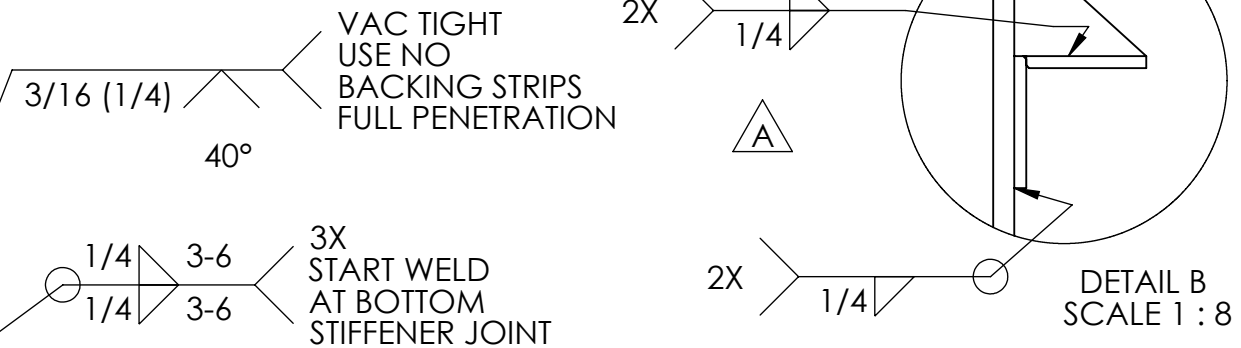
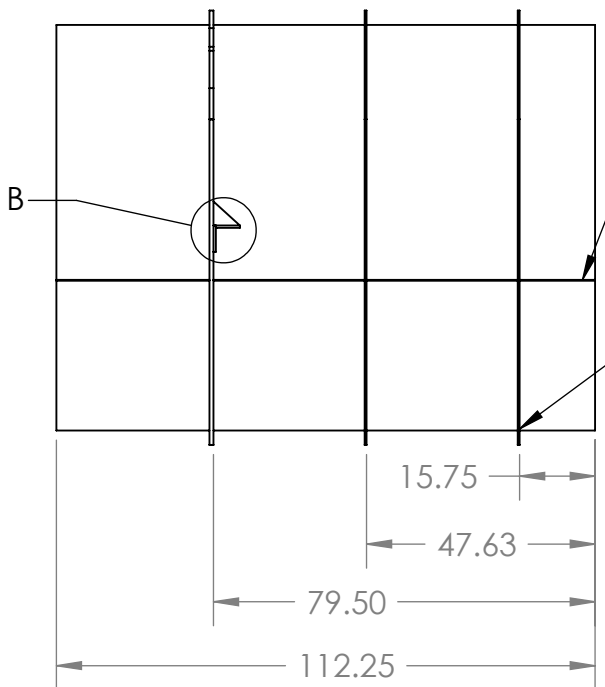
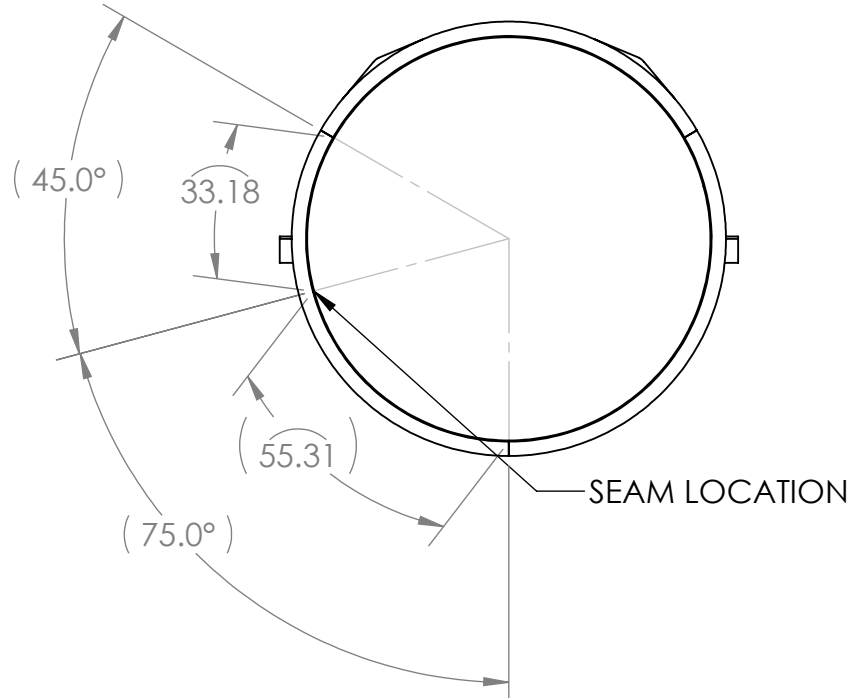
