



SECTION: 0000
TECHNICAL BULLETIN No. 151, Rev. 14
Feb 27, 2002

MANUFACTURING FACILITIES

**GENERAL OFFICES
2200 EAST SECOND STREET
ODESSA, TEXAS**

WORK PERFORMED:

The design and manufacturing of oil and gas process equipment.

PLANTS ESTABLISHED:

Sivalls, Inc., Odessa, Texas 1947
Sivalls, Inc., Pampa, Texas 1979
Sivalls, Inc., Brownwood, Texas 1982

COMPANY OFFICIALS:

| | | | |
|-----------------------------------|-------------------|----------------------------|--------------------|
| President | C. R. Sivalls | Plant Manager, Brownwood | Clayton Kuykendall |
| Executive Vice President | J. A. Zuerker | Manager, Coordinating | R. Fincher, Jr. |
| Vice President, Administration | Stephanie Latimer | Manager, Purchasing | T. Whitworth |
| Vice President, Finance | I. R. Nolen, Jr. | Manager, Distributor Sales | Floyd Rountree |
| Vice President, Marketing | R. E. Griffin | Manager, Domestic Sales | Danny Brister |
| Vice President, Engineering | W. J. Lewallen | Manager, Project Design | Mike Wright |
| Plant Manager, Odessa | E. K. Greenlee | Manager, Proposals | W. R. Temple |
| Plant Manager, Pampa | D. VanHouten | Manager, Engineering | Jim Bradley |
| | | Manager, Quality Control | Wayne Thorp |

SALES OFFICES, SERVICE OFFICES AND DISTRIBUTORS:

See Catalog Supplement CS-0001.

CODES AND SPECIFICATIONS USED FOR DESIGN AND FABRICATION:

| Code or Specification | Description | Odessa Plant | Pampa Plant | Brownwood Plant |
|-----------------------|------------------------|--------------|-------------|-----------------|
| API 12D | Large Welded Tanks | yes | na | na |
| API 12F | Small Welded Tanks | yes | yes | yes |
| API 12J | Oil and Gas Separators | yes | yes | yes |
| API 12K | Indirect Heaters | yes | na | yes |
| API 12L | Emulsion Treaters | yes | yes | yes |
| API 620 | Welded Steel Tanks | yes | na | na |
| API 650 | Welded Steel Tanks | yes | na | na |
| ASME SEC. 1 | Power Boilers | yes | yes | yes |
| ASME SEC. IV | Heating Boilers | yes | yes | yes |
| ASME SEC VIII | Pressure Vessels | yes | yes | yes |

Note: Work may be performed in accordance with ANSI or AWS specification upon request by customer.

AUTHORIZED INSPECTION AGENCY:

Hartford Steam Boiler Inspection and Insurance Company

CUSTOM EQUIPMENT FURNISHED BY SIVALLS, INC. INCLUDES:



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Gas Dehydration
Separators
Acid Gas Treating
Oil and Water Treaters
BTEX Removal

Gas Production Units
Water Treating
Offshore Production Facilities

Metering Equipment
Special Storage Tanks
Water Bath Heaters
Salt Bath Heaters



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MATERIAL QUALIFICATION:

Available per Customer's requirements and referenced Codes.

PLANT PROPERTIES:

| Item | units | Odessa Facility | Pampa Facility | Brownwood Facility |
|-----------------|---------|-----------------|----------------|--------------------|
| Total Property | acres | 92.38* | 36.82* | 17.49 |
| Office Space | sq. ft. | 27,727* | 3,750* | 5,142 |
| Shop Facilities | sq. ft. | 92,540 | 22,550* | 29,800 |
| Warehouse | sq. ft. | 12,725 | 2,000 | included |
| Open Yard Area | acres | 33.58* | 36.17* | 16.75 |
| Additional Yard | acres | 62.94* | - | - |

*Branch area is included.

