

# **Quality Control Documents**

**5**

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# Travel Sheet (Front)

No. PPF-GN--FF-045 Rev. 0

DO NOT START CONSTRUCTION WITHOUT AI REVIEW						TRAVEL SHEET REVISION No.:			
A.I. REVIEW:						REVIEW DATE:			
SERIAL No.: 08-3180-0000			JOB No.: 3180-0000			VESSEL TYPE: HORIZONTAL TANGENT SEPARATOR			
DRAWING No.: D-08-3180-0000-001			DWG REVISION No.: 0			TRAVEL SHEET INITIATION BY: BA			
Seq.	Item	Comments	Q.C.I.	Date	A.I. Hold Points	A.I.	Date	Owner	Date
1.	Calculations in File		BA	JAN 7/09	R	H209-01-08			
2.	Release of App'd Dwg.		BA	02/23/08	H	H208-10-31			
3.	Materials Examined		BA	DEC 10/08					
4.	Heat Numbers Recorded		BA	DEC 19/08	R	DEC 24 2008			
5.	MTRs Checked		BA	DEC 19/08	I	DEC 24 2008			
6.	WPS(s) checked		BA	DEC 19/08		H208-10-31			
7.	Welder(s) Qualified		BA	DEC 19/08					
8.	Thickness Verified & Recorded		BA	DEC 5/08					
9.	Shell(s) & Head(s) Fit-up Inspection		BA	DEC 5/08					
10.	Nozzle & Fitting Fit-up Inspection		BA	DEC 10/08					
11.	Nozzle Orientation		BA	DEC 10/08					
12.	Nozzle & Flange Rating Checked		BA	DEC 16/08					
13.	Impact Tests	EXEMPT							
14.	Internals Checked		BA	DEC 23/08					
15.	Final Internal Inspection	Shell Side Tube Side	BA	DEC 24/08	H	DEC 24 2008			
16.	Weld Sizes Checked		BA	DEC 19/08	I	DEC 24 2008			
17.	Welder I.D. Checked		BA	DEC 19/08	I	DEC 24 2008			
18.	Final External Inspection		BA	DEC 23/08	I	DEC 24 2008			
19.	Radiography	FULL PER UG-11(a)	BA	DEC 24/08	R	H208-12-30			
20.	Other NDE	HP/RT	BA	DEC 24/08		H209-01-08			
21.	Final Ext. Prior to P.W.H.T.		BA	DEC 24/08	H	DEC 24 2008			
22.	PWHT Chart Checked	Done @ 1150F ±25F	BA	DEC 24/08	R				
23.	Hydrostatic Test	Shell Side Gauge # 028/029 Tube Side Gauge #	BA	DEC 31/08	H	H208-12-31			
24.	CRN Drawing	CRN# U7552.2	BA	JAN 7/09	R	H209-01-08			
25.	NCR# 48, 56		BA	DEC 23/08		H209-01-08			
26.	Nameplate Stamping		BA	JAN 8/09	H	H209-01-08			
27.	Manuf. Data Report Completed & Verified		BA	JAN 8/09	H	H209-01-08			
28.	Nameplate Installation		BA	JAN 19/09					

The Authorized Inspector shall be presented with the Travel Sheet prior to construction so that he/she can designate additional inspection points and/or Hold points. Any revisions shall be marked with a delta symbol with revision number and described at the bottom of this page.

\*Denotes an A.I. inspection Point \*\* Denotes an A.I. Hold Point

\*GTAINWEIR \*CSI- GRIND BELOW MINIMUM THICKNESS - REWELD ~ 24" LENGTH AND RT AGAIN. (M) DEC 24 2008 OTHERWISE RT OKAY.



## Travel Sheet (Back)

No. PPF-GN--FF-043 Rev

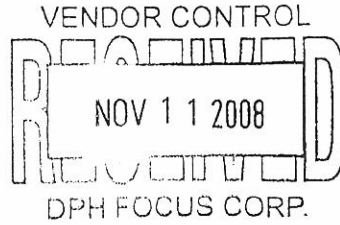
MATERIAL THICKNESS VERIFICATION AND IDENTIFICATION				WELDER I.D. / WELDER SYMBOLS / FIT-UP						
Description	Thickness	Material Spec & Grade	Heat & Plate Identifier or ID Number	Weld ID	Welder Symbol	Fit-up Exam.	Weld ID	Welder Symbol	Fit-up Exam.	Verify Type 1 joint
Shell#1	✓ .75"	SA-516-70N	414807 8321193300	L-	K		C-	A,K,F		
Shell#2	✓ .75"	SA-516-70N	414807 8321193300	L-	W,XX		C-			
Shell#3				L-			C-			
Shell#4				L-			C-			
Shell#5				L-			C-			
Shell#6				L-			C-			
Head#1	✓ .75"	SA-516-70N	62500 872031310		WT,R,C		C-			
Head#2	✓ .75"	SA-516-70N	62508 872031310		ATFW		C-			
Head#3							C-			
Head#4							C-			
Boot #1 Shell				L-			C-			
Boot #1 Head							C-			
Boot #2 Shell				L-			C-			
Boot #2 Head							C-			
Cone				L-			C-			

ATTACHMENT AND / OR NOZZLE MATERIAL THICKNESS VERIFICATION AND IDENTIFICATION						WELDER SYMBOLS / FIT-UP			
Mark	Mat. I.D.	Neck	Fitting	Flange	Repad or Attachment	Cat. B	Cat. C	Cat. D	Pad OD
N1	Spec-Grd	SA-106-B		SA-105N	SA-516-70N		S	✓	✓
	Thk./Rating	14" SCH 80		14" 150 SCH 160	3/4				
	Heat# or ID	S0520616		95978	79418 18943				19" ✓
N2	Spec-Grd	SA-106-B		SA-105N	SA-516-70N		S	✓	✓
	Thk./Rating	14" SCH 80		14" 150 SCH 160	3/4				
	Heat# or ID	S0520616		95978	79418 18943				19" ✓
N3	Spec-Grd	SA-106-B		SA-105N			S	✓	
	Thk./Rating	4" XXH		4" 150 XXH					
	Heat# or ID	J5L2533		AU426					
N4	Spec-Grd	SA-106-B		SA-105N			S	✓	
	Thk./Rating	3" XXH		3" 150 XXH					
	Heat# or ID	S31816		21520					
NSA	Spec-Grd	SA-106-B		SA-105N			S	✓	
	Thk./Rating	2" SCH 160		2" 150 SCH 160					
	Heat# or ID	S25191		70344					
NSB	Spec-Grd	SA-106-B		SA-105N			H	XX	
	Thk./Rating	2" SCH 160		2" 150 SCH 160					
	Heat# or ID	S25191		13145					
N6	Spec-Grd	SA-106-B		SA-105N			S	XX	
	Thk./Rating	4" XXH		4" 150 XXH					
	Heat# or ID	J5L2533		AU426					
N7	Spec-Grd	SA-106-B		SA-105N			S	F	
	Thk./Rating	6" XXH		6" 150 XXH					
	Heat# or ID	X25051		314A7					





