

Ⓐ 492071

ALBERTA MUNICIPAL AFFAIRS
 Alberta Boilers Safety Association
 200, 4208 - 97 Street
 Edmonton, AB T6E 5Z9
 Partial/ Partiel

**MANUFACTURER'S DATA REPORT
 FOR PRESSURE VESSEL
 DÉCLARATION DE CONFORMITÉ DU CONSTRUCTEUR
 D'APPAREILS SOUS PRESSION**

Upon shipment of a pressure vessel, this form fully and correctly filled in must be mailed to the office of the Chief Inspector in the province of installation in accordance with the regulations under the Act governing the construction and installation of pressure vessels.

Au moment de l'expédition d'un appareil sous pression, ce formulaire complété correctement, doit être envoyé au bureau de l'inspecteur en chef de la province d'installation tel que prévu dans les règlements de la loi sur les appareils sous pression.

Manufactured by Construit par	Name and address of Manufacturer/ Nom et adresse du constructeur Dynacorp Fabricators Inc. 9815 - 48 St SE Calgary, T2C 2R2
Manufactured for Construit pour	Name and address of Purchaser or Consignee/ Nom et adresse du client ou de son représentant Dynacorp Fabricators Inc. 9815 - 48 St SE Calgary, T2C 2R2
Ultimate owner Utilisateur	Name and address/ Nom et adresse Haltech Testing Inc., Box 42, Baytree, Alberta, T0H 0A0
Location of installation Lieu d'installation	Address/ Adresse Portable

Pressure vessel/ Appareil

Type/ Genre Horizontal Vessel	Overall Length/Longueur totale 18' seam to seam	Serial No./ N° de série 2J3-168-1	Year built/Année de fabrication 2003
Provincial Registration No. - C.R.N./N° d'enregistrement provincial - N.E.C. P9840.21		National Board No./ N° National Board	Drawing No./ N° de dessin 5100-08-01 Rev 1A

The chemical and physical properties of all parts meet the requirements of material specifications of the A.S.M.E. Code.
 Les propriétés chimiques et physiques de toutes les composantes respectent les exigences des spécifications de matériaux de code ASME.

The design, construction and workmanship conform to CSA B51. La conception, la construction et la façon sont conformes à ACNOR B51.	ASME Section VIII	Division I	Addenda/Supplément 2002	Code case No. N° de cas
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Manufacturer's partial data reports properly identified and signed by authorized inspectors have been furnished for the following items of the report, and attached to this report:

rapports partiels du constructeur adéquatement identifiés et signés par les inspecteurs autorisés ont été produits pour les items suivants du rapport, et attachés à ce rapport:

Names of parts/ Nom de la composante	Item No./ N° d'item	Manufacturer's Name/ Nom du constructeur	Identifying Stamp/ Estampe d'identification

Shell/ Virole

Description	Material Matériau	Thickness Épaisseur	Corr. Allow. Surépais. de corr.	Diameter Diamètre	Longitudinal Joints Joints longitudinaux			P.W.H.T. Traitement therm		Girth Joints Joints de circonférence		Number of courses Nombre de sections
					Type	R.T. Radiog.	Efficiency Efficacité	Temp.	Time Durée	Type	R.T. Radiog.	
Rolled Plate	SA-516 70N	0.625"	0.0625"	78" OD	1	RT1	100%	1150F	60 min	1	RT-1	2

Heads/ Tetes

Description	Material Matériau	Min. Thickn. Épais minim.	Corr. Allow. Surép. Corr.	Crown. Radius Rayon couron.	Knuckle Radius Petit rayon	Ellipse Ratio Rapp. ellipse	Conical Apex Angle Angle conique	Hemisph. Radius Ray. Hémisph	Flat Diameter Diam. plat	Side to pressure Côte sous pression
Formed Plate	SA-516 70N	0.560"	0.0625"			2:1				Concave
Removable bolts used (describe other fastenings) Boulons amovibles utilisés (décrire tout autre attache)					Mat'l Spec./ Spéc. du mat.			Grade		Size/ Dimension

