

1 2 3 4 5 6 7 8 9 10 11 12

A

B

C

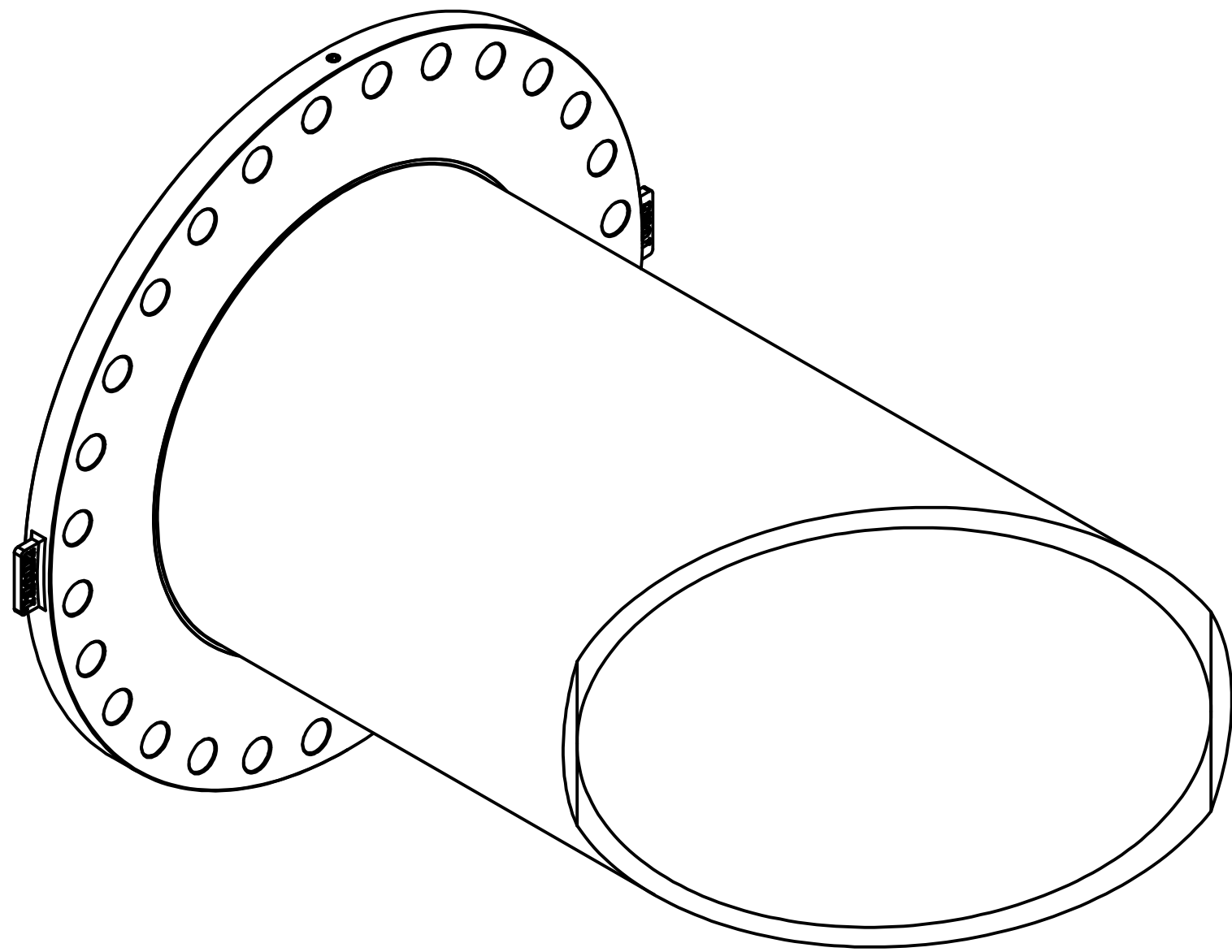
D

E

