

COIL

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CORAL
OILFIELD SERVICES

(780) 402-9800
www.coraloilfield.com

MAWP 150 PSI AT 350 °F

MAEWP 125 PSI AT 350 °F

MDMT 50 °F AT 150 PSI

SERIAL NO. 4645-01 YEAR BUILT 2018

CRN V9366.213

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MAWP 125 PSI AT 300 °F

MAEWP — PSI AT — °F

MDMT 50 °F AT 125 PSI

SERIAL NO. 4645-1 YEAR BUILT 2015

CRN V9366.213

①681000

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

A#
4645-01
S/N#

As Required by the Provisions of the ASME Boiler and Pressure Vessel Code Rules, Section VIII, Division 1

1. Manufactured and certified by Coral Oilfield Services Inc., 15303-94st, Grande Prairie, Alberta, T8X 0L2, CANADA
(Name and address of Manufacturer)

2. Manufactured for Haltec Testing Inc, Box 92, Baytree, Alberta, T0H 0A0, CANADA
(Name and address of Purchaser)

3. Location of installation Baytree, Portable
(Name and address)

4. Type Horizontal Separator 4645-01
(Horizontal, vertical, or sphere) (Tank, separator, jkt. vessel, heat exch., etc.) (Manufacturer's serial number)

V9366.213 3968-Rev.3 90 2018
(CRN) (Drawing number) (National Board number) (Year built)

5. ASME Code, Section VIII, Div. 1 2017/ N/A N/A N/A
[Edition and Addenda, if applicable (date)] [Code Case Number] [Special Service per UG-120(d)]

Items 6-11 incl. to be completed for single wall vessels, jackets of jacketed vessels, shell of heat exchangers, or chamber of multichamber vessels.

6. Shell: (a) Number of course(s) 3 (b) Overall length 30' 0.0"

Course(s)			Material	Thickness		Long. Joint (Cat. A)			Circum. Joint (Cat. A, B, & C)			Heat Treatment	
No.	Diameter	Length	Spec./Grade or Type	Nom.	Corr.	Type	Full, Spot, None	Eff.	Type	Full, Spot, None	Eff.	Temp.	Time
1	108.0" ID	10' 0"	SA-516-70N	0.5	0.125	TYPE 1	FULL	1.00	TYPE 1	FULL	1.0	1125°	60 MINS
1	108.0" ID	10' 0"	SA-516-70N	0.5	0.125	TYPE 1	FULL	1.00	TYPE 1	FULL	1.0	1125°	60 MINS
1	108.0" ID	10' 0"	SA-516-70N	0.5	0.125	TYPE 1	FULL	1.00	TYPE 1	FULL	1.0	1125°	60 MINS

Body Flanges on Shells													
No.	Type	ID	OD	Flange Thk	Min Hub Thk	Material	How Attached	Location	Bolting				
									Num & Size	Bolting Material	Washer (OD, ID, thk)	Washer Material	
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A

7. Heads: (a) SA-516-70N (1125F for 1hr) (Material spec. number, grade or type) (H.T. - time and temp.)
(b) SA-516-70N (1125F for 1hr) (Material spec. number, grade or type) (H.T. - time and temp.)

	Location (Top, Bottom, Ends)	Thickness		Radius		Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure		Category A		
		Min.	Corr.	Crown	Knuckle					Convex	Concave	Type	Full, Spot, None	Eff.
(a)	END	0.625	0.125	N/A	N/A	2:1	N/A	N/A	N/A		X	N/A	N/A	N/A
(b)	END	0.625	0.125	N/A	N/A	2:1	N/A	N/A	N/A		X	N/A	N/A	N/A

Body Flanges on Heads													
	Location	Type	ID	OD	Flange Thk	Min Hub Thk	Material	How Attached	Bolting				
									Num & Size	Bolting Material	Washer (OD, ID, thk)	Washer Material	
(a)	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A

8. Type of jacket N/A Jacket closure N/A
(Describe as ogee & weld, bar, etc.)
If bar, give dimensions; if bolted, describe or sketch N/A

9. MAWP 125 psi N/A at max. temp. 300 °F N/A Min. design metal temp. -50 °F at 125 psi
(Internal) (External) (Internal) (External)

10. Impact test N/A at test temperature of N/A
(Indicate yes or no and the component(s) impact tested)

11. Hydro., pneu., or comb. test pressure HYDRO at 163 psi Proof test N/A

Items 12 and 13 to be completed for tube sections.

