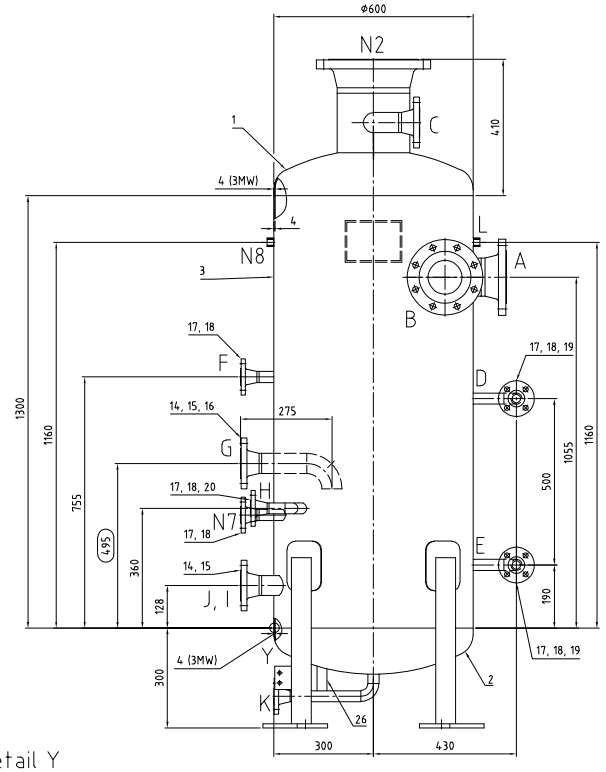
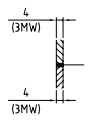
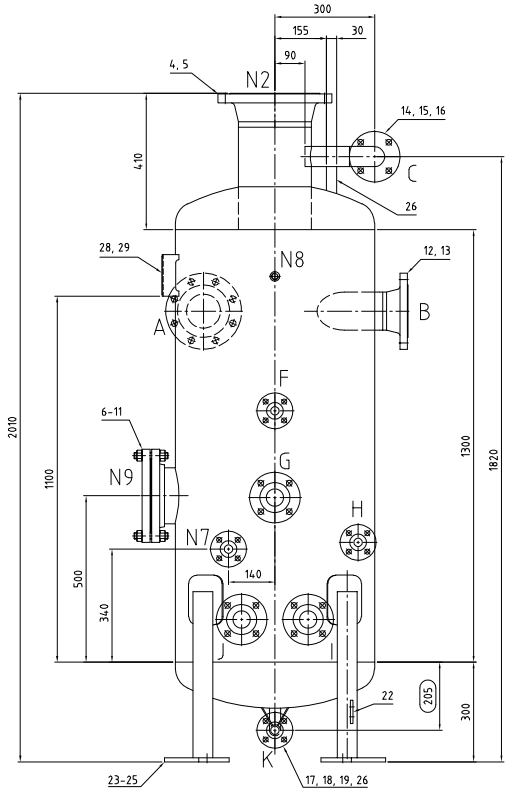
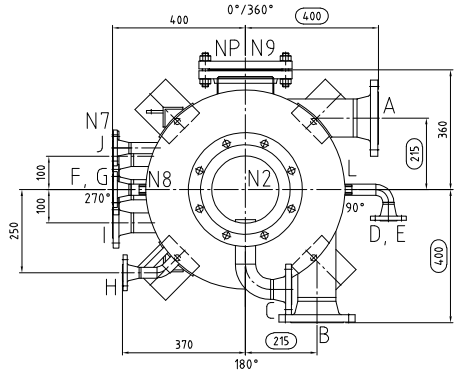


