

BETHLEHEM STEEL COMPANY

SHIPBUILDING DIVISION

BALTIMORE YARD

SALE ORDER

NO. 25-7128

SUPPLEMENT

NO.

SHEET NO. 40 OF

CUSTOMER'S NO(S).

DATE 6-7-63

S.S. "ESSO DALLAS" AND OWNERS

DATE
ENTEREDREF.
NO.

SOLD TO

[illegible]

BETHLEHEM STEEL COMPANY

SHIPBUILDING DIVISION

BALTIMORE

YARD

SALE ORDER

NO. 25-7128

SUPPLEMENT

NO.

SHEET NO. 41 OF

CUSTOMER'S NO(S).

DATE 6-11-63

S.S. "ESSO DALLAS" AND OWNERS

SOLD TO

DATE
ENTEREDREF.
NO.ITEM
NO.

A-Stein

B-Kroll

DESCRIPTION

OR - Ireland, Tyrrell, Keech

THE FOLLOWING ITEMS ARE HEREBY CANCELLED IN THEIR ENTIRETY:

- | | |
|----|----|
| 01 | 40 |
| 02 | 41 |
| 03 | 42 |
| 04 | 45 |
| 05 | 50 |
| 06 | 51 |
| 07 | 52 |
| 08 | 53 |
| 09 | 54 |
| 10 | 58 |
| 11 | 60 |
| 12 | 65 |
| 14 | 68 |
| 15 | 70 |
| 17 | 72 |
| 18 | 73 |
| 19 | 74 |
| 20 | 75 |
| 21 | 77 |
| 22 | 80 |
| 23 | 82 |
| 24 | 84 |
| 25 | 86 |
| 26 | 87 |
| 27 | 89 |
| 30 | 90 |
| 32 | 91 |
| 34 | 92 |
| 35 | 93 |
| 36 | 96 |
| 37 | 99 |
| 38 | |
| 39 | |
32. LINE SHAFT BEARINGS - A.B.S. SURVEY (303) 265
37. MEGGER TEST (303) 700
45. AUXILIARY CONDENSATE PUMP - WORTHINGTON, VERT. CENT. 3 UZS-1 (303) 830
46. STEERING GEAR PUMPS (303) WATERBURY SIZE 5, TYPE A 750
52. FUEL OIL SERVICE AND TRANSFER PUMP - WORTHINGTON HOR. DUPLEX 7 $\frac{1}{2}$ " x 3 $\frac{1}{2}$ " x 10" (303) 600
53. TWO (2) FUEL OIL SERVICE PUMPS - DeLAVAL VERT. SCREW (303) 395
55. ENGINE ROOM GENERAL SERVICE PUMP - WORTHINGTON VERT. DUPLEX 14 x 10 x 12 (303) 760
58. TWO (2) LUBRICATING OIL PUMPS - DeLAVAL VERT. SCREW (303) 460
101. AFTER DECK SANDBLASTING AND COATING (CORROSION PROJECT) 11377
151. 200 KW AUXILIARY GENERATOR (303) 55
- - - - -
44. PARTIAL CANCELLATION - MAIN CONDENSATE PUMPS - P/S - TWO (2) WORTHINGTON, TYPE 3 UZS-1 VOLUTE PUMP (303)

Title of this item is corrected to read as follows:

PORT MAIN CONDENSATE PUMP

Portion of this item dealing with Starboard Condensate Pump is hereby cancelled.

50. PARTIAL CANCELLATION - FIRE AND BUTTERWORTH PUMP AND TURBINE - WORTHINGTON - TYPE 3-UB-1 VOLUTE P. (303) WHITON 85 HP TURBINE - A.B.S. SURVEY

Portion of this item dealing with opening up of fire and Butterworth pump is hereby cancelled.