# Inspection & Test Plan



Pyramid Job # 3180  
 Client Tag # V-5800  
 Description: INLET SEPARATOR

Process	Task	Forms/Exhibits	QCI	TPI
Kick Of Meeting	Scope Work		H	H
	Issue ITP	This form	H	H
	NDE Requirement		H	H
Material Receiving	MTR / LOC	Supplier Documents	H	R
	PO	7.1	R	R
	MRR	7.4	R	R
Cutting	Traceability	pick ticket	I	
	Dimension	Cut List	I	
	Material	DWG	I	R
Welding	Welder Qualification	9.2	H	R
	WPS Approval	9.1	H	R
	Welding Factors	WPs	R	R
	Visual	Welding Log	H	R
	Repair/NCR	10.1	H	R
	Weld Mapping	Welding Map	R	R
NDE / PWHT	Request	NDE Request 12.1	R	R
	Results	PWHT/NDT Reports	R	R
	Repair		H	R
Pressure Test	Pre - Punch	14.6	H	I
	Package Release	14.2/14.5	H	H
	Test Witness	14.1	H	H
	Post - punch	14.6	H	H
Structural	Visual Inspection		H	I
Final release	Final Walk Down		H	H
	Deficiency List	14.6	H	H
Turn Over	QC Dossier	QC Documents	R	R

QCI : Quality Control Inspector      Pyramid Process Fabricators Inspector  
 TPI : Third party inspector          Client or Authorized Inspector  
 H: 100 % Inspection (Hold point )    Do not proceed unless released by QC  
 I: Spot Inspection                        Random Inspection  
 R: Review                                    Review documents such as reports  
 W: Witness point                          Proceed after notification

**VENDOR DRAWING REVIEW**

A. Reviewed without comment. Proceed. Provide As-Built drawing.

B. Reviewed with comments. Release for Construction. Proceed with fabrication.

C. Reviewed with comments. Release for Review. Do not proceed.

D. Reviewed with comments. Review. Do not proceed.

E. \_\_\_\_\_

RETURN REPRODUCIBLE DWG. BY \_\_\_\_\_

DATE Nov 11 SIGNED [Signature]

DPH FOCUS JOB # **9971**



# Inspection & Test Plan

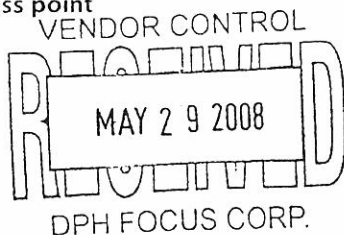
Pyramid Job#: 3180  
 Client Tag#: V-5800  
 Description: INLET SEPERATOR

VENDOR DRAWING REVIEW	
<input type="checkbox"/>	A. Reviewed without comment. Proceed. Provide As-Built drawing.
<input checked="" type="checkbox"/>	B. Reviewed with comments. Reissue For Construction. Proceed with fabrication.
<input type="checkbox"/>	C. Reviewed with comments. Reissue For Review. Proceed with material order only.
<input type="checkbox"/>	D. Reviewed with comments. Reissue For Review. DO NOT proceed with mat'l. or fabr.
<input type="checkbox"/>	E. _____
RETURN REPRODUCIBLE DWG. BY _____	
DATE <u>June 7, 04</u> SIGNED <u>[Signature]</u>	

Process	Task	Form or Exhibit#	QCI	TPI
Kick Of Meeting	Scope Work	5.1	H	H
	Issue ITP	This Form	H	H
	NDE Requirement	5.1	H	H
Material Receiving	MTR / LOC	Supplier Documents	H	R
	PO	7.1	R	R
	MRR	7.4	R	R
Cutting	Traceability	pick ticket	I	
	Dimension	Cut List	I	
	Material	DWG	I	R
Welding	Welder Qualification	9.2	H	R
	WPS Approval	9.1	H	R
	Welding Factors	WPS	R	R
	Visual	Welding Log	H	R
	Repair / NCR	10.1	H	R
NDE / PWHT	Weld Mapping	Welding Map	R	R
	Request	NDE Request / 12.1	R	R
	Result	PWHT / NDE report	R	R
Pressure Test	Repair	14.2	H	R
	Pre - Punch	14.6	H	I
	Package Release	14.2 / 14.5	H	H
	Test Witness	14.1	H	H
Structural	Post - punch	14.6	H	H
	Visual Inspection		H	I
Final release	Final Walk Down		H	H
	Deficiency List	14.6	H	H
Turn Over	QC Dossier	QC Documents	R	R

QCI : Quality Control Inspector  
 TPI : Third party inspector  
 H: 100 % Inspection (Hold point )  
 I: Spot Inspection  
 R: Review  
 W: Witness point

Pyramid Process Fabricators Inspector  
 Client or Authorized Inspector  
 Do not proceed unless released by QC  
 Random Inspection  
 Review documents such as reports  
 Proceed after notification



DPH FOCUS JOB # 9971






# PYRAMID CORPORATION WELDING TICKET INFORMATION SHEET

Welders Name: Richard Neumann

ABSA File No.: MW-70315

Stamp No.: "W"

012/896059	91794A
<p>THIS IS TO CERTIFY THAT  <b>RICHARD ALEXANDER NEUMANN</b>          HAS COMPLETED AN ALBERTA APPRENTICESHIP PROGRAM AND HAVING ACHIEVED          THE STANDARDS ESTABLISHED UNDER THE ALBERTA APPRENTICESHIP AND          INDUSTRY TRAINING ACT, IS HEREBY AUTHORIZED TO WORK IN THE TRADE AS A          JOURNEYMAN AND TO USE THE TITLE CERTIFIED JOURNEYMAN</p>	
WELDER	
EFFECTIVE DATE May 20th, 2008	ISSUE DATE June 11th, 2008
 HONOURABLE DOUG HETHERINGTON MINISTER OF ADVANCED EDUCATION AND TECHNOLOGY	 SHIRLEY DUL EXECUTIVE DIRECTOR OF APPRENTICESHIP & INDUSTRY TRAINING
	



*Richard Neumann*



**WELDING PERFORMANCE QUALIFICATION**

Richard Alexander Neumann 70315  
Name File No.

This card is issued pursuant to the Safety Codes Act and Pressure Welders' Regulations, subject to the limitations on the reverse side.

Nov. 4, 2007 *Richard Neumann*  
Date of Test Signature of Welder or Operator

*Shirley Dul* CARD 70315  
Safety Codes Officer

**PERFORMANCE QUALIFICATION**  
 (In accordance with Section IX, A.S.M.E. Code)  
 Form No. AB-119 Rev (02/05)

Process(es) <i>SAW</i>	Material (P.No.) <i>P1 to P1</i>
Max Deposited Weld Metal <i>MAX</i>	Minimum Pipe Dia. <i>2 1/8"</i>
Filler Metal Group (F.No.) <i>F6</i>	Position(s) Qualified <i>Flat</i>
Backing <i>With</i>	Progression <i>N/A</i>
<i>Nov. 3, 2007</i>	<i>Shirley Dul</i>
<small>Date of Expiry</small>	<small>Signature of Safety Codes Officer</small>




# PYRAMID CORPORATION WELDING TICKET INFORMATION SHEET


Welders Name: Carlos Espinosa

ABSA File No.: W-6580

Stamp No.: "Z"



**Alberta**  
LABOUR




**ABSA**

Form No. AB-117 Rev. (03-10)

Grade "B" Pressure Welder's  
Certificate of Competency

This is to Certify that: Carlos Espinosa  
having complied with provisions of the Safety Codes Act, is authorized to engage in  
pressure welding in accordance with the prescribed Regulations.

