



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 Certified Welders	-	5	-	1
		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
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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'
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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
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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
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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
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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: Capacity:	Pullmax Beveling Machine Maximum Plate Thickness Bevel Type (inches) single bevel 2" with 1/16" land double bevel 2" with 1/16" land	Type: Capacity:	Trumpf Beveling Machine 2"
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WELDING POSITIONERS:

Capacity: 4500 lbs. Quantity: 4
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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
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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
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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
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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
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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
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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