

C.W. *[Signature]*
EXONE *[Signature]*

NOV 24

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G11-3/6

INSTRUCTIONS FOR THE USER

Annealing data for Iron and Steel NO. 10

This package contains everything needed for the annealing of iron and steel. These are: (1) The EXO-ANNEAL, which is a heavy, dark colored material; (2) The THERMO-GARD, which is a light, soft material; (3) The SUPEREX, which is the best of the three materials; (4) The SUPEREX CEMENT; and (5) Wire which is used to bind the EXO-ANNEAL to the pipe. However, if a binding machine is available, a more secure fit will be obtained if the SUPEREX is used.

1. EXO-ANNEAL sections are wired around the pipe as shown in the attached sketch. Note groove in EXO-ANNEAL that fits over weld bead.
2. The pipe at each end of the EXO-ANNEAL is covered with THERMO-GARD (or, in some cases, with asbestos blanket), as shown in the sketch.
3. The EXO-ANNEAL is covered with 1900° SUPEREX, as shown in the sketch, so that it extends over the edges of the EXO-ANNEAL about 2 inches at each end. For pipe sizes up to 14 inches, 4 light-up holes, approximately 2 inches wide, are cut in the SUPEREX so that each end of the EXO-ANNEAL can be ignited at two locations, 180° apart. For pipe sizes 16 to 20 inches, 8 light-up holes are required, and for pipe sizes above 20 inches, 12 light-up holes are needed. For complex assemblies, points of ignition are indicated on drawing.
4. In cases of nozzle wells or large vessels or large boilers, the customer must cover the EXO-ANNEAL with insulation. In such case, the EXO-ANNEAL is ignited at 2-foot intervals at the outer edges of the insulation.
5. The cracks in the EXO-ANNEAL and the SUPEREX are filled with SUPEREX CEMENT. The cement is mixed with sufficient

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water to give it moldability. When possible, open pipe ends should be covered to prevent air currents through the pipe.

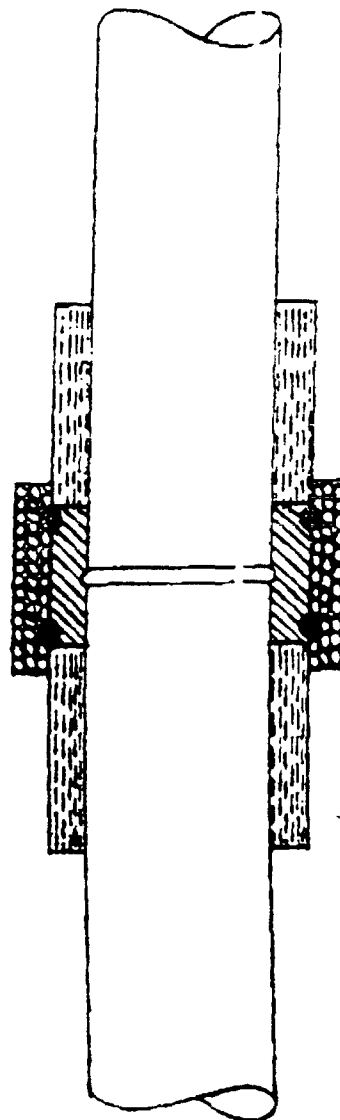
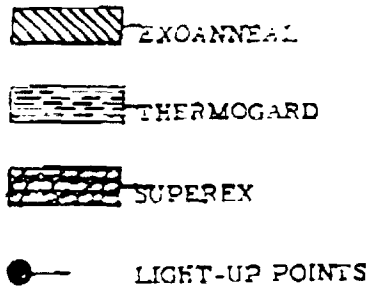
6. The EXO-ANNEAL is ignited through the light-up holes using a cutting, welding, or similar torch that will develop temperatures in excess of 2000°. When igniting the EXO-ANNEAL with a cutting or welding torch, the oxygen trigger should not be used, since this procedure would fuse the EXO-ANNEAL without igniting it.
7. The plugs removed from the light-up holes are replaced and the cracks filled with SUPEREX CEMENT. The EXO-ANNEAL will complete its burning in from 5 to 10 minutes during which time flame and smoke will emanate from the assembly.
8. The heating and slow cooling of the weld then proceed without further attention. The weld should be allowed to cool to 500° F., after which the EXO-ANNEAL and the insulating material can be removed from the pipe. Approximately 3 hours should be allowed for this purpose.

NOTE: In some cases, particularly in small or thin-walled pipe, the EXO-ANNEAL may be lined with asbestos felt or paper. This should not be removed.

*Patent applied for.

12/7/61

1-001132



EXOMET, INCORPORATED
EXOANNEAL Assembly for Pipe-to-Pipe Weld

L 001121

Dwg. No. P-3

(8 0 0010 03)

L 001193

P.O. BOX 149
LUFKIN, TEXAS 75901
713-234-6811



PURCHASE ORDER NO. 2 00801

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11-14-79

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Installation of Pump #1449-stock from blow tank to B.S. washers

TERMS	FOB	VIA	FREIGHT
Net 30	S/P	Motor Freight	Collect

ITEM	DESCRIPTION	QUANTITY	UNIT PRICE	TOTAL PRICE
A	CONFIRMING 8" DeZurik knife gate valve, series L size 8", figure #824 (304 S.S.), end style: Wafer face-to-face, BFE impreg- nated asbestos packing (will accept Fabrivaive #37R) DeZurik #0800, Fig. 024, A, S. Note: Packing to be shipped loose. Confirming order Jody Gray to Don LeGrand, 11-6-79.	1	408.00	408.00

11/20/79 11-109
2-021
2-00801
Pump #1449/0-5
025/0-5

Pump #1449/025 LOC Room

ORDER NO.	DATE	QUANTITY	UNIT PRICE	TOTAL PRICE	CARRIER	DATE
1	Central 11/26/79	CALL ON	11/27/79			

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