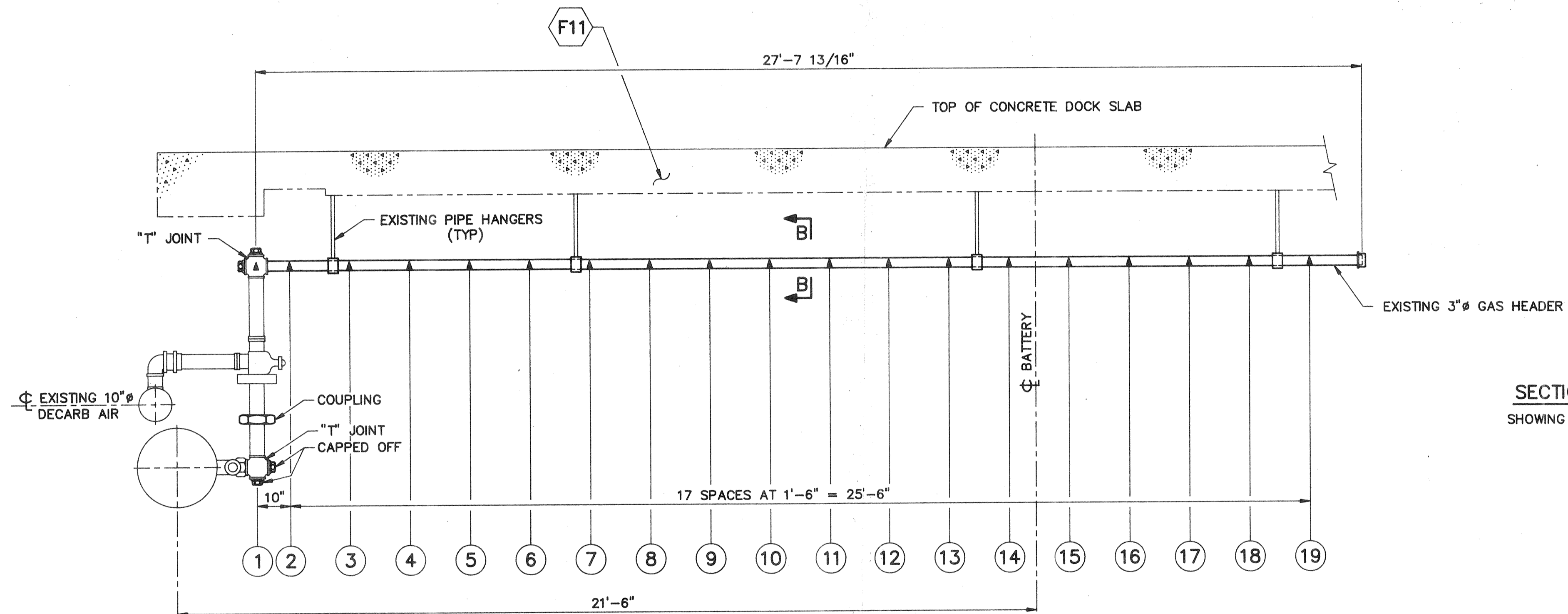
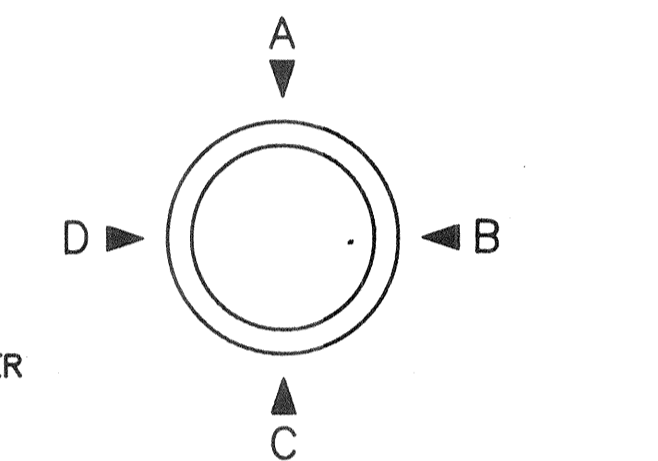


**KEY PLAN OF GAS HEADERS**  
BATTERY NO. 2



**SECTION "C-C" (LOOKING SOUTH)**  
TYPICAL SECTION OF 3" DIA. SHORT GAS HEADERS  
(A DENOTES LOCATIONS OF ULTRASONIC THICKNESS TESTING)



