

National Board Number: 240
 Mfg. Representative: U. JSTF Date: 29/DEC/2020
 Authorized Inspector: Boonluw Date: 06/JAN/2021

FORM U-1A MANUFACTURER'S DATA REPORT FOR PRESSURE VESSELS
(Alternative Form for Single Chamber, Completely Shop or Field Fabricated Vessels Only)
As Required by the Provisions of the ASME Boiler and Pressure Vessels Code Rules, Section VIII, Division 1

1. Manufactured and certified by Cryolor Asia Pacific Pvt Ltd No 1, GST Road Chennai-Madurai NH45 Kadamalaiputhur Village Perumberkandigai Post
Maduranthagam Taluk, Tamilnadu 603310 India
 (Name and address of Manufacturer)

2. Manufactured for Stock
 (Name and address of Purchaser)

3. Location of installation Not known
 (Name and address)

4. Type Vertical C240002 NA Refer Form U-4 240 2020
 (Horizontal or vertical, tank) (Manufacturer's serial number) (CRN) (Drawing number) (National Board number) (Year built)

5. ASME Code, Section VIII, Division 1 2019 None Low Temperature-320°F (-196°C)
 [Edition and Addenda, if applicable (Date)] (Code Case numbers) [Special Service per UG 120(d)]

6. Shell SA 240M Type 304 0.393 In.(10mm) 0.0In.(0.0 mm) 72.283 In.(1836 mm) 354.842 In.(9013 mm)
 (Material spec. number, grade) (Nominal thickness) (Corr. allow.) (Inner Diameter) [Length (overall)]

Body Flanges on Shells												
No.	Type	ID	OD	Flange Thk	Min Hub Thk	Material	How Attached	Location	Bolting			
									Num & Size	Bolting Material	Washer (OD, ID, thk)	Washer Material
-	-	-	-	-	-	-	-	-	-	-	-	-

7. Seams Type 1 dbl Butt Full 1.0 None None Refer Form U-4 Full 0.9, 1.0 6
 [Long (welded, dbl., snl., lap, butt)] [R.T.(Spot or Full)] (Eff. %) (H.T. Temp.) (Time, hr) [Girth (Welded, Dbl., Snl., Lap, Butt)] [R.T. (Spot or Full)] [Eff.] (No. of Courses)

8. Heads: (a) Material SA 240M Type 304 (b) Material SA 240M Type 304
 (Spec. no., grade) (Spec. no., grade)

	Location (Top, Bottom, Ends)	Minimum Thickness	Corrosion Allowance	Crown Radius	Knuckle Radius (mm)	Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure (Convex or Concave)
(a)	Top End	0.393 In.(10mm)	0.0 In.(0.0 mm)	NA	NA	2:1	NA	NA	NA	Concave
(b)	Bottom End	0.393 In.(10mm)	0.0 In.(0.0 mm)	NA	NA	2:1	NA	NA	NA	Concave

Body Flanges on Heads												
	Location	Type	ID	OD	Flange Thk	Min Hub Thk	Material	How Attached	Bolting			
									Num & Size	Bolting Material	Washer (OD, ID, thk)	Washer Material
(a)	-	-	-	-	-	-	-	-	-	-	-	-
(b)	-	-	-	-	-	-	-	-	-	-	-	-

9. MAWP 350psig (2.413Mpa) NA at max. temp. 120°F (50°C) NA
 (Internal) (External) (Internal) (External)

Min. design metal temp. -320°F (-196°C) at 350psig (2.413Mpa) Hydro., pneu., or comb. test pressure Cold Stretching Pressure 580, 151 Psig(4.0 MPa)

Proof test NA

10. Nozzles, inspection, and safety valve openings:

Purpose (Inlet, Outlet, Drain etc)	No.	Diameter or Size	Type	Material		Nominal Thickness		Reinforcement Material	Attachment Details		Location (Insp. Open.)
				Nozzle	Flange	Nom.	Corr.		Nozzle	Flange	
See attached Form U-4 for Nozzle Details											
-	-	-	-	-	-	-	-	-	-	-	-

11. Supports: Skirt No Lugs NA Legs NA Other Refer Form U-4 Attached Refer Form U-4 Remarks (4)
 (Yes or no) (Number) (Number) (Describe) (Where and how)

12. Remarks: Manufacturer's Partial Data Reports properly identified and signed by Commissioned Inspectors have been furnished for the following items of the report: NA

(Name of part, item number, Manufacturer's name and identifying stamp)

This Vessel has been constructed using Cold-Stretching Process in accordance with Mandatory Appendix 44, Hence 'CS' marked on Code Name plate.

