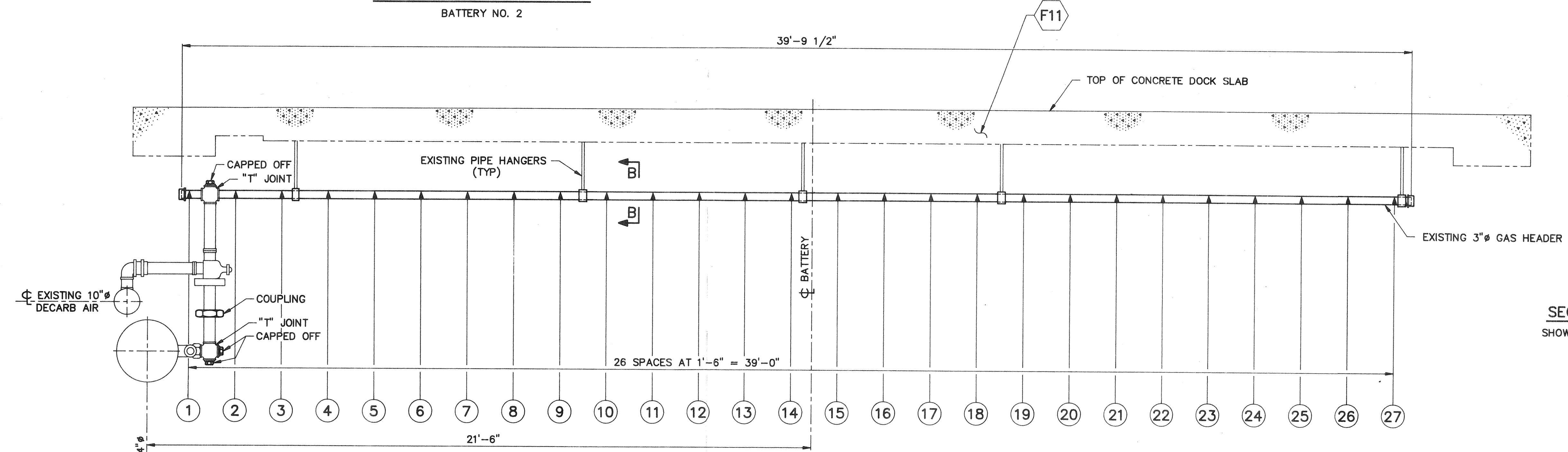
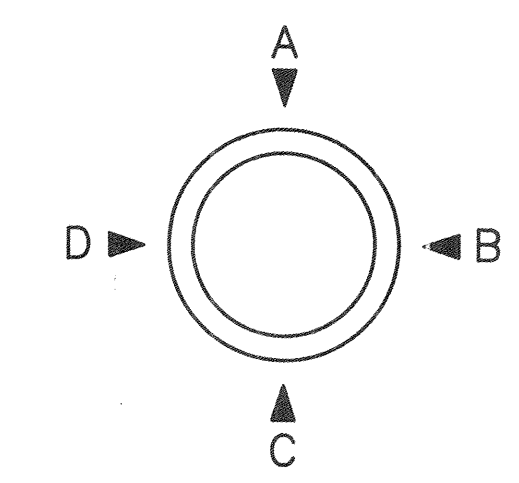


