

TANKS
Bilton Welding and
Manufacturing



Welding & Manufacturing Ltd.

TECHNICAL PACKAGE

JOB # D0591

SHIPPING DATE: JANUARY 21, 2009
CUSTOMER: CANADIAN SPIRIT RESOURCES INC.
C/O EXCELSIOR ENGINEERING LTD.
CONTACT: DOCUMENT CONTROL
LOCATION: C-93-H/94-B-1

DESCRIPTION
400 BBL SW AG STORAGE TANK

TAG # N/A

AFE # 1086004

CUSTOMER PO # 1757.11

SERIAL NUMBER STTK-NG-T2-14902

1/21/2009

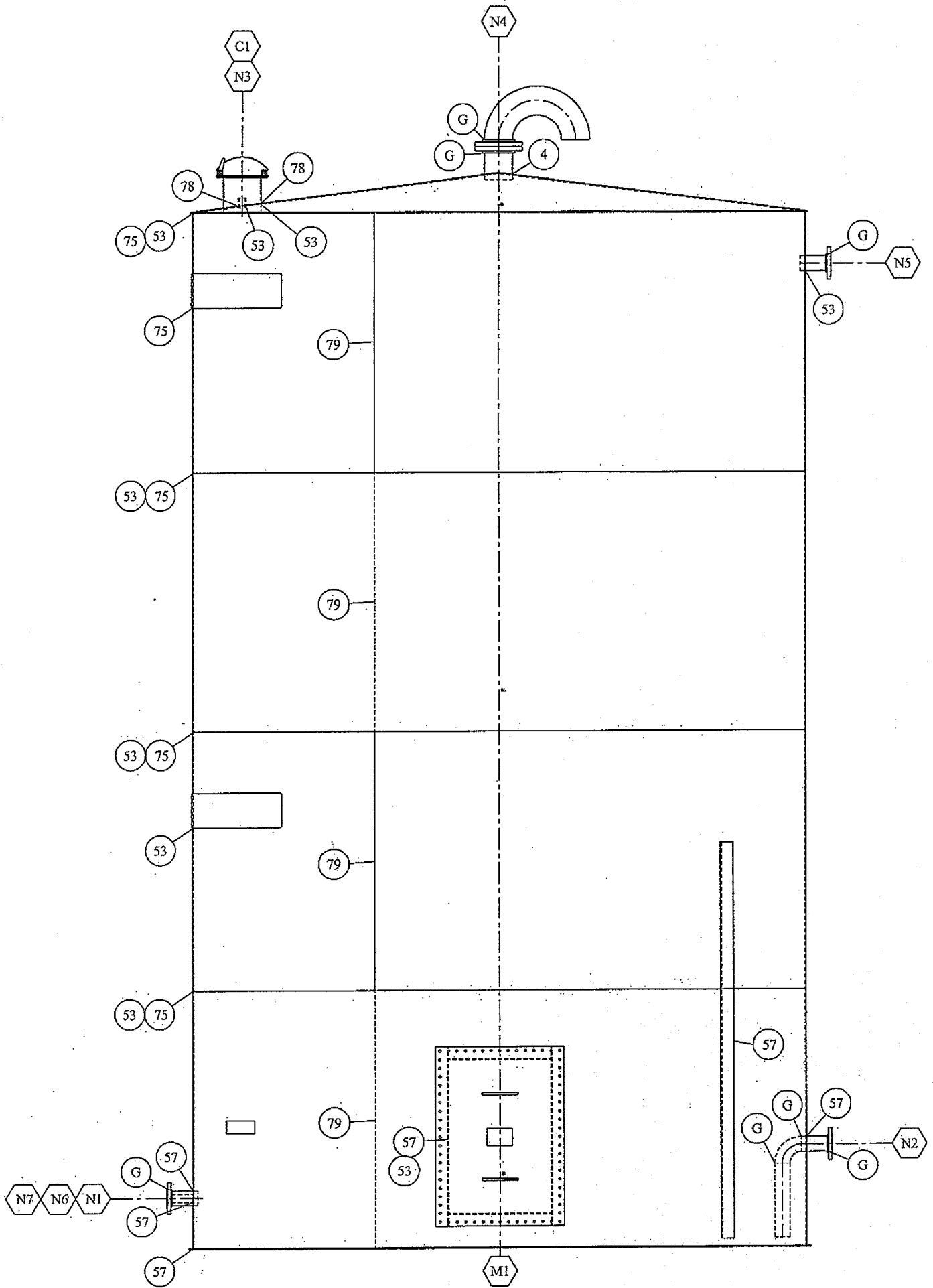
MADE IN
CANADA

BITON

INNISFAIR
ALBERTA

