

FORM U-1A MANUFACTURER'S DATA REPORT FOR PRESSURE VESSELS

Alternative Form for Single Chamber, Completely Shop-Fabricated Vessels  
Required by the Provisions of the ASME Code Rules, Section VIII, Division 1

(A) 2897367

Job # 21-6390

Dec 8/93

1. Manufactured & Certified by: Western Rock Bit Company Limited, 1026 Western Drive, Crossfield, Alberta, Canada. T0M 0S0  
(Name & Address of Manufacturer)

2. Manufactured for: Chancellor Energy Resources Inc. 950, 333-5th Ave S.W., Calgary, Alta. T2P 3B6  
(Name & Address of Purchaser)

3. Location of Installation: Stewart Lake Gas Plant LSD 1-23-32-28 W4th M.  
(Name & Address)

4. Type: Horizontal Tank 31003 A F7803.24 9210-2D N/A 1993  
(Horiz. or Vert Tank) (Mfr's Serial No.) (CRN) (Drawing No.) (Natl Bd No.) (Year Built)

5. The Chemical and physical properties of all parts meet the requirements of material specifications of the ASME BOILER AND PRESSURE VESSEL CODE. The design, construction, and workmanship conform to ASME Rules, Section VIII, Division 1 1992  
Year

to 1992 N/A N/A  
Addenda(Date) Code Case Nos. Special Service per UG-120(d)

6. Shell: SA 516-70 .7781" (19.8 mm) Nil 9' 0" (2743 mm) 49' 8.25" (15145 mm)  
Mat'l (Spec No. Grade) Norm Thk (in.) Cor.Allow (in.) Diam I.D. (ft & in.) Length (overall) (ft & in.)

7. Seams: Welded, Dbl. Butt Full 100% N/A N/A Welded, Dbl. Butt Spot (uw1a, 5b) 5  
Long (Welded, Dbl., Sngl. Lap, Butt) R.T. (Spot/Full) Eff. (%) H.T. Temp. (°F) Time (hr) Girth (Welded, Dbl., Sngl. Lap, Butt) R.T. (Spot, Partial, or Full) No. of Courses

8. Heads: (a) Mat'l. SA 516-70 (b) Mat'l. \_\_\_\_\_  
(Spec No., Grade) (Spec No. Grade)

Location (Top, Bottom, Ends)	Minimum Thickness	Corrosion Allowance	Crown Radius	Knuckle Radius	Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure (Convex or Concave)
a) Ends	.7725" (19.62mm)	Nil			2:1 S.E.				Concave
b)									

If Removable, Bolts used (Describe other fastenings) \_\_\_\_\_

9. MAWP 250 Psi (1724 Kpa) psi at max. temp. 115°F (46°C)  
Min. design metal temp. -20°F (-29°C) at 250 Psi (1724 Kpa) Hydro. pneu., or comb. test pressure 375 Psi (2586 Kpa) Hydrostatic

10. Nozzles, inspection and safety valve openings:

Purpose (Inlet, Outlet, Drain)	No.	Diam. or Size	Type	Mat'l	Nom Thk.	Reinforcement Mat'l	How Attached	Location
Manway	1	18 NPS	RFWN	SA106B/SA105	.500" (12.7mm)	SA516-70	Welded	Shell
Liquid In	1	3 NPS	RFWN	SA106B/SA105	.300" (7.62mm)	SA516-70	Welded	
Liquid Out	1	4 NPS	RFWN	SA106B/SA105	.337" (8.56mm)	SA516-70	Welded	
Continued on U-4	form							

11. Supports: Skirt No Lugs None Legs None Other Saddles (2) \_\_\_\_\_ Attached Shell - Welded  
(Yes or No) (No) (No) (Describe) (Where & How)

12. Remarks: Manufacturer's Partial Reports properly identified and signed by Commissioned Inspectors have been furnished for the following items of the report:  
(Name of Part, item number, Mfr's name & identifying stamp)  
25,300 USWG (95.5m<sup>3</sup>) LPG Storage. Impact testing exempt per UG 20 (f).  
Surface Area = 1645 sq.ft. (152.8m<sup>2</sup>)  
Heads form to UCS 79. Manufactured to Dwg. No. 9311-11D

