NOTES:

1. WELDING AND INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH ASME SECTION IX.
   NO CODE STAMP REQUIRED.

2. NUMBER OF PIPE BUTT WELDS SHOULD BE MINIMIZED.
   100% DYE PENETRANT INSPECTION REQUIRED.

3. MATERIAL CERTIFICATIONS REQUIRED.

4. DESIGN PRESSURE 1500 PSI. ASSEMBLY SHALL BE PRESSURE TESTED WITH WATER TO 2250 PSI.

ITEM | NAME | MATERIAL | DESCRIPTION | DWG
--- | --- | --- | --- | ---
5 | hg nozzle flange | SS-316L, ASTM A269 | RIGID SEAMLESS TUBE, 12MM OD X 1MM WALL X 1.000 N/A | 203-HJ T0620B
4 | tubing bend flange | SS-316L | SEAMLESS RIGID TUBING, 12MM OD X 1MM WALL | 203-HJ T0625B
3 | hg supply reducer flange | SS-316L, ASTM A276 | FLOW REDUCER | 203-HJ T0624A
2 | hg primary supply assy | SS-316L | RIGID SEAMLESS TUBE & PIPE | 203-HJ T0623B
1 | hg nozzle flange | SS-316L, ASTM A240 | NOZZLE FLANGE | 203-HJ T0622A

ITEM | small/medium/large | QTY. | NAME | MATERIAL | DESCRIPTION | DWG
--- | --- | --- | --- | --- | --- | ---
51 | small | 1 | hg nozzle | SS - 316L, ASTM A269 | RIGID SEAMLESS TUBE, 12MM OD X 1MM WALL X 1.000 | N/A
41 | tubing bend flange | 1 | SS-316L | SEAMLESS RIGID TUBING, 12MM OD X 1MM WALL | 203-HJT-0625B
31 | hg supply reducer flange | 1 | SS-316L, ASTM A276 | FLOW REDUCER | 203-HJT-0624A
21 | hg primary supply assy | 1 | RIGID SEAMLESS TUBE & PIPE | 203-HJT-0623B
11 | hg nozzle flange | 1 | SS-316L, ASTM A240 | NOZZLE FLANGE | 203-HJT-0622A

WELDING AND INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH ASME SECTION IX. NO CODE STAMP REQUIRED.

NUMBER OF PIPE BUTT WELDS SHOULD BE MINIMIZED. 100% DYE PENETRANT INSPECTION REQUIRED.

MATERIAL CERTIFICATIONS REQUIRED.

DESIGN PRESSURE 1500 PSI. ASSEMBLY SHALL BE PRESSURE TESTED WITH WATER TO 2250 PSI.

WELDING AND INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH ASME SECTION IX. NO CODE STAMP REQUIRED.

NUMBER OF PIPE BUTT WELDS SHOULD BE MINIMIZED. 100% DYE PENETRANT INSPECTION REQUIRED.

MATERIAL CERTIFICATIONS REQUIRED.

DESIGN PRESSURE 1500 PSI. ASSEMBLY SHALL BE PRESSURE TESTED WITH WATER TO 2250 PSI.
1. ALL DIMENSIONS ARE IN INCHES
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M
3. MACHINED FINISH 125 MICRO-INCHES RMS
4. CONCENTRICITY .010 TIR
5. MACHINED ANGLES FORMED ANGLES
6. BREAK SHARP CORNERS AND REMOVE ALL BURRS
7. WHOLE NUMBERS AND FRACTIONS
8. X DECIMALS .030
9. XX DECIMALS .010
10. XXX DECIMALS .005 UNLESS OTHERWISE NOTED

NOTES

1. WELDING AND INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH ASME SECTION IX. NO CODE STAMP REQUIRED.
2. NUMBER OF PIPE BUTT WELDS SHOULD BE MINIMIZED. 100% DYE PENETRANT INSPECTION REQUIRED.
3. MATERIAL CERTIFICATIONS REQUIRED.
4. DESIGN PRESSURE 1500 PSI. ASSEMBLY SHALL BE PRESSURE TESTED WITH WATER TO 2250 PSI.

SECTION A-A
SCALE 1:2

REAM BORE 1MM ID
AFTER WELDING