Pressure - Temperature/ Pression - température

Pressure Vessel Part Partie de l'appareil	Constructed for max. allowable working pressure Construit pour une pression maximale de marche permise	At max. temp. A une temp. max.	Min. Temp. (when less than -29°C) Temp. min. (inférieure à -29°C)	Test pressure (hydro-pneumatic or combination) Pression d'épreuve (hydro-pneumatique ou combinaison)
Vessel	250 psig 1724 kPa	200F 93.3C	-50F -45.5C	325 psig 2241 kPa

Tube Section/ Faisceau tubulaire

Tube sheet/ Plaque tubulaire	Material/ Matériau	Diameter/ Diamètre	Nominal Thickness Épaisseur nominale	Corr. Allow. Surépais. corrosion	Attachment Mode d'attachement
Tube material/ Matériau des tubes	Diameter/ Diamètre	Nominal Thickness (gauge) Épaisseur nominale (calibre)	Number/ Nbre	Type (Straight or U) Type (Droit ou U)	Heating Surface Surface de chauffe

Jacket/ Chemise

Type of jacket/ Genre de chemise	Jacket closure Fermeture de chemise	Proof Test Pression d'épreuve	Heating Surface Surface de chauffe	Sketch/ Schéma
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Safety Valve Outlets/ Soupapes de sûreté

Number/ Nombre 1	Dimension 3" 150 ANSI RF	Location/ Endroit Shell
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Nozzles and Openings/ Tubulures et ouvertures

Purpose/ But	Number Nombre	Dimension	Type	Material Matériau	Nominal Thickness Épaisseur nominale	Reinforcement material Matériau de renfort	How attached Genre d'attaches	Location/ Endroit
Drain, steams coil	2	4" NPS	CI150 RFSO	SA-106B	XXH		UW16c	Shell/Head
Inlet/Outlet	2	6" NPS	CI150 RFSO	SA-106B	XXH		UW16c	Shell
Liquid out, Drain	7	3" NPS	CI150 RFSO	SA-106B	XXH		UW16c	Shell/Head
Manway	1	24" NPS	CI150 RFSO	SA-106B	Sch 40	SA-516 70N	UW16c	Head
LG/PI	10	3/4" NPS	6000# Cplg	SA-105N	6000#		UW16c	Shell/Head
Manway	1	20" NPS	CI150 RFSO	SA-106B	Sch 40	SA-516 70N	UW16c	Shell
Spare	1	2" NPS	6000# CPLG	SA-105N	6000#		UW16c	Shell

Supports/ Supports

Skirt/ Jupe Yes/ Oui No/ Non <input type="checkbox"/> <input type="checkbox"/>	Lugs/ Orettes No./ Nbre	Legs/ Pieds No./ Nbre	Other/ Autres (Description) Saddle	Attached/ Attaches (Where and How/ Méthode et endroit) Shell by fillet weld
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Remarks/ Observations (Cubical capacity/ Volume)

8 cu. ft/18.63 cu. m 15,000 lbs/6628 kg
 Drawing: V-2J3-168-1 R1
 Heads shells, repads exempt per UCS 66 Curve D with Fig UCS 66.1 Reduction
 Nozzles, couplings exempt per UCS 66 (b)(3). Flanges exempt per UCS 66(g)

Certificate of Compliance/ Certificat de conformité

We certify that the statements made in this data report are correct and that the said vessel has been constructed in accordance with the Provincial Registered design below and the requirements of standard CSA B51.

Nous certifions que les données de la déclaration de conformité sont correctes et que l'appareil a été construit en accord avec l'enregistrement provincial ci-dessous et les exigences de la norme ACNOR B51.

Provincial Registered Design
 Enregistrement provincial P9840.21

Manufacturer
 Constructeur Dynacorp Fabricators Inc.

