

BILL OF MATERIALS

ITEM	QTY.	DESCRIPTION	MATERIAL	SCH.	ACTUAL THICKNESS	HEAV#	WELD. PART NO.	WELD. DETAIL NO.	WELD. SIZE	WELDER NO.	WELDER I.D.	FT-UP	FINAL	A.I. HOLD DATE	A.I. DATE
1	1	SHELL 37" I.D. ROLLED 83 1/2" LG	SA-435	250			1	K	1/4"						
2	2	37" I.D. HEMISPHERICAL HEAD (1.6845" MIN.)	SA-414-C	211			2	K	1/4"						
3	1	3/4" SERIES 504 L.P.G. FLANGE W/ PILOT	SA 105	--			3	D	1/4"						
4	2	1" SERIES 505 L.P.G. FLANGE W/ PILOT	SA 105	--			4	D	1/4"						
5	2	1 1/4" SERIES 506 L.P.G. FLANGE W/ PILOT	SA 105	--			5	D	1/4"						
6	2	LIFTING HANDLE, SMALL, SERIES 2-300-LUG	SA 105	--			6	D	1/4"						
7	1	LATCH: 100A x1 1/4 x1 1/2 LG. SEE DETAIL	SA-36	1345			7	D	1/4"						
8	1	HINGE: 100A x1 1/2 x5 3/4" ROUNDED. SEE DETAIL	SA-36	1345			8	D	1/4"						
9	1	REGULATOR BRACKET: 148A x1 3 3/8 LG. SEE DETAIL	SA-36	0747			9	C	3/8"						
10	1	LEG BRG. PLATE 1/4" THK. X 25 5/8 LG. ROUNDED. SEE DETAIL	SA-36	250			10	C	3/8"						
11	1	LEG SUPPORT PLATE 1/4" THK. X 35 3/8 LG. SEE DETAIL	SA-36	250			11	B	1/4"						
12	1	3/4" NPS L.P.G. EVACUATION TUBE 37" LG. ASSY.	SA-105	3000#											
13	1	CODE NAME PLATE	SA-240-30AL	--											

SCHEDULE OF OPENINGS

MARK	SERVICE	QTY.	SIZE	RATING	TYPE	MATERIAL	SCH.
C1	EVACUATION	1	3/4"	3000#	EMC. ASSY.	SA 105	--
C2	AUX.	1	1"	--	L.P.G. FITT.	SA 105	--
C3	AUX.	1	3/4"	--	L.P.G. FITT.	SA 105	--
C4	AUX.	1	1 1/4"	--	L.P.G. FITT.	SA 105	--
C5	AUX.	1	1"	--	L.P.G. FITT.	SA 105	--
C6	AUX.	1	1 1/4"	--	L.P.G. FITT.	SA 105	--

* T MIN = THICKNESS OF THINNEST MATERIAL WELDED UNLESS OTHERWISE SPECIFIED

WELD TYPES

A	B	C	D	E	F	G	K
DOUBLE FILLET PER UW-16(b)	FULL PENETRATION WITH OPTIONAL BACK WELD	FULL PENETRATION & COVER WELD	GROOVE / FILET (UW-16.2 (a))	FULL PENETRATION WITH REINFORCEMENT	FULL PENETRATION	FILET	BUTT WELD WITH ONE PLATE EDGE OFFSET

ALL LONG SEAMS
3:1 TAPER AS REQUIRED

NOTES

INSPECTION BY: HARTFORD STEAM BOILER INSPECTION AND INSURANCE CO., OF CT
IMPACT TESTING IS EXEMPT PER UW-20(f)
FOR NON CORROSIVE SERVICE PER UW-46(a)
FOR CORROSIVE SERVICE PER UW-46(b)
P.W.H.T. NONE
NDE- 100% LONGITUDINAL, SPOT CIRCUMFERENTIAL (RT-4)
SHELL SEAM TO SEAM - ± 1/4" FROM O-LINE AND 1/2" ROTATION
ATTACHMENTS ± 1/4" FROM O-LINE AND 1" ROTATION

REVISIONS

REV#	DATE	DESCRIPTION	REV. BY	APPROVED
1	6/10/16	UPDATED NAME PLATE, ADDED NDE AND P.W.H.T. NOTES, ADDED TOLERANCES, UPDATED DETAIL 'D'.	PKK	DF
2	7/11/16	UPDATED LIFTING HANDLE PER CUSTOMER REQUEST	PKK	DF
3	8/28/16	UPDATED PER CUSTOMER REQUEST	PKK	DF

APPROX. WEIGHT 900#

THIS VESSEL HAS BEEN DESIGNED & FABRICATED TO MEET CRITERIA OF ASME CODE SECTION VIII, DIVISION 1 SPECIFICATIONS 2015 EDITION.