☐ Beth. Matr.☐ Cust. Matr.☐ B/M Req'd

Order written by

57. CORRECTION - BILGE AND BALLAST PUMP - FORWARD PUMPROOM - SIZE 14 x 14 x 12 (303)

Title of this item is corrected to read as follows:

FUEL AND BALLAST PUMP FORWARD PUMPROOM152. CORRECTION - DRAIN LINES (503)

Use 1½" ex. hvy. galv. pipe in place of 2".

1960 148. SUPPLEMENT - INSURANCE CLAIM (TIME AND PLACE UNKNOWN) STARBOARD SIDE SHELL PLATES AND INTERNALS

Clean #2 port and stbd. deep tanks and forward pumproom bilges for hot work.

1980 146. SUPPLEMENT - INSURANCE CLAIM 214 - HEAVY WEATHER NOVEMBER 27, 1962

(c) Clean starboard bunker tank for hot work.

140. SUPPLEMENT - RUDDER (103)

550 a. Vee out and weld six (6) 6" and one (1) 18" fractures, vee out and pad weld approx. 18" fracture bottom edge of rudder plating forward end. Test and prove tight.

b. Thoroughly clean pitted area top of rudder near palm forward end port side and fill with Devcon steel putty.

130 11. SUPPLEMENT - BOILER VALVES (313)

Overhaul same as item 11, two (2) 1½" steam stop valves for 1K sootblowers.

275 155. DRAIN TRAPS EXTERNAL DESUPERHEATER (303)

Disconnect and remove to shop, two (2) 1" drain traps from external desuperheater, open up, renew all worn and defective parts, reassemble, test and prove in good working order. Reinstall, renew gaskets, bolts and nuts, prove tight. Replace insulation as original.

270 15. SUPPLEMENT - MACHINERY SPACE PIPE (303)

a. Renew one (1) section drain pipe size 3½" dia. approx. 12' long, bent, flanged, with one (1) 2" dia. x 1' flanged outlet, located under purifier

650 156. COASTWISE FREEBOARD MARKINGS (ABS)

Check vessels coastwise freeboard markings; if found incorrect, remove old markings and install corrected coastwise freeboard markings. To be verified by a Surveyor of ABS as per attached papers.

157. BOILER TEST (303)

/200 Apply hydrostatic pressure to two (2) main boilers (Babcock & Wilcox) steam lines in accordance with USCG requirements. Blanks to be installed at turbines. Water in boilers to be heated to approx. 80 deg. F. prior to test. Refractory to be removed and replaced as required for examination.

After test has been satisfactorily completed, boilers are to be emptied, blanks removed, disturbed flanges rejointed and nuts hardened up after steam is on line. All disturbed insulation to be replaced as original.

BETHLEHEM STEEL COMPANY

SHIPBUILDING DIVISION

BALTIMORE

YARD

SALE ORDER

NO. 25-7128

SUPPLEMENT

NO.

SHEET NO. 44 OF

CUSTOMER'S NO(S).

DATE 6-12-63

S.S. "ESSO DALLAS" AND OWNERS

SOLD TO

DATE
ENTEREDREF.
NO.[illegible]

BETHLEHEM STEEL COMPANY

SHIPBUILDING DIVISION

BALTIMORE YARD

SALE ORDER

NO. 25-7128

SUPPLEMENT

NO.

SHEET NO. 45 OF

CUSTOMER'S NO(S).

DATE 6-12-63

SOLD TO

S.S. "ESSO DALLAS" AND OWNERS

DATE
ENTEREDREF.
NO.

DIST.—YARD

ITEM
NO.

A-Stein B-Kroll

DESCRIPTION O.R. - Ireland, Tyrrell, Keech

108A.

1070

SUPPLEMENT - SEA VALVES AND STRAINERS (103)

Chip and clean pitted areas of low injection sea valve and fill areas with Red Hand Diamond Cement.

Chip and clean pitted areas of high injection sea valve and fill areas with Red Hand Diamond Cement.