Signature Michael Hebel Date 2/07/03

Certificate of Shop Inspection/ Certificat d'inspection en usine

I, the undersigned, a duly authorized Boiler and Pressure Vessel Inspector
 Je, soussigné, inspecteur autorisé de chaudières et appareil sous pression
 employed by
 employé par Alberta Boilers Safety Association

of Alberta
 have inspected the above vessel and state that to the best of my knowledge and belief, the manufacturer has constructed the vessel in accordance with the Provincial registration CRN P9840.21
 and the requirements of standard CSA B51.

ai inspecté l'appareil précité et autant que je sache, crois que le constructeur a construit l'appareil en accord avec l'enregistrement provincial NEC
 et les exigences de la norme ACNOR B51.

Inspector's Name
 Nom de l'inspecteur Vanessa Rawlins
 Signature Vanessa Rawlins Date July 2/03

Certificate of Compliance - Field Work/ Certificat de conformité - Installation au chantier

We certify that the field installation of all parts of the vessel conforms with the requirements of Provincial Regulations.

Nous certifions que l'installation au chantier de toutes les composantes de l'appareil est conforme aux règlements provinciaux.

Installer's Name
 Nom de l'installateur _____

Signature _____
 Date _____

Certificate of Field Inspection/ Certificat d'inspection - Installation au chantier

I, the undersigned, a duly authorized Boiler and Pressure Vessel Inspector
 Je, soussigné, inspecteur autorisé de chaudières et appareil sous pression
 employed by
 employé par _____

have inspected the items not covered by the Shop Inspection Certificate and the installation of the items and state that to the best of my knowledge and belief the construction and assembly of the items are in accordance with the Provincial Regulations.

ai inspecté les composantes non couvertes par le certificat d'inspection en usine et l'installation de l'appareil et, autant que je sache, la construction et l'assemblage de l'appareil sont en accord avec les règlements provinciaux.

