



# 1.1-FRM-001VS Visual External Inspection Report

Report #:	PSV Service Report Avail. <input checked="" type="checkbox"/> Y <input type="checkbox"/> N MDR Avail. <input checked="" type="checkbox"/> Y <input type="checkbox"/> N UT Verified <input checked="" type="checkbox"/> Y <input type="checkbox"/> N	<input checked="" type="checkbox"/> Installation <input checked="" type="checkbox"/> External <input checked="" type="checkbox"/> Internal
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Date:	2022-08-11	WO #:	1001-T1	Proc. Used:	Cat 1 - Unfired Separator	Rec. Insp. Interval:	3
Inspected By:	Dwight Colp ISI-PVPP Cert# 000692, API 510 #43558, API 570 #45288			Radiography:	1		
Client:	Tara Energy			Heat Treatment:	Yes		
Coordinator:	Jeff Warr			National Board Number:	59		
Region:	NE B.C, Alberta	Area:	North Peace	Notes: Vessel Capacity 2122FT3 (60M3)			
Facility:	Portable						
Location, LSD	Portable						
Description:	<input checked="" type="checkbox"/> Vessel <input type="checkbox"/> Exchanger <input type="checkbox"/> Tank <input type="checkbox"/> Heater						
Service Fluid:	<input type="checkbox"/> Sweet <input checked="" type="checkbox"/> Sour Fluid Name: Well Emulsion						
Unit Name / #:	ST-06	Equip#:	ST-06				
Equip. Name:	Horizontal Separator						
Jurisdiction #:	0669163	CRN:	V9366.213				
Manufacturer:	Coral Oilfield Services Inc.						
Year Built:	2017	S/N:	4570-01				

Components:	Diameter	Length	Material	Nominal t	CA	Comment
Shell:	108"	30'	SA516-70N	0.5"	0.125"	
Head:	108"	2:1	SA516-70N	0.5"	0.125"	
Channel:						
Tube:						
Other:						

**PSV Data:** PSV Capacity Verified:  Y  N Block Valve(s) Installed:  Yes  No Car-sealed Open:  Yes  No  N/A

Zones:	MDMT	Design T	MAWP	Set Press	Tag#	Model	Manf.	PSV CRN	Serial Number	In.	Out.	Capacity	Serv. Co.	Serv. Date
Shell Side:	50F	300F	125 PSI	125 PSI	ST-06	83J7811341-60-60-0	Taylor	0G01316.2C	037824-354	3"	3"	3226 SCFM	Kings Energy	2017-10-02
Tube Side:														
Other:														

**Orientation:**  Hor.  Ver. **Foundation:**  Concrete  Gravel  Timbers  Steel  Other: \_\_\_\_\_ Condition: Good

**Support:**

<input checked="" type="checkbox"/> Saddle:	<input checked="" type="checkbox"/> Seal-welded	<input checked="" type="checkbox"/> Free to move	Condition: Good
<input type="checkbox"/> Skirt:	<input type="checkbox"/> Free of debris	Comment:	Condition:
<input type="checkbox"/> Hangers:	<input type="checkbox"/> Secure	Comment:	Condition:
<input type="checkbox"/> Other (Specify):			Condition:

**Overall:** General Condition: Good  Dead Legs Exist Electrical Grounding:  None  Indirect  Direct  Secure

Ext. Surface:  Painted  Fire-proofed  Cladded  Insulated  Other: \_\_\_\_\_ Condition: Good

Ext. Fixtures:  Ladder  Platform(s)  Other (Specify): \_\_\_\_\_ Condition:

Int. Surface:  Coated  Weld Overlay  Cladded  Lined  Thermal Sprayed Condition:

Int. Fixtures:  Baffle  Vortex Breaker  Float  Weir  Impingement plate Condition: Good

**Nozzles:**  MW  Inspection port only MW Size: \_\_\_\_\_  Davit arm:  Greased  Double-nutted Condition: Good

Reinforcement pads used  Weep holes visible  No evidence of weeping Comment: Good

Piping:		Well-coated	Proper joints	Free of leaks	Proper supports	Fluid is identified	Flow dir. shown	Drains properly	Comments:
	<input checked="" type="checkbox"/> PSV piping:	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
<input checked="" type="checkbox"/> Inlet piping:	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
<input checked="" type="checkbox"/> Outlet piping:	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
<input checked="" type="checkbox"/> Drain piping:	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
<input checked="" type="checkbox"/> Instrument piping:	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	

**Valves:**

<input checked="" type="checkbox"/> Manual isolation valves:	<input checked="" type="checkbox"/> Free from leaks	Comment: No Concerns
<input checked="" type="checkbox"/> Automated control valves:	<input checked="" type="checkbox"/> Free from leaks	Comment: No Concerns
<input checked="" type="checkbox"/> Vents and/or drains:	<input checked="" type="checkbox"/> Properly plugged	Comment: No Concerns

**Gauges:**

<input checked="" type="checkbox"/> Pressure:	Range: 0 -	Reading:	Condition: Good
<input type="checkbox"/> Temperature:	Range:	Reading:	Condition:
<input checked="" type="checkbox"/> Sight Glass Level:		Reading: MT	Condition: Good

**Recommended Actions:**

- 
- 
- 

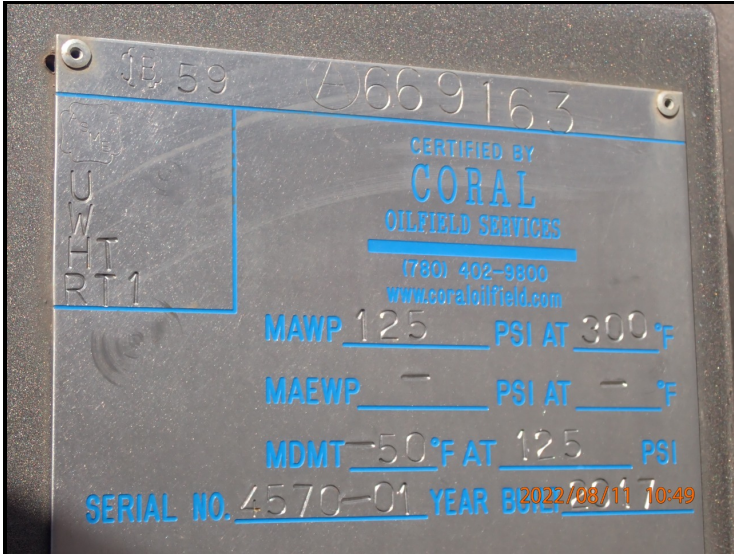
**Summary:** The vessel exterior and the associated piping are considered to be in Good condition.