12. Tubesheet N/A N/A N/A N/A N/A
[Stationary (material spec. no.)] [Diameter (subject to press.)] (Nominal thickness) (Corr. allow.) Attachment (welded or bolted)

N/A N/A N/A N/A N/A
[Floating (material spec. no.)] (Diameter) (Nominal thickness) (Corr. allow.) (Attachment)

13. Tubes N/A N/A N/A N/A N/A
(Material spec. no., grade or type) (O. D.) (Nominal thickness) (Number) (Type (Straight or U))

(A) 681000

Manufactured by **Coral Oilfield Services Inc., 15303-94st, Grande Prairie, Alberta, T8X 0L2, CANADA**
 Manufacturer's Serial No. **4645-01** CRN **V9366.213** National Board No. **90**

ns 14-18 incl. to be completed for inner chambers of jacketed vessels or channels of heat exchangers.
 14. Srieil: (a) No. of course(s) **11** (b) Overall length **44' 5.0"**

Course(s)			Material	Thickness		Long. Joint (Cat. A)			Circum. Joint (Cat. A, B, & C)			Heat Treatment	
No.	Diameter	Length	Spec./Grade or Type	Nom.	Corr.	Type	Full, Spot, None	Eff.	Type	Full, Spot, None	Eff.	Temp.	Time
8	2.375" OD	7' 5"	SA-106-B	0.218	0.0625	SMLS	NONE	0.85	TYPE 7	NONE	0	N/A	N/A
2	2.375" OD	1' 0"	SA-106-B	0.218	0.0625	SMLS	NONE	0.85	TYPE 7	NONE	0	N/A	N/A
1	2.375" OD	2' 6"	SA-106-B	0.218	0.0625	SMLS	NONE	0.85	TYPE 3	NONE	0.6	N/A	N/A

Body Flanges on Shells													
No.	Type	ID	OD	Flange Thk	Min Hub Thk	Material	How Attached	Location	Bolting				
									Num & Size	Bolting Material	Washer (OD, ID, thk)	Washer Material	
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A

15. Heads: (a) **N/A** (Material spec. number, grade or type) (H.T. - time and temp.) (b) **N/A** (Material spec. number, grade or type) (H.T. - time and temp.)

Location (Top, Bottom, Ends)	Thickness		Radius		Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure		Category A			
	Min.	Corr.	Crown	Knuckle					Convex	Concave	Type	Full, Spot, None	Eff.	
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A

Body Flanges on Heads													
Location	Type	ID	OD	Flange Thk	Min Hub Thk	Material	How Attached	Bolting					
								Num & Size	Bolting Material	Washer (OD, ID, thk)	Washer Material		
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A

16. MAWP **150 psi** (Internal) **125 psi** (External) at max. temp. **350 °F** (Internal) **350 °F** (External) Min. design metal temp. **-50 °F** at **150 psi**

17. Ict test **N/A** at test temperature of **N/A**
 [Indicate yes or no and the component(s) impact tested]

18. Hydro., pneu., or comb. test pressure **Hydro. at 195 psi** Proof test **N/A**

19. Nozzles, inspection, and safety valve openings:

Purpose (Inlet, Outlet, Drain, etc.)	No.	Diameter or Size	Type	Material		Nozzle Thickness		Reinforcement Material	Attachment Details		Location (Insp. Open.)
				Nozzle	Flange	Nom.	Corr.		Nozzle	Flange	
MANWAY	2	20 NPS	RFWN	SA-106-B	SA-105N	0.375	0.125	SA-516-70N	UW16.1(D)	TYPE 1	SHELL
INLET/OUTLET/DRAIN	5	4 NPS	RFWN	SA-106-B	SA-105N	0.674	0.125		UW16.1(D)	TYPE 1	SHELL
PSV/WATER/OIL	4	3 NPS	RFWN	SA-106-B	SA-105N	0.600	0.125		UW16.1(D)	TYPE 1	SHELL/HEAD
SPARGE/ HEATER COIL	8	2 NPS	RFWN	SA-333-6	SA-105N	0.436	0.125		UW16.1(D)	TYPE 1	HEAD
LEVEL GAUGES / PI	12	1 NPS	RFWN	SA-333-6	SA-105N	0.358	0.125		UW16.1(D)	TYPE 1	HEAD

