



# Chemical Plant - New Tank Farm

Process Piping

Contract Value: \$2.1 million



**Project Description:** The nature of the project was to provide a new and fully operational tank farm with unloading and distribution requirements within a nine month schedule. Ground was broken in April 2008. In spite of the late project start and various challenges, the facility was receiving product in December 2008 and was under operation in January 2009. S. P. McCarl & Company, Inc. was responsible for installing all process piping systems as well as erecting all the required structural steel and tanks.

The process piping scope included nearly 10,000 lineal feet of ASME code welded carbon steel piping with approximately 2,000 weld joints for process systems. The associated utility systems comprised of approximately 3,000 lineal feet of stainless piping and copper tubing and the scope included setting equipment consisting of twenty-three tanks ranging from 8,000 gallons through 30,000 gallons as well as thirty-three pumps. To support the numerous large tanks and piping systems required installation of approximately 200,000 lbs. of structural support steel as well as insulation, including stainless jacketing, of 60% of the piping and tanks.



**Technical Challenge:** The schedule and working conditions were the primary challenge of this project. S. P. McCarl & Company, Inc. directly employed ten to fourteen persons while also managing twenty to thirty subcontracted employees. In addition, there was an electrical/controls prime contractor whose manpower ranged from twenty to thirty persons.



The job site was very congested due to the tight schedule. To complete the work on schedule, close coordination between S. P. McCarl & Company, Inc. project leaders and other team members was paramount while also ensuring the project was completed with no recordable injuries and with quality installation.