Inspector's Name
 Nom de l'inspecteur _____
 Signature _____ Date _____

ITEM	QTY.	SIZE	TYPE	RATING	SCH.	MAT'L SPEC.	DESCRIPTION
100. VESSEL							
101	2	78" OD	FORMED PLATE			SA-516-70N	HEAD: 78"00 X 5/8" THK. (0.560" MIN.) 2:1 SE 2" SF
102	1	78" OD	ROLLED PLATE			SA-516-70N	SHELL: 78"00 X 5/8" THK. X 120" LG
103	1	78" OD	ROLLED PLATE			SA-516-70N	SHELL: 78"00 X 5/8" THK. X 96" LG
200. CONNECTION							
201	1	24"	RFSO	150#		SA-350-LF2	ANSI FLANGE
202	1	4"	RFSO	150#		SA-350-LF2	ANSI FLANGE
203	7	3"	RFSO	150#		SA-350-LF2	ANSI FLANGE
204	1	24"	RF	150#		SA-350-LF2	ANSI BLIND FLANGE
205	9	3/4"	CPLG	6000#		SA-105N	4" LONG CPLG T.O.E.
206	1	4"	SMLS PIPE		XXH	SA-106B	11-3/8" LONG
207	1	6"	SMLS PIPE		XXH	SA-106B	8-11/16" LONG
208	1	4"	RFSO	150#		SA-350-LF2	ANSI FLANGE
209	1	3"	RF	150#		SA-350-LF2	ANSI BLIND FLANGE
210	1	3"	SMLS PIPE		XXH	SA-106B	6-1/16" LONG
211	1	4"	SMLS PIPE		XXH	SA-106B	6-1/16" LONG
212	1	3"	SMLS PIPE		XXH	SA-106B	14" LONG
213	1	24"	SMLS PIPE		40	SA-106B	9-1/4" LONG
214	1	3"	SMLS PIPE		XXH	SA-106B	7-1/2" LONG
215	1	3/4"	CPLG	6000#		SA-105N	6" LONG CPLG T.O.E.
216	1	5/8" THK	FORMED PLATE			SA-516-70N	REPAD: 5/8" THK. X 35"00 FORMED TO FIT 78" OD, 2:1 SE HEAD
217	1	3"	SMLS PIPE		XXH	SA-106B	15-1/8" LONG
218	1	3"	SMLS PIPE		XXH	SA-106B	6-1/16" LONG
219	1	6"	RFSO	150#		SA-350-LF2	ANSI FLANGE
220	1	3"	SMLS PIPE		XXH	SA-106B	8-11/16" LONG
221	1	3"	SMLS PIPE		XXH	SA-106B	6-1/16" LONG
222	-	-	-	-	-	-	-
223	1	6"	RFSO	150#		SA-350-LF2	ANSI FLANGE
224	1	6"	SMLS PIPE		XXH	SA-106B	1'-4 1/2" LONG
225	1	2"	CPLG	6000#		SA-105N	4" LONG CPLG. T.O.E.
226	1	20"	RFSO	150#		SA-350-LF2	ANSI FLANGE
227	1	20"	RF	150#		SA-350-LF2	ANSI BLIND FLANGE
228	1	5/8" THK	FORMED PLATE			SA-516-70N	REPAD: 5/8" THK. X 30" O.D. (ROLLED TO FIT SHELL O.D.)
229	1	20"	SMLS PIPE		40	SA-106B	11" LONG
300. INTERNAL ASSEMBLIES							
301	2	6"	RFSO	150#		SA-105N	ANSI FLANGE
302	2	3/8" THK	PLATE			SA-36	WEAR PLATE 3/8" THK. PLATE CUT AS SHOWN
303	1	2 1/2"	RFSO			SA-105N	ANSI FLANGE
304	1	5/8"	STUD			SA-193-B7	5/8" x 3-1/2" LG FOR 3" 150# RFSO
305	4	5/8"	NUT			SA-194-2H	NUT FOR 3" 150# RFSO
306	8	3/8" THK	PLATE			SA-36	WEAR PAD: 3/8" X 4"
307	2		FLAT BAR			SA-36	3/8" x 2 1/2" x 12" LG.
308	2					316 S.S.	R24 RTJ SEAL RING
309	1	8"	RFSO	150#		SA-105N	ANSI FLANGE

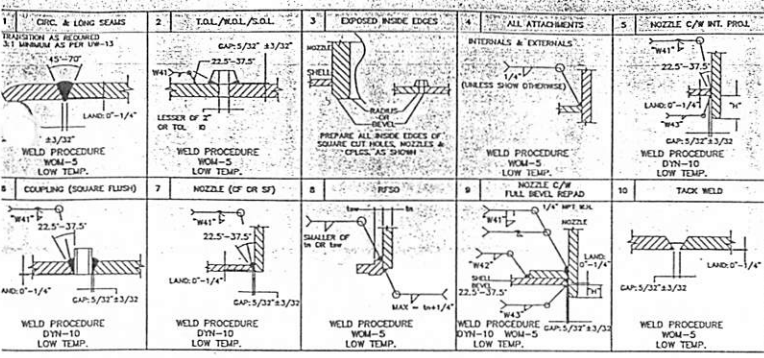
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 -USE ONLY THE FITTING AND FLANGE MATERIALS MARKED WITH THIS JOB #.
 -FOR PIPE:
 -WRITE
 -MATERIAL/GRADE
 -HEAT NO.
 -SCH.
 -LENGTH
 ON EACH CUT PIECE.
 -STAMP MATERIAL I.D. ON EACH CUT PIECE.