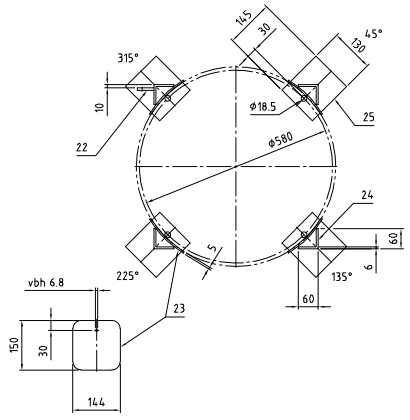
detail Y



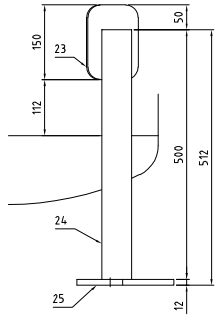




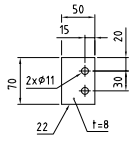
foot layout



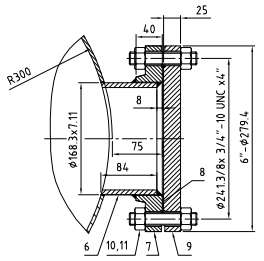
detail foot



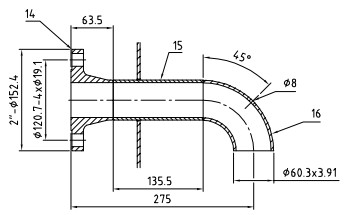
detail
earthing plate



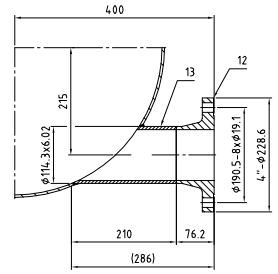
detail N9



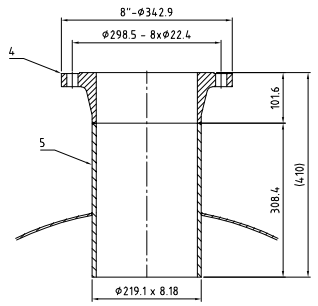
detail G



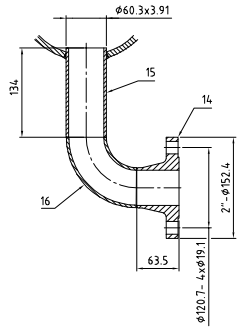
detail A, B



detail N2



detail C



alle Innenkanten gerundet oder gefast /
exposed inside edges shall be rounded or chamfered

zulässige Nahtüberhöhung / permissible weld reinforcement UW-35:

Material Nominal Thickness, mm	Maximum Reinforcement, mm Categories B and C Butt Welds	Other Welds
Less than 2.4	2.5	0.8
2.4 to 4.8, incl.	3	1.5
over 4.8 to 13, incl.	4	2.5
over 13 to 25, incl.	5	2.5
over 25 to 51, incl.	6	3
over 51 to 76, incl.	6	4
over 76 to 102, incl.	6	5.5
over 102 to 127, incl.	6	6
over 127	8	8

Kanfenversatz / allignment tolerance: ≙ t/4

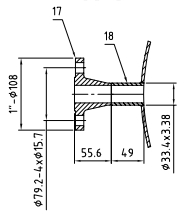
Toleranz Kehlnähte/ tolerance fillet welds: -0, +3mm

Abweichung von der Rundheit (shell)
deviation from true circular form UG-80: max. 3.0mm
skirt of heads: < 1% D =5mm

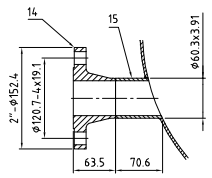
Behälter mit FV:
zur Rundheitsüberprüfung Schablonen von QCM verwenden
vessels with FV:
for out of roundness check UG-80b use templates provided by QCM