Additional notes are attached:

Item  is suitable for service.  
 is NOT

Inspector's Signature: \_\_\_\_\_

PHOTOS



Vessel Nameplate



Vessel Overview



PSV Overview



PSV Service Tag



Inlet Piping



Gas Outlet Piping

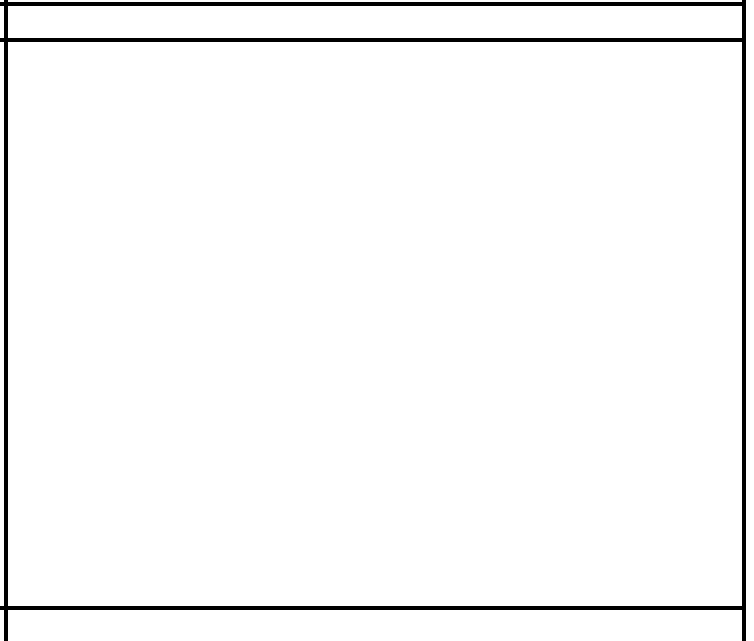
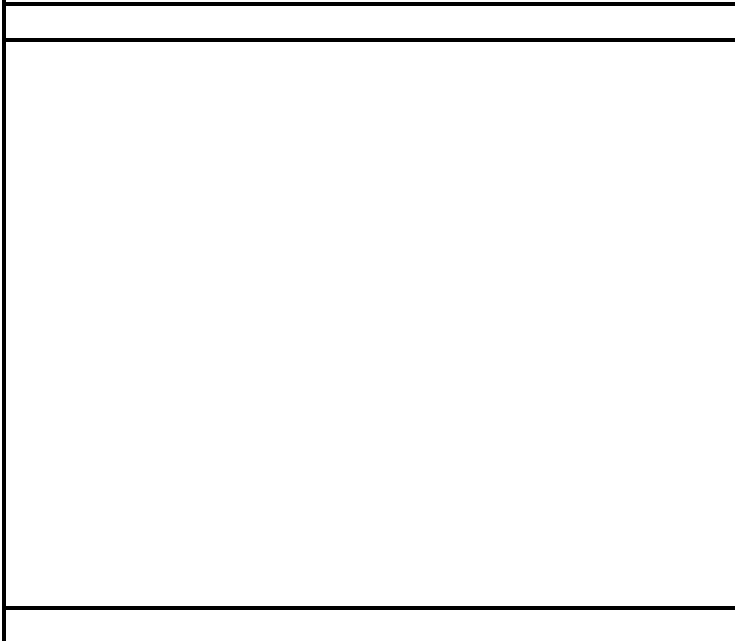
PHOTOS



Liquid Outlet Piping



Meter Run



Date:	2022-08-08	WO #:	1001-TI	Proc. Used:	Cat 1 - Unfired Separator
Inspected By:	Dwight Colp ISI-PVPP Cert# 000692, API 510 #43558, API 570 #4528			Notes:	
Client:	Tara Energy				
Coordinator:	Jeff Warr				
Region:	NE B.C, Alberta	Area:	North Peace		
Facility:	Portable				
Location, LSD	Portable				
Description:	<input checked="" type="checkbox"/> Vessel <input type="checkbox"/> Exchanger <input type="checkbox"/> Tank <input type="checkbox"/> Heater				
Service Fluid:	<input type="checkbox"/> Sweet <input checked="" type="checkbox"/> Sour Fluid Name: Emulsion				
Unit Name / #:	ST-06	Equip#:	ST-06		
Equip. Name:	Horizontal Separator ST-06				
Jurisdiction #:	669163	CRN:	V9366.213		
Manufacturer:	Coral Oilfield Services				
Year Built:	2017	S/N:	4570-01		
Scope:	A visual internal (VI) inspection was performed on all accessible shell and head surfaces, nozzles, welds, etc.				
Manway:	Gasket Surfaces:	<input checked="" type="checkbox"/> Compliant with code	Comment: No concerns		
	Manway Nozzle:	<input checked="" type="checkbox"/> No pitting, erosion, etc.	Comment: No concerns		
Shell and Head Surfaces:	<input type="checkbox"/> Coated	<input type="checkbox"/> Continuous and well-adhered	Comment:		
	Uniform Corrosion:	<input checked="" type="checkbox"/> Insignificant amount	Comment: No concerns		
	Pitting Corrosion:	<input checked="" type="checkbox"/> None noted	Comment: No concerns		
	Erosion:	<input checked="" type="checkbox"/> None noted	Comment: No concerns		
	Mechanical Damage:	<input checked="" type="checkbox"/> None noted	Comment: No concerns		
Welds:	Uniform Corrosion:	<input checked="" type="checkbox"/> Insignificant amount	Comment: No concerns		
	Pitting Corrosion:	<input checked="" type="checkbox"/> None noted	Comment: No concerns		
	Welding Defects:	<input checked="" type="checkbox"/> None noted	Comment: No concerns		
NDT:	<input checked="" type="checkbox"/> NDT was performed by: PIMS		Type: <input type="checkbox"/> MPI ( <input type="checkbox"/> WF <input type="checkbox"/> B&W <input type="checkbox"/> Dry) <input type="checkbox"/> LPI <input checked="" type="checkbox"/> UT <input type="checkbox"/> RT <input type="checkbox"/> Other: _____		
	Extent: Vessel and Piping				
	Results: No concerns				
Nozzles:	Obstructions:	<input checked="" type="checkbox"/> None noted	Comment: No concerns		
	Corrosion:	<input checked="" type="checkbox"/> None noted	Comment: No concerns		
	Erosion:	<input checked="" type="checkbox"/> None noted	Comment: No concerns		
Attachments:	<input type="checkbox"/> Vortex Breaker	<input type="checkbox"/> Secure <input type="checkbox"/> Good condition	Comment:		
	<input type="checkbox"/> Impingement Plate	<input type="checkbox"/> Secure <input type="checkbox"/> Good condition	Comment:		
	<input checked="" type="checkbox"/> Internal Piping	<input checked="" type="checkbox"/> Secure <input checked="" type="checkbox"/> Good condition	Comment: No concerns		
	<input checked="" type="checkbox"/> Demister	<input checked="" type="checkbox"/> Secure <input checked="" type="checkbox"/> Good condition	Comment: No concerns		
	<input type="checkbox"/> Heating Coil	<input type="checkbox"/> Secure <input type="checkbox"/> Good condition	Comment:		
	<input checked="" type="checkbox"/> Weir	<input checked="" type="checkbox"/> Secure <input checked="" type="checkbox"/> Good condition	Comment: No concerns		
	<input checked="" type="checkbox"/> Inlet Diffuser	<input checked="" type="checkbox"/> Secure <input checked="" type="checkbox"/> Good condition	Comment: No concerns		
	<input type="checkbox"/>	<input type="checkbox"/> Secure <input type="checkbox"/> Good condition	Comment:		
Notes:					
Recommended Actions:	1. No recommendations.				
	2.				
	3.				