Renew 10" dia. x approx. 9" long flanged nipple sea chests for General Service Pump aft engine room starboard side, use extra heavy steel pipe. Coat inside of flanged nipple with two coats of Apexior. With require removing and replacing 10" sea valve.

Chip and clean pitted areas in valve body of sea valve to aux. circulator sea chest. Fill areas with diamond Red Hand Cement.

Renew valve guide of 1½" boiler blow sea valve.

Weld 3/8" x 9" long groove in starboard sea chest spool piece in aft pump room.

Furnish and install one (1) 4" dia. 150 lb. flanged, steel, gate valve overboard from electric bilge pump.

DIST.—OTHER

O. Spec. Cont.

☐ Beth. Matr.☐ Cust. Matr.☐ B/M Req'd

Order written by

BETHLEHEM STEEL COMPANY

SHIPBUILDING DIVISION

BALTIMORE

YARD

SALE ORDER

NO. 25-7128

SUPPLEMENT

NO.

SHEET NO. 46 OF

CUSTOMER'S NO(S).

DATE 6-12-63

S.S. "ESSO DALLAS" AND OWNERS

SOLD TO

DATE
ENTEREDREF.
NO.ITEM
NO.

A-Stein

B-Kroll

DESCRIPTION

OR - Ireland, Tyrrell, Keech

DIST.—YARD

June 8, 11, 12, 1963

Gross Tons - 17,578
 Official No. - 259,248

158.

SURVEY OF DAMAGE ALLEGED TO HAVE BEEN SUSTAINED IN CONSEQUENCE OF
 COLLISION BETWEEN THE S.S. "ESSO DALLAS" AND THE M.V. "OTCO BAYWAY"
 WHILE ON VOYAGE FROM NEW HAVEN, CONNECTICUT TO NEWARK, NEW JERSEY
 ON JANUARY 19, 1963, AT APPROXIMATELY 2320 HOURS.

Those Attending:

Mr. J.B. Ireland Jr.
 Mr. J.R. Thompson
 Mr. V.K. Spjut

Rep. Humble Oil & Refining Co.
 Rep. Seaboard Shipping Corp.
 Rep. U.S. Salvage behalf Underwriters
 for Seaboard Shipping Corp.
 Rep. Amn. Bureau of Shipping
 Rep. U.S. Coast Guard

FOUNDRECOMMENDEDStarboard Side

The after 3' of K-3 and
 the forward 17' of K-4
 creased at bottom riveted
 seam to a depth of 4".

The after 4' of K-3 to be cropped
 and K-4 to be removed and renewed
 as one plate.
 (33'-6" x 7'-6" x 40.8#)

Plate K-4 bodily set in
 approximately 12' forward
 of after butt and just
 forward of after butt to
 a depth of approximately
 2".

The after 9' of the J-3
 and the forward 9' of
 J-4 creased at top riveted
 seam to a depth of approx-
 imately 4".

The after 10' of J-3 and the for-
 ward 8' of J-4 to be cropped and
 renewed as one plate.
 (18'-0" x 8'-0" x 33.15#)

DIST.—OTHER

H.O. Spec. Cont.

☐ Beth. Matr.☐ Cust. Matr.☐ B/M Req'd

Order written by

158. DAMAGE, COLLISION, JAN. 19, 1963, ETC. - (CONT'd)FOUND

Side longitudinal shell frames #2 & #3 from deck buckled from forward bulkhead extending aft for approximately 24'.

Three (3) brackets in way of above longitudinal buckled.

Web frame #99 buckled in way of #2 & #3 side longitudinals.

Web frame #98 distorted in way of #2 & #3 side longitudinals.

RECOMMENDED

To be cropped and part renewed.
4" x 8" angles - 24" each. 17.2#

To be removed and renewed.
(39" x 22" x 1/2" each)

To be cropped and part renewed.
103" x 52" x 1/2" fitted with 6" x 1/2" face bar and four (4) stiffeners
4" x 20" x 1/2".