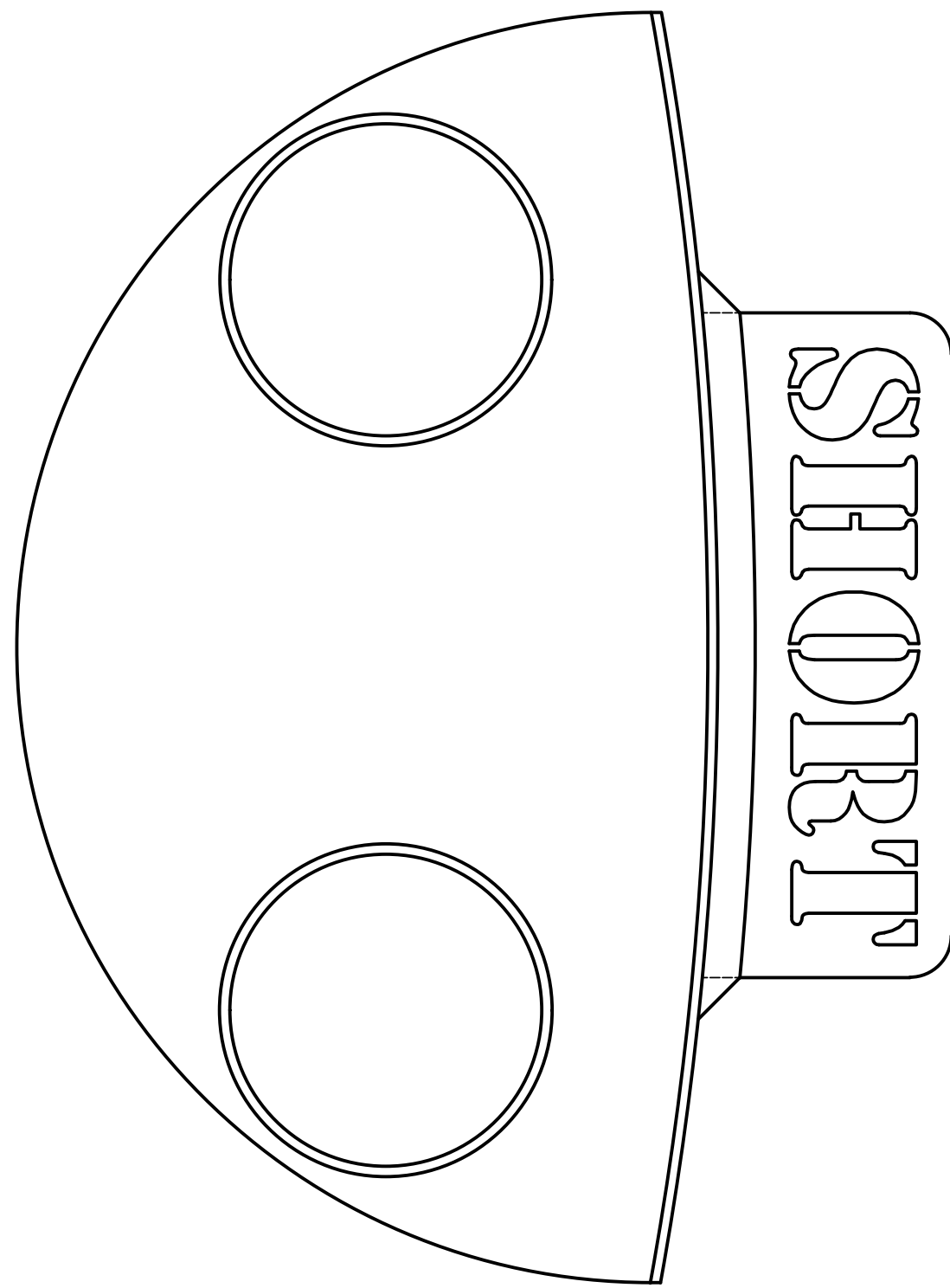
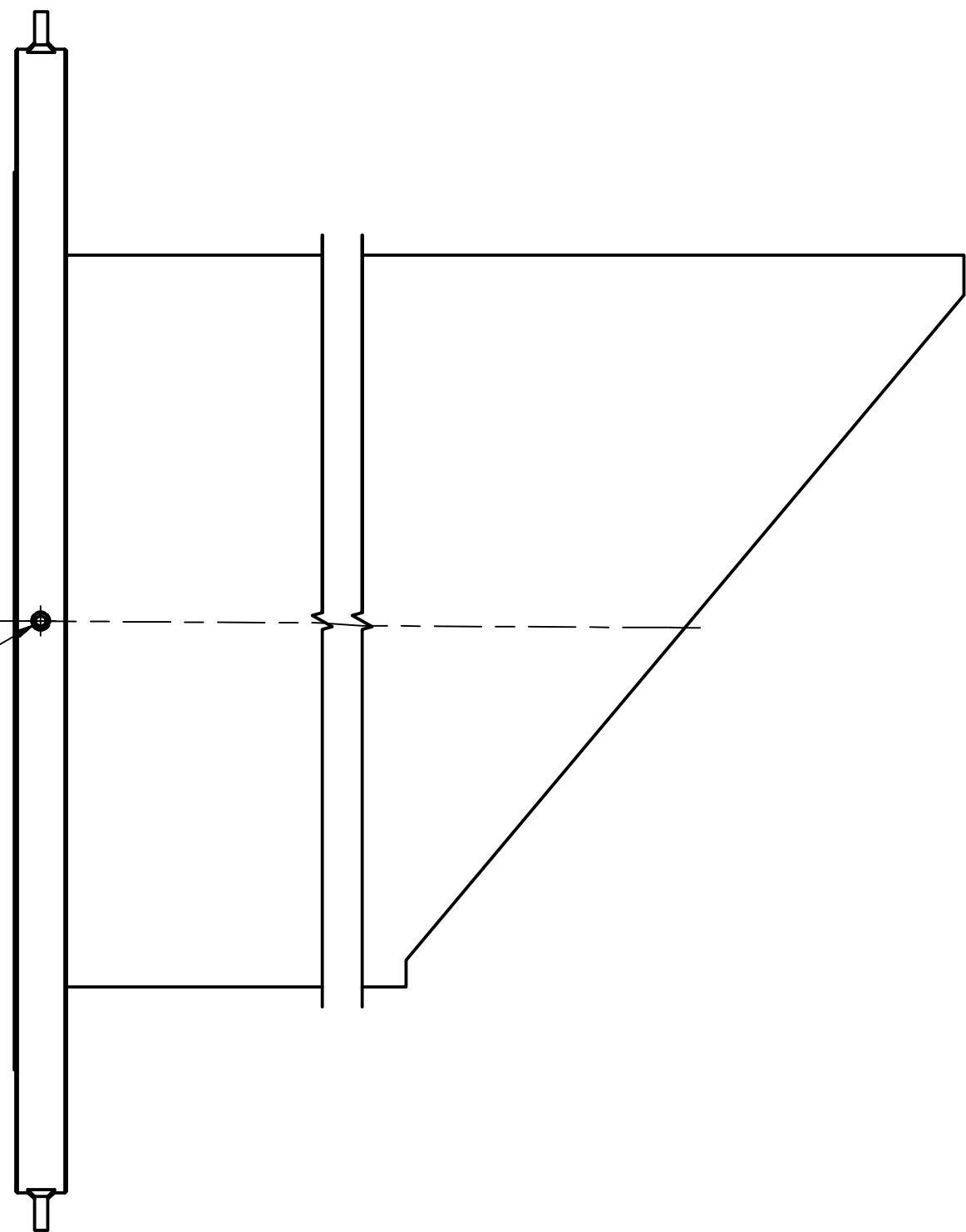
F