PERSONNEL:

GENERAL

| Titles | Odessa Office | Odessa Plant | Pampa Plant | Brownwood Plant |
|----------------------|---------------|--------------|-------------|-----------------|
| Executives | 6 | - | - | - |
| Managers | 7 | 1 | 1 | 1 |
| Foremen | - | 7 | - | - |
| Office Personnel | 25 | - | 1 | 1 |
| Production Personnel | - | 81 | 11 | 30 |
| Totals | 38 | 89 | 13 | 32 |

OTHER

| Titles | Odessa Office | Odessa Plant | Pampa Plant | Brownwood Plant |
|----------------------------|---------------|--------------|-------------|-----------------|
| Engineers | 5 | - | - | - |
| Designers and Draftsmen | 9 | - | - | - |
| Inspection and NDE | - | 5 | - | 1 |
| Certified Welders | - | 33 | 11 | 13 |
| Totals | 13 | 38 | 11 | 14 |

SALES & SERVICE (all branches) 9
 DISTRIBUTORS Domestic 4
 International 10
TOTAL EMPLOYEES 168

SHIPPING FACILITIES:

| Item | Odessa | Pampa | Brownwood |
|-----------------|--------|-------|-----------|
| Contract Truck | yes | yes | yes |
| Railroad Siding | yes | no | no |
| Contract Crane | yes | yes | yes |

MATERIAL SOURCES:

| Plate | Heads |
|--|---|
| U. S. Steel Armco Gulf State Steel Laturno Steel Lukens Thyssen | Trinity Prescor Hall F & D Fort Worth F & D Gulf Rail Car |



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HEAT TREATING FACILITIES:

| Item | Odessa | Pampa | Brownwood |
|-------------------------|-----------------|-------|---------------|
| Inside Dimensions | 12' x 12' x 60' | na | 4' x 4' x 20' |
| Automatic Control | none | na | yes |
| Manual Control | yes | na | yes |
| Number of Thermocouples | 6 | na | 6 |
| Maximum Temperature | 1200 | na | 1650 |

Note: The Odessa Plant has a twin 25 ton hoist (41'-6" under hook) on a fifty ton bridge which is located at the oven.

TESTING BY SIVALLS, INC.:

| Item | Odessa | Pampa | Brownwood |
|-------------------|----------|----------|-----------|
| Radiography | yes | contract | yes |
| Ultrasonics | yes | yes | yes |
| Magnetic Particle | yes | yes | yes |
| Liquid Penetrant | yes | yes | yes |
| Physical | | | |
| Tensiles | contract | contract | contract |
| Bends | yes | yes | yes |
| Impact | contract | contract | contract |
| hardness | yes | yes | yes |
| Hydrostatic, psig | 22,000 | 15,000 | 15,000 |
| Air, Maximum psig | 125 | 125 | 125 |

STOCK AVAILABLE (tons):

| Item | Odessa | Pampa | Brownwood |
|----------------------|--------|-------|-----------|
| Wide Flange & I-Beam | 75 | 25 | 75 |
| Channel | 100 | 10 | 50 |
| Angle | 100 | 25 | 75 |
| Plate | 300 | 200 | 100 |
| Pipe | 200 | 50 | 200 |

COATINGS:

| | | |
|---------------------|--------------------|---------------------------|
| Sandblast | Polyesters | High Temperature Finishes |
| Alkyds Primer | Polurethanes | Phenolines |
| Zinc Primers | Vinyls | Flakeline Coatings |
| Acrylics & Lactices | Chorinated Rubbers | |
| Alkyds Finishes | Zinc Systems | |

TONNAGE PRODUCTION CAPACITY PER MONTH:

| | |
|-----------|-----|
| Odessa | 600 |
| Pampa | 300 |
| Brownwood | 300 |

HAULING AND SETTING EQUIPMENT: (Located at various plants & branches)



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**TYPE: 4 - diesel road trucks with winches and poles
5 - drop deck trailers
5 - flat bed platform trailers**

ODESSA PLANT

ADDRESS:

**Sivalls, Inc. Phone: 915/337-3571
P. O. Box 2792 Fax: 915/337-2624
2200 East Second Street E-Mail: rgriffin@sivalls.com
Odessa, TX 70760 WEB Site www.sivalls.com**

