1. All welds must be watertight.
2. Welding & inspections shall be performed in accordance with AWS D.1.6.
3. All welds shall be dye penetrant inspected.
4. Material certifications required.

**Notes:**
- Welds and inspections shall be performed in accordance with AWS D.1.6.
- All welds shall be dye penetrant inspected.
- Materials certifications required.

**Item NO.** | **QTY.** | **Description** | **Material** | **Length** |
--- | --- | --- | --- | --- |
12 | 1 | Bent Bracket, 75 Wide x 10 Thk | SS - 304L, ASTM A204 | — |
11 | 1 | Plate, 39.50 x 70.75 x .250 | SS - 304L, ASTM A240 | 70.75 |
10 | 2 | Round, 38 OD x 4.25 | SS - 304L, ASTM A276 | 4.25 |
9 | 1 | Plate, 37.50 x 37.00 x .250 | SS - 304L, ASTM A240 | 37.50 |
8 | 1 | Plate, 37.00 x 69.25 x .250 | SS - 304L, ASTM A240 | 69.25 |
7 | 2 | Plate, 4.50 x 6.00 x 1.50 | SS - 304L, ASTM A240 | 1.50 |
6 | 1 | Plate, 3.50 OD x .25 THK | SS - 304L, ASTM A240 | N/A |
5 | 1 | Pipe, 3" SC, 40 x 1.00 | SS - 304L, ASTM A312 | 1.00 |
4 | 1 | Plate, 38.00 x 37.00 x .250 | SS - 304L, ASTM A240 | 37.00 |
3 | 1 | Plate, 37.00 x 69.25 x .250 | SS - 304L, ASTM A240 | 69.25 |
2 | 1 | Plate, 37.50 x 68.75 x .50 | SS - 304L, ASTM A240 | 68.75 |
1 | 1 | Plate, 11.88 Dia x .250 | SS - 304L, ASTM A240 | 2.50 |

**Estimated Weight:** 923 lbs

Lip can be fabricated from strip, miter welded and ground.
NOTES
1. ALL WELDS MUST BE WATERTIGHT
2. WELDING & INSPECTIONS SHALL BE PERFORMED IN ACCORDANCE WITH AWS D.1.6
3. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
4. MATERIAL CERTIFICATIONS REQUIRED

FABRICATE TO MATCH HG LEAK DETECTOR
1/4-20 0.25 DP

THRU.
1.00

4X

TYP. LIP
1.00

4X

0

SECTION Y-Y

TUBE TO BE FLUSH WITH INSIDE WALL
1/4-20 Tapped Hole

THRU.
2.25

10-32 UNF - 2B

THRU.
1.25

12-24 UNC - 2B

THRU.
2.25
NOTES
1. ALL WELDS MUST BE WATERTIGHT
2. WELDING & INSPECTIONS SHALL BE PERFORMED IN ACCORDANCE WITH AWS D.1.6
3. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
4. MATERIAL CERTIFICATIONS REQUIRED
NOTES
1. ALL WELDS MUST BE WATER-TIGHT
2. WELDING & INSPECTIONS SHALL BE PERFORMED IN ACCORDANCE WITH AWS D.1.6
3. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
4. MATERIAL CERTIFICATIONS REQUIRED