



METAL FABRICATION.



A National Leader in
Custom Industrial Metal Fabrication



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Ci Metal Fabrication was recently tasked with fabricating a large liquor storage and agitator tank for an OEM contractor with a very intensive list of requirements and specifications. After successfully fabricating custom metal components for more than half a century, Ci Metal Fabrication was able to rise to the occasion and craft a high-quality product on time and on budget.

The large liquor storage and agitator tank was specified as 15 feet wide by 30 feet long and 15 feet tall. It was constructed from one-half inch thick LDX 2205 duplex stainless steel to hold up to the conditions the end user required. Carbon support steel was also added to the exterior of the tank to further fortify the custom project. The stainless steel components were masked, while all carbon steel components received a coat of red oxide primer.

In addition to its highly customized construction, the large tank was fabricated into the largest sections possible for shipping purposes, with each section bevel-prepped and match-marked for field erection. The tank was fabricated to API 650 specifications which required extensive welding criteria and NDT testing. Weld coupons had to be fabricated for bend-and-break testing to certify PQRs and WPSs to cover all of the welding, and all welder credentials and certifications had to be submitted. Finally, NDT testing such as radiograph and liquid penetration had to be performed with full documentation and reports.

To ensure the shipping of the project went as smoothly as possible, Ci Metal Fabrication worked closely with the OEM contractor to map the shipping units (fabrication modules) to best support shipping and yet still minimize the number of pieces involved in the field erection. Before the tank could be shipped the interior and exterior of the stainless shell underwent a thorough decontamination cleaning process to remove all dirt, oil, grease and carbon contamination.

Ultimately the project was finished on time and shipped to the customer for installation during their scheduled outage. This is just one example of many successful custom metal fabrication projects performed by Ci Metal Fabrication.