Welding & Manufacturing Ltd

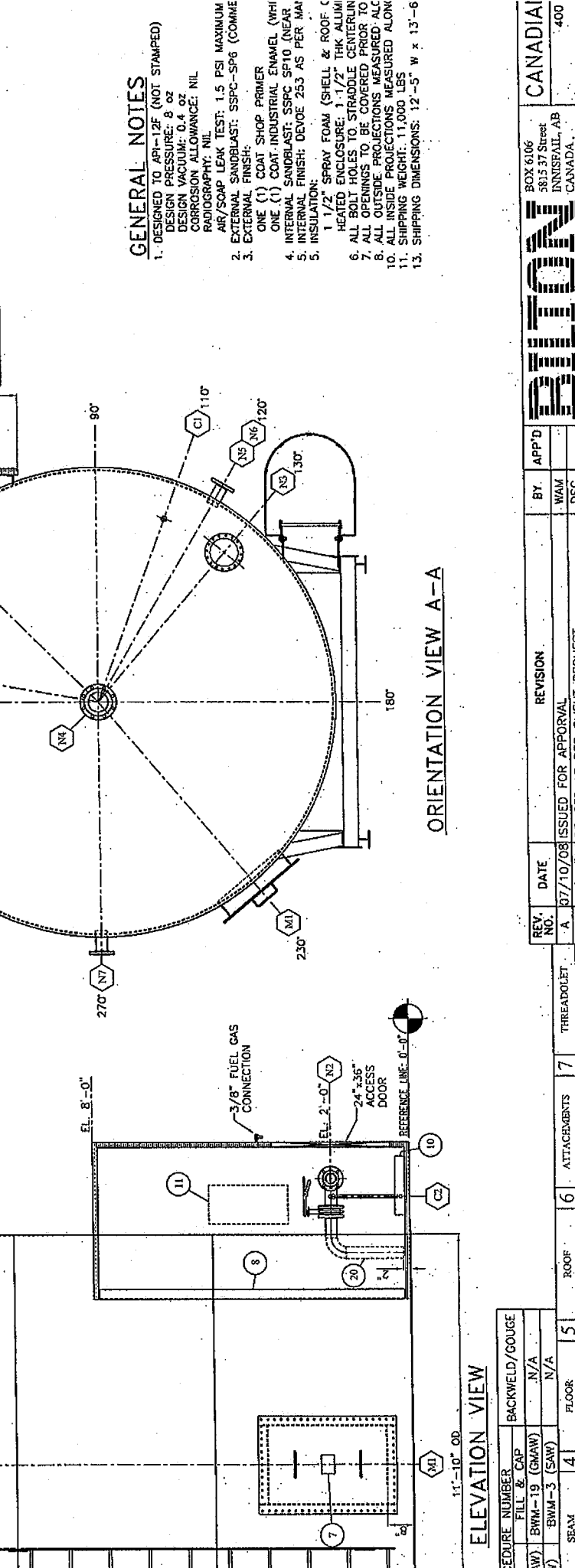
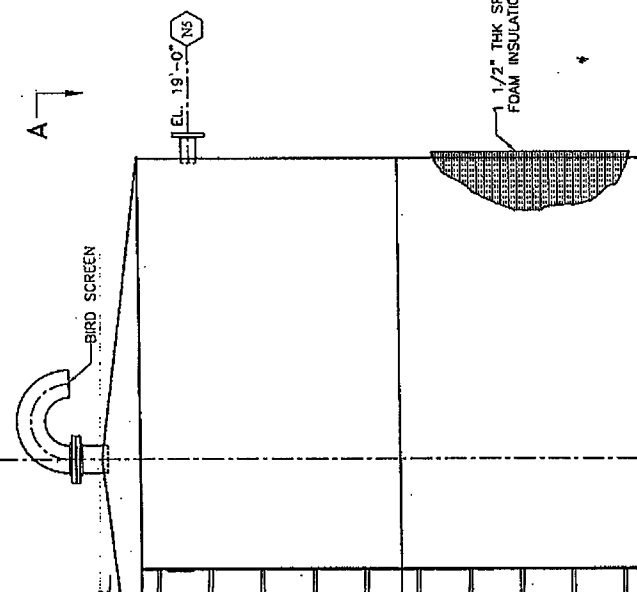
SERIAL NUMBER	STTK-NGT-2-14-902	D05911
YEAR BUILT	2008	
NOMINAL DIAMETER	11'-10" OD	LENGTH 20'-0"
NOMINAL CAPACITY	WT	BBL 4.00
INTERIOR THICKNESS	SHELL 3/16" SA36	HEADS
INTERIOR THICKNESS	ROOF 3/16" SA36	FLOOR 1/4" SA36
EXTERIOR THICKNESS	SHELL	HEADS
EXTERIOR THICKNESS		FLOOR
DESIGN PRESSURE	8 OZ	TEST AIR/ SOAP 1.5 PSI
COATING	INT. DEVOE 253	EXT. PRIMER/1 COAT 1.E