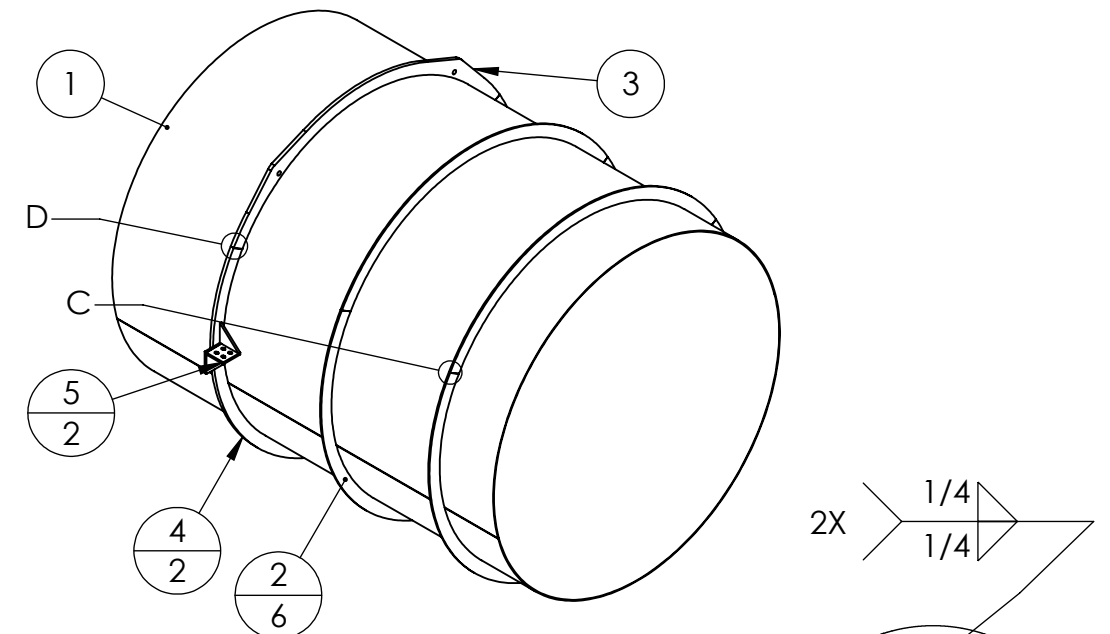
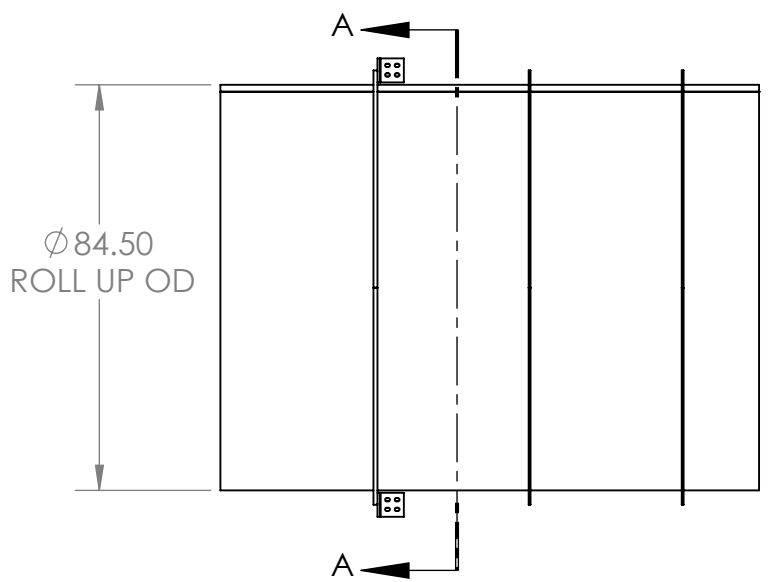
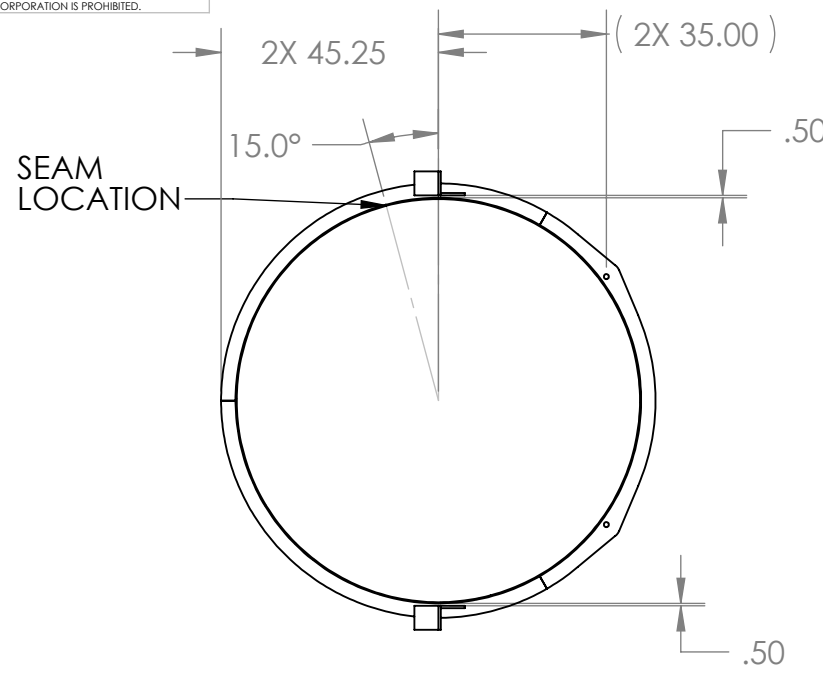


