



WELD MAP			
WELD No.	WELDER ID	NDT REPORT	WPS No.
W1			
W2			
W3			
W4			
W5			
W6			

WELDING CONSUMABLES		
WIRE TYPE	SIZE	LOT No.

APPROVED WPS	

BILL OF MATERIAL				
ITEM	ITEM QTY	PART NUMBER	DESCRIPTION	HEAT No.
1	1	A1-18001-200-07 24in CL150 RFWN flange	24" XS CLASS 150 ASME B16.5 RFWN FLANGE, A105N	
2	1	A1-18001-300-01 24in pipe	24" XS x 3027mm PIPE, API 5L Gr.B PSL-2	
3	1	A1-18001-300-02 End cap	Ø581mm x 1/4" PLATE, G40.21 260W	
4	1	A1-18001-450-00 U-bolt assembly	ANVIL Fig.137 OR APPROVED EQUIVALENT, GALVANIZED, c/w 4 HEX NUTS	
5	1	Tag mount - 6in	C6x8.2 x 6" [152mm], 44W	

REVISION HISTORY		
REV	DATE	DESCRIPTION
A	4/23/19	ISSUED FOR REVIEW

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EST. WT. 1,575 lbs.  
UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES. BREAK ALL SHARP EDGES 01" OR 0R 45° RADI  
95 T.I.R. .010. INTERPRET DWG PER ANSI Y14.5 STANDARD.  
TOLERANCES:  
X = ±.125  
X.X = ±.050  
X.XX = ±.015  
X.XXX = ±.005  
ANGLES ±1/2°  
125/ FINISH ON ALL MACHINED SURFACES

DO NOT SCALE

DRAWN BY: JDS  
DATE: 4/23/19

CHECKED BY: DATE  
APPROVED: DATE

MATERIAL & HEAT TREAT

**ALCO** **ALCO Industrial**  
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TITLE  
24" SUPPORT SPOOL- SP-K3493 - MAPS  
IOL KEARL PLANT 2 - EXTRACTION

PROJECT No. A1-18001  
REFERENCE 074-2300-080-141-010 01  
FILE NAME A1-18001-300-00 Elbow support spool - maps.iq

REV. A  
SHEET 1 OF 1