Allgemeintoleranzen für Behälter / general tolerances for vessel: DIN 28005

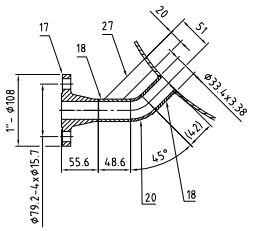
detail F



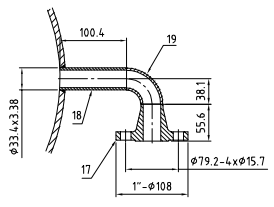
detail J, I



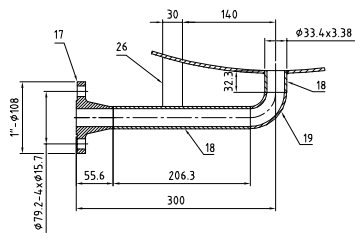
detail H



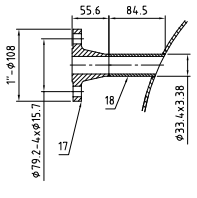
detail D, E



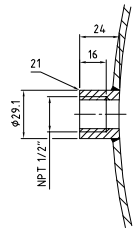
detail K



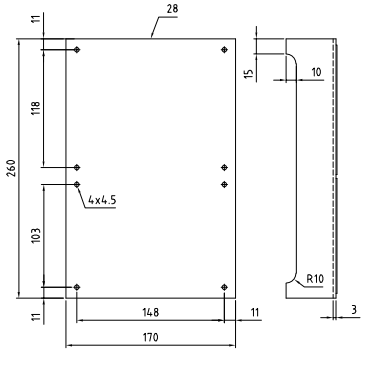
detail N7



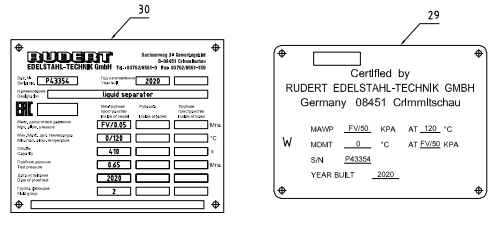
detail L, N8



name plate holder



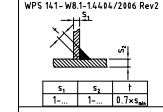
name plate



material: 316L

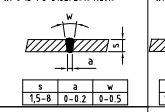
vessel completely pickled and passivated

Kehlnaht/Fillet weld
WPS 141/111-4571-2 Rev.1
WPS 141-W8.1-14484/2006 Rev2



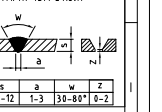
s_1	s_2	t
1-...	1-...	$0.7 \times s_{min}$

Längsnaht/Longitudinal seam
WPS 15-P8-316L/2019 Rev.0



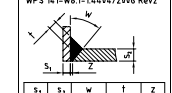
s	a	w
1.5-8	0-0.2	0-0.5

Rundnaht/Circular seam
WPS 141/111-4571-2 Rev.1



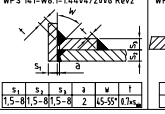
s	a	w	z
1.5-12	1-3	30-80°	0-2

Stutzennaht/Nozzle weld
WPS 141-W8.1-14484/2006 Rev2



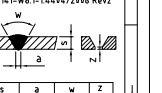
s_1	s_2	w	t	z
1.5-8	=s_1	45-55°	$0.7 \times s_{min}$	0-2

Stutzennaht/Nozzle weld
WPS 141-W8.1-14484/2006 Rev2



s_1	s_2	a	w	t
1.5-8	1.5-8	2	45-55°	$0.7 \times s_{min}$

Rundnaht/Circular seam
WPS 141-W8.1-14484/2006 Rev2



s	a	w	z
1.5-8	1-3	30-80°	0-2

Technical Data / Technische Daten

design according to: / Ausführung nach:		ASME Sec. VIII, Div. 1, Ed. 19 (without U-Stamp)		
Pressure chamber / Druckraum		Shell side / Mantelseite	Tube side / Rohrseite	Inspection by: / Abnahme durch: TÜV Thüringen e.V.
Design pressure gauge (MAWP) / Zulässiger Betriebsüberdruck	kPa	FV / 50	/	
Initial test pressure gauge / Prüfüberdruck erstmalig	kPa	65	/	Supervision of manufacture by: / Fertigungskontrolle durch: QCM Rudert
Min. design metal temp. (MDMT) / Min. Berechnungstemp. Werkstoff	°C	0	/	
Design temperature / Zulässige Betriebstemperatur	°C	120	/	Weight to be supplied: / Liefergewicht: ca. 225 kg
Test temperature / Prüftemperatur	°C	RT	/	Operating weight: / Betriebsgewicht: - kg
Nominal volume / Nennvolumen	m^3	0.41	/	Bundle weight: / Bündelgewicht: - kg
Joint efficiency / Schweißfaktor		0.7	/	Total heat exchanger surf.: / Gesamtaustauschfläche: - m^2
Corrosion allowance / Abnutzungszuschlag	mm	0	/	S/N: / Herstell-Nr.: P43354
Other additional allowances / Sonstige Zuschläge	mm	0	/	Year of manufacture: / Herstell-Jahr: 2020

