


TSEA Compressor Station

Inlet Cooler Scope of Supply (AR-250)

Prepared for Nexen Inc.

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1. Introduction**1.1 General**

This scope of supply is prepared to detail the requirements for an Inlet Cooler (AR-250) and identifies the minimum technical requirements. The Inlet Cooler shall be fully winterized with two Ruffneck heaters to prevent freezing.

1.2 Definitions

The following definitions shall apply throughout this specification:

Vendor: Primary equipment manufacturer who has unit responsibility for the complete equipment packages.

Purchaser: Nexen Inc. (Owner)

Tri Ocean Engineering Consultant

1.1 Vendor's Responsibility

Vendor shall be fully responsible for the complete mechanical design, thermal design, fabrication, inspection, testing, electrical, instrumentation, materials, and structural components plus preparation for shipment of the air cooled heat exchangers (ACHE). Vendor shall be in full compliance with this scope of supply, its attachments, standards, applicable codes, and all provincial / federal regulations.

Vendor shall bring to the attention of Purchaser any requirements of this scope of work that, in their opinion, are not in accordance with good engineering practice or are otherwise not suitable for the intended service.

Compliance with this scope of supply and other referenced specifications does not relieve Vendor from the responsibility of providing equipment complete in every respect of proper design, workmanship and materials to meet the specified design conditions

1.2 Sub-Contractors

Vendor may only subcontract items to Sub-Contractors that have been approved by the Purchaser beforehand.



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Vendor must manage any Sub-Contractors to ensure that their product or service meets the performance and delivery requirements as described herein.

Vendor shall ensure that the appropriate level of inspection and expediting is applied to all Sub-Contractors.

1.3 Units of Measure

Units shall be in accordance with the 'Système International' (SI) form of units.

1.4 Environmental Design Data

The TSEA Compressor Station is to be located in Northern British Columbia with the following Geographical Coordinates and elevation of site:

- Geographical Coordinates = d-7-I / 94-0-8
- Elevation of site = 665 m ASL, (2200 ft)

The following tables give the site design conditions used for this project:

**Table 1.4-1
Environmental Design Parameters**

Barometric Pressure	
Average	93.5 kPaa
Design Air Temperature	
Winter Design Temperature	-45°C
Summer Design Temperature	32°C
Wind Speeds	
Basic Wind Speed (summer)	13 km/h; 8 mi/h
Basic Wind Speed (winter)	12 km/h; 7.5 mi/h
Hourly Wind Pressures	
1 in 10 year	0.3 kPa
1 in 50 year	0.4 kPa
Precipitation	
Ground Snow Load	2.4 kPa
Maximum Precipitation Incidence	70 mm (24 h-period)

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**Table 1.4-1
Environmental Design Parameters**

Relative Humidity	
Design Maximum	100%
Design Minimum	10%

**Table 1.4-2
Seismic Data**

S _a (0.2)	0.12
S _a (0.5)	0.056
S _a (1.0)	0.034
S _a (2.0)	0.022
PGA	0.059

1.5 Deviations

If during the course of the detail design or fabrication further deviations are identified, they will be brought to the attention of Purchaser by Vendor in writing. Vendor shall identify the technical, cost and schedule implications of the deviation. Purchaser will re-issue the Agreed to Deviations list with a PO revision if the deviation is approved. No work affecting a deviation shall proceed until approval has been received in writing. Where there is a cost impact a PO revision shall be received prior to proceeding with the work.

2. Codes, Regulations and Standards

The package shall be designed, constructed and inspected in compliance with all applicable federal and provincial acts, laws and regulations and the design will be carried out in accordance with all specifications, codes and standards applicable to this type of unit.

The latest editions of industry codes and standards along with the Nexen and Tri Ocean specification shall be used in conjunction with this scope of supply.

2.1 Industry Codes and Standards

- British Columbia, Ministry of Transportation and Highways
- BCSCA, British Columbia Safety Authority

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- All applicable industry standards given in the Nexen specifications below

2.2 Nexen Standards

- GS-120-01, Sour Service Definition and Material Requirements
- GS-120-05 & 05A, Welding
- GS-120-06 & 06A & 06B, Nondestructive Examination (NDE)
- GS-130-20, Heat Exchangers
- GS-140-01, Piping
- GS-150-10, Instrumentation Installation
- GS-160-30, Electrical Motors
- GS-180-40, Structural Steel Fabrication and Erection
- GS-180-41, Structural Steel Fabrication – Stairs, Ladders and Platforms
- Colours Nexen vessel & equipment parts 1 and 2

2.3 Order of Precedence

The reference documents have the following order of precedence:

- Federal and Provincial Acts and Regulations
- Purchase Order Documents
- Inlet Cooler Data Sheet
- This Scope of Supply
- Referenced Client Specifications and Standards
- Referenced Industry Standards

Where conflict exists between specifications and documents referenced herein, the order of precedence defines the superseding document. Where continuing conflict exists between specifications, Purchaser shall be notified for resolution in writing prior to fabrication.