Additional notes are attached:

Item  is suitable for service.  
 is **NOT**

Inspector's  
Signature: \_\_\_\_\_



PHOTOS



2022/08/11 10:57

Inlet Diffuser



2022/08/11 10:54

Typical Nozzle Condition



2022/08/11 10:54

Demister Pack



2022/08/11 10:55

General Shell Condition



2022/08/11 10:55

Wier to Shell Weld



2022/08/11 10:54

Clean End Floats and Nozzles

PHOTOS



Internal Piping

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

A#  
4570-01  
S/N#

(Alternative Form for Single Chamber, Completely Shop or Field Fabricated Vessels Only)  
As Required by the Provisions of the ASME Boiler and Pressure Vessel Code Rules, Section VIII, Division 1

669163

- Manufactured and certified by **Coral Oilfield Services Inc., 15303-94st, Grande Prairie, Alberta, T8X 0L2, CANADA**  
(Name and address of Manufacturer)
- Manufactured for **Haltec Testing Inc., Box 92, Baytree, Alberta, T0H0A0, Canada**  
(Name and address of Purchaser)
- Location of Installation **stock, Baytree, Alberta**  
(Name and address)
- Type **Horizontal Separator** **4570-01** **V9366.213** **3968 Rev.3** **59** **2017**  
(Horizontal or vertical, tank) (Manufacturer's serial number) (CRN) (Drawing number) (National Board number) (Year built)
- ASME Code, Section VIII, Division 1 **2015/ N/A** **N/A** **N/A**  
(Edition and Addenda, if applicable (date)) (Code Case numbers) (Special service per UG-120(d))
- Shell: **SA-516-70N** **0.5"** **0.125"** **108" (ID)** **30'**  
(Material spec. number, grade) (Nominal thickness) (Corr. allow.) (Inner diameter) (Length (overall))

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

- Seams: **Type 1** **Full** **1.00** **1125 °F** **1.0 Hour** **Type 1** **Full** **1.00** **3**  
(Long. (welded, dbl., sngl., lap, butt)) (R.T. (spot or full)) (Eff. %) (H.T. temp) (Time, hr) (Girth. (welded, dbl., sngl., lap, butt)) (R.T. (spot or full)) (Eff. %) (No. of courses)

- Heads: (a) Material **SA-516-70N** (b) Material **SA-516-70N**  
(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)	END	0.5"	0.125"	N/A	N/A	2:1	N/A	N/A	N/A	Concave
(b)	END	0.5"	0.125"	N/A	N/A	2:1	N/A	N/A	N/A	Concave

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

- Internal pressure **125 psi** at max. temp. **300 °F**  
(Internal) (External) (Internal) (External)  
Min. design metal temp. **-50 °F** at **125 psi** Hydro, pneu., or comb. test pressure **HYDRO at 163 psi**  
Proof test **N/A**

- 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	
Gas Inlet/Outlet	5	4"	RFWN	SA-106Gr.B	SA-105N	0.674"	0.125"	N/A	UW16.1(D)	Type 1	Shell
PSV, Water/Oil Outlet	4	3"	RFWN	SA-106Gr.B	SA-105N	0.600"	0.125"	N/A	UW16.1(D)	Type 1	Shell/Head
Sparge, Heater Coil	8	2"	RFWN	SA-106Gr.B	SA-105N	0.436"	0.125"	N/A	UW16.1(D)	Type 1	Head

Additional Nozzles - See Attached U-4...

- Supports: Skirt **No** Lugs **2** Legs **No** Other **Saddles (2)** Attached **Shell, Welded**  
(Yes or no) (Number) (Number) (Describe) (Where and how)

- Remarks: Manufacturer's Partial Data Reports properly identified and signed by Commissioned Inspectors, have been furnished for the following items of the report:  
**N/A**  
(Name of part, item number, Manufacturer's name and identifying stamp)

-Impact Test exempt SA105N and SA106-B exempt as per UCS 66 (b) (1) (b)  
-All other material are exempt per UCS-66a, UCS-67a(3) for the filler metal, and Fig UCS-66, Note C for stud and nuts  
-Heater coil: MAWP 150PSI @ 350F, MAEWP 125PSI, MDMT -50F @ 150PSI, C.A 1/16, 2" 150 RFSO SA-105n Flange  
2" NPS XH SA-106B Pipe  
-Vessel Capacity 2122FT3 (60M3)  
-Construction DWG NO. 3968-01 Rev.5  
-1 1/8" X 6 1/4" Studs SA-193-B7M c/w 2 Nuts Each SA194-2HM for both M1A M1B  
Additional Remarks - See Attached U-4...