WELDING NOTES:
 -USE PREHEAT
 -MONITOR INTERPASS TEMPERATURE
 -ALL PER WQM-5

DWG. RELEASE
 FABRICATION COPY NO: ___ OF ___
 DATE: _____
 SIGNED: _____

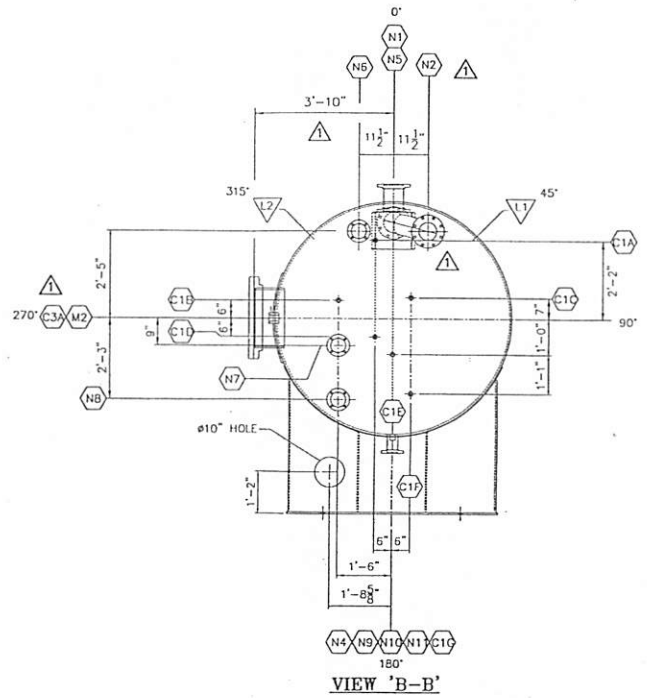
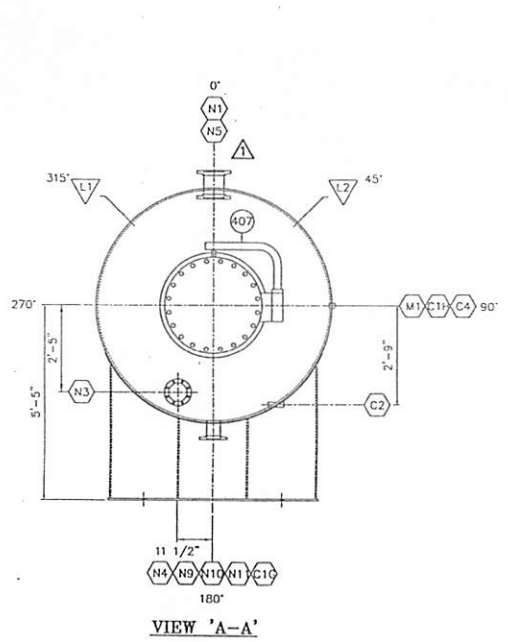
ITEM	QTY.	SIZE	TYPE	RATING	SCH.	MAT'L SPEC.	DESCRIPTION
300. INTERNAL ASSEMBLIES							
310	1	8"	RF	150#		SA-105N	ANSI BLIND FLANGE
311	1	8" X 6"	CONC. RED.		40	SA-234-WPB	CONCENTRIC REDUCER
312	1	8"	SMLS PIPE		40	SA-106B	15-5/8" LG. C/W SLOTS. (SEE DETAIL)
313	16	3/4"	STUD			SA-193-B7	3/4" X 4" LG. FOR 6" 150# RFSO
314	32	3/4"	NUT			SA-194-2H	NUT FOR 6" 150# RFSO
315	2	1/4" THK	PLATE			SA-36	TOP / BTM PLATE
316	1	3/8" THK	PLATE			SA-36	OUTLET PLATE: 3/8" THK. X 11 7/8" X 12"
317	-	-	-	-	-	-	-
318	11	3/8" THK				SA-36	1.5" X 1.5" X 0.125" ANGLE X 12" LG.
319	6	3/8" THK				SA-36	2" X 2" X 0.125" ANGLE X 12" LG.
320	-	-	-	-	-	-	-
321	-	-	-	-	-	-	-
322	1	1"	SMLS PIPE		80	SA-333-GR.6	20'-0" LONG T.O.E.
323	1	2-1/2"	SMLS PIPE		80	SA-333-GR.6	20'-0" LONG
324	1	4"	RF	150#		SA-350-LF2	BLIND FLANGE
325	2	2-1/2"	WELD CAP		80	SA-420-WPL6	WELD CAP
326	1	1"	T.O.L	3000#		SA-350-LF2	T.O.L
327	3	1/4" THK	PLATE			SA-36	3/4" X 2" LONG
328	-	-	-	-	-	-	-
329	3	6"	RFSO	150#		SA-105N	ANSI FLANGE
330	1	6"	RFWN	150#		SA-105N	ANSI FLANGE
331	1	6"	SMLS PIPE		STD	SA-106B	8-3/4" LONG
332	2	6"	45" L.R.		STD	SA-234-WPB	45" L.R. WELD ELBOW
333	16	3/4"	STUD			SA-193-B7M	3/4" X 4" LG. FOR 6" 150# RFSO
334	32	3/4"	NUT			SA-194-2HM	NUT FOR 6" 150# RFSO
335	1	6"	GASKET	150#		316-SS	6" 150# RF
400. EXTERNAL ASSEMBLIES							
401	2	3/8" THK	ROLLED PLATE			SA-516-70N	WEAR PAD: 3/8" THK. X 8"W X 92" LG ROLLED TO FIT SHELL 78"00
402	-	-	-	-	-	-	-
403	2	1/2" THK				SA-36	1/2" THK. PLATE BENT AS SHOWN
404	4	1/2" THK	PLATE			SA-36	GUSSET: 1/2" THK. 5-1/2" X 26-1/2"
405	2	5/8" THK	PLATE			SA-36	BASE PLATE: 5/8" THK. 7" X 69-1/2"
406	1					SA-36	DYN. STD. NAMEPLATE BRACKET
407	1					SA-106B	DAVITARM ASSY.
408	20	1-1/4"	STUD			SA-193-B7M	STUD: 1-1/4" x 7" LG
409	40	1-1/4"	NUT			SA-194-2HM	NUT
410	1	24"	GASKET	150#		316 S.S.	24" 150 RF
411	4		BOLT			GR. 8	1-1/8" x 2-1/2" COARSE CW/NUTS, FLAT & LOCK WASHERS
412	1					SA-106B	DAVITARM ASSY.
413	20	1 1/8"	STUD			SA-193-B7M	1 1/8" x 6 1/4" LG. FOR 20" 150# RFSO
414	40	1 1/8"	NUT			SA-194-2HM	NUT FOR 20" 150# RFSO
415	1	6"	GASKET	150#		316-SS	20" 150# RF

