

REPORT ON WATER TUBE BOILERS.

No. 121

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No. in Survey held at Wolverhampton. Date, First Survey 23rd August 1949 Last Survey 26th May 1950.
Reg. Bk. on the two La Mont forced circulation boilers W. T. Turner & Sons Ltd. No. 11812 Gross 10802
Haveron Hill-on-Tees. 2632/3 By whom built When built 1950.
Engines made at By whom made John Thompson Water Tube Boilers Ltd. When made 1950.
Boilers made at Wolverhampton By whom made Eagle Oil Shipping Co. Ltd. Port belonging to
Nominal Horse Power Owners

WATER TUBE BOILERS—MAIN, AUXILIARY, OR DONKEY—Manufacturers of Steel for Steam Drums: Colvilles Ltd.
Date of Approval of plans 1-2-50 and various dates. Number and Description or Type
of Boilers Two La Mont Marine Type. Design Working Pressure 560 lb/sq. in. Tested by Hydraulic Pressure to 890 lb/sq. in. Date of Test 19.10.50
No. of Certificate 7323/4 Can each boiler be worked separately Yes Total Heating Surface of Boilers 11812 sq. ft. (see Confirmation sheet)
Is forced draught fitted Yes Area of fire grate (coal) in each boiler 5-Hallend-Hooden. No. and description of safety valves on
No. and type of burners (oil) in each boiler One - 2 1/2" Double High Lift Area of each set of valve 7.95 sq. in. Pressure to which they are adjusted No.
Are they fitted with easing gear Yes. In case of donkey boilers state whether steam from main boilers can enter the donkey boiler No.
Smallest distance between boilers or uptakes and bunkers or woodwork Height of boiler 20 ft. Width and Length 13'0" x 15'0".
Steam Drums:—Number in each boiler One Inside diameter 3'6" Thickness of plates 1 1/4" Description of riveting:—
Range of Tensile Strength 28/32 Tons/sq. in. Are drum shell plates welded or flanged Yes (see Confirmation sheet) Pitch of rivets
Cir. seams long. seams Diameter of rivet holes in long. seams Pitch of rivets
Lap of plate or width of butt straps Thickness of straps Percentage strength of long. joint:—Plate Rivet
Diameter of tube holes in drum Pitch of tube holes 4 1/2" x 2 1/2" Circular Percentage strength of shell in way of tubes Diagonal 74.5%
Working pressure by rules appd. 560 lb/sq. in. Steam Drum Heads or Ends:—Range of tensile strength 28/32 Tons/sq. in. Thickness of plates 1 1/4" Water Drums: Number
Radius or how stayed 3'0" (inside) Size of manhole or handhole 16" x 12" Working pressure by rules appd. Water Drums: Number
in each boiler Inside Diameter Thickness of plates Range of tensile strength Are drum shell plates
welded or flanged Description of riveting:—Cir. seams long. seams Diameter of rivet holes in
long. seams Pitch of rivets Lap of plates or width of butt straps Thickness of straps
Percentage strength of long. joint:—Plate Rivet Diameter of tube holes in drum Pitch of tube holes
Percentage strength of drum shell in way of tubes Working pressure by rules Water Drum Heads or Ends:—Range of
Tensile strength Thickness of plates Radius or how stayed
Size of manhole or handhole Working pressure by rules Headers or Sections:—Number
Material Thickness Tested by Hydraulic Pressure to Tubes:—Diameter
Thickness Number Steam Dome or Collector:—Description of Joint to Shell
Inside diameter Thickness of shell plates Range of tensile strength
Description of longitudinal joint Diameter of rivet holes Pitch of rivets Lap of plate or width of
butt straps Thickness of straps Percentage strength of long. joint Plate Rivet
Working Pressure of shell by rules Crown or End Plates:—Range of tensile strength
Thickness Radius or how stayed Working pressure by rules
SUPERHEATER:—Number in each boiler Two Inside Diameter 5 1/8"
Thickness 3/4" Material Mild Steel (S.D.) Range of tensile strength 28/32 Tons/sq. in. Are drum shell plates welded
or flanged Description of riveting:—Cir. seams long. seams Diameter of rivet holes in
long. seams Pitch of rivets Lap of plates or width of butt straps Thickness of straps Long 2 1/4"
Percentage strength of long. joint:—Plate Rivet Diameter of tube holes in drum 1.135" Pitch of tube holes Circ. 2.6"
Percentage strength of Headers in way of tubes Diagonal 63% Working pressure by rules appd. Headers or Ends:—Flat Mild Steel
Thickness 1" Range of tensile strength 28/32 Tons/sq. in. Radius or how stayed Fusion Welded Size of manhole or handhole 4 1/2" x 3 3/8"
Working pressure by rules appd. Number, diameter, and thickness of tubes 94-18 9/16" x 8g. Tested by Hydraulic Pressure to 890 lb/sq. in.
Date of Test 14.10.50 A safety valve fitted to each section of the superheater which can be shut off from the boiler steam drum.
No. and description of Safety Valves One - 2 1/2" double High Lift. Area of each set of valves 7.95 sq. in.
Pressure to which they are adjusted Is easing gear fitted Yes.
Spare Gear. Has the spare gear required by the rules been supplied Yes.