BUILDING AND CRANE DATA:

| Bay Dimensions | Type Crane | Span (ft) | Number | Capacity (Tons) | Under Hook(ft) |
|----------------|------------|-----------|--------|-----------------|----------------|
| 93' x 425' | Bridge | 60 | 1 | 5 | 22 |
| | Bridge | 60 | 2 | 72 | 22 |
| | Jib | - | 10 | 2 | 18 |
| | Jib | - | 3 | 1 | 18 |
| 87' x 350' | Bridge | 60 | 2 | 25 | 30 |
| | Bridge | 60 | 1 | 10 | 30 |
| | Bridge | 25 | 3 | 2 | 30 |
| 45' x 85' | Bridge | 25 | 1 | 2 | 30 |
| 56' x 201' | Bridge | 37 | 1 | 10 | 19 |

The following sizes and weights can be handled:

- Plate Thickness 6 inches max.
- Diameter 12 feet max.
- Length 200 feet max.
- Weight 200,000 lbs. max.

CUTTING EQUIPMENT:

| Item | Number | Maximum Capacity |
|-------------------------------|--------|------------------|
| Plasma Cutter | 1 | 1" plate |
| Pantograph Plasma Pipe Cutter | 1 | 24" diameter |
| Plate Shear | 1 | 16 gauge |
| Plate Shear | 1 | 2 @ x 10' |
| Automatic Flame Cutting | 5 | 4" |
| Abrasive Cutting | 1 | 4" pipe |
| Band Saw | 1 | 16" pipe |

Koike Optical Tracer Pattern Torch with 8' x 8' Pattern Table
Capacity 6 - torches 6" thick carbon steel
1 - plasma torch cuts 2" thick carbon steel
3" thick stainless steel
3" thick aluminum

PIPE THREADERS:



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| | |
|--|---|
| Type: Ridgid 535 Quantity: 1 Capacity: Operation Pipe Diameter: Cut: 3" thru 2" nominal pipe Bevel: 3" thru 2" nominal pipe Groove: 3" thru 2" nominal pipe | Type: Collins 55N Quantity: 2 Capacity: Operation Pipe Diameter: Cut: 2" thru 4" nominal pipe Bevel: 2" thru 4" nominal pipe Groove: 2" thru 4" nominal pipe Thread: 2" thru 4" nominal pipe |
|--|---|

PLATE ROLLS:

| | | |
|--|---|---|
| Type: Bertsch Initial Pinch Plate Thickness: 12" x 10" 2" x 60" Minimum I.D.: 36" @ 12" Dia. of Top Roll: 22" | Type: Bertsch Initial Pinch Plate Thickness: f" x 10" Minimum I.D.: 21" @ f" Dia. of Top Roll: 15 ³ " | Type: Rol shear Plate Thickness: 22 gauge x 4' |
|--|---|---|

Note: Outside sources of rolling are available for plate up to 6" thick.

BRAKES:

| | |
|--|---|
| Type: Steelweld Hydraulic Ram Capacity: 300 ton Plate Thickness: 5/8" @ 4" (max.) Length: 15' @ 3/16" | Type: Chicago S106 Hand Brake Capacity: ----- Plate Thickness: 16 gauge Length: 121" @ 1/6 guage |
|--|---|

ANGLE ROLL:

| |
|--|
| Type: Buffalo Capacity: 3" x 3" x 3/8" angle leg out, 48" diameter 22" x 22" x 3/8" angle leg in 36" diameter 3" x 5/8" flat on edge in 48" diameter 2" xxHvy pipe in 36" diameter |
|--|

TUBING AND BENDING:

| | | | |
|--|--|---|---|
| Type: Greenlee Hydraulic Bender Quantity: 1 Model: 785-BE Capacity: 6" maximum; dies to 4" xxHvy pipe | Type: Greenlee Hydraulic Bender Quantity: 2 Model: 880M2 Capacity: 2" xhvy pipe | Type: Greenlee Ratchet Bender Quantity: 2 Model: 1800 Capacity: 1" std conduit | Type: Greenlee Electric Bender Quantity: 1 Model: 855 Capacity: 2" std conduit |
|--|--|---|---|

