and 13 to be completed for tube sections

12. Tubesheets: SA-240 T-316 SS 15.625" 1" 0 WELDED
(Stationary Mat'l (Spec. No., Gr.)) (Diam. (in) (Subject to pressure)) (Nom. Thk. (in)) (Corr. Allow. (in)) (Attach (Welded, Bolted))
- SA-36 15.500" .187" 0 WELDED TO STAY RODS
(Floating Mat'l (Spec. No., Gr.)) (Diam. (in)) (Nom. Thk. (in)) (Corr. Allow. (in)) (Attach)
13. Tubes: SA-249 T-316L SS 1" .049 97 STRAIGHT
(Mat'l (Spec. No., Gr.)) (O.D. (in)) (Nom. Thk. (in or Gauge)) (Number) (Type (Straight or "U"))

Items 14-17 incl. to be completed for inner chambers of jacketed vessels or channels of heat exchangers

14. Shell: SA-240 T-316 SS .134 0 1'-4" 1'-8"
(Mat'l (Spec. No., Grade)) (Nom. Thk. (in)) (Corr. Allow. (in)) (Diam. I.D. (ft & in)) (Length Overall (ft & in))
15. Seams: WLD DBL BUTT --- 70 ---
(Long (Dbl. Sngl.)) (H.T. (Spot or Full)) (EH (%)) (H.T. Temp. (F))
- WLD DBL BUTT --- 2
(Type) (Girth (Dbl. Sngl.)) (H.T. (Spot, Partial, or Full)) (No. of Courses)

16. Heads: (a) Mat'l. SA-36 w/SA-240 T-316 1/2" CLADDING (Spec No., Grade) (b) Mat'l. SA-36 w/SA-240 T-316 1/2" CLADDING (Spec No., Grade)

	Location (Top, Bottom, Ends)	Minimum Thickness	Corrosion Allowance	Crown Radius	Knuckle Radius	Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure (Convex or Concave)
(a)	<u>TOP</u>	<u>.750</u>	<u>0</u>	<u>FLAT</u>	---	---	---	---	---	<u>FLAT</u>
(b)	<u>BOTTOM</u>	<u>.750</u>	<u>0</u>	<u>FLAT</u>	---	---	---	---	---	<u>FLAT</u>

If removable, bolts used (describe other fastenings) (18) EACH END, 5/8 x 11UNC x 3-3/4" C.S. GR. 2 BOLTS, TOTAL -
(Mat'l. Spec. No., Gr., Size No.)

17. MAWP FULL VAC & 15 psi at max. temp. 250 °F. Min. temp. (when less than -20°F) --- °F.
Hydro., pneum., or comb. test press. 25 psi.

(12/82)

This form (E00108) may be obtained from the Order Dept., ASME, 345 E. 47th St., New York, N.Y. 10017

Form U-1 (Back)

16. Nozzles, Inspection and Safety Valve Openings: CUSTOMER TO SUPPLY & INSTALL PROPER SAFETY VALVE.

Purpose (Inlet, Outlet, Drain, etc.)	No.	Size (Inches)	Type	Matl.	Weld Thick.	Welding Proc.	How Attached	Location
GAUGE	2	1/2"	CPLG	SA-182 T-316	3000#	---	WELDED	SHELL
INLET	1	10"	S/O FLG	SA-105 150# w/SA-240 T-316	16L .164 NECK	---	WELDED	SHELL
OUTLET	1	1"	L/J FLG	SA-105 150# w/SA-240 T-316	16L SCH.10 NECK	---	WELDED	HEAD
INLET & OUTLET	2	4"	STUB	SA-312 T-304	SCH. 40	---	WELDED	HEAD
VENT	1	2"	L/J FLG	SA-105 150# w/SA-240 T-316	16L SCH.10 NECK	---	WELDED	SHELL
DRAIN	1	1"	CPLG	SA-182 T-316	3000#	---	WELDED	HEAD
DRAIN	1	1"	CPLG	SA-181 C.S.	3000#	---	WELDED	SHELL

18. Supports: Skirt NO Lugs 2 Legs --- Other --- Attached --- RINGS & SHELL - WELDED
(Yes or no) (No.) (No.) (Describe) (Where and how)

20. Remarks: Manufacturer's Partial Data Reports properly identified and signed by Commissioned Inspectors have been furnished for the following items of the report: NONE
(Name of part, item number, figure, name and identifying stamp)

16" OD FLASH COOLER, FCC-1, #853693
APPROX. EMPTY WEIGHT 2000 LBS.

BOLTING RINGS & MOUNTING LUG RINGS ARE SA-36 C.S. MATL.

CERTIFICATE OF SHOP COMPLIANCE

We certify that the statements made in this report are correct and that all details of design, material, construction, and workmanship of this vessel conform to the ASME Code for Pressure Vessels, Section VIII, Division 1.

"U" Certificate of Authorization No. 5842 expires JUNE 30, 19 88
Date 10/15/85 Co. name WALKER STAINLESS EQUIP. CO. Signed Stephen D Day
(Manufacturer) (Representation)

CERTIFICATE OF SHOP INSPECTION

Vessel constructed by WALKER STAINLESS EQUIP. CO. at NEW LISBON, WI

I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State or Province of WISCONSIN and employed by D.I.L.H.R. of MADISON, WI

have inspected the pressure vessel described in this Manufacturer's Data Report on 10/15, 19 85, and state that, to the best of my knowledge and belief, the Manufacturer has constructed this pressure vessel in accordance with ASME Code, Section VIII, Division 1. By signing this certificate neither the Inspector nor his employer makes any warranty, expressed or implied, concerning the pressure vessel described in the Manufacturer's Data Report. Furthermore, neither the Inspector nor his employer shall be liable in any manner for any personal injury or property damage or a loss of any kind arising from or connected with this inspection.

Date 10/15/85 Signed Virgil Karabek Commissions NB683 WIS
(Authorized Inspector) (National Board, State, Province and No.)

CERTIFICATE OF FIELD ASSEMBLY COMPLIANCE

We certify that the field assembly construction of all parts of this vessel conforms with the requirements of Section VIII, Division 1 of the ASME Boiler and Pressure Vessel Code.

"U" Certificate of Authorization No. _____ expires _____, 19 _____
Date _____ Co. name _____ Signed _____
(Assembler that certified and constructed field assembly) (By Representative)

CERTIFICATE OF FIELD ASSEMBLY INSPECTION

I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State or Province of _____ and employed by _____

of _____ have compared the statements in this Manufacturer's Data Report with the described pressure vessel and state that parts referred to as data items _____, not included in the certificate of shop inspection, have been inspected by me and that, to the best of my knowledge and belief, the Manufacturer has constructed and assembled this pressure vessel in accordance with ASME Code, Section VIII, Division 1. The described vessel was inspected and subjected to a hydrostatic test of _____ psi. By signing this certificate neither the Inspector nor his employer makes any warranty, expressed or implied, concerning the pressure vessel described in this Manufacturer's Data Report. Furthermore, neither the Inspector nor his employer shall be liable in any manner for any personal injury or property damage or a loss of any kind arising from or connected with this inspection.

Date _____ Signed _____ Commissions _____
(Authorized Inspector) (National Board, State, Province and No.)