4669163

FORM U-1A (Back)

NB Number 59

CERTIFICATE OF SHOP/FIELD 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 BOILER AND PRESSURE VESSEL CODE, Section VIII, Division 1. "U" Certificate of Authorization Number 45860 expires September 17, 2019

Date 09/25/2017 Co. name Coral Oilfield Services Inc. (Manufacturer) Signed [Signature] (Representative)

CERTIFICATE OF SHOP/FIELD INSPECTION

Vessel constructed by Coral Oilfield Services Inc. at 15303-94st, Grande Prairie, Alberta, T8X 0L2, CANADA 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 component described in this Manufacturer's Data Report on September 21, 2017, 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.

Date 09/25/2017 Signed [Signature] (Authorized Inspector) Commissions 15266, AB439-A [National Board (incl. endorsements)]



ST-06



# INSPECTION AND TEST REPORT

\*037824-354\*

Work to be performed in accordance with "QF9.51 PSV Production and Service Control Procedure Listing"

<b>Owner:</b>	TARA ENERGY SERVICES	<b>AFE:</b>	.	<b>Date:</b>	09/09/2022	<b>Job:</b>	111762
<b>Instructions:</b>	<input type="checkbox"/> Rental <input type="checkbox"/> Quote <input checked="" type="checkbox"/> Pretest <input checked="" type="checkbox"/> Repair <input type="checkbox"/> Test Only <input type="checkbox"/> New <input type="checkbox"/> Reset <input type="checkbox"/> B.E.R <input type="checkbox"/> VR Update	<b>Loc:</b>	STOCK TANK	<b>V-Ord:</b>	VORD-11567	<b>Plant \ Area:</b>	GRANDE PRAIRIE
<b>L.S.D.:</b>	NOT PROVIDED						
<b>Unit/Vessel:</b>	NOT PROVIDED						

<b>Valve Data:</b>	<b>Seal:</b>	Broken	<b>Style:</b>	FLG_Conv	<b>Inlet:</b>	RF	<b>Outlet:</b>	RF	
	<b>Seal ID:</b>		<b>Bonnet:</b>	Closed	<b>Inlet Size:</b>	3.00 inches	<b>Outlet Size:</b>	3.00 inches	
<b>Make:</b>	Taylor	<b>NamePlate:</b>	Orig/Dupl.	<b>Cap:</b>	Closed	<b>Inlet Rating:</b>	150#	<b>Outlet Rating:</b>	150#
<b>CRN:</b>	0G01316.2C	<b>Service:</b>	Sour	<b>Orifice:</b>	J	<b>Capacity:</b>	3226 SCFM	<b>Cold Diff Set:</b>	125 psig
<b>Asset No:</b>	95882	<b>Product:</b>	Gas	<b>Orifice Area:</b>	1.431 sq in.	<b>Code Stmp:</b>	NB/UV	<b>Set Press:</b>	125 psig
<b>Model No:</b>	83J5811341-60-60-0			<b>Serial No:</b>	037824-354	<b>Replacing:</b>			

<b>Pilot Data:</b>	<b>Model:</b>	<b>Serial No:</b>
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<b>Pretest Data:</b>	<b>Test Data:</b>	<b>Value:</b>	<b>Units:</b>	<b>Pretest Date:</b>	09/12/2022	
<b>Media:</b>	Air	<b>Test 1:</b>	130	psig	<b>Pretest By:</b>	Jacques Blackb
<b>Method:</b>	Bench	<b>Test 2:</b>	126	psig	<b>Notes1:</b>	Required
		<b>Test 3:</b>	0	psig	<b>Notes2:</b>	

<b>Disassembly:</b>	<b>Height:</b>	1.71 IN	<b>Guide Ring:</b>	<b>Nozzle Ring:</b>	<b>Dismantled Date:</b>	09/12/2022
					<b>Dismantled By:</b>	Jacques Black

<b>Inspection:</b>	<b>Crit Dim Data:</b>	<b>Minimum:</b>	<b>Actual:</b>	<b>Insp Tool Data:</b>	<b>Inspected Date:</b>	09/12/2022
<b>Seat Matl:</b>	Viton(FKM) 9	<b>Disc:</b>	SUB	<b>Insp Tool 1:</b>	<b>Inspected By:</b>	Jacques Blackb
<b>Replaced:</b>	N	<b>Disc Step:</b>		<b>Insp Tool 2:</b>		
<b>Converted:</b>	N	<b>Nozzle:</b>	SOFT	<b>Insp Tool 3:</b>		
<b>Inlet Cond:</b>	Rusty	<b>Nozzle Step 1:</b>		<b>Spring No:</b>	05-006710	
<b>Outlet Cond:</b>	Rusty	<b>Nozzle Step 2:</b>				

Component	Clean	Oily	Rusty	Carbon	Other	Action	Part Number
Gasket(s)	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	WORN	Replaced	K82J11
Other	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		Supply	FG3-150-316
Other	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		Supply	PV-SP
PCDF	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		Supply	PCDF
Poly Tag	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		Supply	107032

<b>Assembly:</b>	<b>Converted From:</b>	<b>Converted To:</b>	<b>Assemble Date:</b>	09/12/2022
	Replace Nameplate affixed & Original Lined out:	No	<b>Assembled By:</b>	Jim Alford

<b>Final Test:</b>	<b>Set Press:</b>	125 psig	<b>Gauge 1:</b>	KGP-1-10K	<b>Vacuum Set:</b>	<b>Test Date:</b>	09/12/2022
<b>Media:</b>	Air	<b>Back Press:</b>	0	<b>Gauge 2:</b>	KGP-2-10K	<b>Tested By:</b>	Casey OConne
<b>Method:</b>	Bench	<b>Cold Diff Set:</b>	125 psig	<b>BLD %:</b>		<b>Witness:</b>	js
<b>Simmer:</b>		<b>Act Test Press:</b>	125 psig	<b>Leakage:</b>	0 BPM	<b>Set Press Def:</b>	POP
<b>Re-Seal:</b>				<b>Leak Test Press:</b>	113 psig	<b>Back Pres Test:</b>	50 psig