To be heated and faired in place.

Notes

Necessary fairing of top seam of plate K-4 in way of two (2) set in areas.

Necessary removal and replacement of closed chock.

Necessary burning loose and rewelding of fashion plate for removal and renewal of plate K-4.

Necessary staging to be erected and afterwards removed.

All new and disturbed work to be sand blasted and coated with Humble Rust Ban 191, as original inside of tanks and coating as original on exterior side.

Necessary gas free certificate to be issued prior to commencement of repairs

Necessary testing of #1 and #2 starboard wing tanks.

Vessel to be cleaned and gas freed prior to commencement of repairs.
(Separate bill to be submitted by Owners).

All scrap and material removed in connection with the foregoing recommended repairs shall become the property of the contractor and credit for same is reflected in the above lump sum.

BETHLEHEM STEEL COMPANY

SHIPBUILDING DIVISION

BALTIMORE YARD

SALE ORDER

NO. 25-7128

SUPPLEMENT

NO.

SHEET-NO. 48 OF

CUSTOMER'S NO(S).

DATE 6-13-63

S.S. "ESSO DALLAS" AND OWNERS

SOLD TO

DATE
ENTEREDREF.
NO.ITEM
NO.

A-Stein

B-Kroll

DESCRIPTION OR - Ireland, Tyrrell, Keech

147.

CANCELLATION - INSURANCE CLAIM NO. 236

This item is hereby cancelled in its entirety.

All costs to be charged to Item No. 158.

DIST.—YARD

1		41
2		42
3		45
5		50
6		51
7		52
8		53
9		54
0		58
1		60
2		65
4		68
5		70
0		72
1		73
2		74
3		75
5		77
5		80
7		82
0		84
2		86
4		87
5		89
6		90
7		91
3		92
9		93
0		99

DIST.—OTHER

O. Spec. Cont.

☐ Beth. Matr.☐ Cust. Matr.☐ B/M Req'd

Order written by

BETHLEHEM STEEL COMPANY

SHIPBUILDING DIVISION

BALTIMORE

YARD

SALE ORDER

NO. 25-7128

SUPPLEMENT

NO.

SHEET NO. 49 OF

CUSTOMER'S NO(S).

DATE 6-14-63

S.S. "ESSO DALLAS" AND OWNERS

SOLD TO

DATE
ENTEREDREF.
NO.ITEM
NO.

A-Stein

B-Kroll

DESCRIPTION OR - Ireland, Tyrrell, Keech

159.

ENGINE ROOM SKYLIGHTS (303)

950

While engine room skylight is removed for lowering of new condenser water box head, remove skylight from vessel and sandblast to white metal, the inside of skylight and coat with Humble Rust Ban 191. Replace in good order, renewing gasket and defective bolts and nuts.

160.

STBD. CARGO TANK STRIPPER BELLMOUTHS (103)

380

Install liners between flanges of 6" stripper bellmouths in the following stbd. cargo tanks. Bellmouth flange bolts to be removed and with bellmouth legs resting on bottom of vessel with a 7/8" opening between bellmouths and shell, install liner of correct thickness between flanges including flange gasket each side of liner. Renew bolts and nuts (galvanized).

# 1	Stbd. Tank Opening From Bellmouth to Shell	- 1-1/16"
# 2	" " " " " " " "	- 1-3/4"
# 5	" " " " " " " "	- 1-1/8"
#10	" " " " " " " "	- 1-3/4"

161.