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3. General Information

3.1 Schedule

Vendors shall provide a preliminary schedule with their bid showing early and late completion dates.

A bi-weekly update of the schedule in Microsoft project format is required after PO acceptance.

Vendor shall immediately notify Purchaser of any schedule slippages due to in-house work or third party Vendor delays

It is expected that Vendor will expedite all activities that affect the schedule including internal and external drawing reviews. Purchaser will assign an expeditor to assist as required and to maintain an overview of the schedule status, threats and opportunities.

3.2 Lines of Communication

The Procurement Lead will act as a focal point to ensure that Vendor technical queries are answered in a timely fashion by Purchaser's engineering team.

After PO:

- Vendor shall assign a Project Manager (VPM)
- Purchaser will assign a Responsible Discipline Engineer (RDE)
- All communications will occur via Vendor's Project Manager and Purchaser's Responsible Discipline Engineer. Any direction not provided through these channels will be considered as non-valid and any costs incurred as a result of following such directions shall be to Vendor's account.
- Direction that has major cost or schedule implications shall be formalized after agreement between Purchaser and Vendor by an immediate PO revision generated by the RDE and submitted to Vendor prior to work commencing.
- Any commercial issues shall be communicated to Purchaser's Procurement Lead.
- Any schedule issues shall be identified to Purchaser's Expeditor

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- 3rd party inspectors assigned by Purchaser to monitor the work shall provide formal reporting to the Responsible Discipline Engineer. Informal notification of findings shall be provided to Project Manager. The Inspector is an observer only and is not tasked with providing shop or project direction. Purchaser's Document Control shall be in receipt of all incoming inspection reports.

4. Vendor Scope of Supply

4.1 General

This scope of supply describes the minimum requirements for an Inlet Cooler complete with all supporting equipment, electrical, and instrumentation required for safe and trouble free operation.

Vendor shall guarantee the performance of the exchangers for the conditions noted on the data sheets. This guarantee shall include the Material, Workmanship, Mechanical, Thermal, and Hydraulic design of the exchangers.

ACHEs shall be designed and fabricated to API 661 latest editions, ASME Section VIII Div 1, CSA B51 and client specifications. The exchanger shall comply with the Provincial Regulations and all relevant Codes.

The tube wall temperature shall be above the tube wall critical temperature for the range of operating conditions noted on the data sheet. For critical temperature refer to API 661.

4.2 Gas Analysis

The gas analysis will be

Table 4.2.1
Gas Analysis

Fluid Physical Properties	Analysis	Design
Gross Heating Value	34.05 MJ/m ³	
Gas Composition (mole fraction)		
H ₂	Trace	
He	0.0003	0.0003
N ₂	0.0056	0.0056

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Inlet Cooler Scope of Supply (AR-250)**Table 4.2.1**
Gas Analysis

Fluid Physical Properties	Analysis	Design
CO ₂	0.094	0.1400
H ₂ S	Trace	0.0005 (500 ppm)
C ₁	0.8987	0.8525
C ₂	0.0014	0.0014
C ₃	Trace	0.0000
iC ₄	Trace	0.0000
nC ₄	Trace	0.0000
iC ₅	Trace	0.0000
nC ₅	0.0000	0.0000
C ₆	Trace	0.0000
C ₇	Trace	0.0000
C ₈	0.0000	0.0000
C ₉	0.0000	0.0000
C ₁₀	0.0000	0.0000
C ₁₁	0.0000	0.0000
C ₁₂₊	0.0000	0.0000

4.3**Major Materials**

The scope of work shall include but not be limited to the following major items:

- Inlet Cooler forced draft unit per datasheet 09615-0-DS-ME-00002.00
- Supply and fabrication of exchanger
- Cleaning, painting and insulation
- Heat exchanger shall be completely winterized unit and have automated recirculation louvers.



