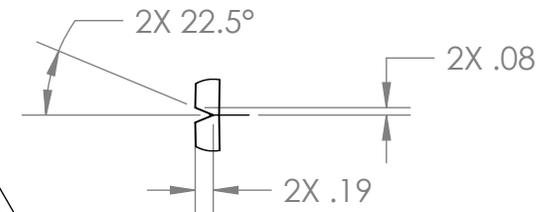
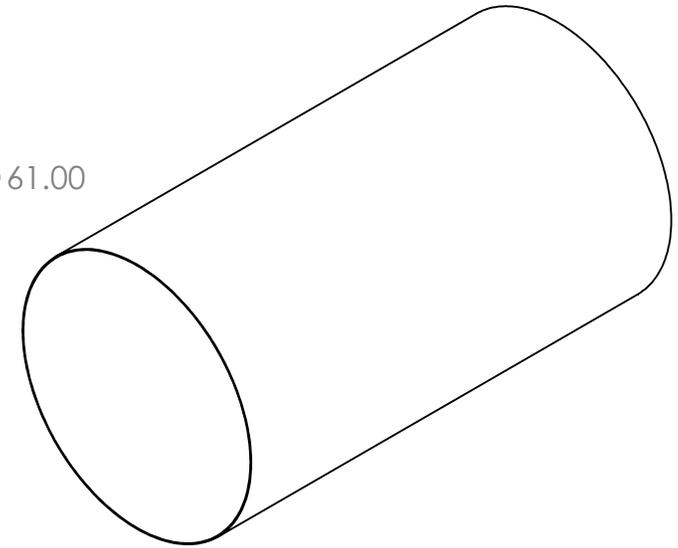
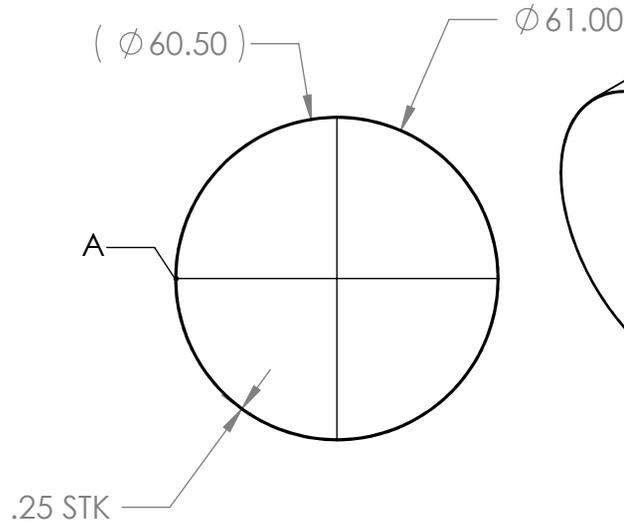
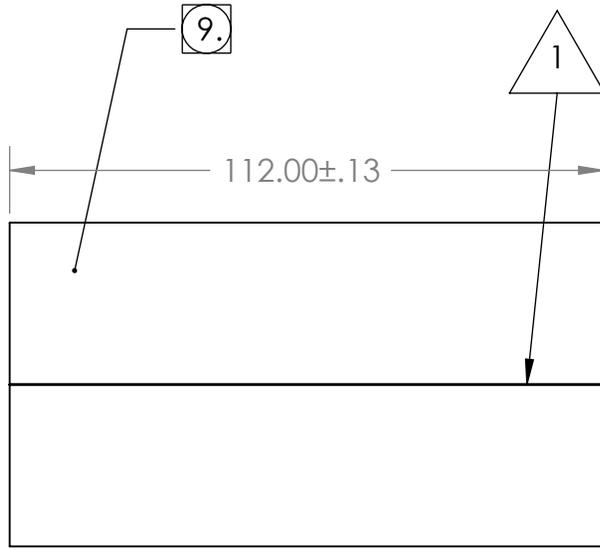


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REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	REVISED WELD PREP	8/11/2010	MKM2
	B	REVISED WELD PREP PER VENDOR CAPABILITIES	8/13/2010	MKM2
	C	RELEASED TO PRODUCTION	8/20/2010	MKM2