Dated at Edmonton, this 1996  
December 6



W- 6580  
File No.

[Signature]  
Chief Inspector and Administrator

Nº 10277

**APPRENTICESHIP AND  
TRADE CERTIFICATION  
BRANCH**

**Alberta**  
ADVANCED EDUCATION  
AND MANPOWER

THIS IS TO CERTIFY THAT  
Carlos M. ESPINOSA

HOLDS A CERTIFICATE OF PROFICIENCY  
AS A / AN Welder - 1st Class

DATE May 23, 1980 No. CB6870

FILE 553815

[Signature]  
DIRECTOR

CONDITIONS OF ISSUE

AFTER EXAMINATION  
VALID FOR ARC WELDING  
(INCLUDING GAS CUTTING)

INTERPROVINCIAL STANDARDS  
SEAL No. NOT AVAILABLE

**PYRAMID CORPORATION 7168**  
WELDER PERFORMANCE QUALIFICATION CARD A.O.Q.P. No.

Name: Carlos Espinosa ABSA File No: W-6580

This card is issued pursuant to the Alberta Safety Codes Act and the Pressure Welders Regulations. The performance qualification is in accordance with Section IX of the ASME Code and subject to the limitations on the reverse side.

Date of Test Oct. 27/2008 [Signature]  
Signature of Welder or Machine Welding Operator

David Mansfield  
Welding Examiner (Print/Type) **Card # 192**

**PERFORMANCE QUALIFICATION**

Process(es)	<u>SMAW SMAW</u>	Material (P-No.)	<u>PI-PII</u>
Filler Metal Group (F-No.)	<u>F3 FA</u>	Min. Outside Pipe Diameter	<u>1" O.D.</u>
Max Deposited Weld Metal	<u>0.25" 0.622"</u>	Position(s) Qualified	<u>ALL</u>
Backing	<u>With/without</u>	Backing Gas	<u>N/A</u>
Progression	<u>Vert. Up Vert. Up</u>		
P.Q. Expiry Date	<u>Oct. 27/10</u>	Welding Examiner Signature	<u>David Mansfield</u>
		Examiner File No.	<u>E-0022A</u>

**PYRAMID CORPORATION 7168**  
WELDER PERFORMANCE QUALIFICATION CARD A.O.Q.P. No.

Name: Carlos Espinosa ABSA File No: W-6580

This card is issued pursuant to the Alberta Safety Codes Act and the Pressure Welders Regulations. The performance qualification is in accordance with Section IX of the ASME Code and subject to the limitations on the reverse side.

Date of Test Oct. 27/2008 [Signature]  
Signature of Welder or Machine Welding Operator

David Mansfield  
Welding Examiner (Print/Type) **Card # 193**

**PERFORMANCE QUALIFICATION**

Process(es)	<u>GMAW (STD) SMAW</u>	Material (P-No.)	<u>PI-PII</u>
Filler Metal Group (F-No.)	<u>F6 FA</u>	Min. Outside Pipe Diameter	<u>1" O.D.</u>
Max Deposited Weld Metal	<u>0.132" 0.632"</u>	Position(s) Qualified	<u>ALL</u>
Backing	<u>With/without</u>	Backing Gas	<u>without</u>
Progression	<u>Downhill uphill</u>		
P.Q. Expiry Date	<u>Oct. 27/10</u>	Welding Examiner Signature	<u>David Mansfield</u>
		Examiner File No.	<u>E-0022A</u>

# PYRAMID CORPORATION WELDING TICKET INFORMATION SHEET

Welders Name: Carlos Espinosa

ABSA File No.: W-6580

Stamp No.: "Z"



**PYRAMID CORPORATION 7168**  
WELDER PERFORMANCE QUALIFICATION CARD A.O.Q.P. No.

Name: Carlos Espinosa ABSA File No: W-6580

This card is issued pursuant to the Alberta Safety Codes Act and the Pressure Welders Regulations. The performance qualification is in accordance with Section IX of the ASME Code and subject to the limitations on the reverse side.

Date of Test: Oct. 28, 2008 Signature of Welder or Machine Welding Operator: [Signature]

Welding Examiner (Print/Type): David Mansfield Card # **197**

**PERFORMANCE QUALIFICATION**

Process(es)	<u>GTAW SMAW</u>	Material (P-No.)	<u>PI</u>
Filler Metal Group (F-No.)	<u>F6 FA</u>	Min. Outside Pipe Diameter	<u>1" O.D.</u>
Max Deposited Weld Metal	<u>0.25" 0.622"</u>	Position(s) Qualified	<u>ALL</u>
Backing	<u>With/Without With</u>	Backing Gas	<u>With/Without</u>
Progression	<u>Vert. Up Vert. Up</u>		
P.Q. Expiry Date	<u>Oct. 28/10</u>	Welding Examiner Signature	<u>David Mansfield</u>
		Examiner File No.	<u>E-00224</u>



**PYRAMID CORPORATION 7168**  
WELDER PERFORMANCE QUALIFICATION CARD A.O.Q.P. No.

Name: Carlos Espinosa ABSA File No: W-6580

This card is issued pursuant to the Alberta Safety Codes Act and the Pressure Welders Regulations. The performance qualification is in accordance with Section IX of the ASME Code and subject to the limitations on the reverse side.

Date of Test: Oct. 28, 2008 Signature of Welder or Machine Welding Operator: [Signature]

Welding Examiner (Print/Type): David Mansfield Card # **198**

**PERFORMANCE QUALIFICATION**

Process(es)	<u>GTAW SMAW</u>	Material (P-No.)	<u>P8</u>
Filler Metal Group (F-No.)	<u>F6 F5</u>	Min. Outside Pipe Diameter	<u>1" O.D.</u>
Max Deposited Weld Metal	<u>0.2" 0.236"</u>	Position(s) Qualified	<u>ALL</u>
Backing	<u>With/Without With</u>	Backing Gas	<u>With</u>
Progression	<u>Vert. Up Vert. Up</u>		
P.Q. Expiry Date	<u>Oct. 28/10</u>	Welding Examiner Signature	<u>David Mansfield</u>
		Examiner File No.	<u>E-00224</u>



**PYRAMID CORPORATION 7168**  
WELDER PERFORMANCE QUALIFICATION CARD A.O.Q.P. No.

Name: Carlos Espinosa ABSA File No: W-6580

This card is issued pursuant to the Alberta Safety Codes Act and the Pressure Welders Regulations. The performance qualification is in accordance with Section IX of the ASME Code and subject to the limitations on the reverse side.