G

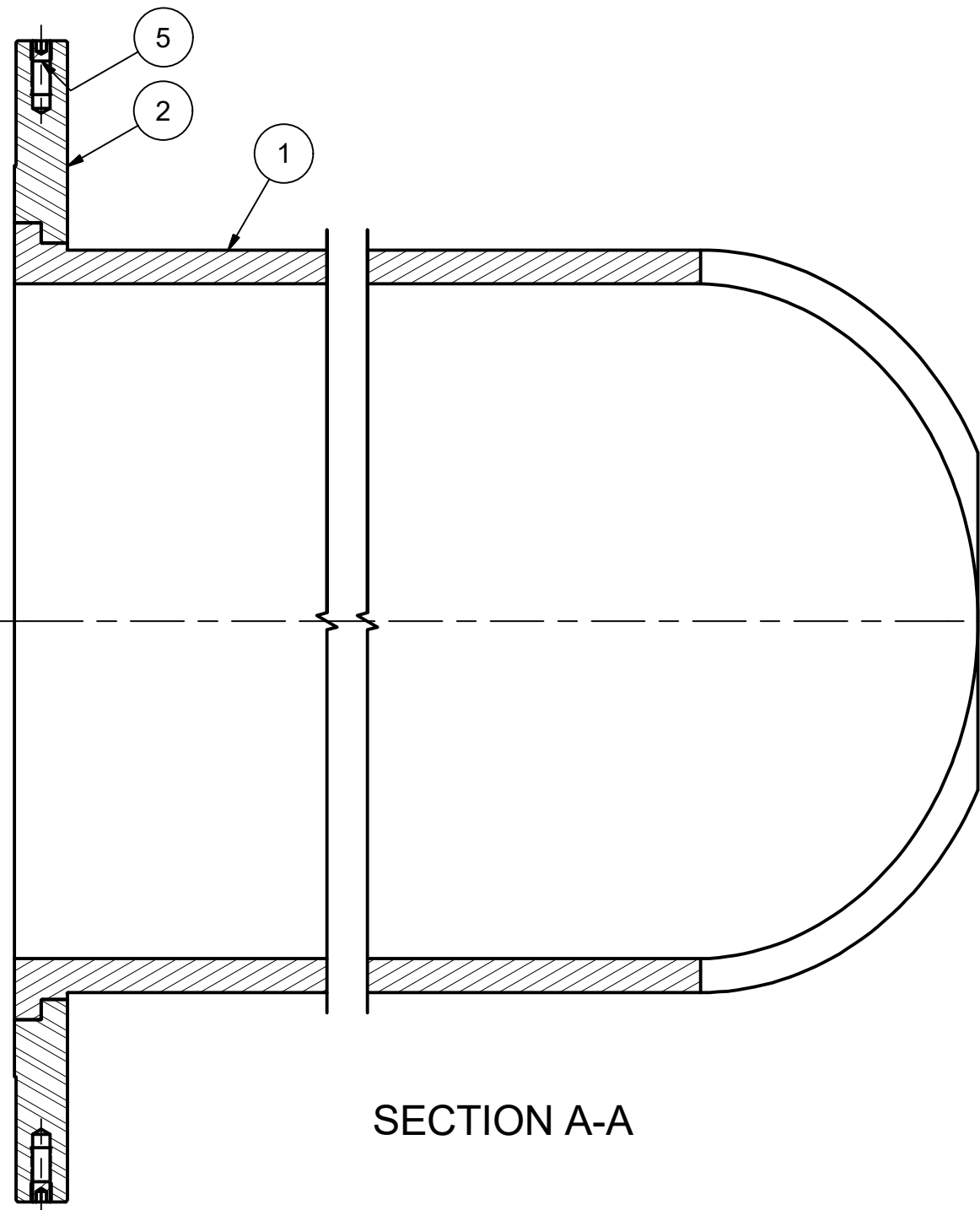
