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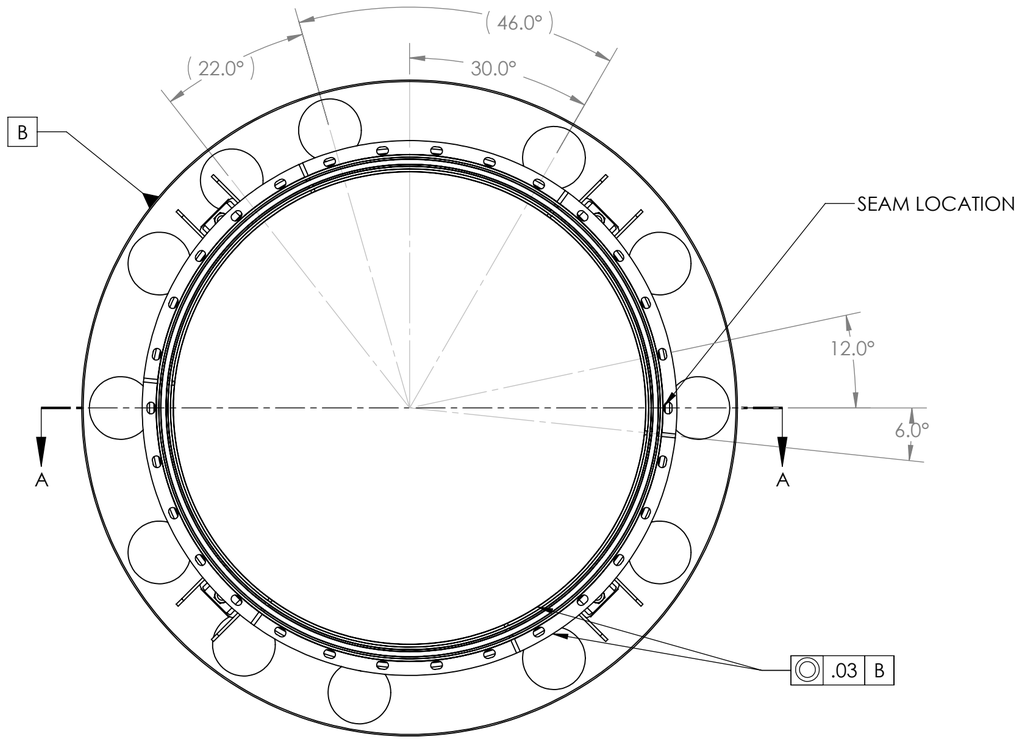
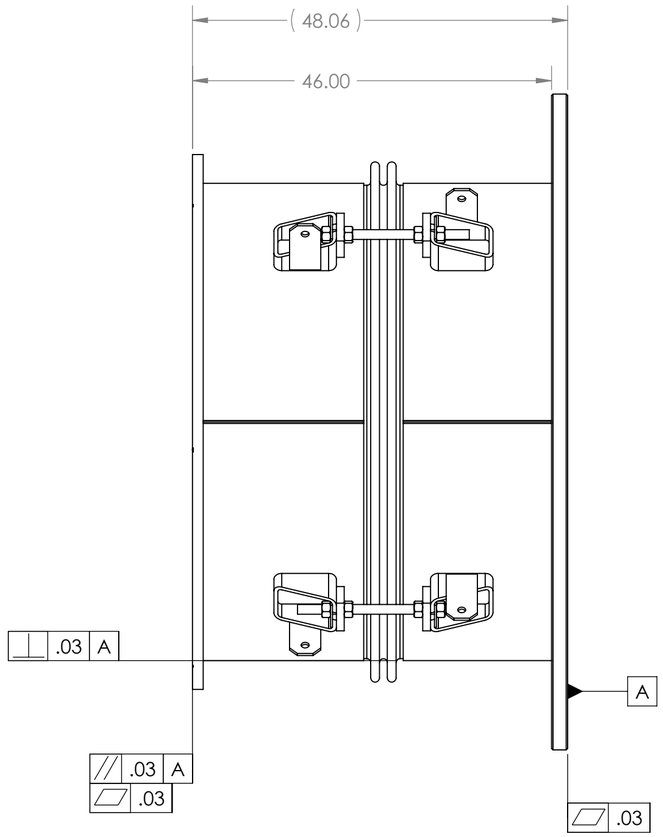
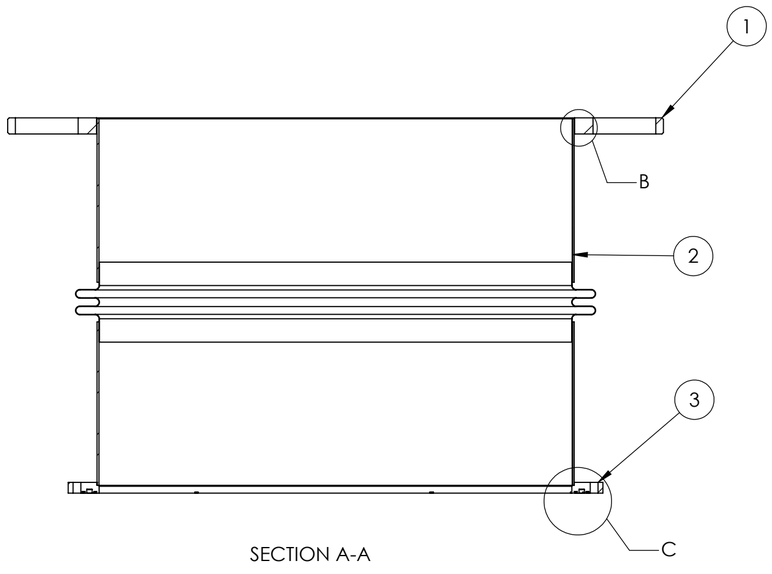
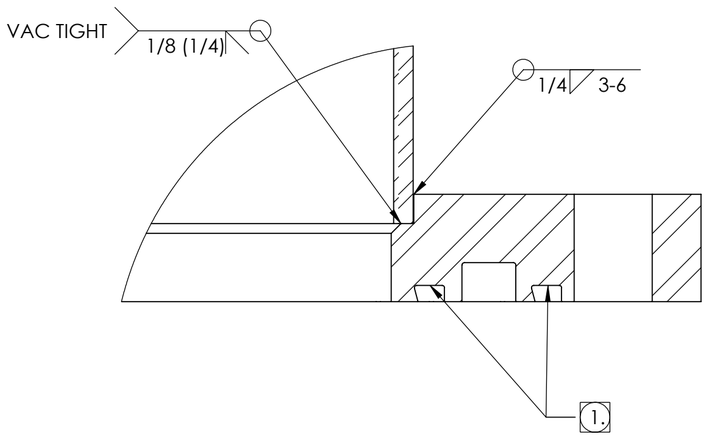
REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED



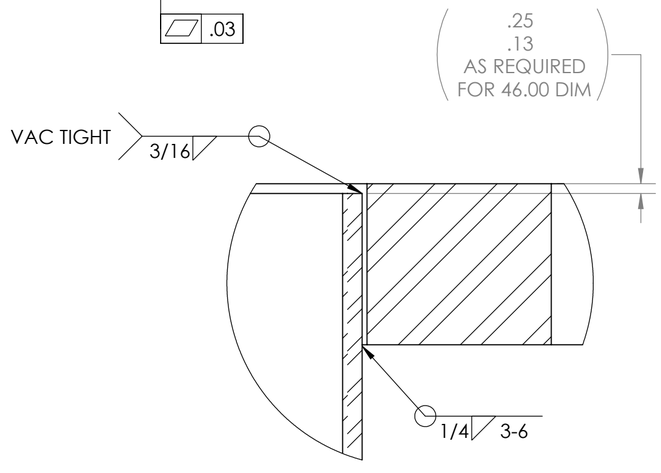




SECTION A-A



DETAIL C
SCALE 1 : 1.5



DETAIL B
SCALE 1 : 1.5

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	114223-02S	PLATE, REDUCER, MC-B#3	1
2	114222-00WS	WELDMENT, BELLOWS SUBASSEMBLY	1
3	114230-00S	FLANGE, 60.50 ID, GROOVED	1

MATERIAL: AISI 304/ AISI 304L DUAL CERT PER SA240

NOTES:

1. VACUUM SEALING SURFACE

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

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

WEIGHT: 2301.90#

APPROVALS		DATE
DRAFTER	MKM2	7/7/10
CHECKER	RW	7/22/10
ENGINEER	MKM2	7/7/10

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www.gnbvalves.com

TITLE:
WELDMENT, NIPPLE, BELLOWS, MC TUBE

DO NOT SCALE DRAWING

SIZE	DWG. NO.	REV
C	114221-02WS	-
SCALE: 1:15	SHEET 1 OF 1	