DETAIL A
SCALE 1 : 2

WELD PREP DETAIL

NOTES

1. SEAM TO ARRIVE WITH WELD PREPS IN PLACE.
2. TACK ROLL UP WITH CERTIFIED ROD ONLY (PROVIDED BY GNB).
3. CARBON STEEL ROLLERS SHALL BE COVERED WITH STAINLESS STEEL PRIOR TO ROLLING TO PREVENT CONTAMINATION.
4. SEAM EDGES SHALL BE PREWORKED TO ENSURE ROUNDNESS OF THE FINAL CYLINDER.
5. ROLL-UP PLATES MAY HAVE SHEARED EDGES ONLY IF THE SHEARED EDGES ARE THEN RE-CUT WITH A TUNGSTEN CARBIDE TOOL TO REMOVE CONTAMINATION BY THE ROLLING VENDOR. ACCEPTABLE CUTTING METHODS ARE PLASMA, LASER, WATER JET, OR CARBIDE CUTTING.
6. FINAL BEVELS TO BE MADE WITH TUNGSTEN CARBIDE TOOLS ONLY.
7. PLATES AND ROLL-UPS MUST REMAIN PROTECTED FROM CONTACT WITH CARBON STEEL OR OTHER SOURCES OF CONTAMINATION DURING MOVING, WORKING, AND STORAGE. COVER CARBON STEEL WITH SST OR HEAVY PAPER, AND KEEP PLATES AND ROLL-UPS WRAPPED OR COVERED AT ALL TIMES WHEN NOT BEING PROCESSED.
8. A 2"X 12" SAMPLE COUPON MUST BE SUPPLIED FOR EACH HEAT LOT FROM WHICH MATERIAL IS SUPPLIED.

9. ETCH THE HEAT/LOT NUMBER AND PART NUMBER ON THE OUTER SHELL WITH A VIBRATORY TOOL WITH A MINIMUM TIP RADIUS OF .005"

DESCRIPTION: ROLL-UP, .25 WALL, 60.50 ID, 112 LG		<p>SCIENTIFIC AND INDUSTRIAL EQUIPMENT</p> <p>3200 DWIGHT RD. SUITE 100 ELK GROVE, CA 95758 916-395-3003 FAX: 916-395-3363 WWW.GNBVALVES.COM</p>															
MATERIAL: AISI 304/AISI 304L DUAL CERT PER SA240																	
UNLESS OTHERWISE SPECIFIED:	WEIGHT: 1544.00 #	<table border="1"> <thead> <tr> <th colspan="3">APPROVALS</th> </tr> <tr> <th></th> <th>NAME</th> <th>DATE</th> </tr> </thead> <tbody> <tr> <td>DRAFTER</td> <td>MKM2</td> <td>6/14/10</td> </tr> <tr> <td>CHECKER</td> <td>RW</td> <td>6/14/10</td> </tr> <tr> <td>ENGINEER</td> <td>MKM2</td> <td>6/14/10</td> </tr> </tbody> </table>	APPROVALS				NAME	DATE	DRAFTER	MKM2	6/14/10	CHECKER	RW	6/14/10	ENGINEER	MKM2	6/14/10
APPROVALS																	
	NAME		DATE														
DRAFTER	MKM2		6/14/10														
CHECKER	RW	6/14/10															
ENGINEER	MKM2	6/14/10															
DIMENSIONS ARE IN INCHES																	
TOLERANCES: ± 0°30' FINISH 125																	
ANGULAR: .XX ± .03																	
.XXX ± .005																	
UNSPECIFIED FILLETS: R.015																	
BREAK EDGES .010 x 45°																	
REMOVE ALL BURRS																	
// ◻ ⊥ WITHIN .03																	
THIRD ANGLE PROJECTION																	
DO NOT SCALE DRAWING		DWG. NO. A 114264-00S SCALE: 1:36															
		TITLE: ROLL-UP, MIDSTATION SPOOL SHEET 1 OF 1															