DYNACORP FABRICATORS INC. 9815-48 STREET S.E. CALGARY, ALBERTA. TEL: (403) 720-9600, FAX: (403) 720-8681			
CLIENT	Dynacorp Fabricators Inc.		
PROJECT			
TITLE	78"00 X 18' S/S 250 PSI Horizontal Separator		
DWG	S. LO	DATE	05/12/02
APPROVED	M. HEBER	DATE	05/12/02
DWG NO.	V-2J3-168-1	REV	1
SCALE	1:20	REV	4/4



FABRICATION NOTES:
 - USE ONLY THE FITTING AND FLANGE MATERIALS MARKED WITH THIS JOB #.
 - FOR PIPE -
 - WRITE
 - MATERIAL/GRADE
 - HEAT NO.
 - SCH.
 - LENGTH
 ON EACH CUT PIECE.
 - STAMP MATERIAL I.D. ON EACH CUT PIECE.

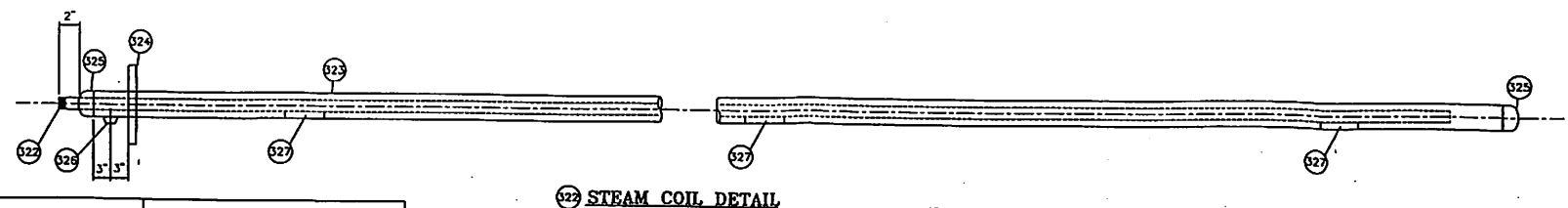
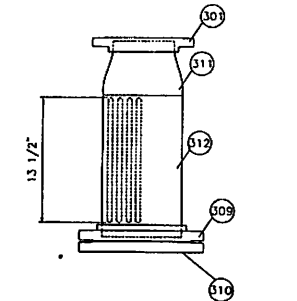
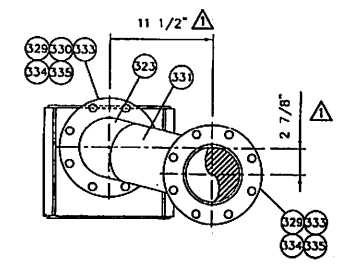
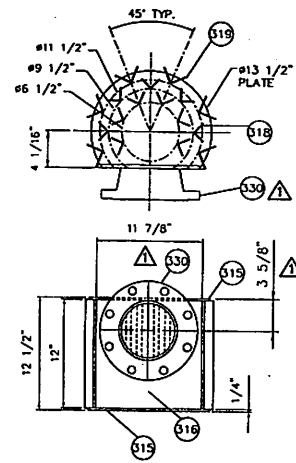
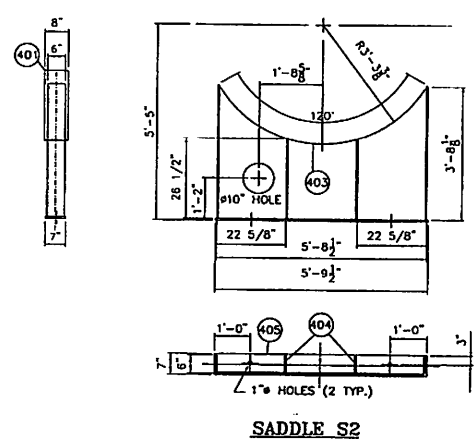
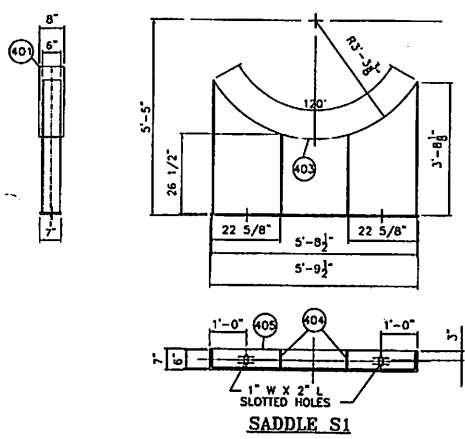
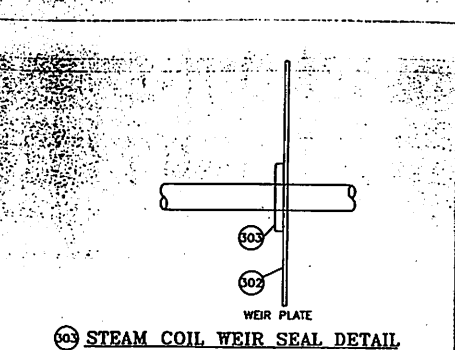
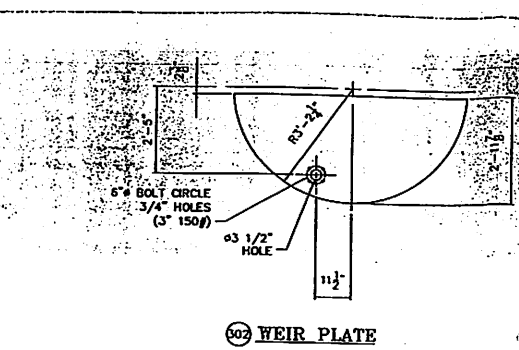
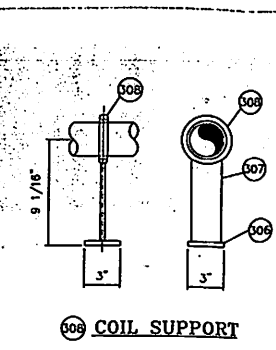
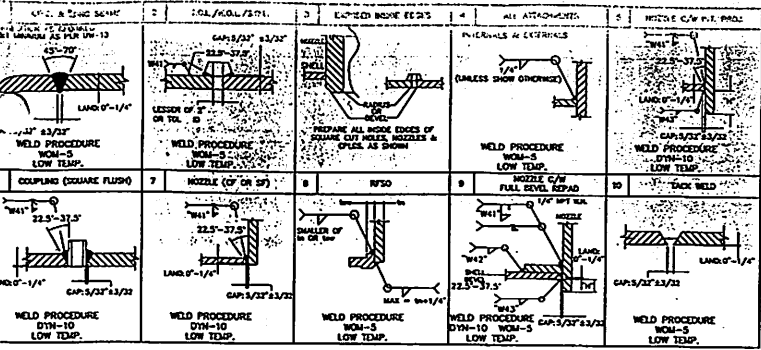
WELDING NOTES:
 - USE PREHEAT
 - MONITOR INTERPASS TEMPERATURE
 - ALL PER WQM-5 DYN-10



