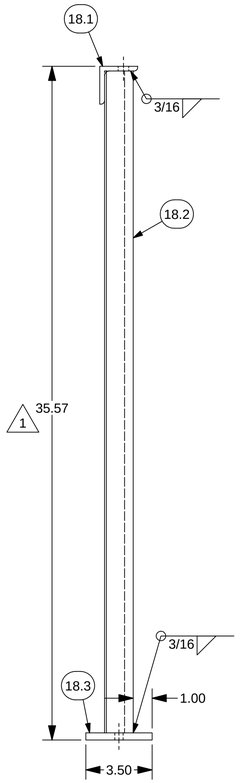
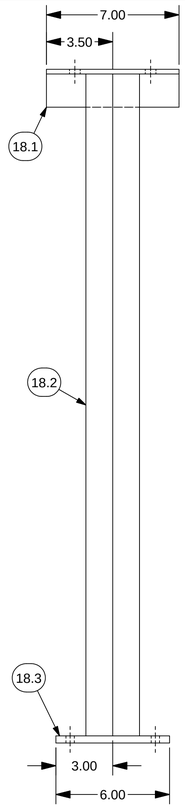
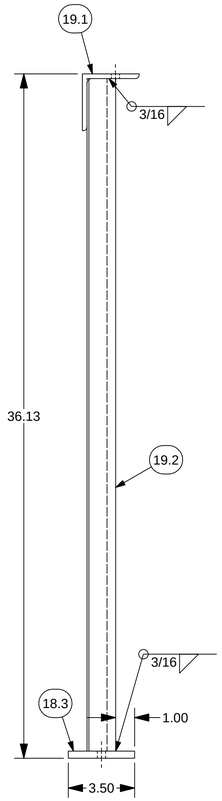
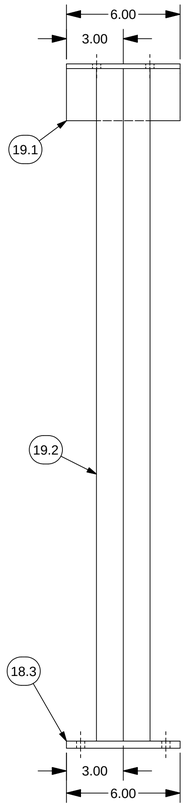


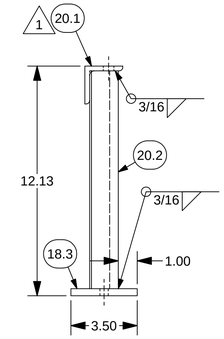


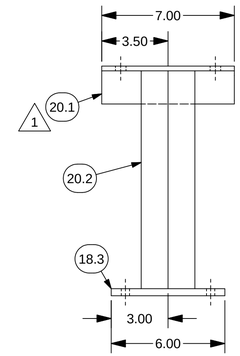
ITEM	QTY	PART NUMBER	MATERIAL
18	2	409-2956-LFF7EA-791	WELDMENT



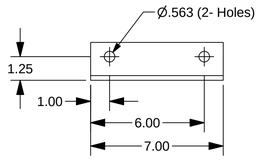


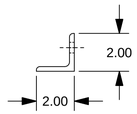
ITEM	QTY	PART NUMBER	MATERIAL
19	2	409-2956-LFF7EA-792	WELDMENT



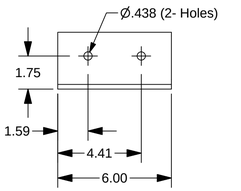


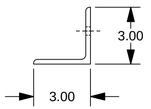
ITEM	QTY	PART NUMBER	MATERIAL
20	2	409-2956-LFF7EA-793	WELDMENT