Date of Test: Nov. 05, 2008 Signature of Welder or Machine Welding Operator: [Signature]

Welding Examiner (Print/Type): David Mansfield Card # **199**

**PERFORMANCE QUALIFICATION**

Process(es)	<u>GMAW SMAW</u>	Material (P-No.)	<u>PI-P11</u>
Filler Metal Group (F-No.)	<u>F6 FA</u>	Min. Outside Pipe Diameter	<u>1" O.D.</u>
Max Deposited Weld Metal	<u>0.132" 0.632"</u>	Position(s) Qualified	<u>ALL</u>
Backing	<u>With/Without With</u>	Backing Gas	<u>Without</u>
Progression	<u>Vert. Up Vert. Up</u>		
P.Q. Expiry Date	<u>Nov. 05/10</u>	Welding Examiner Signature	<u>David Mansfield</u>
		Examiner File No.	<u>E-00224</u>



# PYRAMID CORPORATION WELDING TICKET INFORMATION SHEET

Welders Name: Mario St-Amant

ABSA File No.: W-26190

Stamp No.: "R"

**PYRAMID CORPORATION 7168**  
WELDER PERFORMANCE QUALIFICATION CARD A.O.Q.P. No.

Name: Mario St-Amant ABSA File No. W-26190

This card is issued pursuant to the Alberta Safety Codes Act and the Pressure Welders Regulations. The performance qualification is in accordance with Section IX of the ASME Code and subject to the limitations on the reverse side.

Date of Test: March 11, 2008 Signature of Welder or Machine Welding Operator: [Signature]

The performance qualification is valid for two years from the date of test unless extended inside the card.

Welding Examiner (Print/Type): David Mansfield Card # **122**

**PERFORMANCE QUALIFICATION**

Process(es) GMAW SMAW Material (P-No.) PI-P11

Filler Metal Group (F-No.) F6 F4 Min. Outside Pipe Diameter 1" O.D.

Max Deposited Weld Metal 0.132" 0.632" Position(s) Qualified 1G-Flat

Backing with without With Backing Gas \_\_\_\_\_

Progression downhill n/a

P.Q. Expiry Date: Mar 11, 2010 Welding Examiner Signature: David Mansfield Examiner File No. E-00224

PYRAMID CORPORATION P.Q. EXPIRY DATE EXTENSION (in accordance with the Pressure Welders Regulation, Sect. 9(6))	Card No.: 122	Welding Examiner Signature																		
		Welding Examiner File Number																		

**PYRAMID CORPORATION 7168**  
WELDER PERFORMANCE QUALIFICATION CARD A.O.Q.P. No.

Name: Mario St. Amant ABSA File No. W-26190

This card is issued pursuant to the Alberta Safety Codes Act and the Pressure Welders Regulations. The performance qualification is in accordance with Section IX of the ASME Code and subject to the limitations on the reverse side.

Date of Test: June 10, 2008 Signature of Welder or Machine Welding Operator: [Signature]

The performance qualification is valid for two years from the date of test unless extended inside the card.

Welding Examiner (Print/Type): David Mansfield Card # **155**

**PERFORMANCE QUALIFICATION**

Process(es) SMAW SMAW Material (P-No.) PI-P11

Filler Metal Group (F-No.) F3 F4 Min. Outside Pipe Diameter 2 7/8" O.D.

Max Deposited Weld Metal 0.25" MTBW Position(s) Qualified Flat

Backing with without With Backing Gas \_\_\_\_\_

Progression Flat Flat

P.Q. Expiry Date: June 10/10 Welding Examiner Signature: David Mansfield Examiner File No. E-00224

PYRAMID CORPORATION P.Q. EXPIRY DATE EXTENSION (in accordance with the Pressure Welders Regulation, Sect. 9(6))	Card No.: 155	Welding Examiner Signature																		
		Welding Examiner File Number																		




# PYRAMID CORPORATION WELDING TICKET INFORMATION SHEET

Welders Name: Joel Baker


ABSA File No.: W-15804

Stamp No.: "A"




Grade "B" Pressure Welder's  
Certificate of Competency

This is to Certify that: Joel F. Baker  
having complied with provisions of the Safety Codes Act, is authorized to engage in  
pressure welding in accordance with the prescribed Regulations.



Forms No. AB-117 Rev (98/10)

Dated at Edmonton, this  
April 17, 1997





W-15804  
File No.

Les  
Chief Inspector and Administrator

N<sup>o</sup> 10620

APPRENTICE SHIP AND  
TRADE CERTIFICATION






**JOEL F. BAKER**  
is certified to engage in the trade of  
**WELDER**  
AS A JOURNEYMAN

EFFECTIVE: **MAY 10, 1988**

FILE: 12-A013116      13454P  
Joel Baker  
EXECUTIVE DIRECTOR



**PYRAMID CORPORATION**  
WELDER PERFORMANCE QUALIFICATION CARD

**7168**  
A.O.Q.P. No.

Name: Joel Baker      ABSA File No. W-15804

This card is issued pursuant to the Alberta Safety Codes Act and the Pressure Welders Regulations. The performance qualification is in accordance with Section IX of the ASME Code and subject to the limitations on the reverse side.


Oct 08 2008      Joel Baker  
Date of Test      Signature of Welder or Machine Welding Operator  
The performance qualification is valid for two years from the date of test unless extended inside the card.

David Mansfield  
Welding Examiner (Print/Type)      **Card # 183**

**PERFORMANCE QUALIFICATION**

Process(es)	<u>SMAW SMAW</u>	Material (P-No.)	<u>PI-P11</u>
Filler Metal Group (F-No.)	<u>F3 F4</u>	Min. Outside Pipe Diameter	<u>1" O.D.</u>
Max Deposited Weld Metal	<u>0.25" 0.622"</u>	Position(s) Qualified	<u>ALL</u>
Backing	<u>with/ without</u>	Backing Gas	<u>N/A</u>
Progression	<u>Vert. Up Vert. Up</u>		

Oct. 08/10      David Mansfield      E-00224  
P.Q. Expiry Date      Welding Examiner Signature      Examiner File No.



**PYRAMID CORPORATION**  
WELDER PERFORMANCE QUALIFICATION CARD

**7168**  
A.O.Q.P. No.

Name: Joel Baker      ABSA File No. W-15804

This card is issued pursuant to the Alberta Safety Codes Act and the Pressure Welders Regulations. The performance qualification is in accordance with Section IX of the ASME Code and subject to the limitations on the reverse side.

Oct. 08 2008      Joel Baker  
Date of Test      Signature of Welder or Machine Welding Operator  
The performance qualification is valid for two years from the date of test unless extended inside the card.

David Mansfield  
Welding Examiner (Print/Type)      **Card # 184**

**PERFORMANCE QUALIFICATION**

Process(es)	<u>GMAW SMAW</u>	Material (P-No.)	<u>PI-P11</u>
Filler Metal Group (F-No.)	<u>F6 F4</u>	Min. Outside Pipe Diameter	<u>1" O.D.</u>
Max Deposited Weld Metal	<u>0.132" 0.632"</u>	Position(s) Qualified	<u>1G-Flat</u>
Backing	<u>with/ without</u>	Backing Gas	<u>without</u>
Progression	<u>Flat Flat</u>		

Oct. 08/10      David Mansfield      E-00224  
P.Q. Expiry Date      Welding Examiner Signature      Examiner File No.

# PYRAMID CORPORATION WELDING TICKET INFORMATION SHEET

Welders Name: Joel Baker

ABSA File No.: W-15804

Stamp No.: "A"



**PYRAMID CORPORATION** **7168**  
WELDER PERFORMANCE QUALIFICATION CARD A.O.Q.P. No.

Name: Joel Baker ABSA File No: W-15804

This card is issued pursuant to the Alberta Safety Codes Act and the Pressure Welders Regulations. The performance qualification is in accordance with Section IX of the ASME Code and subject to the limitations on the reverse side.