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REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	REVISED WELD CALLOUTS	8/11/2010	MKM2
	B	REVISED STIFFENER WELD STYLE; RELEASED TO PROTOTYPE	8/24/2010	MKM2



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	114203-01S	ROLL-UP, MC-A TUBES	1
2	114204-00S	STIFFENER, 1/3, PLAIN, MC TUBE	6
3	114205-00S	STIFFENER, LIFTING, MC TUBES	1
4	114206-00S	STIFFENER, THICK, MC TUBES	2
5	114207-00WS	WELDMENT, BRACKET, MC TUBE	2
6	114427-00S	PLATE, BRACKET, BRACE	2

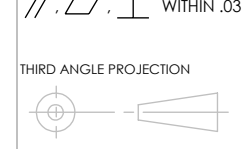
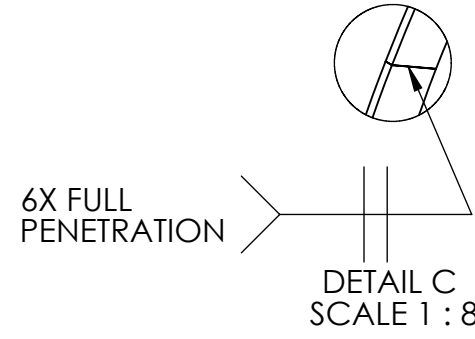
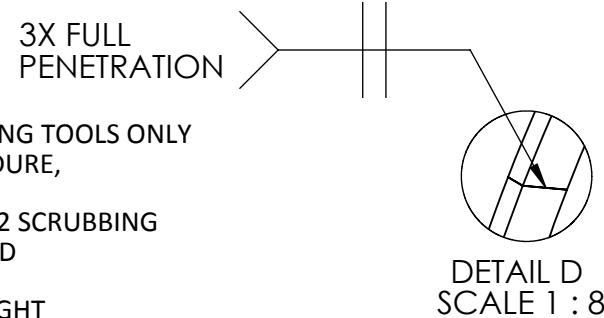
MATERIAL: AISI 304/AISI 304L DUAL CERT PER SA-240

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 TOLERANCES: FINISH 125
 ANGULAR: ± 0°30'
 .XX ± .03
 .XXX ± .005
 UNSPECIFIED FILLETS: R.015
 BREAK EDGES .010x45°
 REMOVE ALL BURRS

WEIGHT: 2556.41 #	
APPROVALS	DATE
DRAFTER MKM2	7/13/10
CHECKER RW	7/22/10
ENGINEER MKM2	7/13/10

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 www.gnbvalves.com

- NOTES:
 1. ALL WELD PREPS TO BE DONE BY TUNGSTEN CARBIDE CUTTING TOOLS ONLY
 2. WELD PER QP1750-W2, LIGO WELDING AND REPAIR PROCEDURE, LATEST REVISION
 3. CLEAN WELD WIRE AND SURFACES TO BE WELDED WITH CO2 SCRUBBING
 4. INTERNAL WELD SURFACE TO BE SMOOTH BUT NOT GROUND
 5. ALL WELDS TO BE GTAW UNLESS OTHERWISE NOTED
 6. ALL INTERNAL WELDS TO BE CONTINUOUS AND VACUUM TIGHT
 7. NO POST WELD HEAT TREATMENT IS REQUIRED



TITLE: WELDMENT, TUBE, RIGHT, MCA TUBE	
DO NOT SCALE DRAWING	DWG. NO. 114252-00WS
SCALE: 1:40	SHEET 1 OF 1
REV B	