KEY PLAN OF GAS HEADERS
BATTERY NO. 2



SECTION "A-A" (LOOKING SOUTH)
TYPICAL SECTION OF 3" DIA. LONG 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											
STATION	U.T. LOCATION							STATION	U.T. LOCATION							STATION	U.T. LOCATION							STATION	U.T. LOCATION							STATION	U.T. LOCATION										
	A	B	C	D	E	F	G		A	B	C	D	E	F	G		A	B	C	D	E	F	G		A	B	C	D	E	F	G		A	B	C	D	E	F	G				
1	18	18	17	17	17	17	17	1	18	18	17	17	17	17	18	18	1	18	18	17	17	16	16	17	17	1	17	17	16	16	17	17	16	15	1	17	17	16	16	16	16	15	15
2	18	17	18	17	18	18	18	2	19	18	17	17	16	16	18	18	2	19	19	17	17	16	16	17	17	2	15	15	17	17	16	16	14	14	2	16	16	15	15	17	16	15	13
3	17	17	18	17	18	18	17	3	18	18	19	17	17	16	16	3	17	17	15	15	12	12	14	14	3	14	14	14	14	11	10	13	13	3	17	17	17	17	11	11	15	15	
4	17	17	17	17	17	17	18	4	19	18	19	17	17	16	16	4	17	16	17	17	12	12	13	13	4	14	14	14	14	14	14	13	13	4	14	14	14	14	14	14	12	12	
5	18	18	18	17	18	17	16	5	18	17	18	18	17	17	17	5	17	17	16	16	13	13	15	15	5	14	14	13	13	13	13	14	14	5	12	12	14	14	14	14	15	15	
6	18	16	17	16	14	13	17	6	16	15	17	16	19	17	17	6	16	16	16	15	13	13	16	16	6	14	14	13	13	13	14	13	6	15	15	15	15	15	15	14	11		
7	15	14	16	16	15	15	14	7	14	14	14	14	16	16	17	7	17	17	16	15	15	15	14	7	14	14	13	13	12	15	15	7	14	14	12	12	15	15	13	11			
8	15	15	16	16	14	14	14	8	18	17	18	16	17	17	15	8	16	16	15	15	13	13	14	8	15	14	14	14	14	13	14	14	8	12	12	12	12	13	13	12	12		
9	15	15	17	17	14	14	16	9	18	17	18	18	17	16	15	9	17	15	17	17	16	16	15	9	15	14	13	13	12	12	14	14	9	13	13	15	15	13	13	13			
10	16	16	17	17	15	15	15	10	15	15	14	13	17	14	14	10	17	16	18	18	15	15	16	14	10	16	16	13	13	12	12	15	15	10	12	12	14	14	13	12	12		
11	16	16	15	15	16	15	17	11	15	15	16	15	11	11	13	11	18	17	17	17	15	15	18	17	11	16	15	14	14	14	13	15	15	11	15	15	15	15	13	13	13		
12	17	16	18	17	15	15	15	12	17	17	15	15	15	14	14	12	18	17	18	18	17	17	18	17	12	18	17	14	14	14	17	15	12	15	15	16	16	16	16	16			
13	16	15	16	16	15	15	15	13	16	16	15	15	15	15	15	13	17	16	17	17	16	16	17	17	13	15	15	14	14	13	16	15	13	16	16	16	16	16	16	16	14		
14	18	18	16	16	15	14	16	14	15	14	15	14	14	13	13	14	18	17	18	18	18	17	17	14	14	15	15	17	17	15	14	16	15	14	17	15	13	13	14	15	15		
15	18	18	17	17	18	17	16	15	17	17	16	16	13	13	15	15	15	19	19	17	17	17	17	17	15	16	16	16	16	16	16	16	16	16	16	16	16	16	16	16	16		
16	18	18	17	17	17	17	16	16	18	18	16	16	15	14	17	17	16	19	19	17	17	17	18	17	16	16	16	16	16	16	16	16	16	16	16	16	16	16	16	16	16	16	
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18	17	17	15	15	16	16	15	15	18	18	18	16	13	13	17	17	18	18	18	18	18	17	18	17	18	16	16	16	16	16	16	16	16	16	16	16	16	16	16	16	16	16	
19	17	17	17	16	16	16	17	15	19	18	18	17	15	14	14	18	18	18	17	17	17	17	16	19	15	15	16	16	16	16	16	16	16	16	16	16	16	16	16	16	16	16	
20	17	17	14	14	14	14	16	16	20	17	17	16	16	14	14	13	13	20	18	18	17	17	16	17	20	16	16	16	16	17	17	16	16	20	14	14	14	14	15	13	15	14	
21	16	16	17	16	14	14	14	14	21	16	16	15	15	14	14	14	21	17	16	17	17	16	16	17	21	17	16	17	16	17	17	16	16	21	16	15	14	14	17	17	17		
22	16	16	14	14	17	16	15	15	22	17	17	15	15	15	15	15	22	18	15	18	18	15	15	17	22	17	16	17	16	16	16	16	22	14	14	14	14	17	17	16	16		
23	17	17	16	16	15	15	17	16	23	18	17	16	16	14	14	15	15	23	18	17	17	15	15	17	23	18	17	18	17	17	16	16	23	17	17	15	14	16	15	16	16		
24	17	17	16	16	14	14	16	16	24	16	15	17	17	17	14	14	24	18	18	17	17	16	16	16	24	18	17	18	18	17	17	17	24	15	15	16	16	14	12	14	14		
25	17	17	14	14	16	15	14	14	25	19	18	18	16	15	15	17	17	25	17	17	17	14	14	17	25	18	18	18	18	17	17	17	25	13	13	13	13	11	11	12	12		
26	17	17	16	16	14	14	13	13	26	16	16	15	15	13	13	15	15	26	17	17	17	14	14	16	26	18	17	18	18	18	18	17	26	14	13	13	13	14	14	14	13		
27	17	17	14	14	17	16	15	14	27	18	18	17	17	15	13	17	17	27	16	15	15	15	16	16	17	27	18	18	18	18	18	18	17	27	14	13	16	16	15	15	15		

- GENERAL NOTES
- ALL 3" GAS HEADERS ARE SCHEDULE 40 PIPE (ORIGINAL WALL THICKNESS = 0.216").
 - (*) DENOTES DENTED INWARDS BY 3/16" ± IN A 3" AREA.
 - (•) DENOTES PIPE IS BULGED OUTWARDS BY 3/16" (-) IN AN 8" AREA AT 180° OF SURFACE (4NO).

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

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

REFERENCE DRAWINGS LISTED ABOVE

ACME STEEL COMPANY

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

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

NOTE: This drawing (or print) is the property of the Acme Steel Company, U.S.A. and shall not be traced, or reproduced in any manner, nor used for any purpose whatsoever except by written permission of Acme Steel Company.

DO NOT SCALE WORK TO DIMENSIONS

DR. DRB
SCALE 1/2"=1'-0"
CH. APP.

W6711-2

2/25/93

REV.