National Board Number: 240
 Mfg. Representative: U. Just Date: 29/DEC/2020
 Authorized Inspector: Suresh Kumar Date: 06/JAN/2021

FORM U-1A

Manufactured by Cryolor Asia Pacific Pvt Ltd No 1, GST Road Chennai-Madurai NH45 Kadamalaiputhur Village Perumberkandigai Post

Maduranthagam Taluk, Tamilnadu 603310 India

Manufacturer's Serial No C240002 CRN N.A National Board No. 240

We certify that the statements made in this report are correct and that all details of design, material, construction, and workmanship of this vessel conform to the ASME BOILER AND PRESSURE VESSEL CODE, Section VIII, Division 1. "U" Certificate of Authorization Number 43,832 expires September 28, 2021

Date 29/DEC/2020 Co. name Cryolor Asia Pacific Pvt Ltd Signed U. Just
 (Manufacturer) (Representative)

CERTIFICATE OF SHOP/FIELD INSPECTION

Vessel constructed by Cryolor Asia Pacific Pvt Ltd at address specified in Sl. No.1

I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and employed by TÜV SÜD Industrie Service GmbH of Westendstrasse 199, 80686 Munich, Germany

have inspected the component described in this Manufacturer's Data Report on 28 December 2020, and state that, to the best of my knowledge and belief, the Manufacturer has constructed this pressure vessel in accordance with ASME BOILER AND PRESSURE VESSEL CODE, Section VIII, Division 1. By signing this certificate neither the Inspector nor his/her employer makes any warranty, expressed or implied, concerning the pressure vessel described in this Manufacturer's Data Report. Furthermore, neither the Inspector nor his/her employer shall be liable in any manner for any personal injury or property damage or a loss of any kind arising from or connected with this inspection.

Date: 06/JAN/2021 Signed Suresh Kumar Sozhan Commissions NB 15133 AI
 (Authorized Inspector) (National Board Authorized Inspector Commission number)

FORM U-4 MANUFACTURER'S DATA REPORT SUPPLEMENTARY SHEET
As Required by the Provisions of the ASME Boiler and Pressure Vessel Code Rules, Section VIII, Division 1

1. Manufactured and certified by Cryolor Asia Pacific Pvt Ltd No 1, GST Road Chennai-Madurai NH45 Kadamalaiputhur Village Perumberkandigai Post Maduranthagam Taluk, Tamilnadu 603310 India
(Name and address of Manufacturer)

2. Manufactured for Stock
(Name and address of Purchaser)

3. Location of installation Not known
(Name and address)

4. Type : Vertical Pressure Vessel C240002
(Horizontal, vertical, or sphere) (Tank separator, heat exch., etc.) (Manufacturer's serial number)
N.A. HC003647 Rev.AB 240 2020
(CRN) (Drawing number) (National Board Number) (Year built)

Data Report (Item Number) **Remarks**

[Girth (Welded, Dbl, Single, Lap., Butt)]	[R.T. (Spot or Full)]	[Eff.(%)]
Shell to Shell Type-1 Double Butt	Full	1.0
Shell to Head Type-2 Single Butt	Full	0.9