<b>Final Insp:</b>	<b>Tag:</b>	<b>Painted:</b>	<b>Pallet:</b>	<b>Sealed:</b>	<b>End Protect:</b>	<b>Flex Gasket:</b>	<b>Inspected By:</b>	Josh Stark
	Yes	Yes	Yes	Yes	Yes	Yes	<b>Signed Off By:</b>	Josh Stark

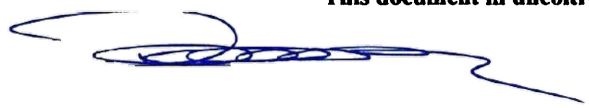
**Pre-Test Comments:** -

**Reset Comments:** PRETEST-REPAIR-PAINT RED

**Inspection Comments:** -

**Final Test Comments:** -

**Sign Off Comments:** PSV Service Report reviewed, Passed Pre-pop API 510 #43558, ABSA ISIPV-PP #000692







<b>Location Name:</b>	Grande Prairie AB	<b>LSD:</b>	Portable
<b>Jur #:</b>	0661163	<b>Equipment/Tag No.</b>	ST-06
<b>Equipment Description:</b>	Horizontal Separator		
<b>Manufacturer:</b>	Coral Oilfield Services Inc.		
<b>Serial Number:</b>	4570-01	<b>CRN:</b>	V9366.213
<b>Shell MAWP:</b>	125	PSI	<b>Shell Design Temp:</b> 300 °F
<b>Tube MAWP:</b>	-	PSI	<b>Tube Design Temp:</b> - °F
<b>Shell Material:</b>	SA516-70N	<b>Head Material:</b>	SA516-70N
<b>Shell Thickness:</b>	12.7	mm	<b>Head Thickness:</b> 12.7 mm
<b>Corrosion Allowance:</b>	3.2	mm	<b>Date Built:</b> 2017
<b>Size:</b>	108"	in	<b>Pipe / Rolled Plate:</b> Plate
<b>RT:</b>	Full	<b>Client DWG #:</b>	-