**SECTION "B-B" (LOOKING EAST)**  
SHOWING TYPICAL LOCATIONS OF U.T. READINGS

**TABLE 2 - ULTRASONIC THICKNESS TEST RESULTS (HUNDREDTHS OF AN INCH)**

GAS HEADER No. C7								GAS HEADER No. C18								GAS HEADER No. D3								GAS HEADER No. D12								GAS HEADER No. D25															
U.T. LOCATION								U.T. LOCATION								U.T. LOCATION								U.T. LOCATION								U.T. LOCATION															
F1	A		B		C		D		F3	A		B		C		D		F5	A		B		C		D		F7	A		B		C		D		F9	A		B		C		D				
STATION	1989	1993	1989	1993	1989	1993	1989	1993	STATION	1989	1993	1989	1993	1989	1993	1989	1993	STATION	1989	1993	1989	1993	1989	1993	1989	1993	STATION	1989	1993	1989	1993	1989	1993	1989	1993	STATION	1989	1993	1989	1993	1989	1993	1989	1993			
1	18	18	19	19	19	18	18	18	1	19	18	17	17	17	17	19	18	1	18	18	18	18	17	18	18	1	18	18	17	16	17	15	18	17	1	18	17	17	17	17	17	16	16				
2	17	17	17	16	17	17	16	16	2	17	17	17	16	17	17	16	16	2	19	19	18	17	18	17	17	2	17	16	18	16	15	14	15	15	2	17	17	17	17	18	17	18	18				
3	17	16	17	16	17	17	16	15	3	17	17	17	16	17	16	17	17	3	18	18	17	17	14	14	18	18	3	16	16	14	14	14	14	15	14	3	17	16	18	16	18	18	18	18			
4	18	18	17	16	17	17	17	17	4	18	16	15	15	15	15	16	16	4	17	17	16	16	15	14	16	16	4	17	17	14	14	14	14	14	13	4	16	16	17	16	13	13	16	16			
5	17	17	16	15	16	15	18	15	5	15	14	15	15	15	14	15	15	5	14	14	14	14	16	14	14	5	16	16	16	16	15	15	16	14	5	13	12	14	14	11	11	14	14				
6	15	15	15	14	18	16	15	15	6	19	18	16	16	17	15	15	15	6	16	16	17	16	16	15	15	15	6	16	16	15	15	16	16	15	15	6	18	17	13	13	13	12	13	12			
7	16	15	15	14	15	15	15	15	7	15	14	15	15	15	15	14	14	7	17	17	13	13	15	14	15	13	7	14	14	16	15	13	12	15	14	7	15	15	12	12	13	12	13	12			
8	18	16	16	15	12	12	16	16	8	19	18	19	14	13	13	16	15	8	16	16	14	14	13	13	15	15	8	15	14	13	13	12	16	15	8	13	13	12	12	14	14	14	13				
9	18	18	15	15	15	15	15	15	9	16	15	14	14	15	14	13	13	9	18	18	13	13	13	13	15	15	9	16	15	12	12	12	10	15	15	9	14	14	10	10	10	10	13	13			
10	18	17	15	14	15	13	15	15	10	18	18	16	15	13	13	16	16	10	18	17	15	15	13	13	16	16	10	14	13	13	13	12	15	14	10	16	16	11	11	10	11	11	11				
11	17	16	16	15	14	14	15	15	11	16	16	13	13	12	12	14	14	11	17	17	15	15	14	13	17	17	11	17	17	14	13	13	13	13	11	16	15	13	13	11	11	16	15				
12	18	17	17	17	14	14	16	16	12	17	17	17	14	13	14	14	14	12	15	14	14	14	12	12	14	14	12	16	15	13	13	14	14	14	14	12	17	16	13	13	11	11	14	14			
13	18	17	15	14	16	15	16	16	13	17	17	15	15	14	14	15	15	13	18	18	15	15	14	14	16	16	13	17	17	15	14	15	15	16	15	13	17	16	18	17	13	13	17	13			
14	17	17	16	16	15	15	16	15	14	18	18	16	16	15	15	15	15	14	18	17	16	16	14	14	16	16	14	17	16	16	16	15	15	16	15	14	15	14	15	14	16	14	16	14			
15	18	17	16	16	16	17	17	17	15	18	18	14	14	15	15	17	16	15	18	17	17	17	17	17	17	17	15	17	15	15	15	11	11	15	15	15	17	17	14	14	13	12	17	11			
16	18	17	16	16	17	17	17	17	16	19	19	17	17	16	15	16	16	16	16	18	18	17	17	18	17	18	16	17	17	16	16	14	14	16	16	16	17	17	15	15	11	11	16	13			
17	17	17	16	16	17	17	17	17	17	18	18	17	17	15	15	17	17	17	17	18	17	17	18	18	18	18	17	18	17	17	16	16	16	16	18	17	17	16	15	15	13	17	13	13	13		
18	17	17	16	16	17	17	17	17	18	17	17	19	18	16	16	17	17	18	18	18	18	18	18	18	18	17	18	18	18	17	15	15	16	16	18	16	16	15	15	14	13	15	12	12	12		
19	17	17	17	17	17	17	17	17	19	17	17	19	18	18	18	18	18	18	19	19	19	18	18	18	18	18	19	19	17	17	16	16	17	16	16	15	19	14	14	15	15	11	11	17	13	13	13

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- GENERAL NOTES**
1. ALL 3" GAS HEADERS ARE SCHEDULE 40 PIPE (ORIGINAL WALL THICKNESS = 0.216").
  2. (\*) DENOTES DENTED INWARDS BY 3/16"± IN A 3" AREA.
  3. (•) DENOTES PIPE IS BULGED OUTWARDS BY 3/16"(-) IN AN 8" AREA AT 180° OF SURFACE (4N0).

**ORBITAL ENGINEERING INC.**  
PITTSBURGH • CLEVELAND • CHICAGO • PHILADELPHIA  
JOB NO. W-6711 SHT. NO. 2S

39695 -- SMALL FUEL GAS PIPING UNDER OVENS - ARRGT  
37196 -- SMALL FUEL GAS PIPING UNDER OVENS - DETAILS

REFERENCE DRAWINGS LISTED ABOVE

**ACME STEEL** ACME STEEL COMPANY

ACME STEEL COMPANY - CHICAGO COKE PLANT  
COKE BATTERY NO. 2  
COKE OVEN GAS HEADER PIPING (SHORT)  
1989 & 1993 ULTRASONIC THICKNESS TESTING

TOLERANCE EXCEPT AS NOTED  
FRAC. DIM ±  
DEC. DIM ±  
TYP. DIM ±  
ANGLES ±

DO NOT SCALE WORK TO DIMENSIONS  
SCALE 1/2"=1'-0"

DR. DRB CH.  
SCALE APP.

W6711-1

2/26/93

REV.