JOB# D0591 WELDER ID MAP

NO.	DESCRIPTION	QTY	UNIT	REV.	DATE	BY	APP'D	REVISION
N1	THIEF HATCH	8	API	APISO	1"	2	1/4	24.25
N2	VENT	6	150	RFSO	1"	1.2	1/4	26.27, 28.29, 30.31, 32
N3	HLSD	3	150	RFSO	1"	6	1/4	12.13
N4	LI	3	150	RFSO	1"	6	1/4	12.13
N5	SPARE	3	150	RFSO	1"	6	1/4	12.13
N6	LG	1	3000	CPLG	1/4"	2	1/4	33, 34, 35
N7	SUCK-OUT	1/2	3000	TOL	---	7	1/4	36, 37, 38, 39, 40
N8	MARWAY	2-5x35	API	FAB	1/2"	2	1/4	41

NO.	DESCRIPTION	QTY	UNIT	REV.	DATE	BY	APP'D	REVISION
1	LADDER	1	---	---	---	---	---	---
2	SKID	1	---	---	---	---	---	---
3	SADDLE	2	---	---	---	---	---	---
4	NAMEPLATE	4	---	---	---	---	---	---
5	ENCLOSURE	1	---	---	---	---	---	---
6	ENCLOSURE	1	---	---	---	---	---	---
7	ENCLOSURE	1	---	---	---	---	---	---
8	HEATER	1	---	---	---	---	---	---
9	HEATER	1	---	---	---	---	---	---
10	HEATER	1	---	---	---	---	---	---
11	HEATER	1	---	---	---	---	---	---
12	HEATER	1	---	---	---	---	---	---
13	HEATER	1	---	---	---	---	---	---
14	HEATER	1	---	---	---	---	---	---
15	HEATER	1	---	---	---	---	---	---
16	HEATER	1	---	---	---	---	---	---
17	HEATER	1	---	---	---	---	---	---
18	HEATER	1	---	---	---	---	---	---
19	HEATER	1	---	---	---	---	---	---
20	HEATER	1	---	---	---	---	---	---
21	HEATER	1	---	---	---	---	---	---
22	HEATER	1	---	---	---	---	---	---
23	HEATER	1	---	---	---	---	---	---
24	HEATER	1	---	---	---	---	---	---
25	HEATER	1	---	---	---	---	---	---
26	HEATER	1	---	---	---	---	---	---
27	HEATER	1	---	---	---	---	---	---
28	HEATER	1	---	---	---	---	---	---
29	HEATER	1	---	---	---	---	---	---
30	HEATER	1	---	---	---	---	---	---
31	HEATER	1	---	---	---	---	---	---
32	HEATER	1	---	---	---	---	---	---
33	HEATER	1	---	---	---	---	---	---
34	HEATER	1	---	---	---	---	---	---
35	HEATER	1	---	---	---	---	---	---
36	HEATER	1	---	---	---	---	---	---
37	HEATER	1	---	---	---	---	---	---
38	HEATER	1	---	---	---	---	---	---
39	HEATER	1	---	---	---	---	---	---
40	HEATER	1	---	---	---	---	---	---
41	HEATER	1	---	---	---	---	---	---
42	HEATER	1	---	---	---	---	---	---