**Photos**



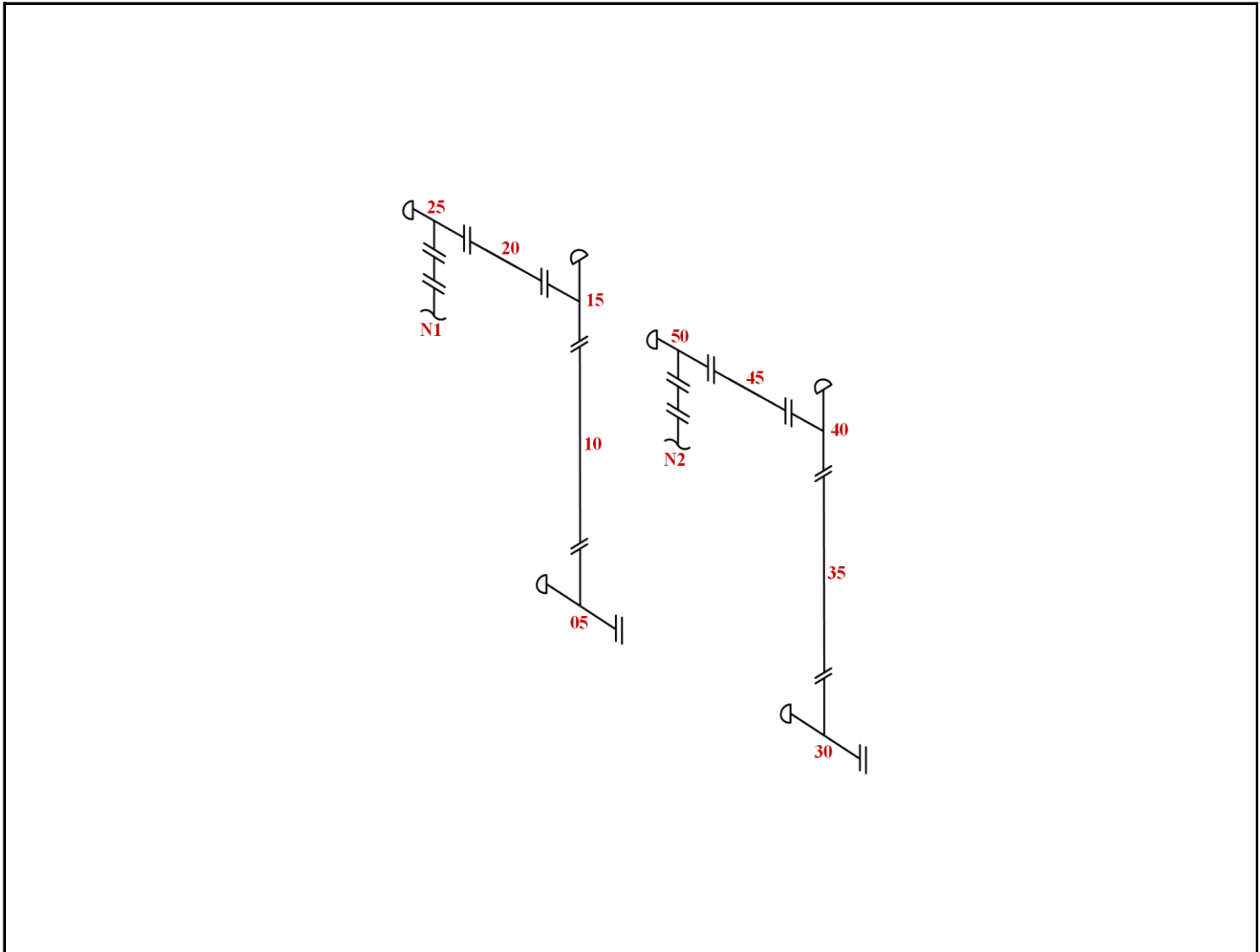
**View of Data Plate**



**Overall view of Equipment**

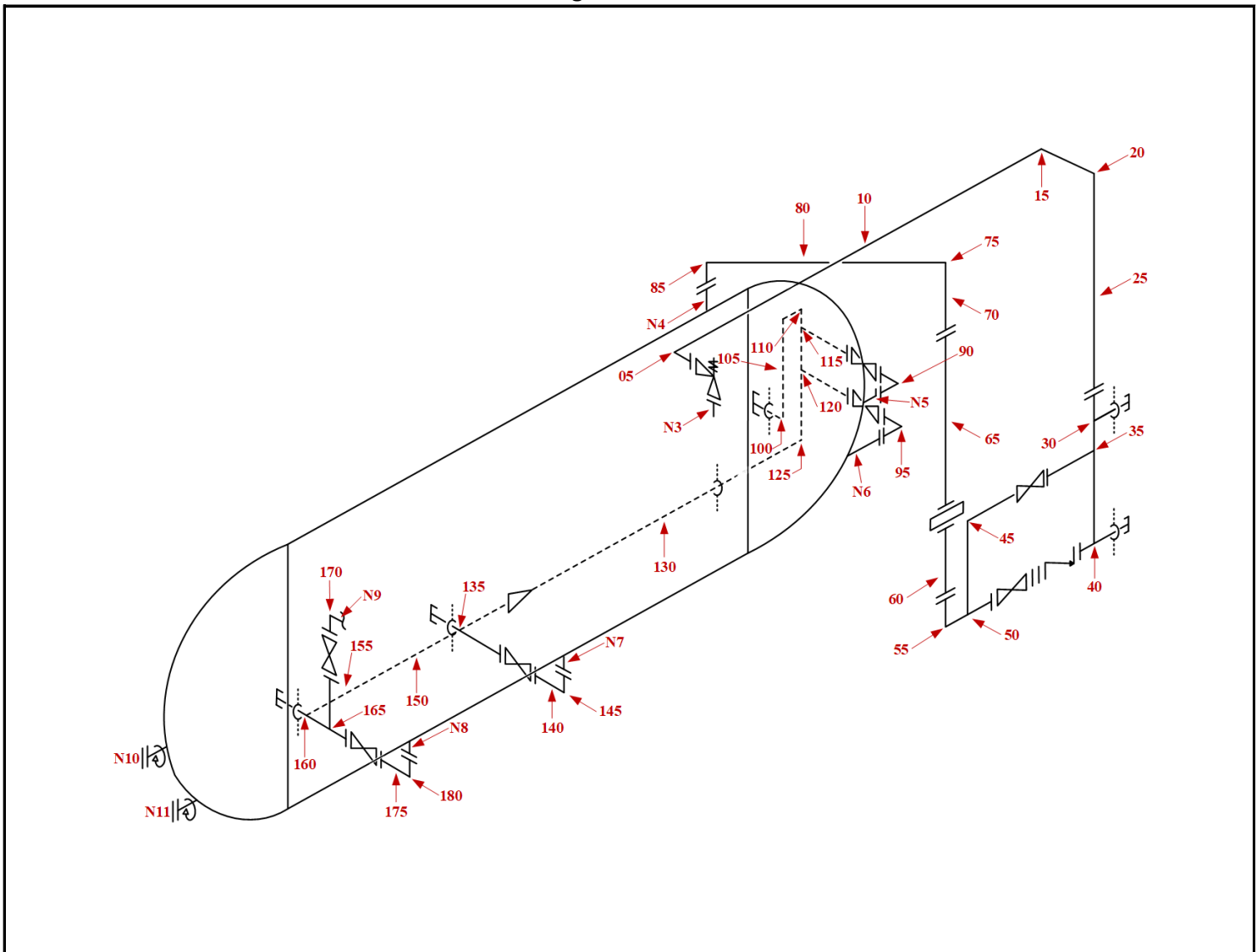
<b>Location Name:</b>	Grande Prairie AB	<b>LSD:</b>	Portable
<b>Jur #:</b>	0661163	<b>Equipment/Tag No.</b>	ST-06
<b>Equipment Description:</b>	Horizontal Separator		
<b>Manufacturer:</b>	Coral Oilfield Services Inc.		
<b>Serial Number:</b>	4570-01	<b>CRN:</b>	V9366.213
<b>Shell MAWP:</b>	125	PSI	<b>Shell Design Temp:</b> 300 °F
<b>Tube MAWP:</b>	-	PSI	<b>Tube Design Temp:</b> - °F
<b>Shell Material:</b>	SA516-70N	<b>Head Material:</b>	SA516-70N
<b>Shell Thickness:</b>	12.7	mm	<b>Head Thickness:</b> 12.7 mm
<b>Corrosion Allowance:</b>	3.2	mm	<b>Date Built:</b> 2017
<b>Size:</b>	108"	in	<b>Pipe / Rolled Plate:</b> Plate
<b>RT:</b>	Full	<b>Client DWG #:</b>	-