MFG AND NAT'L BD. SERIAL NO.

KATEVA MIDWEST, USA
CERTIFIED BY FISCHER FABRICATIONS
MAWP: 250 PSI AT 650° F
MDMT: -20° F AT 250 PSI
YEAR BUILT: 2016

RT-4
SHELL THICKNESS: 0.250 IN.
HEAD THICKNESS: 0.180 IN.
30 FT. STIFFNESS: 96.9 IN.
0.5 DIA. STIFFNESS: 0.1 L.P.G. LENGTH: 10.6 IN.
500
THIS CONTAINER SHALL NOT EXCEED A DESIGN PRESSURE AT 100°F ABOVE GROUND USE ONLY. FRESH LIQUID LEVEL GAUGE INDICATES 80% FULL.

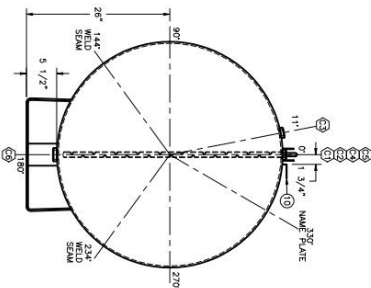
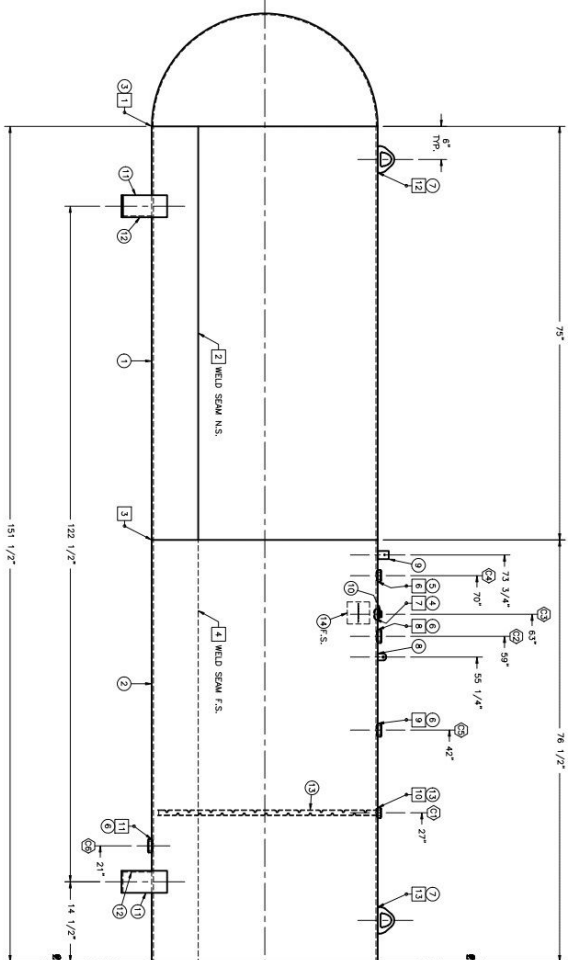
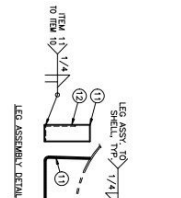
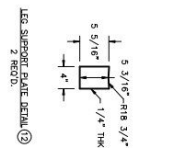
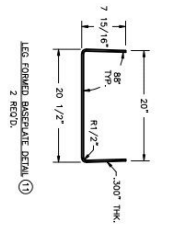
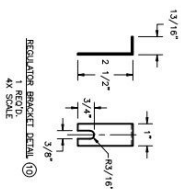
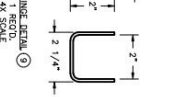
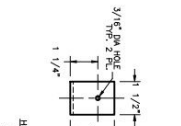
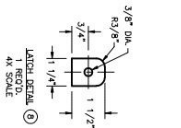
C.R.N.