10. Nozzles, inspection and safety valve openings:

Purpose (Inlet, Outlet, Drain etc.)	Number	Diameter or Size (In.)	Type	Material		Nominal Thickness (In.)		Reinforcement Material	Attachment Details		Location (Insp. Open.)
				Nozzle	Flange	Nom	Corr		Nozzle	Flange	
Safety Line(T1)	1	OD 1.900	w.e	SA 312M TP304	-	0.145	0	-	Fig UW-16.1(c)	-	-
Top Filling Cum Trycock(T2-1)	1	OD 2.375	w.e	SA 312M TP304	-	0.154	0	-	Fig UW-16.1(c)	-	-
High Level(Gas) (T4)	1	OD 0.840	w.e	SA 312M TP304	-	0.109	0	-	Fig UW-16.1(c)	-	-
Hydro Piping(T5)	1	OD 1.900	w.e	SA 312M TP304	-	0.145	0	-	Fig UW-16.1(c)	-	-
Gas Return-1(T6-1)	1	OD 2.375	w.e	SA 312M TP304	-	0.154	0	-	Fig UW-16.1(c)	-	-
Gas Return-2 (T7)	1	OD 1.900	w.e	SA 312M TP304	-	0.145	0	-	Fig UW-16.1(c)	-	-
Condenser Feeding(T8)	1	OD1.050	w.e	SA 312M TP304	-	0.113	0	-	Fig UW-16.1(c)	-	-
Condenser Return(T9)	1	OD1.050	w.e	SA 312M TP304	-	0.113	0	-	Fig UW-16.1(c)	-	-
Gas Return-3 (T10)	1	OD 1.900	w.e	SA 312M TP304	-	0.145	0	-	Fig UW-16.1(c)	-	-
Liquid Withdrawal (B1-1)	1	OD 2.375	w.e	SA 312M TP304	-	0.154	0	-	Fig UW-16.1(c)	-	-
Bottom Filling(B2-1)	1	OD 2.375	w.e	SA 312M TP304	-	0.154	0	-	Fig UW-16.1(c)	-	-
Liquid Withdrawal(B3-1)	1	OD 2.375	w.e	SA 312M TP304	-	0.154	0	-	Fig UW-16.1(c)	-	-
Low Level(Liquid)(B4)	1	OD 0.840	w.e	SA 312M TP304	-	0.109	0	-	Fig UW-16.1(c)	-	-
Hydro Piping(B5)	1	OD 1.900	w.e	SA 312M TP304	-	0.145	0	-	Fig UW-16.1(c)	-	-
Liquid Withdrawal(B10)	1	OD 1.900	w.e	SA 312M TP304	-	0.145	0	-	Fig UW-16.1(c)	-	-

12. Remarks:
- Impact testing exempted for base metal and HAZ as per UHA-51(d)(1)(a) & Mandatory Appendix 44 clause 44-6.1(g)(1). Welding Procedure are Impact tested at -196°C for weld & HAZ as per UHA 51(e)(2)(a) & Mandatory Appendix 44 clause 44-6.1(g)(2)
 - Vessel Model No.: RCIA30
 - "For Non Corrosive Service" - No corrosion allowance considered in design. Hence no inspection opening provided.
 - Three supports welded on shell with main support plate on vessel OD at 15° between axis X0-Y0, Y1-X1 at 39.370 In. from top head to shell weld line. 45° between axis X1-Y0 at 39.370 In. from top head to shell weld line. Three Leg welded with outer vessel shell bottom at location 10° from axis (Y1-X1), 45° from axis (Y0-X1), and 80° from axis (Y0-X0).
 - Duplicate Code name plate provided on outer vessel with nameplate bracket at 3.110 In. from bottom tan line at axis X1.
 - Liquid penetrant examination performed on all categories A, D welds & attachment welds after Cold Stretch of the vessel
 - Pre-use testing of welding consumables performed as per UHA-51(f).
 - Vessel is insulated and enclosed within outer vessel constructed of carbon steel material.
 - Code Name plate tack welded on name plate support rod at a distance of 1.969 In. from center of top head and 30° between axis (X0-Y1) on Top head.
 - 'NA' Indicates as 'Not Applicable', 'OD'- Outside Diameter, 'w.e' – Weld End, 'ID' – Inside Diameter

Certificate of Authorization: Type U No. 43,832 Expires September 28, 2021
Date 29/DEC/2020 Name: Cryolor Asia Pacific Pvt Ltd Signed H. J. P.
(Manufacturer) (Representative)
Date 06/01/2021 Signed Suresh Kumar Sozhan Commissions NB15133 AI
(Authorized Inspector) (National Board Authorized Inspector Commission number)