ISO Drawing of TML's - INLET LINE



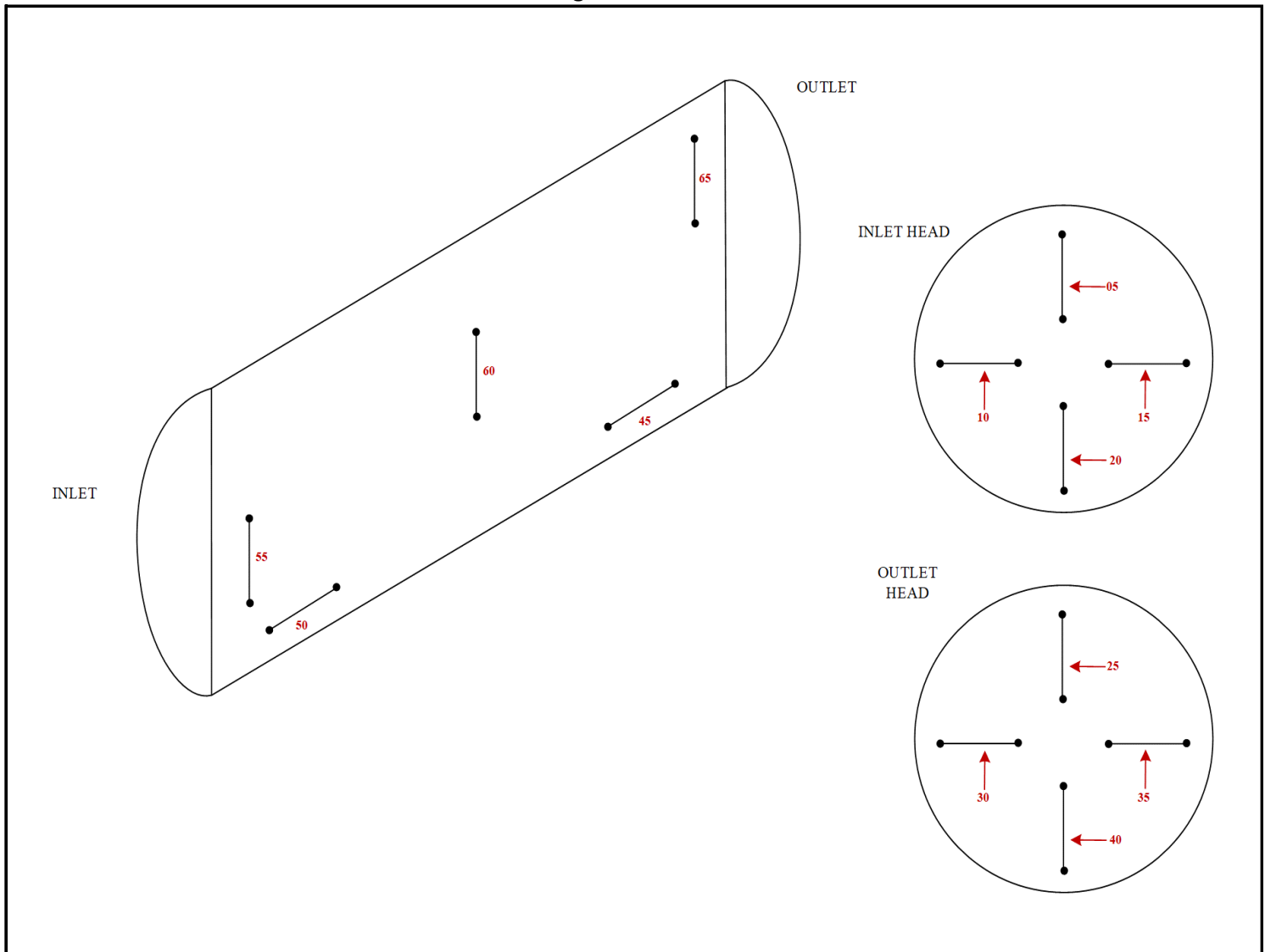
<b>Location Name:</b>	Grande Prairie AB	<b>LSD:</b>	Portable
<b>Jur #:</b>	0661163	<b>Equipment/Tag No.</b>	ST-06
<b>Equipment Description:</b>	Horizontal Separator		
<b>Manufacturer:</b>	Coral Oilfield Services Inc.		
<b>Serial Number:</b>	4570-01	<b>CRN:</b>	V9366.213
<b>Shell MAWP:</b>	125	PSI	<b>Shell Design Temp:</b> 300 °F
<b>Tube MAWP:</b>	-	PSI	<b>Tube Design Temp:</b> - °F
<b>Shell Material:</b>	SA516-70N	<b>Head Material:</b>	SA516-70N
<b>Shell Thickness:</b>	12.7	mm	<b>Head Thickness:</b> 12.7 mm
<b>Corrosion Allowance:</b>	3.2	mm	<b>Date Built:</b> 2017
<b>Size:</b>	108"	in	<b>Pipe / Rolled Plate:</b> Plate
<b>RT:</b>	Full	<b>Client DWG #:</b>	-

ISO Drawing of TML's - INLET LINE



<b>Location Name:</b>	Grande Prairie AB	<b>LSD:</b>	Portable
<b>Jur #:</b>	0661163	<b>Equipment/Tag No.</b>	ST-06
<b>Equipment Description:</b>	Horizontal Separator		
<b>Manufacturer:</b>	Coral Oilfield Services Inc.		
<b>Serial Number:</b>	4570-01	<b>CRN:</b>	V9366.213
<b>Shell MAWP:</b>	125	PSI	<b>Shell Design Temp:</b> 300 °F
<b>Tube MAWP:</b>	-	PSI	<b>Tube Design Temp:</b> - °F
<b>Shell Material:</b>	SA516-70N	<b>Head Material:</b>	SA516-70N
<b>Shell Thickness:</b>	12.7	mm	<b>Head Thickness:</b> 12.7 mm
<b>Corrosion Allowance:</b>	3.2	mm	<b>Date Built:</b> 2017
<b>Size:</b>	108"	in	<b>Pipe / Rolled Plate:</b> Plate
<b>RT:</b>	Full	<b>Client DWG #:</b>	-

ISO Drawing of TML's - FLUID LEGS



Client: Tara Energy Services Inc.

Date: 2022-08-10

Inspector: Jeremy Kerr

<b>Location Name:</b>	Grande Prairie AB		<b>LSD:</b>	Portable	
<b>Jur #:</b>	0661163		<b>Equipment/Tag No.</b>	ST-06	
<b>Equipment Description:</b>	Horizontal Separator				
<b>Manufacturer:</b>	Coral Oilfield Services Inc.				
<b>Serial Number:</b>	4570-01		<b>CRN:</b>	V9366.213	
<b>Shell MAWP:</b>	125	PSI	<b>Shell Design Temp:</b>	300	°F
<b>Tube MAWP:</b>	-	PSI	<b>Tube Design Temp:</b>	-	°F
<b>Shell Material:</b>	SA516-70N		<b>Head Material:</b>	SA516-70N	
<b>Shell Thickness:</b>	12.7	mm	<b>Head Thickness:</b>	12.7	mm
<b>Corrosion Allowance:</b>	3.2		<b>Date Built:</b>	2017	
<b>Size:</b>	108"	in	<b>Pipe/Rolled Plate:</b>	Plate	
<b>RT:</b>	Full		<b>Client DWG #:</b>	-	