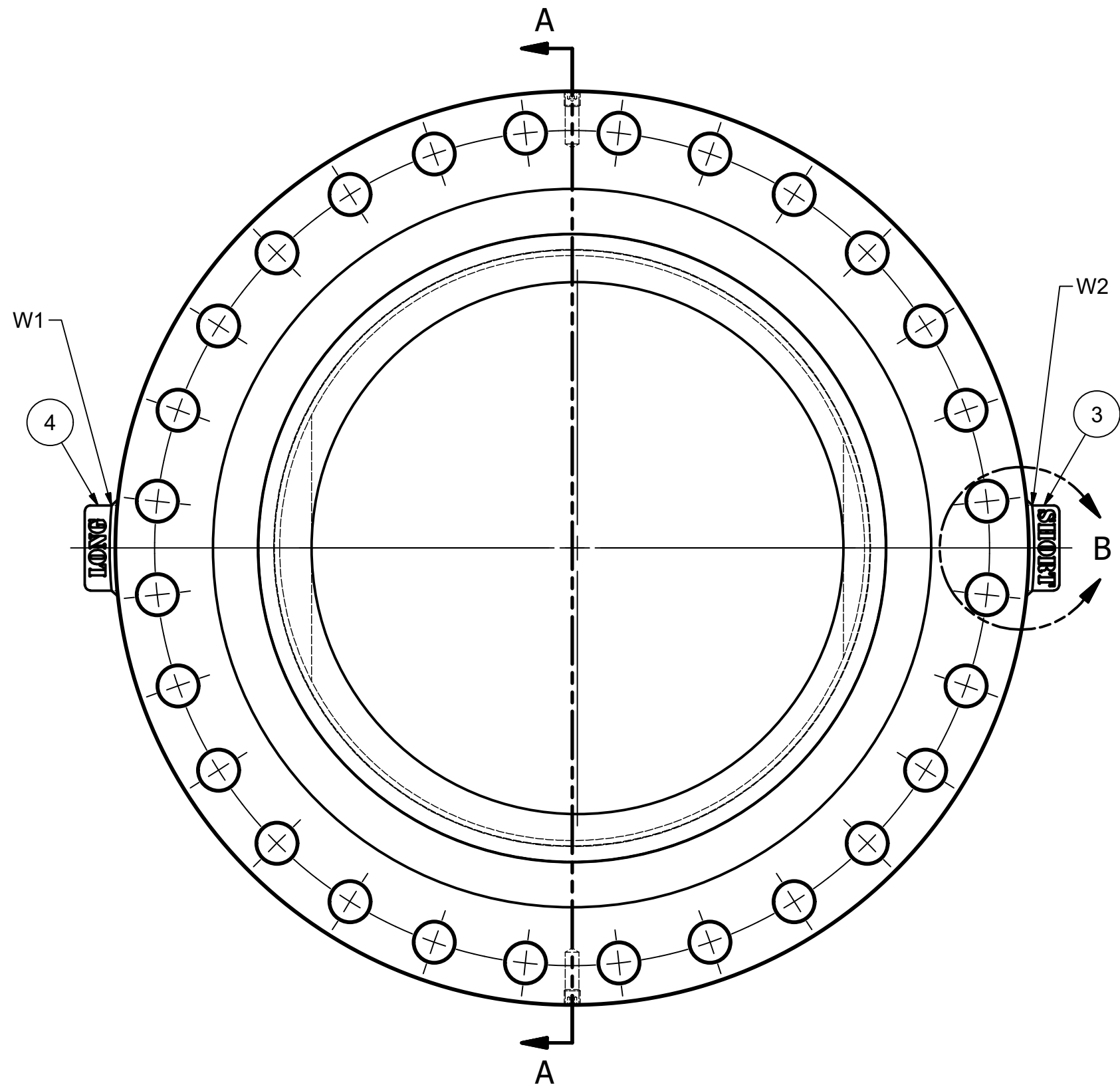
H