CERTIFICATE OF SHOP COMPLIANCE

We certify that the statements made in this report are correct and that all details of design, material, construction, and workmanship of this vessel conform to the ASME Code for Pressure Vessels, Section VIII, Division 1, "U" Certificate of authorization No. 13-551 expires July 19th, 1995  
Date: 93/12/67 Co. Name: Western Rock Bit Co. Ltd. Signed: [Signature]  
(Manufacturer) (Representative)

CERTIFICATE OF SHOP INSPECTION

Vessel constructed by Western Rock Bit Co. Ltd. at 1026 Western Drive, Crossfield, Alberta.  
I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State or Province of Alberta and employed by Alberta Labour - Boiler and Pressure Vessel Safety. have inspected the component described in this Manufacturer's Data Report on Dec 8, 19 93 and state that, to the best of my knowledge and belief, the Manufacturer has constructed this pressure vessel in accordance with ASME Code, Section VIII, Division 1. By signing this certificate neither the Inspector nor his employer makes any warranty, expressed or implied, concerning the pressure vessel described in this Manufacturer's Data Report. Furthermore, neither the Inspector nor his employer shall be liable in any manner for any personal injury or property damage or a loss of any kind arising from or connected with this inspection.  
Date: Dec 8/93 Signed: [Signature] Commissions: ALTA #58  
(Authorized Inspector) (Natl Bd (incl. endorsements), State, Prov & No.)

**FORM U-4 MANUFACTURER'S DATA REPORT SUPPLEMENTARY SHEET**  
**As Required by the Provisions of the ASME Code Rules, Section VIII, Division 1**

Ⓐ 2897367  
 Job # 21-6390

1. Manufactured & Certified by Western Rock Bit Company Limited, 1026 Western Drive, Crossfield, AB, Canada T0M 0S0  
(Name & Address of Manufacturer)
2. Manufactured for Chancellor Energy Resources Inc., 950, 333-5th Ave S.W., Calgary, Alta. T2P 3B6  
(Name & Address of Purchaser)
3. Location of Installation Stewart Lake Gas Plant L.S.D. 1-23-32-28 West 4th M.  
(Name & Address)
4. Type Horizontal Tank 31003 A  
(Horiz., vert. or sphere) (Tank, Separator, Heat exch., etc) (Mfg's Serial No)
- F7803.24 9210-2D N/A 1993  
(CRN) (Drawing No) (Nat'l. Bd. No) (Year Built)

Purpose	No	Diam.	Type	Mat'l.	Nom Thk.	Rein Mat'l.	How Attached	Location
Blowdown	1	2 NPS	RFWN	SA106B/SA105	.218"(5.54mm)		Welded	
Vapour	1	3 NPS	RFWN	SA106B/SA105	.300"(7.62mm)	SA516-70	Welded	
Bypass	1	3 NPS	RFWN	SA106B/SA105	.300"(7.62mm)	SA516-70	Welded	
Relief	1	4 NPS	RFWN	SA160B/SA105	.337"(8.56mm)	SA516-70	Welded	
Bridle	2	2 NPS	RFWN	SA106B/SA105	.218"(5.54mm)		Welded	
Drain	1	2 NPS	RFWN	SA106B/SA105	.218"(5.54mm)		Welded	
Float Gauge	1	8 Hole	Float Gauge	Adaptor SA181			Welded	
P.I.	1	3/4 NPT	F.Cplg	SA105	6000#		Welded	
T.I.	1	1/2 NPT	FNPT	SA106B	.154"(3.91mm)		Welded	

Certificate of Authorization: Type U No. 13-551 Expires July 19 th, 19 95

Date 9/12/07 Co. Name Western Rock Bit Co. Ltd. Signed [Signature]  
(Manufacturer) (Representative)

Date Dec 8 / 93 Signed [Signature] Commissions ALTA #58.  
(Authorized Inspector) (Nat'l. Bd (incl. Endorsements, State, Prov. & No.))