REPAIRS FOUND DURING BOILER EXAMINATION & HYDROSTATIC TEST (303)

1890

- a. Disconnect and remove to shop, one (1) 1" angle stop check valve, boiler compound feed to stbd. boiler, test, locate leak, open for examination. Repair as directed.
- b. Disconnect and remove to shop 2 1/2" stbd. boiler economizer relief valve. Open up, machine seat and disc, grind in, free up, thoroughly clean, close up, renew bonnet gasket, hydrostatic test to required pressure, prove tight. Reinstall, renew flange gasket, stud bolts and nuts.
- d. Renew instulation and refractory inner door back of stbd. boiler access to under economizer tubes.
- e. Install support for bottom row of superheater tubes stbd. and port boilers. Support to be made of stainless steel flat bar and bolts.
- f. Vee out and weld fractures in boiler casing in way of access opening to superheater doors.
A total of four (4) fractures, each 3" long.

DIST.—YARD

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DIST.—OTHER

O. Spec. Cont.

☐ Beth. Matr.☐ Cust. Matr.☐ B/M Req'd

Order written by

161. REPAIRS FOUND DURING BOILER EXAMINATION & HYDROSTATIC TEST (303) - (Cont'd)

- g. Furnish four (4) copies of audiogage thickness readings of main steam line in engine and boiler room as directed. A total of 12 readings.
- h. Disconnect and remove to shop, one (1) flanged globe valve drain of back rear water wall header port boiler. Open, machine seat and disc, grind in, repack valve stem, test to approve pressure, test and prove tight, reinstall, renew gaskets, defective bolt studs and nuts.
- i. Renew stbd. boiler bulkhead steam stop valve outlet flange gasket. Renew flange blankets and valve insulation - size 6". Remove old and repack valve stem.
- j. Renew inlet flange gasket master valve to 200 KW turbine. Check above flange faces for steam cuts of the two above valves. Replace flange blanket insulation - size $1\frac{1}{2}$ ".
- k. Reweld two (2) plugs (outboard) bottom row port boiler superheater.

162. EMERGENCY DIESEL GENERATOR SWITCHBOARD (303)

74 Check and repair as found necessary, feed back breaker from emergency switchboard to main switchboard.

163. 200 KW GENERATOR

200 Check out 200 KW generator and exciter.
Determine reason why generator will not build up voltage.
Repair as directed.

BETHLEHEM STEEL COMPANY

SHIPBUILDING DIVISION

BALTIMORE YARD

SALE ORDER

NO. 25-7128

SUPPLEMENT

NO.

SHEET-NO. 51 OF

CUSTOMER'S NO(S).

DATE 6-17-63

S.S. "ESSO DALLAS" AND OWNERS

SOLD TO

DATE
ENTEREDREF.
NO.

ITEM NO.	A-Stein	B-Kroll	DESCRIPTION	OR - Ireland, Tyrrell, Keech
30A			<u>SUPPLEMENT - H.P. AND L.P. MAIN TURBINE - ABS SURVEY (303)</u>	
730			Open up three (3) hand control nozzles for H.P. turbine for examination. Grind in, machine discs as found necessary. Free up, repack valve stems with approved packing. Renew bonnet gaskets, defective studs and nuts. Replace insulating blankets as original.	
164.			<u>STEAM FUEL SERVICE AND TRANSFER PUMP (303)</u>	
165			Heat steel exhaust line of steam fuel service pump as original as designated so that flanges will line up. Renew flange gasket, bolts and nuts. Replace disturbed insulation. Prove flanges in alignment. Size of pipe, 2½" dia. x approx. 11' long.	
165.			<u>STRAINER BOX FOR ELECTRIC BILGE PUMP (303)</u>	
75			Renew hinge lugs and pin; also, lugs and screw clamp for cover of electric bilge pump strainer cover. Approx. size of strainer, 6" dia	
166.			<u>LEAK OFF FROM MAIN THROTTLE VALVE STEMS (303)</u>	
335			Renew leak off line from main throttle valve stems to 30# exhaust line. Use ex. hvy. steel pipe and fittings. Prove line tight. Renew insulation. Size of pipe, 1½" dia. x approx. 21' long, bent and necessary fittings.	
167.			<u>TRAPS FROM 3RD STAGE FEED WATER HEATER (303)</u>	
390			Disconnect and remove to shop, two (2) 1" and one (1) 2" traps from 3rd stage feed water heater. Open up, machine seats and discs, grind in, renew defective parts. Close up, test and prove in good working order. Reinstall, renew gaskets, bolts and nuts.	
40A			<u>SUPPLEMENT - MAIN-CIRCULATOR PUMP, WORTHINGTON VERT. CENT. 20LCV 16</u>	
450			<u>CORROSION CONTROL MRP 320011</u>	
			Remove impeller assembly to shop, check shaft and coupling for truth. Prepare shaft in way of bearings and metal spray, machine to original size and fit new bearings furnished by vessel. Install impeller and motor in true alignment.	