WELDING EQUIPMENT:

| | | |
|-----------|--------|----------|
| Automatic | Manual | Portable |
|-----------|--------|----------|



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| | | |
|--------------------------|--------------------|----------------|
| 1 1500 amps DC | 68 400 amps DC | 1 200 amps DC |
| 1 800 amps DC | 13 600 amps DC | 1 300 amps DC |
| 3 1000 amps DC | 1 300 amps DC GMAW | |
| 2 600 amps LT-7 Tractors | 1 100 amps DC GMAW | |
| | 3 250 amps DC GMAW | |
| | 3 300 amps DC GTAW | |
| | 8 600 amps DC FCAW | |
| 6 total | 74 total | 2 total |

AUTOMATIC WELDING MANIPULATORS:

| | |
|-------------------------|--------------|
| Type: Ransome 12' x 12' | Type: Webb |
| Quantity: 3 | Quantity: 1 |
| Track: 200 feet | Head: single |
| Heads: 3 single | |

AIR COMPRESSORS:

| | |
|-------------------|----------------------|
| Type: Sullair | Type: Ingersoll-Rand |
| Quantity: 2 | Quantity: 1 |
| Maximum: 125 psig | Maximum: 125 psig |

TRUNNIONS:

| Type | Quantity | Capacity/Set (tons) |
|-----------------------|----------|---------------------|
| Power fitup rolls | 1 | 50 |
| Power fitup rolls | 1 | 30 |
| Power fitup rolls | 1 | 10 |
| 10' idlers | 4 | 50 |
| Webb T-18 with idlers | 18 | 9 |
| Ransome with idlers | 1 | 30 |
| Ransome with idlers | 7 | 60 |
| Ransome with idlers | 1 | 90 |
| Ransome idlers | 5 | 10 |

DRILL PRESSES:

| | |
|---|-----------|
| Type: Sumit Radial | |
| Capacity: maximum hole diameter | 3" |
| maximum radius from column to drill | 82" |
| column diameter | 11" |
| maximum hole size | 12" |
| maximum drilling radius | 16-3/4" |
| maximum distance between spindle and base | 64-3/8" |
| minimum distance between spindle and base | 19-11/16" |

PUNCHES:

| | |
|---------------------------------|--|
| Type: Whitney Hydraulic Gauging | Type: Buffalo Iron Worker |
| Capacity: 30 ton | Capacity: 50 ton punch capacities for punch, shear, notcher, square coper and bar cutter |
| Max. Plate Thickness (inches) | Hole Size (inches) |
| 1/8" | 3" thru 5" |
| 3" | 5/16" thru 2" |
| 3/8" | 3/8" thru 15/16" |

PLATE BEVELERS:



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| | |
|--|---|
| Type: Pullmax Beveling Machine Capacity: Maximum Plate Thickness Bevel Type (inches) single bevel 2" with 1/16" land double bevel 2" with 1/16" land | Type: Trumpf Beveling Machine Capacity: 2" |
|--|---|

WELDING POSITIONERS:

| |
|--|
| Capacity: 4500 lbs. Quantity: 4 |
|--|

HANDLING EQUIPMENT:

| |
|--|
| Type: 1 - 20,000 lbs. tandem trucks with winch 1 - 2,650 lbs. fork lift 1 - 8,000 lbs. fork lift 1 - 11,000 lbs. fork lift 1 - 29,000 lbs. fork lift 1 - 36,000 lbs. fork lift |
|--|

BROWNWOOD PLANT

ADDRESS:

Sivalls, Inc. Phone: 915/643-3621
 P. O. Box 1326
 2300 Dickman Rd.
 Brownwood, TX 76901

BUILDING AND CRANE DATA:

| Bay Dimensions | Type Crane | Span (ft) | Number | Capacity (tons) | Under Hook (ft) |
|----------------|------------|-----------|--------|-----------------|-----------------|
| 50' x 275' | TRDG | 50 | 2 | 5 | 25 |
| 25' x 275' | TRSG | 25 | 2 | 5 | 21.7 |
| 25' x 275' | TRSG | 25 | 2 | 5 | 21.7 |

Outside crane 50' x 150' attached to 50' x 275' bay.