Date of Test: Oct. 08, 2008 Signature of Welder or Machine Welding Operator: [Signature]

Welding Examiner (Print/Type): David Mansfield

Card # 185

### PERFORMANCE QUALIFICATION

Process(es)	<u>GMAW<sup>W</sup> (GTT)</u>	<u>SMAW</u>	Material (P-No.)	<u>P1-P11</u>
Filler Metal Group (F-No.)	<u>E6</u>	<u>E4</u>	Min. Outside Pipe Diameter	<u>1" O.D.</u>
Max Deposited Weld Metal	<u>0.132"</u>	<u>0.632"</u>	Position(s) Qualified	<u>ALL</u>
Backing	<u>without</u>	<u>with</u>	Backing Gas	<u>without</u>
Progression	<u>Downhill</u>	<u>Uphill</u>		
P.Q. Expiry Date	<u>Oct. 08/10</u>	Welding Examiner Signature	<u>David Mansfield</u>	Examiner File No. <u>E-00224</u>

# PYRAMID CORPORATION WELDING TICKET INFORMATION SHEET

Welders Name: Bertrand Beaulieu

ABSA File No.: W-25954

Stamp No.: "F"



20737

## Grade "B" Pressure Welder's Certificate of Competency



This is to certify that Bertrand Beaulieu  
having complied with provisions of the Safety Codes Act, is authorized to engage  
in pressure welding in accordance with the prescribed Regulations.

Dated at Edmonton  
February 28, 2007



W-25954  
File no.

*[Signature]*  
Chief Inspector and Administrator

Department of Post-Secondary  
Education, Training and Labour



Ministère de l'Éducation  
postsecondaire, de la Formation et  
du Travail

This will identify Bertrand Beaulieu  
I.a présente identifier \_\_\_\_\_  
as a Holder of a Certificate of Qualification in respect of the  
comme un détenteur-trice d'un Certificat d'aptitude professionnelle dans la profession de  
Welder \_\_\_\_\_ occupation  
Soudeur

This card issued  
Cette carte fut délivrée le 2006/12/15 Number 1582  
Original certificate issued  
certificat original délivré le 2006/12/15 Registration No  
No d'inscription 10064578  
Director of Apprenticeship and  
Certification *[Signature]*  
Directeur de l'apprentissage et  
certification



**PYRAMID CORPORATION 7168**  
WELDER PERFORMANCE QUALIFICATION CARD A.O.Q.P. No.  
Name: Bertrand Beaulieu ABSA File No: W-25954

This card is issued pursuant to the Alberta Safety Codes Act and the Pressure Welders  
Regulations. The performance qualification is in accordance with Section IX of the ASME  
Code and subject to the limitations on the reverse side.

Oct. 27/2008 *[Signature]*  
Date of Test Signature of Welder or Machine Welding Operator

David Mansfield  
Welding Examiner (Print/Type) Card # 194

### PERFORMANCE QUALIFICATION

Process(es)	<u>SMAW SMAW</u>	Material (P-No.)	<u>PI-P11</u>
Filler Metal Group (F-No.)	<u>F3 FA</u>	Min. Outside Pipe Diameter	<u>1" O.D.</u>
Max Deposited Weld Metal	<u>0.25" 0.622"</u>	Position(s) Qualified	<u>All</u>
Backing	<u>without with</u>	Backing Gas	<u>N/A</u>
Progression	<u>Vert. Up Vert. Up</u>		

Oct. 27/10 David Mansfield E-00224  
P.Q. Expiry Date Welding Examiner Signature Examiner File No.

**PYRAMID CORPORATION 7168**  
WELDER PERFORMANCE QUALIFICATION CARD A.O.Q.P. No.  
Name: Bertrand Beaulieu ABSA File No: W-25954

This card is issued pursuant to the Alberta Safety Codes Act and the Pressure Welders  
Regulations. The performance qualification is in accordance with Section IX of the ASME  
Code and subject to the limitations on the reverse side.

Oct. 27/2008 *[Signature]*  
Date of Test Signature of Welder or Machine Welding Operator

David Mansfield  
Welding Examiner (Print/Type) Card # 195

### PERFORMANCE QUALIFICATION

Process(es)	<u>GTAW SMAW</u>	Material (P-No.)	<u>PI-P11</u>
Filler Metal Group (F-No.)	<u>F6 FA</u>	Min. Outside Pipe Diameter	<u>1" O.D.</u>
Max Deposited Weld Metal	<u>0.132" 0.632"</u>	Position(s) Qualified	<u>IG-Flat</u>
Backing	<u>without with</u>	Backing Gas	<u>without</u>
Progression	<u>Flat Flat</u>		

Oct. 27/10 David Mansfield E-00224  
P.Q. Expiry Date Welding Examiner Signature Examiner File No.



# PYRAMID CORPORATION WELDING TICKET INFORMATION SHEET

Welders Name: Karsten Czulay

ABSA File No.: W-26226

Stamp No.: "K"



21347

## Grade "B" Pressure Welder's Certificate of Competency



W-26226  
File no.

Dated at Edmonton  
September 14, 2007

*[Signature]*  
Chief Inspector and Administrator

**Alberta**  
GOVERNMENT

**QUALIFICATION CERTIFICATE**

THIS IS TO CERTIFY THAT  
**KARSTEN CZULAY**  
HAS ACHIEVED THE STANDARDS ESTABLISHED  
UNDER THE ALBERTA APPRENTICESHIP AND INDUSTRY TRAINING ACT  
AND IS HEREBY AUTHORIZED TO WORK IN THE TRADE AS A JOURNEYMAN  
AND TO USE THE TITLE CERTIFIED JOURNEYMAN

WELDER

EFFECTIVE DATE: July 25th, 2006  
ISSUE DATE: August 8th, 2006

*[Signature]*  
HONOURABLE DENIS HERARD  
MINISTER OF ADVANCED EDUCATION

*[Signature]*  
SHIRLEY DUL, EXECUTIVE  
DIRECTOR OF APPRENTICESHIP  
& INDUSTRY TRAINING



### WELDING PERFORMANCE QUALIFICATION

**KARSTEN CZULAY**  
Name

is qualified as a Grade B Pressure Welder. This card is issued pursuant to the Safety Codes Act and Pressure Welders Regulation, subject to the limitations on the reverse side.

07-09-14  
Date of Test

*[Signature]*  
Signature of Welder

*[Signature]*  
Safety Codes Officer

File W-26226

### PERFORMANCE QUALIFICATION

(In accordance with Section IX, A.S.M.E. Code)  
Form No. AB-118 Rev (10/2006)

Process	SMAW	SMAW	Material	P1 to P1
Max Deposited Weld Metal	6 mm	16 mm	Minimum Pipe Dia.	NPS 2 1/2
Filler Metal Group	F3	F4	Position Qualified	ALL
Backing	No	Yes	Progression	Uphill
09-09-14 Date of Expiry		<i>[Signature]</i> Signature of Safety Codes Officer		



### PYRAMID CORPORATION WELDER PERFORMANCE QUALIFICATION CARD

**7168**  
A.O.Q.P. No

Name: **Karsten Czulay** ABSA File No: **W-26226**

This card is issued pursuant to the Alberta Safety Codes Act and the Pressure Welders Regulations. The performance qualification is in accordance with Section IX of the ASME Code and subject to the limitations on the reverse side.