ITEM	Q.C.M. & DATE	A.I. HOLD	A.I. & DATE
DRAWINGS, Q.A.S. & SPECS CHECKED			
MATERIALS CHECKED & RECORDED			
WELDERS & PROCEDURES CHECKED			
NDE REQUIREMENTS COMPLETED			
INTERNAL/FINISHED WELDS INSPECTED			
DATA REPORT SIGNED			
NAMEPLATE STAMPED			
HYDRO TEST COMPLETED			
GAUGE NO.	RECD. TEST: 115 MIN @ 235 psi	ACTUAL TEST:	MIN @

FISCHER FABRICATIONS L.L.C. KALEVA, MI, U.S.A.

Office: (231) 382-4285
Fax: (231) 382-8812

DESCRIPTION: 500 GALLON PROPANE TANK
SCALE: 1/16" = 1"
APPROVED BY: DATE: CODE: YES
DRAWN BY: NOZ
CHECKED: A.L.
RELEASED: 500 GALLON TANK
STAMP NO.:
REVISION: 3
DATE: 4/15/16



Phone: (231) 258-9900

 Fax: (231) 258-9909

BILL OF MATERIALS

ITEM	QTY.	DESCRIPTION	MATERIAL	SCH.	ACTUAL THICKNESS	HEAT#	MAT' PREP
1	1	SHELL 41" O.D. ROLLED 75"LG	SA-455	.250			
2	1	SHELL 41" O.D. ROLLED 76 1/2"LG	SA-455	.250			
3	2	41" O.D. HEMISPHERICAL HEAD (2045" MIN.)	SA-414-C	.231			
4	1	3/4" SERIES 504 L.P.G. FLANGE W/ PILOT	SA 105	---			
5	1	1" SERIES 505 L.P.G. FLANGE W/ PILOT	SA 105	---			
6	3	1 1/4" SERIES 506 L.P.G. FLANGE W/ PILOT	SA 105	---			
7	2	LIFTING HANDLE: SMALL SERIES 2-900-LUG	SA 105	---			
8	1	LATCH: 10GA X1 1/4"X1 1/2"LG., SEE DETAIL	SA-36	.1345			
9	1	HINGE: 10GA X1 1/2"X3 3/4" FORMED, SEE DETAIL	SA-36	.1345			
10	1	REGULATOR BRACKET: 1GA X1"X3 3/4"LG., SEE DETAIL	SA-36	.0747			
11	1	LEG BASE PLATE: 3.00"X 3" X 3/16" LG., SEE DETAIL	SA-36	.300			
12	1	LEG SUPPORT PLATE: 1/4"X1 1/2"X3 3/8" LG., SEE DETAIL	SA-36	.250			
13	1	3/4" NPS L.P.G. EVACUATION TUBE 40 1/2"LG. ASST.	SA-105	3000#			
14	1	CODE NAME PLATE	SA-240-304L	---			

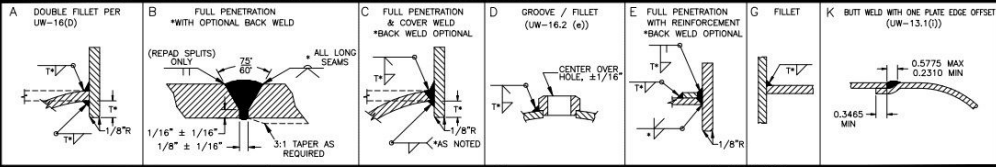
WELD DATA

WELD NO.	WELD DETAIL	WELD SIZE	WPS NO.	WELDER I.D.	FIT-UP Q.C. DATE	FINAL Q.C. DATE	A.I. HOLD DATE	A.I. DATE
1	K	5/16"						
2	B	5/16"						
3	B	5/16"						
4	B	5/16"						
5	K	5/16"						
6	D	1/4"						
7	D	1/4"						
8	D	1/4"						
9	D	1/4"						
10	D	1/4"						
11	D	1/4"						
12	G	3/8"						
13	G	3/8"						
ITEM 8	G	1/8"						
ITEM 9	G	1/8"						
ITEM 10	G	1/8"						
ITEM 11	SEE DETAIL							
ITEM 12	SEE DETAIL							
ITEM 14	G AS REQD							