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- All motors shall be an inverter rated motor to be controlled by a variable frequency drive supplied by purchaser.
- Louvers shall be supplied with Fisher 656 pneumatic actuators and DVC6000-HC positioners.
- Instrumentation and controls
- Each bay shall have two (2) temperature transmitters with resistance temperature devices. (RTD's)
- Vibration transmitters (switches are not acceptable)
- Hail screens
- Bug screens all around.
- Structural c/w access doors
- Lifting lugs
- Header walkways with ladders (both ends)
- Sliding pads
- Construction and start-up spares (10% bolts/nuts/gaskets for field erected connections)
- Preparation for road transport
- Storage preparation

4.4

Modularization

Each bay shall be shop assembled for shipping and minimize field assembly work and reduce installation costs, refer to British Columbia, Ministry of Transportation and Highways Information. All structural supports and bracing, tube bundles, fan, drivers, plenums, louvers, actuators, instrumentation and manifold piping shall be installed prior to shipping. The vendor shall design and supply all lifting lugs required for installation of coolers. Platforms, ladders and recirculation units may be shipped separately if necessary to meet dimensional/weight restrictions.



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4.5

Engineering

- Project management
- Design and engineering
- Drafting services
- Document Control
- Vendor QA
- Vendor expediting
- Inspection and certification
- Documentation and drawings per VDR

4.6

Purchaser-Supplied Materials, Equipment and Services

The Purchaser shall be responsible for supplying the following:

- Variable frequency drive
- Third-party inspection for Vendor's scope of supply
- Transport to site from Vendor's facility
- Site Construction
- Main plant PLC

5.

Technical Requirements

5.1

Inlet Cooler

The Inlet Cooler unit per datasheet 09615-0-DS-ME-00002.00 will be added to as part of future expansion and will be part of bank of Coolers as per Facility Plot Plant (Appendix A)

Additional coolers added as part of future plant expansion will be positioned side by side with this Inlet Cooler; therefore Vendor to consider this future expansion in their thermal and mechanical design. Vendor shall simplify the interconnection of cooler bays on site.



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5.2 Piping

Piping requirements shall be in full compliance with Nexen GS-140-01, Piping

5.3 Structural

Structure requirements shall be in full compliance with Nexen GS-180-40, Structural Steel Fabrication and Erection and GS-180-41, Structural Steel Fabrication – Stairs, Ladders and Platforms.

Wind loading shall be considered per the National Building Code of Canada (NBC) and British Columbia Building Code. Wind pressure information for the site is per the Site Conditions above.

The design of the structure shall also take into account the seismic information given on the data sheet.

5.4 Electrical

Electrical requirements shall be in full compliance with Nexen GS-160-30, Electrical Motors.

All electrical equipment and instrument end devices on the package such as heaters, fans, transmitters, I/P positioners etc. will be wired by others to the junction boxes at Vendor's shop.

3 phase power for auxiliaries shall be rated 460 VAC, 60 Hz.

1 phase power shall be rated 120 VAC, 60 Hz.

Control and accessory power shall be rated 24 VDC.

The cooler motors shall be ASD (VFD) compatible, VFD supplied by Purchaser.

5.5 Area Classification

All electrical and instrumentation devices shall be suitable for a Class I Zone 2 area classification.

5.6 Instrumentation

Instrumentation requirements shall be in full compliance with Nexen GS-150-10, Instrumentation Installation.



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Vendor shall populate Purchaser supplied instrument datasheets. Purchaser will provide the data sheets in SPI format and the appropriate program for Vendor to complete the work.

- All instruments shall be CSA compliant for the classified area specified and so labelled. Instrument end devices shall meet the secondary sealing requirement of the Canadian Electrical Code.
- All instrument air tubing shall be 316 SS c/w Swagelok 316 SS fittings and ferrules. The tubing shall be 3/8" OD and 0.035" WT. All louver actuators shall be tubed to a 2" instrument air header that is mounted on the cooler that Purchaser will connect to the main pipe rack.
- The cooler motors shall be supplied with Metrix vibration transmitters.
- All temperature transmitters shall be Rosemount 3144 series and mounted in accessible locations.
- All louver actuators shall be by Fisher and supplied with DVC-6000 I/P positioners. All louver actuators will be modulated by the main plant PLC.

5.7 Painting

All structural steel shall be hot-dip galvanised. Mechanical equipment shall be painted per manufacturer's standard.

5.8 Registration

Vendor shall be responsible for registering the unit for use in British Columbia, Alberta and Saskatchewan. Exchanger shall be ASME U-Stamped and bears a Canadian Registration Number (CRN). Vessels fabricated outside of Canada shall also have National Board registration.

5.9 P.Eng Stamps

Drawing provided shall be P.Eng stamped by a member or members registered in British Columbia.

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5.10 Personnel Protection

Guarding or insulation shall be provided for any surface with a skin temperature exceeding 72°C. For components where dismantling is required for maintenance guarding is preferred. Components which require surface heat dissipation by design shall be protected with guarding. Insulation shall be in accordance with Nexen Specification GS-200-80.