Prüfungen (von allen Prüfungen Protokolle mit Bewertungen ausstellen)
Tests (Test reports incl.appraisals required in all cases)

Durchstrahlung % Radiographic %	Ultraschall % Ultrasonic %	Farbeindringung % Dye Penetration %	Dichtheitsprüfung Leak Test	Sonstiges Others
-	-	-	-	no impact test exempted per UHA-51

Stutzen Nozzle	Benennung Denomination	DN	PN	DIN-Norm Standard	Dichtfläche Facing	Position Position	Rohrabmessung Dimension
L	conn. anti cavitation line	1/2"NPT					Φ29.1
K	drain	1"	150 lbs	ASME B16.5	RF		Φ33.4x3.38
J	conn. service liquid line	2"	150 lbs	ASME B16.5	RF		Φ60.3x3.91
I	conn. service liquid line	2"	150 lbs	ASME B16.5	RF		Φ60.3x3.91
H	connection magnetic valve	1"	150 lbs	ASME B16.5	RF		Φ33.4x3.38
G	overflow	2"	150 lbs	ASME B16.5	RF		Φ60.3x3.91
F	filling	1"	150 lbs	ASME B16.5	RF		Φ33.4x3.38
E	conn. liquid level indicator	1"	150 lbs	ASME B16.5	RF		Φ33.4x3.38
D	conn. liquid level indicator	1"	150 lbs	ASME B16.5	RF		Φ33.4x3.38
C	conn. steam gas line	2"	150 lbs	ASME B16.5	RF		Φ60.3x3.91
B	gas inlet	4"	150 lbs	ASME B16.5	RF		Φ114.3x6.02
A	gas inlet	4"	150 lbs	ASME B16.5	RF		Φ114.3x6.02
N9	handhole	6"	150 lbs	ASME B16.5	RF		Φ168.3x7.11
N8	measuring connection	1/2"NPT					Φ29.1
N7	spare nozzle	1"	150 lbs	ASME B16.5	RF		Φ33.4x3.38
N2	gas outlet	8"	150 lbs	ASME B16.5	RF		Φ219.1x8.18

Index	Datum/date	Gez./drawn	Gegr./appr.	Art der Änderung / Modification

	Datum/date	Name/name
Gez. / drawn:	15.01.2020	Riedel
Gegr. / appr.:	15.01.2020	Bauerfeind

Benennung / Designation :
liquid separator
43284097

Kennwort/Subject:
Flaeserve
44004972

RUDERT EDELSTAHL-TECHNIK GmbH
Sachsenweg 3 08451 Crimmitschau
Tel.:03762/9561-0 Fax:03762/9561-150
E-Mail: info@rudert-edelstahl.de
Web: www.rudert-edelstahl.de

Zeichnung Nr. / Drawing No.	Projekt Nr. / Project No.	Bestell Nr. / Order No.	Maßstab / Scale	Blatt / sheet
19702-0	P43354	300150699	1:7.5	1/1

Zeichnung ist geistiges Eigentum der RUDERT EDELSTAHL-TECHNIK GmbH. Rechte aus Schutzvermerk DIN34-1-D vorbehalten.
Copyright by Messrs. RUDERT EDELSTAHL-TECHNIK GmbH. All rights provided by "Schutzvermerk DIN34-1-D" reserved

Stand/as per: 15.01.2020