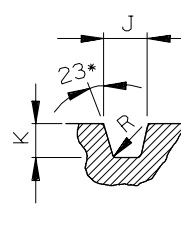
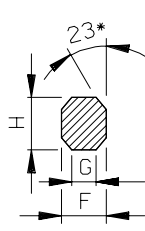
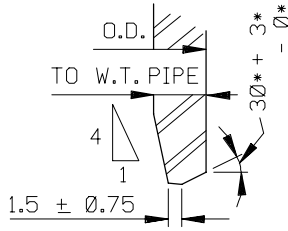
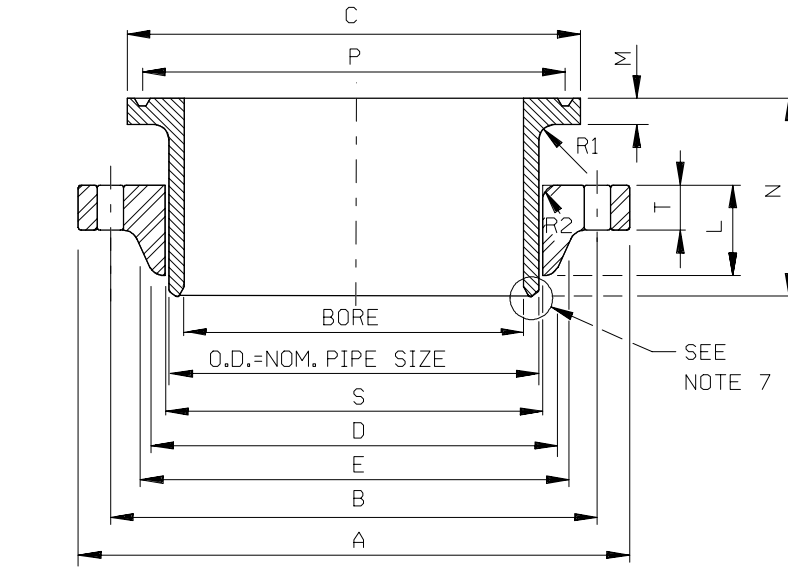


SAUDI ARABIAN OIL COMPANY

NO.	DATE	BY	JO/EWO	DESCRIPTION	CHKD.	CERT.	APPD.
06	06-11-97	ESSD MAQ		DRAWING REVISED AS PER MARK-UP			
05	03-19-94	ESSD CAC		CONSOLIDATED SHEET 1 & 2 INTO SHT.001 METRIC & ENGLISH VERSION & REVISED NOTES 1 & 3			
04	06-14-92	ESSD EPE		DRAWING DIGITIZED INTO CADD DATABASE WITHOUT CHANGES	ORIGINAL SIGNED	ORIGINAL SIGNED	ORIGINAL SIGNED



RING

GROOVE

NOTES:

- DIMENSIONAL TOLERANCES NOT SHOWN, FINISHES AND SPOT FACING SHALL CONFORM TO MSS-SP-44-1991. EXCEPT TOLERANCE ON WALL AND LAP THICKNESS OF STUB END TO BE + 1.5, -0. (* ", -0")
- DRILLING TEMPLATE ARE TAKEN FROM MSS-SP-44.
- MATERIAL: WELDING ENDS AND BACKING FLANGES SHALL BE F52 IN ACCORDANCE WITH 02-SAMSS-011. BACKING FLANGES SHALL BE ASTM A694 F52.
- MAX. ALLOWABLE WORKING PRESSURE 4.96FMPS (720 PSI) FROM -29°C (-20°F) TO 38°C (100°F).
- GROOVE RADIUS 'R'=1.5MM (* ").
- RADIUS AT STUB END 'R1'=13MM (* "), RADIUS AT LOOSE FLANGE 'R2'=13MM (* ").
- TAPER TO MATCH PIPE BORE TO BE IN ACC. WITH ANSI B 31.4.
- BOLTHOLE DIA.=BOLT DIA. + 3MM (* ").
- PURCHASE REQUISITION TO SPECIFY I.D. OF MATCHING PIPE.
- STUD BOLT LENGTH BASED ON CONNECTION TO WELDING NECK FLANGE PER AE-036437.
- MARKING PER 02-SAMSS-011 (NPS IN INCHES)

MANDATORY DRAWING

CLASS 300 RING JOINT

APPROX. MASS KG (LBS.)	STUD SIZE IN. X MM (IN. X IN.)	NO. OF BOLTS	BORE STUB END (MM) (IN.)	T MM (IN.)	S MM (IN.)	P MM (IN.)	M MM (IN.)	L MM (IN.)	K MM (IN.)	J MM (IN.)	I MM (IN.)	H MM (IN.)	G MM (IN.)	F MM (IN.)	E MM (IN.)	D MM (IN.)	C MM (IN.)	B MM (IN.)	A MM (IN.)	NOM. PIPE SIZE (IN.)
1520	2" X 545	28	1292	175	1380	1422	380	55	250	13	20	24	12.3	19	1410	1395	1465	1550	1660	54"
3360	2" X 21*		50*	6*	54*	56	15	2*	9*	*	25/32	*	.485	*	55*	55	57*	61	65*	54"
1890	2" X 570	32	1438	185	1530	1580	430	55	270	13	20	24	12.3	19	1565	1560	1625	1700	1800	60"
4165	2" X 22*		56*	7*	60*	62*	17	2*	10*	*	25/32	*	.485	*	61*	61*	64	67	71*	60"

DRAWING TITLE
DETAILS
54" & 60" LAP JOINT FLANGES
AND STUB ENDS-CLASS 300 R.J.
STD. DWG.

PLANT NO.
990
JO/EWO-

INDEX
L

DRAWING NO.
AE-036438

SHT. NO.
001

REV. NO.
06

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