The foregoing is a correct description,
JOHN THOMPSON WATER TUBE BOILERS LTD. Manufacturer.
J. M. Wright

Dates of Survey During progress of work in shops - - 1949, Aug. 23, Sept. 8, 28, 29, Oct. 4, 21, 22, 23, 24, 25, 26, 27, 28, 29, 30, Nov. 9, 10, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, 30, Dec. 2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, 30, Jan. 2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, 30, Feb. 1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, 30, Mar. 1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, 30, Apr. 2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, 30, May 1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, 30, Jun. 1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 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4, 5, 6, 7, 8, 9,

two La Mont forced circulation Boilers W.T. for Furness P.B. Co. Yard No. 445.

Boiler Headers. Each boiler is fitted with the following headers:-

One main distributor header, $9\frac{1}{4}" \times 5\frac{3}{4}"$ inside $\times 1"$ thick.

Two rear wall headers (inlet and outlet), $4"$ square inside $\times \frac{3}{4}"$ thick.

One economiser header, $3\frac{7}{8}"$ inside diameter $\times \frac{3}{4}"$ thick.

All the above headers are of solid drawn mild steel having a range of tensile strength of 28/32 Tons/sq. in.

On completion of welding and after stress relieving each header was subjected to a satisfactory hydraulic test at the pressure specified on the approved drawings.

Tube Elements. All the tube elements in each boiler have been constructed of cold drawn seamless steel tubes, 1" o.d. $\times 12$ g. thick, and in accordance with the La Mont Boiler Specification, L.M.20. Each element has been tested separately by hydraulic pressure as specified on the approved drawings.

Heating Surface. The heating surface of each boiler is made up as follows:-

(1) Combustion Chamber 341 square feet.	341
(2) 1 st Evaporator Tube Elements 940 " "	940
(3) 2 nd " " " 1335 " "	1550
(4) Superheater " " 1550 " "	1335
(5) Economiser " " 1740 " "	870
Total heating surface per boiler, .. 5906 square feet.		5036

Erection of Boilers. The 1st and 2nd stage evaporator tube elements have been assembled, fitted and expanded in the main distributor headers, the other ends of the elements being retained in a dummy tube plate which will be removed when the steam drums are fitted. The rear wall tube elements have been assembled, fitted and expanded in the inlet and outlet headers and these units were subjected to satisfactory hydraulic tests at a pressure of 890 lbs/sq. in. The completed superheater units have been fitted to both boilers. The economiser tube elements have been assembled and welded to the header stub tubes and the other ends of these elements will be fitted and expanded in the steam drums when erection of the boilers is completed.

The steam drums, which are constructed in accordance with the Society's Rules for Class 1 Welded Pressure Vessels as reported by Birmingham Reports 10, Nos. C.9096 and C.9097, have been despatched separately to Messrs. Furness Shipbuilding & Eng. Co. Ltd, Haverton Hill, where the erection of the boilers is to be completed.

The contaminated Steam Generator and the Flash Chamber which will be operated in conjunction with the La Mont Main Boilers have been constructed in accordance with the Society's Rules for Class 1 Welded Pressure Vessels as reported by Birmingham Reports 10, Nos. C.9437 and C.9792, respectively.

These boilers have been erected at the shipyard & hydraulically tested

to 890 lbs/sq. in. after which they were securely fitted aboard & re-tested

together with all attached pipes. On completion the SV's were adjusted as per report & the boilers

tried out under working conditions & found to be satisfactory.

L. Norman Stuart for self & J.C. Smith.

A. Pemberton. Chairman.

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