20. Supports: Skirt **NO** Lugs **2** Legs **NO** Others **SADDLES** Attached **SHELL, WELDED**
 (Yes or no) (Number) (Number) (Describe) (Where and how)

21. Manufacturer's Partial Data Reports properly identified and signed by Commissioned Inspectors have been furnished for the following items of the report (list the name of part, item number, Manufacturer's name, and identifying number):

N/A

22. Remarks
-impact tests exempt as per UCS 66a and UCS 66b
-vessel capacity 2122FT3 (60m3)
-construction DWG. No. 3968-01 Rev.6
-2 Manway blinds 20" class 150 SA-105N
-all nozzles class 150
-1 1/8" x 6 1/4" studs Gr.SA193-B7M, 1 1/8" nuts Gr.SA-194-2HM used on Manway M1 & M2
-coil flanges 2 NPS class 150 RFSO SA-105N
- coil elbows 2 NPS SCH XH SA-234-WPB

Manufactured by **Coral Oilfield Services Inc., 15303-94st, Grande Prairie, Alberta, T8X 0L2, CANADA**
 Manufacturer's Serial No. 4645-01 CRN V9366.213 National Board No. 90

CERTIFICATE OF SHOP COMPLIANCE

We certify that the statements in this report are correct and that all details of design, material, construction, and workmanship of this vessel conform to the ASME BOILER AND PRESSURE VESSEL CODE, Section VIII, Division 1. U Certificate of Authorization Number **45860** Expires **September 17, 2019**

Date 06/29/2018 Name Coral Oilfield Services Inc. Signed [Signature]
 (Manufacturer) (Representative)

CERTIFICATE OF SHOP INSPECTION

I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and employed by **Alberta Boilers Safety Association (ABSA), of Edmonton, AB**

have inspected the pressure vessel described in this Manufacturer's Data Report on June 22, 2018, and state that,

to the best of my knowledge and belief, the Manufacturer has constructed this pressure vessel in accordance with ASME BOILER AND PRESSURE VESSEL CODE, Section VIII, Division 1. By signing this certificate neither the Inspector nor his/her employer makes any warranty, expressed or implied, concerning the pressure vessel described in this Manufacturer's Data Report. Furthermore, neither the Inspector nor his/her 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.

NB15266 D00007597

Date 06/29/2018 Signed [Signature] Commissions: 15266, AB439-A
 (Authorized Inspector) (National Board Authorized Inspector Commission number)

CERTIFICATE OF FIELD ASSEMBLY COMPLIANCE

We certify that the statements made in this report are correct and that the field assembly construction of all parts of this vessel conforms with the requirements of ASME BOILER AND PRESSURE VESSEL CODE, Section VIII, Division 1. U Certificate of Authorization Number _____ Expires _____

Date _____ Name _____ Signed _____
 (Assembler) (Representative)

CERTIFICATE OF FIELD ASSEMBLY INSPECTION

I, the undersigned, holding a valid commission issued by The National Board of Boiler and Pressure Vessel Inspectors and employed by _____

have compared the statements in this Manufacturer's Data Report with the described pressure vessel and state that parts referred to as data items _____, not included in the certificate of shop inspection, have been inspected by me and to the best of my knowledge and belief, the Manufacturer has constructed and assembled this pressure vessel in accordance with the ASME BOILER AND PRESSURE VESSEL CODE, Section VIII, Division 1. The described vessel was inspected and subjected to a pressure test of _____. By signing this certificate neither the Inspector nor his/her employer makes any warranty, expressed or implied, concerning the pressure vessel described in this Manufacturer's Data Report. Furthermore, neither the Inspector nor his/her 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 _____ Signed _____ Commission _____
 (Authorized Inspector) (National Board Authorized Inspector Commission number)