ORIENTATION VIEW A-A

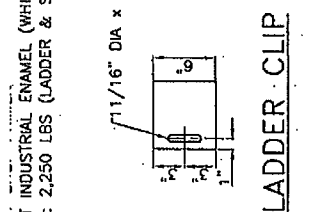
- GENERAL NOTES**
- DESIGNED TO API-12F (NOT STAMPED)
DESIGN PRESSURE: 8 oz
DESIGN VACUUM: 0.4 oz
CORROSION ALLOWANCE: NIL
RADIOGRAPHY: NIL
AIR/SOAP LEAK TEST: 1.5 PSI MAXIMUM
 - EXTERNAL SANDBLAST: SSPC-SP6 (COMM)
 - EXTERNAL FINISH:
ONE (1) COAT SHOP PRIMER
ONE (1) COAT INDUSTRIAL ENAMEL (WHI)
 - INTERNAL SANDBLAST: SSPC SP10 (NEAR)
 - INTERNAL FINISH: DEVCO 253 AS PER MAI
 - INSULATION:
1 1/2" SPRAY FOAM (SHELL & ROOF)
HEATED ENCLOSURE: 1 1/2" THK ALUMI
 - ALL BOLT HOLES TO STRADDLE CENTERLINE
 - ALL OPENINGS TO BE COVERED PRIOR TO
 - ALL OUTSIDE PROJECTIONS MEASURED: ALC
 - ALL INSIDE PROJECTIONS MEASURED: ALONK
 - SHIPPING WEIGHT: 11,000 LBS
 - SHIPPING DIMENSIONS: 12'-5" W x 13'-6"

CEDURE NUMBER	BACKWELD/GOUGE
AW) BWM-19 (GMAW)	N/A
W) BWM-3 (SAW)	N/A

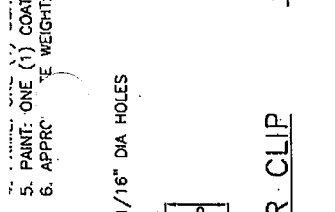
SEAM	FLOOR	ROOF	ATTACHMENTS	7	THREADOLET	DATE	REVISION	BY	APP'D
4	5		6			07/10/08	ISSUED FOR APPROVAL	WAM	NSC

4	Z	PULL	1 1/4" FLATBAR x 6 1/2" DIA PULL CAP
5	1	PULL	4" STRUCTURAL PIPE SCH XH x 7'
6	2	PULL	4" STRU PIPE SCH XH x 7'
7	4	SADDLE	4" x 4" x 4" HSS x 1'-9 7/8"
8	2	SADDLE	8" x 1/4" THK x 9'-4" LG. ROLL 1
9	2	LADDER	RAIL: 3/8" THK x 234" LG
10	20	LADDER	RUNGS: 3/4" HRR x 1'-6 3/4" LG
11	1	LADDER	BOTTOM BAND: 3" x 1/4" FLATBAR x 8'
12	2	LADDER	MID BAND: 2" x 1/4" FLATBAR x 7'-9 5/8"
13	1	LADDER	TOP BAND: 3" x 1/4" FLATBAR x 7'-9 5/8"
14	7	LADDER	BARS: 1 1/2" x 1/4" FLATBAR x 12'
16	1	LADDER	TOP LADDER CLIP: 6" x 3/8" THK x 8" LG
17	1	LADDER	TOP LADDER CLIP: 6" x 3/8" THK x 12" LG
18	2	LADDER	MID LADDER CLIP: 6" x 3/8" THK x 8" LG
20	2	LADDER	MID LADDER CLIP: 6" x 3/8" THK x 12" LG
21	8	LADDER	BOLTS: 5/8" DIA x 2" LG BOLTS c/

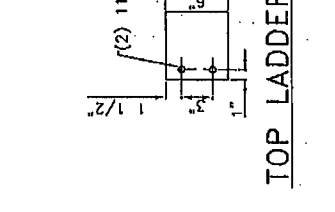
5. PAINT: ONE (1) COAT INDUSTRIAL ENAMEL (WHITE)
 6. APPROX WEIGHT: 2,250 LBS (LADDER & SKID)