5.11 Noise

Vendor shall complete the noise datasheet(s) for each item and include in the proposal. The noise level limit shall be 85 dBA at 1 meter below the fan or tube bundle, whichever is lower.

5.12 Nameplates

Nameplates shall be attached directly to the equipment casing. The nameplate shall include the following:

- Service
- Equipment name
- Equipment tag number
- Purchaser's purchase order number
- Type, size, design conditions, etc.
- Weight

6. Quality Assurance, Inspection and Testing**6.1 General**

Vendor is requested to submit an Inspection and Test Plan (ITP) for this equipment, based on Vendor's standard quality program. Purchaser shall be permitted to observe stages of construction and testing as will be specified in Purchaser mark-ups to Vendor supplied ITP.

Testing must conform to the Nexen specifications listed in this document. Purchaser mark-ups to Vendor ITP do not waive Vendor responsibility for compliance.



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Vendor is responsible for ensuring that:

- Each component conforms to specified dimensional, materials, and functional requirements.
- Certification and labelling is as specified.
- Verifications of quality, performed during fabrication, are traceable to the item verified after fabrication.

6.2 Non Destructive Evaluation (NDE) & Factory Testing

All NDE within the package shall be in accordance with Nexen Std. GS-120-06 & 06A and 06B, Non-Destructive Examination.

Equipment testing must meet industry standards.

All welds transmitting loads from the lifting lugs to the skid or equipment shall be 100% tested by magnetic particle examination. Additionally, full penetration welds associated with lifting lugs shall be 100% tested by ultrasonic examination.

This responsibility also applies to components purchased by Vendor, and provided as part of the item delivered to Purchaser. Under this Specification, Vendor shall incorporate all pertinent quality requirements and provision (for right of inspection and surveillance by the Purchaser) into this Sub-Vendor contracts and procurements.

6.3 Welding

All welding of process piping within the package shall be in accordance with Nexen Std. GS-120-05 & 05A, Welding.

Vendor shall submit proposed connection designs to Purchaser for review prior to fabrication.

7. Preparation for Shipment

7.1 Shipping/Storage

Vendor shall prepare all components for shipment and storage to the destination. Vendor shall be responsible for loading and anchoring all components to prevent damage during shipment. Vendor's preparation for shipment shall include the following:

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- Short term preservation
- All construction debris shall be removed from internal and external surfaces.
- Equipment shall be thoroughly washed and internal surfaces flushed.
- Equipment and piping shall be dried of water before installation of shipping protection.
- All unpainted equipment parts shall be thoroughly cleaned of rust and mill scale and coated with light oil or other form of rust preventative.
- All exposed connections shall be protected. Flanges shall be covered with a minimum of 20 mm (3/4") thick plywood or a preformed plastic cover. Threaded and tube joints shall be plugged or wrapped and weld joints shall be wrapped.
- Delicate parts and accessories supplied with the equipment shall be packaged separately. A detailed ship loose list shall be supplied prior to final skid inspection. All parts and accessories being shipped separately shall be tagged, crated and clearly labelled with the equipment number.
- All heaters shall be test fitted then removed and shipped loose with the package.
- Sharp corners and small protuberances shall be protected against being knocked off during transport, loading and unloading.
- In general, equipment shall be protected against vibration during transportation as well as shocks encountered during loading and unloading.

7.2**Release for Shipment**

Prior to shipment, Purchaser's representative shall verify all shipping preparations and document completeness. Purchaser will arrange for pick up and transportation to site.

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8. Documentation Requirements

8.1 General

Any exceptions to the VDR provided with the requisition or the requirements listed below not clearly identified in Vendor quotation will be considered accepted.

8.2 Pre-Fabrication

In addition to the requirements outlined in the VDR, Vendor shall provide the following information for approval prior to fabrication:

- Start-up and 2 year operating spares and special tools required
- Approximate package dimensions, weight and layout (with bid)
- Bill of materials including all instruments
- All Vendor drawings
- Welding procedures

8.3 Post-Fabrication

Vendor shall supply three (3) copies of the package databook. One must ship with the skid. One will be supplied to Nexen at their Fort Nelson location. The final book will be provided for Nexen records in Calgary. Each copy of Vendor databook shall contain an electronic copy, CD format, containing the detailed bill of materials, government and other applicable forms, drawings, and start-up procedures.

In addition to the requirements outlined in the VDR, the final databook shall contain:

- Vendor completed instrument data sheets (template supplied by Tri Ocean)
- Start-up, setup and commissioning procedures
- Certified copies of all test data
- Mill test certificates
- Government forms
- AutoCAD files



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