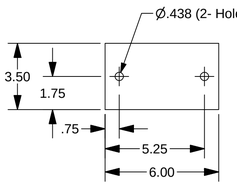


ITEM	QTY	PART NUMBER	MATERIAL
20.1	2	SLFFPD7EA-790-01	2 x 2 x 1/4 ANGLE - ASTM A36

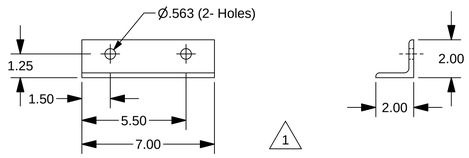




ITEM	QTY	PART NUMBER	MATERIAL
19.1	2	409-2956-LFF7EA-792-02	3 x 3 x 1/4 ANGLE - STAINLESS STEEL, 304



ITEM	QTY	PART NUMBER	MATERIAL
18.3	6	409-2956-LFF7EA-790-02	3/8"Thk - A36 STEEL PLATE



ITEM	QTY	PART NUMBER	MATERIAL
18.1	2	409-2956-LFF7EA-790-01	2 x 2 x 1/4 ANGLE - ASTM A36

1	20.2	2	409-2956-LFF7EA-793-01	INLET PIPE STAND ANGLE	2 x 2 x 1/4 ANGLE - ASTM A36	11.50 in	SAW
1	20.1	2	SLFFPD7EA-790-01	4" PIPE MOUNT ANGLE	2 x 2 x 1/4 ANGLE - ASTM A36	7.00 in	SAW/PUNCH
	20	2	409-2956-LFF7EA-793	INLET PIPE STAND	WELDMENT	12.13 in	WELD
	19.2	2	409-2956-LFF7EA-792-01	DISCHARGE PIPE STAND ANGLE	2 x 2 x 1/4 ANGLE - ASTM A36	35.50 in	SAW
	19.1	2	409-2956-LFF7EA-792-02	2" PIPE MOUNT ANGLE	3 x 3 x 1/4 ANGLE - STAINLESS STEEL, 304	6.00 in	SAW/PUNCH
	19	2	409-2956-LFF7EA-792	2" PIPE STAND	WELDMENT	36.13 in	WELD
	18.3	6	409-2956-LFF7EA-790-02	BASE PLATE	3/8"Thk - A36 STEEL PLATE	.375 in 6.00 in	3.50 in BURN
1	18.2	2	409-2956-LFF7EA-791-01	DISCHARGE PIPE STAND ANGLE	2 x 2 x 1/4 ANGLE - ASTM A36	34.94 in	SAW
1	18.1	2	409-2956-LFF7EA-790-01	3" PIPE MOUNT ANGLE	2 x 2 x 1/4 ANGLE - ASTM A36	7.00 in	SAW/PUNCH
	18	2	409-2956-LFF7EA-791	DISCHARGE PIPE STAND	WELDMENT	35.08 in	WELD
ITEM	QTY	PART NUMBER	DESCRIPTION	MATERIAL	THICKNESS	LENGTH	WIDTH Process

BILL OF MATERIAL

NOTES:
1. WELD CONNECTIONS: VISUALLY INSPECT ALL WELD CONNECTIONS.
2. WELDS ARE TO BE 1/16" LESS THAN THE MINIMUM THICKNESS OF MATERIAL WHERE NOT SPECIFICALLY CALLED OUT OR NOTED OTHERWISE. ALL WELDING SHALL CONFORM TO THE AMERICAN WELDING SOCIETY CODE D1.1. ALSO ASME/ANSI B16 STANDARDS FOR PIPES & FITTINGS AND FOLLOW THE PROPER WPS POSTED IN WORK AREA.
3. ALL MATERIAL SHALL BE ASTM A36, UNLESS OTHERWISE STATED.
4. DO NOT PAINT INTERNALLY OR EXTERNALLY THREADED PARTS OR PARTS WITH FINISHED SURFACES THAT HAVE BEEN MACHINED FOR TIGHT TOLERANCE FITUP.
5. PAINT FINISH:
   BLAST SSPC-SP10/NACE 2, 2 mil
   2-COATS PHENICON HS (LIGHT GRAY)
   PART-A (920A175)
   PART-B (700-C-685)

ProEnergy SERVICES
Document Control
Feb 15, 2011

REV	DESCRIPTION	AUTHOR	DATE	CHECKED B	QA/QC
1	CHG DISC PIPE 4" TO 3"	S. Boerckel	2/15/2011	T. KOONTZ	B. MADDUX
0	ISSUED FOR FABRICATION	S. Boerckel	1/27/2011	T. KOONTZ	B. MADDUX

REVISION HISTORY

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UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS
X.X ± 0.10
X.XX ± 0.06
X.XXX ± 0.03
HOLE DIA ± 0.03
ANGLES ± 0.50'
SURFACE ✓ HFS-SF
SQUARENESS ± 0.06
DO NOT SCALE DRAWING

DRAWN S. Boerckel 1/27/2011
CHECKED T. KOONTZ 2/3/2011
QA B. MADDUX 2/3/2011
REVIEWER
PROJECT NO 409-2956-1
CUSTOMER EDC - MARGARITA ISLAND
JOB NO

ProEnergy SERVICES
2201 ProEnergy Blvd
SEDALIA, MISSOURI 65301 USA
PHONE: 1-660-829-5100
FAX: 1-660-829-1160

TITLE
PIPE SUPPORTS
WELDMENTS
LIQUID FUEL FORWARDING SKID - 7EA

SIZE D | ML: | DWG NO 409-2956-LFF7EA-0791-1 | REV 1
SCALE: 1/4"=1" | WEIGHT: 69 LBS TOTAL | SHEET 1