The following sizes and weights can be handled:

Plate Thickness 12 inches max.
 Diameter 16 feet max.
 Length 40 feet max.
 Weight 20,000 lbs. max.

CUTTING EQUIPMENT (PLATE):

| Item | Number | Maximum Capacity |
|-------------------------|--------|------------------|
| Plate Shear | 1 | 2" x 10' |
| Automatic Flame Cutting | 2 | 1" |
| Abrasive Cutting | 2 | 2" pipe |

CUTTING EQUIPMENT (PIPE):

| |
|--|
| Type: Vernon Model G Pipe Panograph Capacity: 3" thru 48" Operation: straight cuts / bevel cuts / miter cuts / saddle cuts |
|--|

PIPE THREADERS:

| | |
|--|--|
| Type: Collins 44A Quantity 1 Capacity: Operation Pipe Diameter Cut 3" thru 4" nominal pipe Bevel 3" thru 4" nominal pipe Groove 3" thru 4" nominal pipe Thread 3" thru 4" nominal pipe | Type: Ridgid 235 Pipe Threader Quantity 1 Capacity: Operation Pipe Diameter Cut 3" thru 2" nominal pipe Thread 3" thru 2" nominal pipe |
|--|--|

PLATE ROLLS:

| Type | Plate Thickness (inches) | Minimum I.D. (Inches) | Dia. Of Top Roll (inches) |
|---------------|--------------------------|-----------------------|---------------------------|
| Initial Pinch | 2 | 14 | 12 |

BRAKES:

| Type | Capacity (tons) | Plate Thickness (inches) | Length |
|-----------|-----------------|--------------------------|-------------|
| Hydraulic | 350 | 3/8" | 16'-6" @ 3" |

TUBING AND BENDING:

| Type | Quantity | Model | Capacity |
|----------------------|----------|--------------------|----------------------------------|
| Teledyne Pines No. 4 | 1 | Hot and Cold Bends | 1" - 4" nom. pipe, all schedules |

WELDING EQUIPMENT:

| | |
|-------------------|----|
| Welding Machines: | |
| SAW | 2 |
| SMAW | 38 |
| GMAW | 3 |
| Portable | 1 |
| total | 44 |

AUTOMATIC WELDING MANIPULATORS:

| | | |
|-----------------------------------|--|--|
| Type Quantity Track Head | Preston Easton 2 25 feet single | Preston Easton 1 50 feet single |
|-----------------------------------|--|--|

TRUNNIONS:

| | | |
|--|---------|---------------------|
| Type | Sets | Capacity/Set (tons) |
| Fitup Rolls Single Wheels with Driver | 1 10 | 10 9 |

DRILL PRESSES:

| | | | |
|-----------|---|--------|--|
| Type: | Sokaluce 2000 Radial | | |
| Capacity: | maximum hole diameter | 2-3/8" | |
| | maximum radius from column to drill | 79" | |
| | column diameter | 163" | |
| | maximum hole size | 12@ | |
| | maximum drilling radius | 392" | |
| | maximum distance between spindle and base | 72" | |
| | minimum distance between spindle and base | 16" | |

PUNCHES:

| | | | |
|-----------|-------------------------------------|-----------------------|--|
| Type: | Iron Worker | | |
| Capacity: | 56 ton | | |
| | Maximum Plate Thickness (inches) | Hole Size (inches) | |
| | 2 | 12" | |

PLATE BEVELERS:

| | | | |
|-----------|-------------------------|----------------------|--|
| Type: | Torch | | |
| Capacity: | Maximum Plate Thickness | | |
| | Bevel Type | (inches) | |
| | Single Bevel | 1/2" with 1/16" land | |
| | Double Bevel | 1/2" with 1/16" land | |

WELDING POSITIONERS:

| | |
|-----------|-----------|
| Capacity: | 4500 lbs. |
| Quantity: | 2 |

HANDLING EQUIPMENT:

| | |
|-------|---------------------------|
| Type: | 1 - 15,000 lbs. fork lift |
|-------|---------------------------|