Sept. 17, 2007  
Date of Test

*[Signature]*  
Signature of Welder or Machine Welding Operator

*[Signature]*  
Welding Examiner (Print/Type)

Card # 081

### PERFORMANCE QUALIFICATION

Process(es)	GMAW SMAW	Material (P-No.)	PI-P11
Filler Metal Group (F-No.)	F6 FA	Min. Outside Pipe Diameter	1" OD
Max Deposited Weld Metal	0.132" 0.632"	Position(s) Qualified	1G-Flat
Backing	without with	Backing Gas	
Progression	Downhill N/A		
Sept. 17/09 P.Q. Expiry Date	<i>[Signature]</i> Welding Examiner Signature	E-00224 Examiner File No.	

# PYRAMID CORPORATION WELDING TICKET INFORMATION SHEET

Welders Name: Karsten Czulay

ABSA File No.: W-26226

Stamp No.: "K"

<b>PYRAMID CORPORATION</b> Card No.: 081 <b>P.Q. EXPIRY DATE EXTENSION</b> <small>(In accordance with the Pressure Welders Regulation Sect. 89)</small>	Welding Examiner Signature																			
	Welding Examiner File Number																			

**PYRAMID CORPORATION 7168**  
**WELDER PERFORMANCE QUALIFICATION CARD** A.O.Q.P. No.

Name: Karsten Czulay ABSA File No. W-26226

This card is issued pursuant to the Alberta Safety Codes Act and the Pressure Welders Regulations. The performance qualification is in accordance with Section IX of the ASME Code and subject to the limitations on the reverse side.

Date of Test: Sept. 17, 2007 Signature of Welder or Machine Welding Operator: [Signature]

The performance qualification is valid for two years from the date of test unless extended inside the card.

Welding Examiner (Print/Type): David Mansfield Card # **082**

**PERFORMANCE QUALIFICATION**

Process(es)	<u>SMAW SMAW</u>	Material (P-No.)	<u>P1-P11</u>
Filler Metal Group (F-No.)	<u>F3 F4</u>	Min. Outside Pipe Diameter	<u>1" OD</u>
Max Deposited Weld Metal	<u>0.25" 0.622"</u>	Position(s) Qualified	<u>6G-ALL</u>
Backing	<u>with without</u>	Backing Gas	
Progression	<u>Vertical up Vertical up</u>		

P.Q. Expiry Date: Sept. 17/09 Welding Examiner Signature: David Mansfield Examiner File No.: E-00224

<b>PYRAMID CORPORATION</b> Card No.: 082 <b>P.Q. EXPIRY DATE EXTENSION</b> <small>(In accordance with the Pressure Welders Regulation Sect. 89)</small>	Welding Examiner Signature																			
	Welding Examiner File Number																			

**PYRAMID CORPORATION 7168**  
**WELDER PERFORMANCE QUALIFICATION CARD** A.O.Q.P. No.

Name: Karsten Czulay ABSA File No. W-26226

This card is issued pursuant to the Alberta Safety Codes Act and the Pressure Welders Regulations. The performance qualification is in accordance with Section IX of the ASME Code and subject to the limitations on the reverse side.

Date of Test: Oct. 02, 2007 Signature of Welder or Machine Welding Operator: [Signature]

The performance qualification is valid for two years from the date of test unless extended inside the card.

Welding Examiner (Print/Type): David Mansfield Card # **089**

**PERFORMANCE QUALIFICATION**

Process(es)	<u>GMAW SMAW</u>	Material (P-No.)	<u>P1-P11</u>
Filler Metal Group (F-No.)	<u>F6 F4</u>	Min. Outside Pipe Diameter	<u>1" OD</u>
Max Deposited Weld Metal	<u>0.132" 0.632"</u>	Position(s) Qualified	<u>6G-ALL</u>
Backing	<u>with without</u>	Backing Gas	
Progression	<u>Downhill Uphill</u>		

P.Q. Expiry Date: Oct. 02/09 Welding Examiner Signature: David Mansfield Examiner File No.: E-00224




















# PYRAMID CORPORATION WELDING TICKET INFORMATION SHEET

Welders Name: Trevor Friesen

ABSA File No.: W-20371

Stamp No.: "XX"




Grade IV Pressure Welder's  
Certificate of Competence

This is to Certify that **Trevor Friesen**  
having complied with provisions of the Safety Codes Act, is authorized to engage in  
pressure welding in accordance with the prescribed Regulations.

Dated at Edmonton, this  
**July 10, 2002**

**W- 20371**




15156

012744633 44379A

THIS IS TO CERTIFY THAT  
**TREVOR WAYNE FRIESEN**  
HAS COMPLETED AN ALBERTA APPRENTICESHIP PROGRAM AND HAVING ACHIEVED  
THE STANDARDS ESTABLISHED UNDER THE ALBERTA APPRENTICESHIP AND  
INDUSTRY TRAINING ACT IS HEREBY AUTHORIZED TO WORK IN THE TRADE AS A  
JOURNEYMAN AND TO USE THE TITLE CERTIFIED JOURNEYMAN

WELDER

EFFECTIVE DATE: December 29th, 2001      ISSUE DATE: January 6th, 2002

  
SHIRLEY DUL EXECUTIVE  
DIRECTOR OF APPRENTICESHIP  
& INDUSTRY TRAINING



**PYRAMID PROCESS FABRICATORS 7168**  
WELDER PERFORMANCE QUALIFICATION CARD A.O.Q.P. No.

Name: Trevor Friesen      ABSA File No. W-20371

This card is issued pursuant to the Alberta Safety Codes Act and the Pressure Welders Regulations. The performance qualification is in accordance with Section IX of the ASME Code and subject to the limitations on the reverse side.

Nov. 07, 2008      [Signature]  
Date of Test      Signature of Welder or Machine Welding Operator

David Mansfield  
Welding Examiner (Print/Type)      **Card # 201**

**PERFORMANCE QUALIFICATION**

Process(es)	<u>SMAW SMAW</u>	Material (P-No)	<u>PI-P11</u>
Filler Metal Group (F-No)	<u>F3 FA</u>	Min. Outside Pipe Diameter	<u>1" O.D.</u>
Max. Deposited Weld Metal	<u>0.25" 0.622"</u>	Position(s) Qualified	<u>ALL</u>
Backing	<u>Without With</u>	Backing Gas	<u>N/A</u>
Progression	<u>Vert. Up Vert. Up</u>		
P.Q. Expiry Date	<u>Nov. 07/10</u>	Welding Examiner Signature	<u>David Mansfield</u>
		Examiner File No.	<u>E-00224</u>

**PYRAMID PROCESS FABRICATORS 7168**  
WELDER PERFORMANCE QUALIFICATION CARD A.O.Q.P. No.

Name: Trevor Friesen      ABSA File No. W-20371

This card is issued pursuant to the Alberta Safety Codes Act and the Pressure Welders Regulations. The performance qualification is in accordance with Section IX of the ASME Code and subject to the limitations on the reverse side.