DWG. RELEASE
 FABRICATION COPY NO: ___ OF ___
 DATE: _____
 SIGNED: _____

REV.	DESCRIPTION	DATE	BY	APPROVED
1	DELETED M12, ADDED M2, M3, & C3A	17/04/03	WH	
0	ISSUED FOR CONSTRUCTION	14/04/03	MH	MH

DYNACORP FABRICATORS INC. 9615-48 STREET S.E. CALGARY, ALBERTA. TEL: (403) 720-9900, FAX: (403) 720-9901					
CLIENT	Dyncorp Fabricators Inc.				
PROJECT					
TITLE	78"OD X 18' S/S 250 PSI Horizontal Separator				
DWG	S. LO	DATE	05/12/02	APPROVED	M. HEBER
				DATE	05/12/02
DWG NO.	V-2J3-168-1	JOB #	2J3-168	SCALE	1:20
				REV	1
				SHEET	2/4



FABRICATION NOTES:
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 -OR PIPE:
 -WRITE
 -MATERIAL/GRADE
 -HEAT NO.
 -SCH.
 -LENGTH
 ON EACH CUT PIECE.
 -STAMP MATERIAL I.D. ON EACH CUT PIECE.

-WELDING NOTES:
 -USE PREHEAT
 -MONITOR INTERPASS TEMPERATURE
 -ALL PER WOM-5
 DYN-10

DWG. RELEASE
 FABRICATION COPY NO: ___ OF ___
 DATE: _____
 SIGNED: _____

REV.	DESCRIPTION	DATE	BY	APPROVED
1	CHANGED OUTLET COALESCER DETAIL.	11/04/02	MM	
2	ISSUED FOR CONSTRUCTION	11/04/02	MM	

DYNACORP FABRICATORS INC. 9615-48 STREET S.E. CALGARY, ALBERTA TEL: (403) 720-9900 FAX: (403) 720-9851			
PROJECT: Dynacorp Fabricators Inc.			
TITLE: 78"OD X 18' S/S 250 PSI Horizontal Separator			
DWG: S. LO	DATE: 05/12/02	APPROVED: M. HEBER	DATE: 05/12/02
DWG. NO: 2J3-168-1	ADD. NO: 2J3-168	SCALE: 1:20	SHEET: 1/3/4

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