AIR COMPRESSORS

Type: Westinghouse
 Quantity: 2
 Maximum: 125 psig

PAMPA PLANT**ADDRESS:**

Sivalls, Inc.
 P. O. Box 1862
 2-3/4 miles west of Pampa on Hwy 60
 Pampa, TX 79765

Phone: 806/665-7111

BUILDING AND CRANE DATA:

| Bay Dimensions | Type Crane | Span (ft) | Number | Capacity (tons) | Under Hook (ft) |
|----------------|------------|-----------|--------|-----------------|-----------------|
| 50' x 200' | TRDG | 50 | 2 | 5 | 25 |
| 25' x 200' | TRSG | 25 | 2 | 5 | 21.7 |
| 25' x 200' | TRSG | 25 | 2 | 5 | 21.7 |

Outside crane 50' x 75' attached to 50' x 200' bay

The following sizes and weights can be handled:

Plate Thickness 1 inches max.
 Diameter 16 feet max.
 Length 40 feet max.
 Weight 20,000 lbs. max.

CUTTING EQUIPMENT (PLATE):

| | Number | Maximum Capacity |
|-------------------------|--------|------------------|
| Plate Shear | 1 | 2" x 10' |
| Automatic Flame Cutting | 3 | 1" |
| Bug-O Cutting Machine | 1 | 1" pipe |

CUTTING EQUIPMENT (PIPE):

| | |
|--|--|
| Type: Vernon Model G Pipe Panograph | Type: Band Saw |
| Capacity: 3" thru 48" | Capacity: 10" |
| Operation: straight cuts / bevel cuts / miter cuts / saddle cuts | Operation: straight cuts / bevel cuts / miter cuts / saddle cuts |

PIPE THREADERS:

| |
|-----------------------------------|
| Type: Collins 44A |
| Quantity: 1 |
| Capacity: Operation Pipe Diameter |
| Cut 3" thru 4" nominal pipe |
| Bevel 3" thru 4" nominal pipe |
| Groove 3" thru 4" nominal pipe |
| Thread 3" thru 4" nominal pipe |

PLATE ROLLS:

| |
|----------------------------|
| Type: Double Initial Pinch |
| Plate Thickness: 2" x 10' |
| Minimum I.D.: 13" |
| Dia. of Top Roll: 11" |

ANGLE ROLL:

| | |
|-----------|-----------------|
| Type: | Pullmax |
| Capacity: | 3" x 3" x 5/16" |

WELDING EQUIPMENT:

| | |
|--------------------------|----|
| Welding Machines: | |
| SAW | 4 |
| SMAW | 24 |
| GMAW | 11 |
| total | 39 |

AUTOMATIC WELDING MANIPULATORS:

| | | | | | |
|-----------|------------------|-----------|----------------|-----------|---------|
| Type: | Preston - Easton | Type: | Jetline Seamer | Type: | Lewis |
| Quantity: | 3 | Quantity: | 1 | Quantity: | 1 |
| Track: | 25 feet | Track: | 11 feet | Track: | 20 feet |
| Head: | single | Head: | single | Head: | single |

TRUNNIONS:

| Type | Sets | Capacity/Set (tons) |
|---------------------------|------|---------------------|
| fitup rolls | 3 | 10 |
| single wheels with driver | 17 | 9 |
| single wheels with driver | 2 | 3 |
| idlers only | 3 | 42 |

PUNCHES:

| | |
|-----------|-------------------------------------|
| Type: | Iron Worker |
| Capacity: | 56 ton |
| | Maximum Plate Thickness (inches) 2@ |
| | Maximum Hole Size (inches) 1-1/16" |

WELDING POSITIONERS:

| | | | |
|-----------|------|-----------|-----|
| Quantity: | 1 | Quantity: | 1 |
| Capacity: | 1000 | Capacity: | 250 |

HANDLING EQUIPMENT:

| | |
|-------|------------------------------------|
| Type: | 1 - 2 ton truck with winch |
| | 1 - A64 Ford 13,000 lbs. fork lift |

AIR COMPRESSORS:

| | |
|-----------|----------|
| Type: | Sullair |
| Quantity: | 2 |
| Maximum: | 125 psig |