Nov. 07, 2008      [Signature]  
Date of Test      Signature of Welder or Machine Welding Operator

David Mansfield  
Welding Examiner (Print/Type)      **Card # 202**

**PERFORMANCE QUALIFICATION**

Process(es)	<u>GMAW SMAW</u>	Material (P-No)	<u>PI-P11</u>
Filler Metal Group (F-No)	<u>F6 FA</u>	Min. Outside Pipe Diameter	<u>1" O.D.</u>
Max. Deposited Weld Metal	<u>0.132" 0.632"</u>	Position(s) Qualified	<u>Flat</u>
Backing	<u>Without With</u>	Backing Gas	<u>Without</u>
Progression	<u>Flat Flat</u>		
P.Q. Expiry Date	<u>Nov. 07/10</u>	Welding Examiner Signature	<u>David Mansfield</u>
		Examiner File No.	<u>E-00224</u>

# PYRAMID CORPORATION WELDING TICKET INFORMATION SHEET

Welders Name: Shane Basinger

ABSA File No.: W-19957

Stamp No.: "H"



Form No. AB-117 (Rev. 09/00)

## Grade 'D' Pressure Welders Certificate of Competence

This is to Certify that: Shane Basinger  
having complied with provisions of the Safety Codes Act is authorized to engage in  
pressure welding in accordance with the prescribed Regulations.

Dated at Edmonton, this  
**January 24, 2002**



W- 19957

File No.

*[Signature]*  
Chief Inspector and Administrator

14798

012/315349 43953A

THIS IS TO CERTIFY THAT  
**SHANE JOHN BASINGER**  
HAS COMPLETED AN ALBERTA APPRENTICESHIP PROGRAM AND HAVING ACHIEVED  
THE STANDARDS ESTABLISHED UNDER THE ALBERTA APPRENTICESHIP AND  
INDUSTRY TRAINING ACT, IS HEREBY AUTHORIZED TO WORK IN THE TRADE AS A  
JOURNEYMAN AND TO USE THE TITLE CERTIFIED JOURNEYMAN

WELDER

EFFECTIVE DATE: November 6th, 2001      ISSUE DATE: November 29th, 2001

*[Signature]*      *[Signature]*  
DR. LYLE OBERG, MINISTER OF LEARNING      MURIEL DUL, EXECUTIVE DIRECTOR OF APPRENTICESHIP & INDUSTRY TRAINING



**PYRAMID CORPORATION** **7168**  
WELDER PERFORMANCE QUALIFICATION CARD      A.O.Q.P. No.

Name: Shane Basinger      ABSA File No. W-19957

This card is issued pursuant to the Alberta Safety Codes Act and the Pressure Welders Regulations. The performance qualification is in accordance with Section IX of the ASME Code and subject to the limitations on the reverse side.

Date of Test: Sept. 03, 2008      *[Signature]*  
Signature of Welder or Machine Welding Operator

The performance qualification is valid for two years from the date of test unless extended inside the card.

David Mansfield      Card # **172**  
Welding Examiner (Print/Type)

PERFORMANCE QUALIFICATION			
Process(es)	<u>SMAW SMAW</u>	Material (P-No.)	<u>PI-P11</u>
Filler Metal Group (F-No.)	<u>F3 F4</u>	Min. Outside Pipe Diameter	<u>1" OD</u>
Max Deposited Weld Metal	<u>0.25" 0.622"</u>	Position(s) Qualified	<u>ALL</u>
Backing	<u>With/ Without</u>	Backing Gas	<u>N/A</u>
Progression	<u>Vert. Up Vert. Up</u>		
P.Q. Expiry Date	<u>Sept. 03/10</u>	Welding Examiner Signature	<u>David Mansfield</u>
		Examiner File No.	<u>E-00224</u>

**PYRAMID CORPORATION** **7168**  
WELDER PERFORMANCE QUALIFICATION CARD      A.O.Q.P. No.

Name: Shane Basinger      ABSA File No. W-19957

This card is issued pursuant to the Alberta Safety Codes Act and the Pressure Welders Regulations. The performance qualification is in accordance with Section IX of the ASME Code and subject to the limitations on the reverse side.

Date of Test: Sept. 03, 2008      *[Signature]*  
Signature of Welder or Machine Welding Operator

The performance qualification is valid for two years from the date of test unless extended inside the card.

David Mansfield      Card # **173**  
Welding Examiner (Print/Type)

PERFORMANCE QUALIFICATION			
Process(es)	<u>GMAW SMAW</u>	Material (P-No.)	<u>PI-P11</u>
Filler Metal Group (F-No.)	<u>F6 F4</u>	Min. Outside Pipe Diameter	<u>1" OD</u>
Max Deposited Weld Metal	<u>0.132" 0.632"</u>	Position(s) Qualified	<u>IG-Flat</u>
Backing	<u>With/ Without</u>	Backing Gas	<u>Without</u>
Progression	<u>Flat Flat</u>		
P.Q. Expiry Date	<u>Sept. 03/10</u>	Welding Examiner Signature	<u>David Mansfield</u>
		Examiner File No.	<u>E-00224</u>

# PYRAMID CORPORATION WELDING TICKET INFORMATION SHEET

Welders Name: Shane Basinger

ABSA File No.: W-19957

Stamp No.: "H"



**PYRAMID CORPORATION 7168**  
WELDER PERFORMANCE QUALIFICATION CARD A.O.Q.P. No.

Name: Shane Basinger ABSA File No: W-19957

This card is issued pursuant to the Alberta Safety Codes Act and the Pressure Welders Regulations. The performance qualification is in accordance with Section IX of the ASME Code and subject to the limitations on the reverse side.

Date of Test: Sept. 04, 2008 Signature of Welder or Machine Welding Operator: [Signature]

Welding Examiner (Print/Type): David Mansfield Card # **174**

**PERFORMANCE QUALIFICATION**

Process(es) GMAW (GT) SHAW Material (P-No.) PI-P11  
 Filler Metal Group (F-No.) F6 FA Min. Outside Pipe Diameter 1" OD  
 Max Deposited Weld Metal 0.132" 0.632" Position(s) Qualified ALL  
 Backing Without With Backing Gas Without  
 Progression Downhill Uphill

P.Q. Expiry Date: Sept. 04/10 Welding Examiner Signature: David Mansfield Examiner File No.: E-00224



**PYRAMID PROCESS FABRICATORS 7168**  
WELDER PERFORMANCE QUALIFICATION CARD A.O.Q.P. No.

Name: Shane Basinger ABSA File No: W-19957

This card is issued pursuant to the Alberta Safety Codes Act and the Pressure Welders Regulations. The performance qualification is in accordance with Section IX of the ASME Code and subject to the limitations on the reverse side.

Date of Test: Nov. 13, 2008 Signature of Welder or Machine Welding Operator: [Signature]

Welding Examiner (Print/Type): David Mansfield Card # **203**

**PERFORMANCE QUALIFICATION**

Process(es) GTAW SMAW Material (P-No.) P1  
 Filler Metal Group (F-No.) F6 FA Min. Outside Pipe Diameter 1" O.D.  
 Max Deposited Weld Metal 0.25" 0.622" Position(s) Qualified ALL  
 Backing Without With Backing Gas With/Without  
 Progression Vert. Up Vert. Up

P.Q. Expiry Date: Nov. 13/10 Welding Examiner Signature: David Mansfield Examiner File No.: E-00224

# PYRAMID CORPORATION WELDING TICKET INFORMATION SHEET

Welders Name: Tyler Kozubski

ABSA File No.: W-24784

Stamp No.: "T"



20497

## Grade "T" Pressure Welder's Certificate of Competence



This is to certify that **Tyler Kozubski**  
having complied with provisions of the Safety Codes Act, is authorized to engage  
in pressure welding in accordance with the prescribed Regulations.