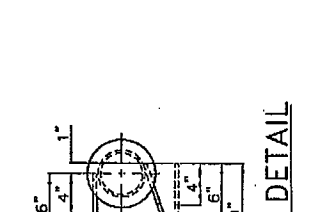
LADDER CLIP



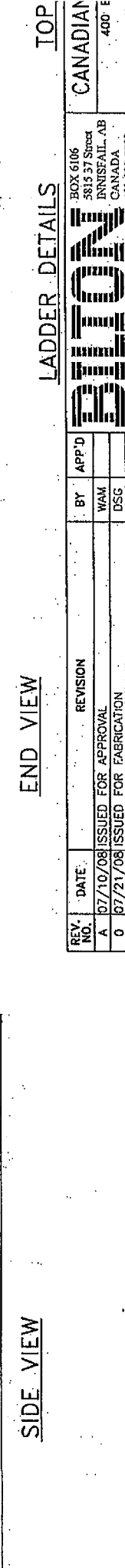
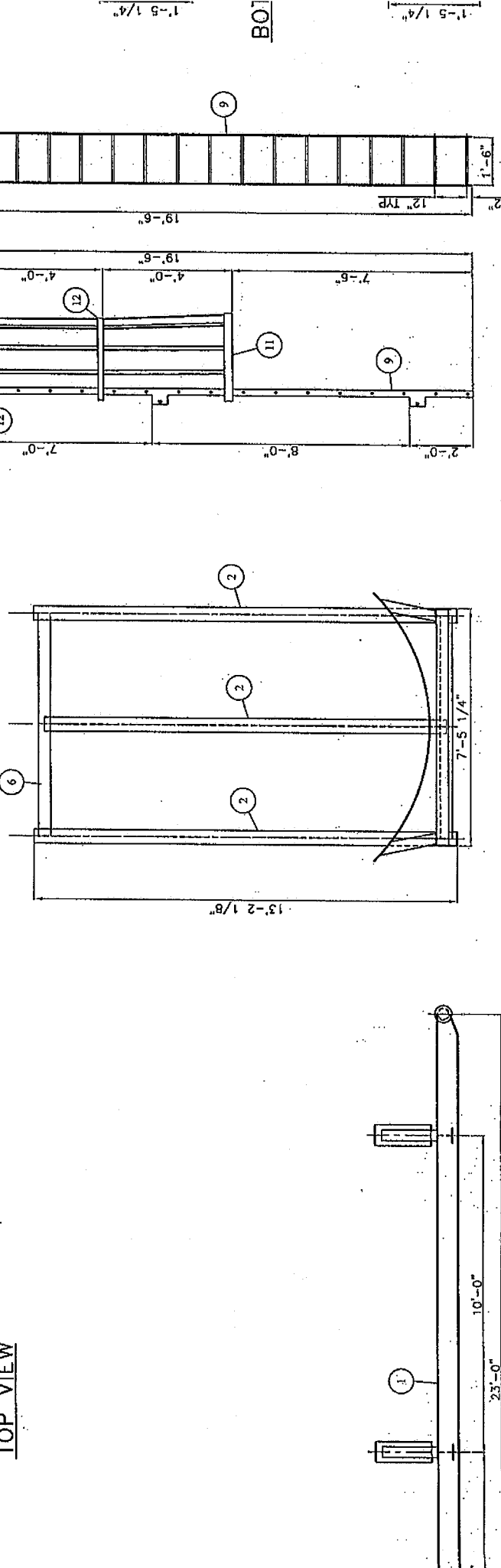
TOP LADDER CLIP



COPE DETAIL



PAD DETAIL



LADDER DETAILS

TOP

REV. NO. DATE REVISION BY APP'D

A 07/10/08 ISSUED FOR APPROVAL WAM

0 07/21/08 ISSUED FOR FABRICATION DSG

BOX 6106
 5813 57 Street
 INNSISFAIL, AB
 CANADA

CANADIAN
 400 E

LADDE

1-5 1/4"

19'-6"

19'-6"

7'-6"

7'-6"

4'-0"

4'-0"

4'-0"

2'-0"

2'-0"

8'-0"

7'-0"

7'-6"

12" TYP

1'-6"

9

10

11

12

13

14

16

17

18

20

21