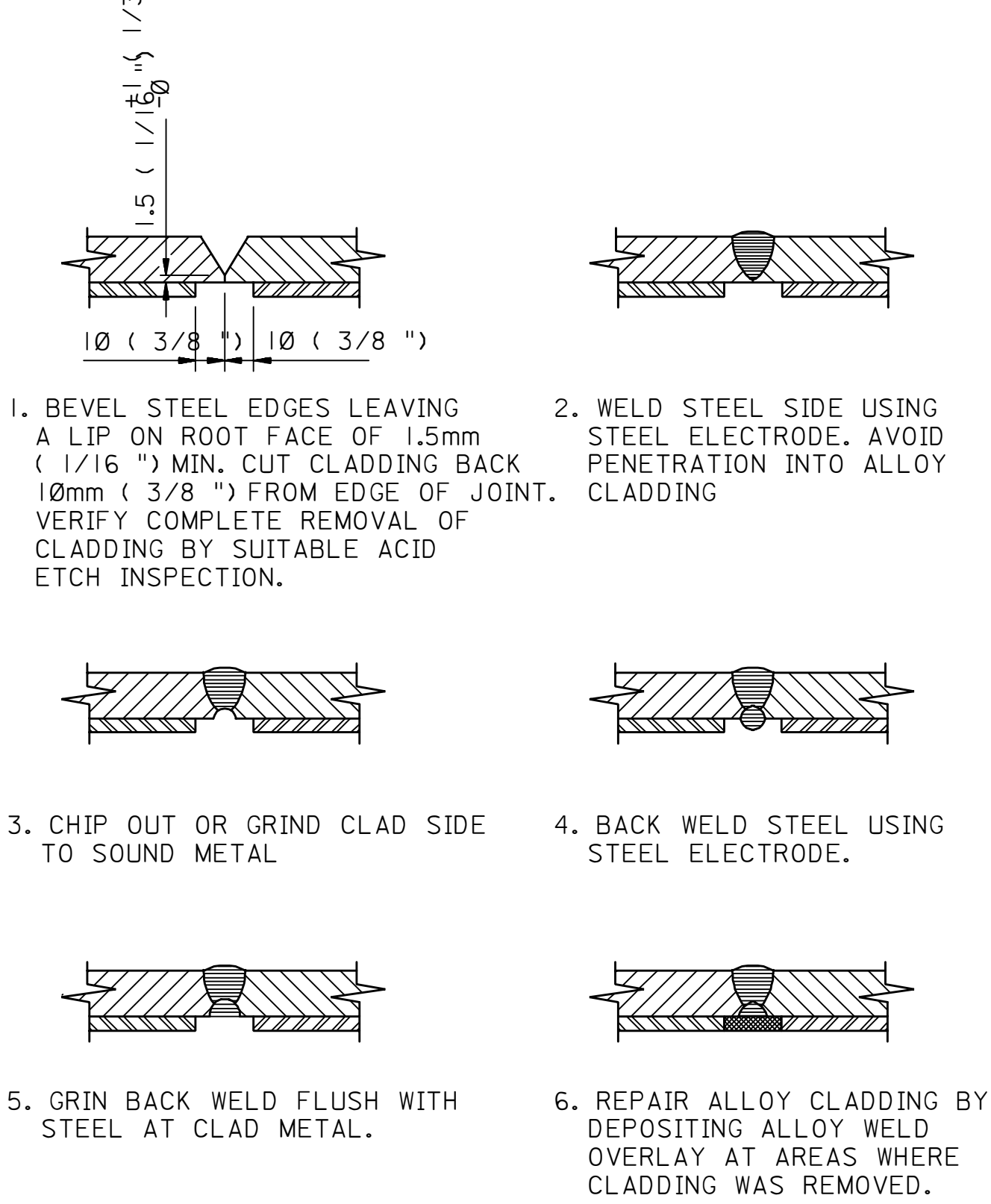
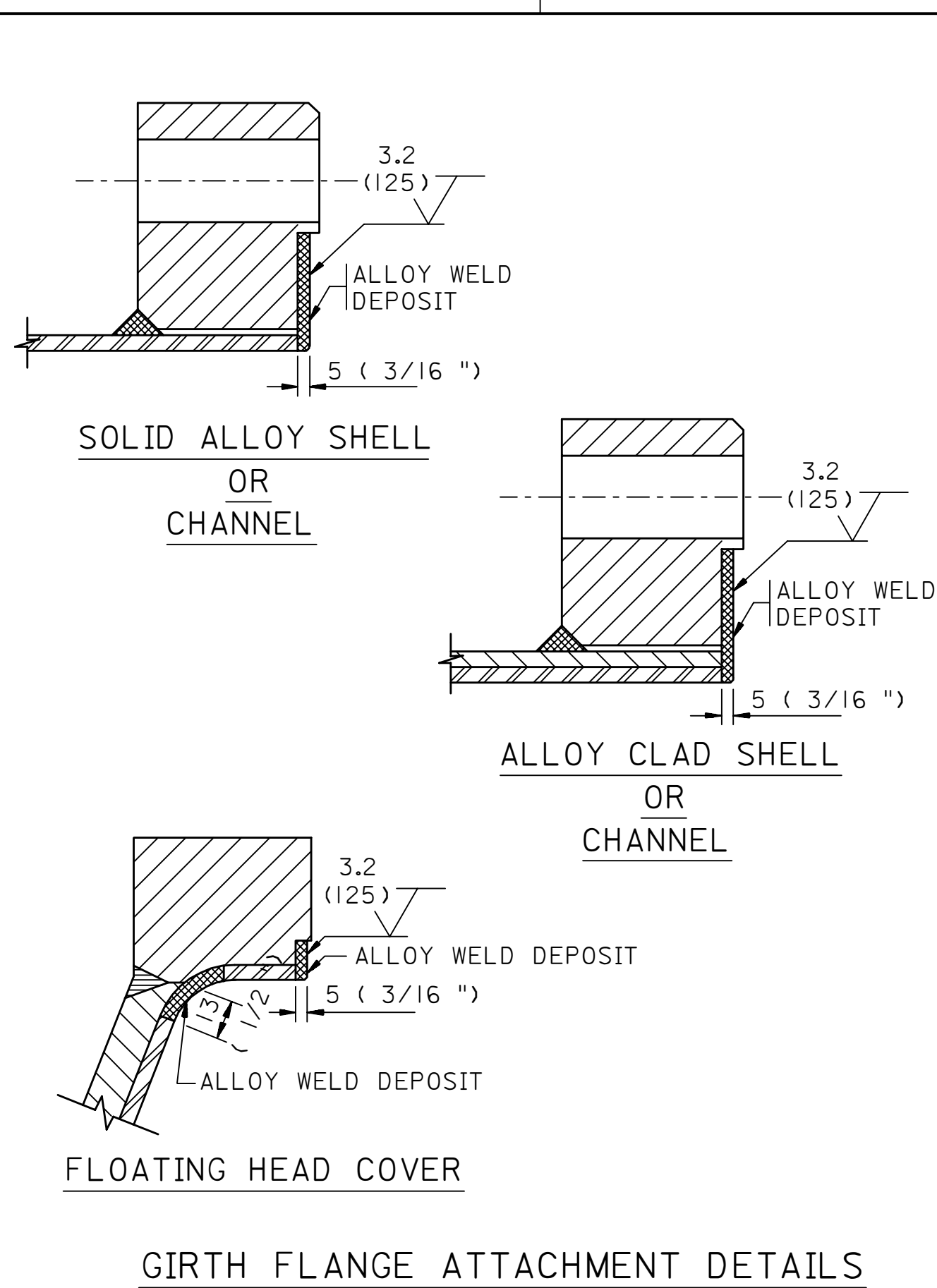
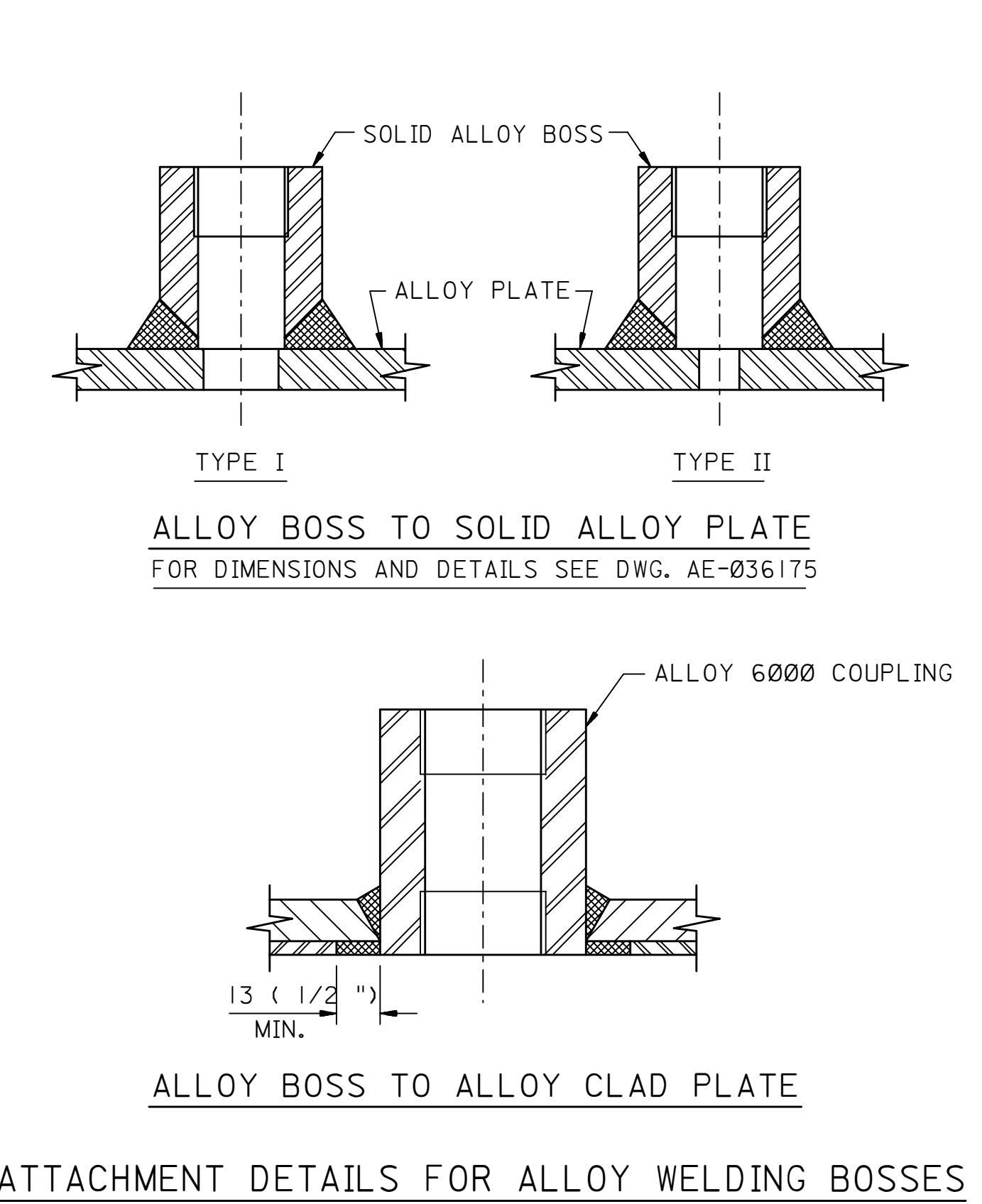
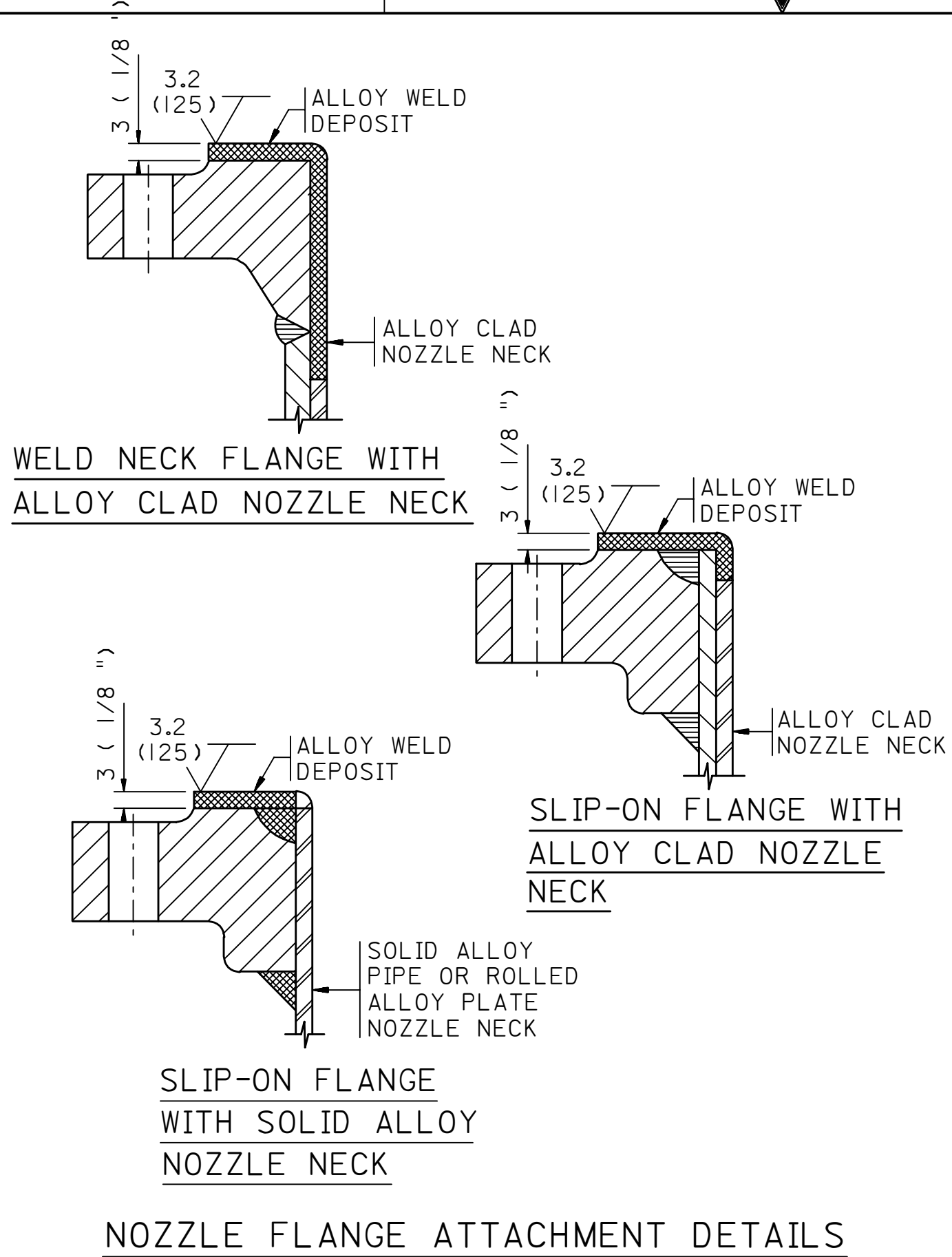
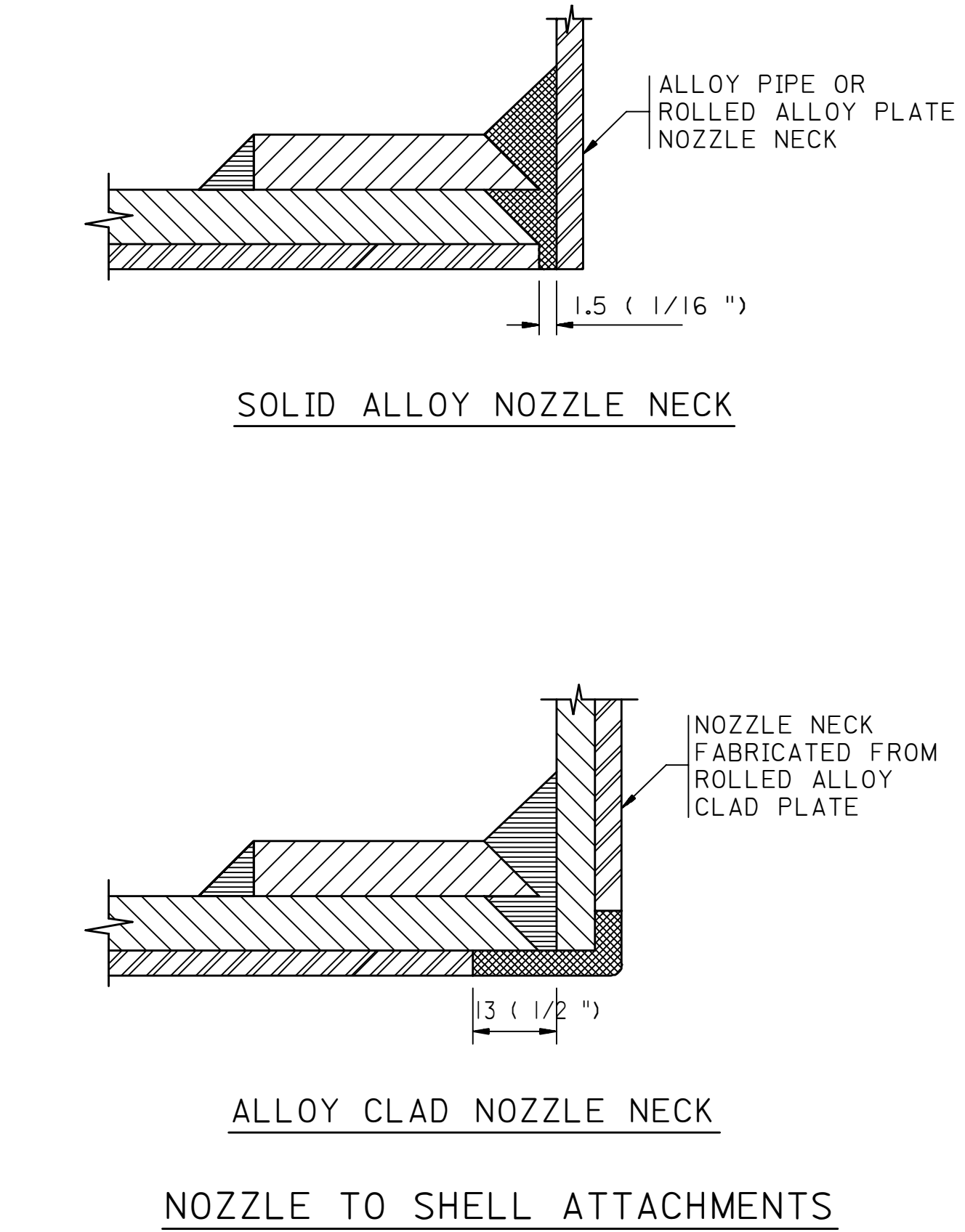


20	001	990	W	AB-036367	001	066
REV. NO.	SHT. NO.	DRAWING NUMBER	INDEX	PLANT NO.	NO.	REV. NO.



WELDING PRODEDURE FOR CLAD STEEL PLATE