Ø21/32 ± 2 1/2  
3/4-10 UNC ± 2  
TYP 2



DETAIL B




SECTION A-A

BILL OF MATERIAL				
ITEM	ITEM QTY	PART NUMBER	DESCRIPTION	HEAT No.
1	1	A1-19010-200-02 HCWI nozzle insert	30" HCWI NOZZLE, ASTM A532 CLASS III TYPE A, PF# 741280	
2	1	A1-19010-200-01 30in CL300 RFBL flange - thinned	Ø30" CLASS 300 RFBL FLANGE, A516 Gr.70N, ASME B16.47 Ser.A, 50mm THICK	
3	1	A1-19010-100-03 Tab - SHORT	4" x 1 1/2" x 1/2" PLATE, A516 Gr.70	
4	1	A1-19010-100-04 Tab - LONG	4" x 1 1/2" x 1/2" PLATE, A516 Gr.70	
5	2	ANSI B18.3 - 3/4-10 UNC x 0.75	3/4"-NC x 3/4" SOCKET HEAD SET SCREW, FLAT POINT, Gr.5	

WELD MAP				
WELD No.	WELDER ID	NDT REPORT	WPS No.	VT OK
W1				
W2				

WELDING CONSUMABLES		
WIRE TYPE	SIZE	LOT No.

APPROVED WPS		

THIS DOCUMENT CONTAINS PROPRIETARY INFORMATION AND SUCH INFORMATION MAY BE USED FOR ANY PURPOSE OR IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM ALCO INC. OR ITS DIVISIONS.	EST. WT.		DO NOT SCALE		 <b>ALCO Industrial</b> 2103 - 8 Street, Nisku, Alberta, Canada T9E 7Y9 Phone: (780) 451-6222 • Fax: (780) 452-4355
	UNLESS OTHERWISE SPECIFIED		DRAWN BY: GVD	DATE: 4/05/19	
	ALL DIMENSIONS ARE IN INCHES. BREAK ALL SHARP EDGES 0.01" OR 0.04" RADIUS PER ANSI Y14.5 STANDARD.		CHECKED BY: KLS	DATE: 1/03/19	
	TOLERANCES:		APPROVED: BEM	DATE: 1/03/20	
	X = ± .118		MATERIAL & HEAT TREAT		
	X.X = ± .050		PROJECT No.		
	X.XX = ± .015		A1-19010		
	X.XXX = ± .005		REFERENCE		
	ANGLES:		DD300-L-87-1		
	125° ± .12°		REV. 0		
FINISH ON ALL MACHINED SURFACES:		FILE NAME			
A1-19010-200-00 300D-6A -6B N7 insert-map.iq		SHEET 1 OF 1			

REVISION HISTORY			
REV	DATE	DESCRIPTION	INITIALS
0	2/21/20	ISSUED FOR CONSTRUCTION	BEM