SCHEDULE OF OPENINGS

MARK	SERVICE	QTY.	SIZE	RATING	TYPE	MATERIAL	SCH.
C1	EVACUATION	1	3/4"	3000#	EVAC. ASSY.	SA 105	---
C2	AUX.	1	1 1/4"	---	L.P.G. FITT.	SA 105	---
C3	AUX.	1	3/4"	---	L.P.G. FITT.	SA 105	---
C4	AUX.	1	1"	---	L.P.G. FITT.	SA 105	---
C5	AUX.	1	1 1/4"	---	L.P.G. FITT.	SA 105	---
C6	AUX.	1	1 1/4"	---	L.P.G. FITT.	SA 105	---

WELD TYPES



NOTES

INSPECTION BY: MARLBORO STEAM BOILER INSPECTION AND INSURANCE CO., OF CT
 IMPACT TESTING IS EXEMPT PER UG-20(F)
 FOR NON CORROSIVE SERVICE PER UG-46(4)
 POWDER COATING TO MEET OR EXCEED 500 HOURS SALT SPRAY.
 PRHT - NONE
 NDE - NON LONGITUDINAL SPOT ON HEAD TO SHELL JOINTS PER UW-11(b), SPOT ON SHELL TO SHELL JOINT PER UW-11(a)(2)(b)(RT-4)
 SHELL SEAM TO SEAM - ± 1/4"
 NOZZLE LOCATION - ± 1/8" FROM O-LINE AND 1/2" ROTATION
 ATTACHMENTS ± 1/4" FROM O-LINE AND 1" ROTATION
 APPROX. WEIGHT 1750#

REVISIONS

REV#	DATE	DESCRIPTION	REV. BY	APPROVED
1	8/1/16	UPDATED PER CUSTOMER REQUEST	PJK	DF
2	8/25/16	UPDATED PER CUSTOMER REQUEST	PJK	DF
3	7/14/17	CHANGED TEMP. AND SHELL THK.	PJK	DF

UW RT-4
 MAWP: 250 PSI AT 400° F
 MDMT: -20° F AT 250 PSI
 YEAR BUILT: 2017
 HEAD THICKS: 0.204 IN. HEAD - HEMISPHERICAL
 SHELL THICKS: 0.250 IN. CW LENGTH SURFACE: 174.84 SQ. FT. 192.5 IN. O.S. DIA. 41.5 IN. - D.T. LENGTH 11.5 IN.
 THIS CONTAINER SHALL NOT CONTAIN A PRODUCT HAVING A WORKING PRESSURE IN EXCESS OF 250 PSIG AT 100° F. ABOVE GROUND USE ONLY.
 PRESSURE LEVEL SHALL BE INDICATED BY FULL COLOR LABELING SERVICE ONLY (NEVER PORTABLE FOR HOME PROPANE TANK).
 C.A.N.

THIS VESSEL HAS BEEN DESIGNED & FABRICATED TO MEET CRITERIA OF ASME CODE SECTION VIII, DIVISION 1 SPECIFICATIONS 2015 EDITION.

ITEM	Q.C.M. & DATE	A.I. HOLD	A.I. & DATE
DRAWINGS, CALCS & SPECS CHECKED		*	
MATERIALS CHECKED & RECORDED		*	
WELDERS & PROCEDURES CHECKED		*	
NDE REQUIREMENTS COMPLETED		*	
INTERNAL/FINISHED WELDS INSPECTED		*	
DATA REPORT SIGNED		*	
NAMEPLATE STAMPED		*	
HYDRO TEST COMPLETED		*	
GAUGE NO.:	REV'D: TESTE15 MN @ 325 psf	ACTUAL TEST:	MN @ p.s.f.

FISCHER FABRICATIONS L.L.C. KALEVA, MI. U.S.A.
 Office: (231) 262-8265
 Fax: (231) 262-8212
 DESCRIPTION: 1000 GALLON PROPANE TANK
 SCALE: 1/16"=1"
 APPROVED BY: [Signature] DATE: [] CODE: YES
 D.C.M.: []
 DRAWN BY: NDZ
 FILENAME: 1000 GALLON TANK ALL: []
 STD. MODEL: --- REVISION: 3 DATE: 7/29/16
 DWG.#: 1000 JOIN# --- INTR# ---