- NOTES:
- ALL CARBON STEEL WELDS TO BE COMPLETED PRIOR TO MAKING ANY ALLOY WELDS.
 - ALL ATTACHMENT WELDS SHALL BE IN ACCORDANCE WITH THE REQUIREMENTS OF THE APPLICABLE CONSTRUCTION CODES.
 - DOUBLE BEVELED SHELL PLATE ONLY WHERE I.D. OF SHELL PERMITS INSIDE WELDING, OTHERWISE SINGLE BEVELED SHELL PLATE.
 - ALL DIMENSIONS IN MILLIMETERS UNLESS NOTED OTHERWISE.
 - SURFACE FINISH IN MICROMETERS WITH MICROINCH DIMENSIONS IN PARENTHESIS.

- LEGEND:
- ALLOY WELD
 - CARBON STEEL WELD
 - CARBON STEEL PLATE
 - ALLOY PLATE OR CLADDING

THIS STANDARD DRAWING SUPERSEDES DWG. NB-427070									
02	MAY92	ESSD FDR		DRAWING DIGITIZED INTO CADD DATABASE WITHOUT CHANGES					
REV. NO.	DATE	BY	JO/EWO	DESCRIPTION			CHKD.	CERT.	APPD.
SAUDI ARABIAN OIL COMPANY									
DRAWN BY <u>K.P.B.</u> CHECKED BY _____ SCALE <u>NONE</u>									
DATE STARTED _____ DATE COMPLETED <u>DEC '75</u>									
OPR'G. DEPT. _____ ENG. DEPT. <u>ORIGINAL SIGNED</u>									
APP'D FOR CONSTR. _____									
THIS DRAWING IS NOT TO BE USED FOR CONSTRUCTION OR FOR ORDERING MATERIAL UNTIL CERTIFIED AND DATED					CERTIFIED <u>ORIGINAL CERTIFIED</u> BY _____ DATE <u>12-17-75</u>				
JOINT PREPARATION & WELDING DETAILS									
ALLOY AND CLAD									
PRESSURE VESSELS AND HEAT EXCHANGERS									
STD. DWG.									
PLANT NO.		INDEX		DRAWING NUMBER			SHT. NO.		REV. NO.
990		W		AB-036367			001		02