DIST.—YARD

DIST.—OTHER

O. Spec. Cont.

☐ Beth. Matr.☐ Cust. Matr.☐ B/M Req'd

Order written by

110R. SUPPLEMENT - LIFEBOATS (103)

- 1605 a. Remove to shop aft port lifeboat. Renew #A1 port and stbd. bottom plates. Renew two (2) metal floors. Renew two (2) chock doublers. Renew one (1) scupper. Test and prove tight. Apply one (1) coat of no-oxide to inside of boats new plating. Replace boat in good order.
- b. Remove from vessel fwd. port and stbd. boats, also aft stbd. lifeboat to dock. Take delivery of Owner furnished lifeboat and install in fwd. stbd. life boat chocks. Paint out all "Esso New York" markings and replace with "Esso Dallas". Load the fwd. port motor lifeboat and the aft stbd. life boat on the truck.
- c. Take delivery of the repaired lifeboats and install in correct positions. Load fwd. stbd. lifeboat on same truck (lifeboat previously removed from vessel).

168. LEADS FOR 400 KW SPEED CHANGERS (303)

- 73 Renew cable from junction box to speed changer motors for each 400 KW generator turbine. Size, 3-conductor #14 approx. 4' long each. Requires two.

169. DECK EXHAUST FITTING AFT MOORING WINCH (103)

- 265 a. Renew deck fitting for aft deck winch exhaust. Requires one. Size, 4" dia. ex. hvy. 90° elbow, flanged, welded to deck plates.
- b. Size of doubler on poop deck item 116 1/2" x 2'-6" x 4'-6". Install one (1) doubler on ventilator in way of doubler plate size 1/4" x 6" x 12".

\$ 37,345.00 Total
 21 175. Insurance
 \$ 16 170 Repairs

11 355
 .4815 cancellation

- 148 Supplement - Insurance Claim (Time and Place Unknown) Starboard Side Shell
 Clean #2 port and stbd deep tanks and forward pumproom bilges for Rob work \$ 1960.00
- 146 Insurance claim 214 Heavy Weather November 27, 1962
 Clean starboard Bunker tank for Rob work 1980.
- 158 Survey of Damage alleged to have been sustained in consequence of Collision
 Between the S.S. Esso Dallas and the M.V. "OTCO Bayway" while en voyage
 from New Haven, Connecticut to Newark, New Jersey, on January 19, 1963
 17235
 21175.

We look to both Vessel and Owners for Payment of this Bill.

(W/t-9)

Newport News, Virginia, July 1, 1963.

S.S. ESSO GETTYSBURG and Owners.
Humble Oil & Refining Co.
P.O. Box 1512
Houston, Texas

Bill No. 7022

Checked By.....

To Newport News Shipbuilding and Dry Dock Company Dr.

J. O. 717

Product. S

Making repairs and/or renewals to the S.S. Esso Gettysburg at this
plant as detailed in the attached customer's order No. 717-S dated
June 28, 1963.

For the sum of----- \$79,980.00

Net on Receipt of Invoice

Make Payment to
Newport News Shipbuilding & Dry Dock Company
Attention: Treasurer
Newport News, Virginia