TML#	Description	Shape	Size	Sch	Nom	Flag	2022-08-10		
							Min	Avg	
<b>NOZZELS</b>									
N1	Inlet Nozzel	Circ	4"	NS	17.12	14.98		17.05	17.46
N2	Inlet Nozzel	Circ	4"	NS	17.12	14.98		17.15	17.66
N3	PSV Nozzel	Circ	3"	NS	15.24	13.34		14.71	14.96
N4	Gas Out Nozzel	Circ	4"	NS	17.12	14.98		17.66	18.15
N5	Water/Oil Out Nozzel	Circ	3"	NS	15.24	13.34		16.70	17.20
N6	Water/Oil Out Nozzel	Circ	3"	NS	15.24	13.34		15.40	15.63
N7	Drain Nozzel	Circ	4"	NS	17.12	14.98		18.96	19.78
N8	Drain Nozzel	Circ	4"	NS	17.12	14.98		19.98	20.63
N9	Water/Oil Out Nozzel	Circ	3"	NS	15.24	13.34		14.56	15.21
N10	Sparge Nozzel	Circ	2"	NS	11.07	9.69		11.30	11.60
N11	Sparge Nozzel	Circ	2"	NS	11.07	9.69		11.07	11.37
<b>INLET</b>									
5	Pipe	C/S	4"	Sch160	13.49	11.80		12.73	15.14
10	Pipe	Pipe	4"	Sch160	13.49	11.80		13.35	13.87
15	Pipe	Tee Cap	4"	Sch160	13.49	11.80		13.25	15.15
20	Pipe	Pipe	4"	Sch160	13.49	11.80		12.81	13.13
25	Pipe	Tee Cap	4"	Sch160	13.49	11.80		12.92	14.08
30	Pipe	C/S	4"	Sch160	13.49	11.80		12.56	15.28
35	Pipe	Pipe	4"	Sch160	13.49	11.80		12.45	13.05
40	Pipe	Tee Cap	4"	Sch160	13.49	11.80		12.16	14.01
45	Pipe	Pipe	4"	Sch160	13.49	11.80		13.02	13.98
50	Pipe	Tee Cap	4"	Sch160	13.49	11.80		12.70	14.75
<b>VESSEL PIPING</b>									
5	Pipe	Elbow	3"	Sch40	5.50	4.80		5.59	6.17
10	Pipe	Pipe	3"	Sch40	5.50	4.80		5.25	5.49
15	Pipe	Elbow	3"	Sch40	5.50	4.80		5.73	6.06
20	Pipe	Elbow	3"	Sch40	5.50	4.80		5.73	5.87
25	Pipe	Pipe	3"	Sch40	5.50	4.80		5.63	5.83

30	Pipe	Tee Neck	3"	Sch40	5.50	4.80		6.02	7.73
35	Pipe	Tee Neck	3"	Sch80	7.62	6.67		7.12	9.20
40	Pipe	Tee Neck	4" x 3"	Sch80	8.56	7.49		8.23	9.82
45	Pipe	Elbow	3"	Sch80	7.62	6.67		7.96	8.18
50	Pipe	Tee Neck	4" x 3"	Sch80	8.56	7.49		8.33	10.80
55	Pipe	Elbow	4"	Sch80	8.56	7.49		8.58	8.83
60	Pipe	Pipe	4"	Sch80	8.56	7.49		8.36	8.45
65	Pipe	Pipe	4"	Sch80	8.56	7.49		8.31	8.66
70	Pipe	Pipe	4"	Sch80	8.56	7.49		8.60	9.05
75	Pipe	Elbow	4"	Sch80	8.56	7.49		8.16	8.28
80	Pipe	Pipe	4"	Sch80	8.56	7.49		8.63	9.06
85	Pipe	Elbow	4"	Sch80	8.56	7.49		8.82	9.19
90	Pipe	Elbow	3"	Sch80	7.62	6.67		7.77	7.95
95	Pipe	Elbow	3"	Sch80	7.62	6.67		7.63	7.92
100	Pipe	Elbow	3"	Sch80	7.62	6.67		7.67	8.03
105	Pipe	Pipe	3"	Sch80	7.62	6.67		7.13	7.30
110	Pipe	Elbow	3"	Sch80	7.62	6.67		7.48	7.62
115	Pipe	Tee Neck	3"	Sch80	7.62	6.67		6.63	9.03
120	Pipe	Tee Neck	3"	Sch80	7.62	6.67		7.50	9.76
125	Pipe	Elbow	3"	Sch80	7.62	6.67		7.50	7.72
130	Pipe	Pipe	3"	Sch80	7.62	6.67		7.43	7.88
135	Pipe	Cross	4"	Sch80	8.56	7.49		8.41	8.88
140	Pipe	Pipe	4"	Sch80	8.56	7.49		8.36	8.91
145	Pipe	Elbow	4"	Sch80	8.56	7.49		8.50	8.74
150	Pipe	Pipe	4"	Sch80	8.56	7.49		8.07	8.91
155	Pipe	Pipe	4"	Sch80	8.56	7.49		8.49	8.86
160	Pipe	Tee Neck	4"	Sch80	8.56	7.49		9.15	11.65
165	Pipe	Tee Neck	4" x 3"	Sch80	8.56	7.49		8.04	9.57
170	Pipe	Elbow	3"	XXS	15.24	13.34		15.08	15.26
175	Pipe	Pipe	4"	Sch80	8.56	7.49		8.30	8.81
180	Pipe	Elbow	4"	Sch80	8.56	7.49		8.17	8.68

**HEAD & SHELL**

5	Head	Ellipsodial	108"	NS	12.70	11.10		15.95	16.06
10	Head	Ellipsodial	108"	NS	12.70	11.10		16.08	17.06
15	Head	Ellipsodial	108"	NS	12.70	11.10		16.50	17.10
20	Head	Ellipsodial	108"	NS	12.70	11.10		15.94	16.44
25	Head	Ellipsodial	108"	NS	12.70	11.10		15.95	16.07
30	Head	Ellipsodial	108"	NS	12.70	11.10		15.61	16.32
35	Head	Ellipsodial	108"	NS	12.70	11.10		16.06	16.97
40	Head	Ellipsodial	108"	NS	12.70	11.10		12.90	12.96
45	Shell	Cylindrical	108"	NS	12.70	11.10		12.86	12.97
50	Shell	Cylindrical	108"	NS	12.70	11.10		12.73	12.82
55	Shell	Cylindrical	108"	NS	12.70	11.10		12.74	12.93
60	Shell	Cylindrical	108"	NS	12.70	11.10		13.00	13.08
65	Shell	Cylindrical	108"	NS	12.70	11.10		13.25	13.64

All flagged thicknesses were verified as above the minimum thickness required for pressures up to 125 PSI.