Dated at Edmonton  
December 14, 2006



W-24784

File no

*[Signature]*  
Chief Inspector and Administrator

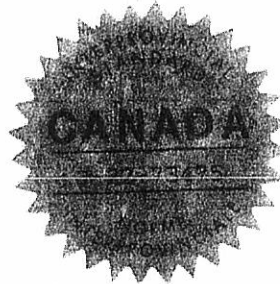
012/927604 65570A

THIS IS TO CERTIFY THAT  
**TYLER KOZUBSKI**  
HAS COMPLETED AN ALBERTA APPRENTICESHIP PROGRAM AND HAVING ACHIEVED  
THE STANDARDS ESTABLISHED UNDER THE ALBERTA APPRENTICESHIP AND  
INDUSTRY TRAINING ACT IS HEREBY AUTHORIZED TO WORK IN THE TRADE AS A  
JOURNEYMAN AND TO USE THE TITLE CERTIFIED JOURNEYMAN

WELDER

EFFECTIVE DATE: January 20th 2005      ISSUE DATE: March 16th 2005

**Alberta** GOVERNMENT  
HONOURABLE DAVID MANNSFIELD      MINISTER OF ADVANCED EDUCATION



*[Signature]*



### PYRAMID CORPORATION      7168 WELDER PERFORMANCE QUALIFICATION CARD      A.O.Q.P. No.

Name: Tyler Kozubski      ABSA File No: W-24784

This card is issued pursuant to the Alberta Safety Codes Act and the Pressure Welders Regulations. The performance qualification is in accordance with Section IX of the ASME Code and subject to the limitations on the reverse side.

Date of Test: Oct. 09/2008      Signature of Welder or Machine Welding Operator: *[Signature]*

David Mansfield      Card # 196  
Welding Examiner (Print/Type)

#### PERFORMANCE QUALIFICATION

Process(es)	<u>SMAW SMAW</u>	Material (P-No.)	<u>PI-PII</u>
Filler Metal Group (F-No.)	<u>F3 F4</u>	Min. Outside Pipe Diameter	<u>2 1/8" O.D.</u>
Max Deposited Weld Metal	<u>0.25" 0.614"</u>	Position(s) Qualified	<u>6G-ALL</u>
Backing	<u>without with</u>	Backing Gas	<u>N/A</u>
Progression	<u>Vert. Up Vert. Up</u>		

Oct. 09/10      David Mansfield      E-00224  
P.Q. Expiry Date      Welding Examiner Signature      Examiner File No.



### PYRAMID CORPORATION      7168 WELDER PERFORMANCE QUALIFICATION CARD      A.O.Q.P. No.

Name: Tyler Kozubski      ABSA File No: W-24784

This card is issued pursuant to the Alberta Safety Codes Act and the Pressure Welders Regulations. The performance qualification is in accordance with Section IX of the ASME Code and subject to the limitations on the reverse side.

Date of Test: Nov. 13/2008      Signature of Welder or Machine Welding Operator: *[Signature]*

David Mansfield      Card # 200  
Welding Examiner (Print/Type)

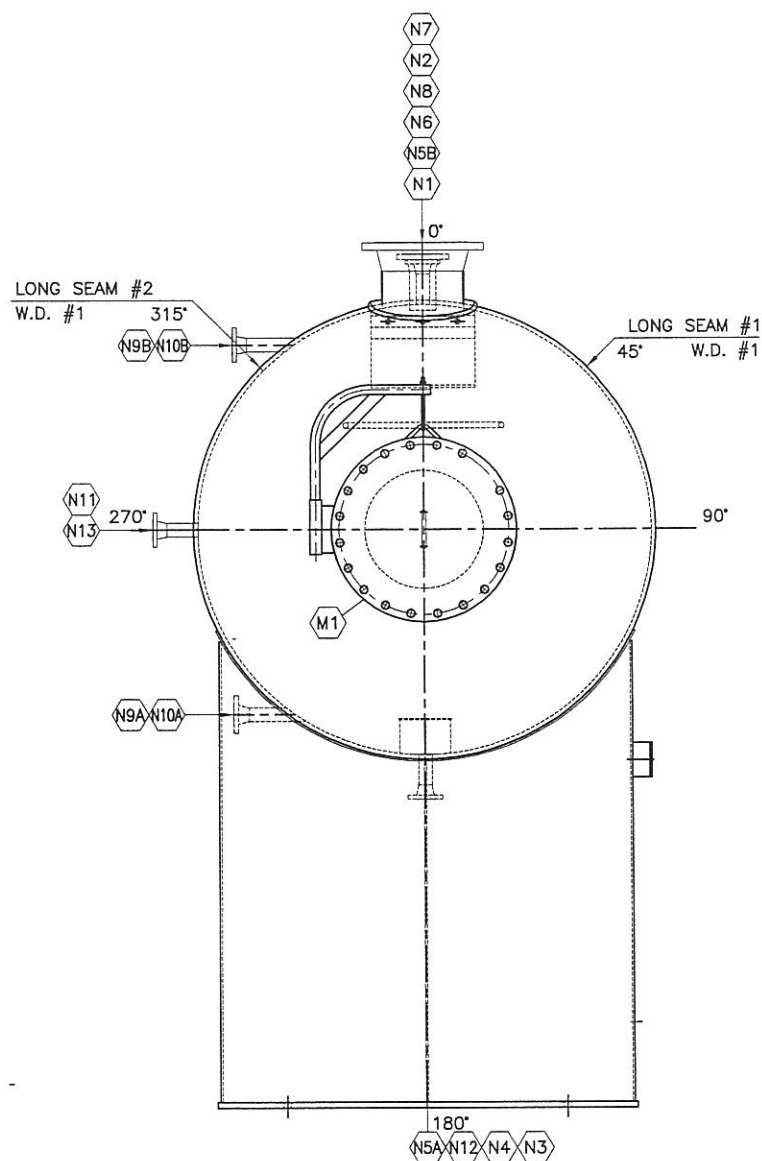
#### PERFORMANCE QUALIFICATION

Process(es)	<u>SMAW SMAW</u>	Material (P-No.)	<u>PI-PII</u>
Filler Metal Group (F-No.)	<u>F6 F4</u>	Min. Outside Pipe Diameter	<u>1" O.D.</u>
Max Deposited Weld Metal	<u>0.132" 0.632"</u>	Position(s) Qualified	<u>1G-Flat</u>
Backing	<u>without with</u>	Backing Gas	<u>Without</u>
Progression	<u>Flat Flat</u>		

Nov. 13/10      David Mansfield      E-00224  
P.Q. Expiry Date      Welding Examiner Signature      Examiner File No.

Q.C. VESSEL WELD MAPPING					
WELD#	WELDER ID	WELD TYPE	NDT REPORTS	DATE	WPS#
N1	S	C	3406	Dec 10/08	22R2/11/11F-02
N1	V	D			
N2	V	PAD OD			
N2	S	C	3400	DEC 10/08	
N2	V	D			
N2	V	PAD OD			
N3	S	C	3006	Nov 20/08	
N3	V	D			
N4	S	C	3006	Nov 20/08	
N4	V	D			
NSA	S	C	3006	Nov 20/08	
NSB	V	D			
NSB	H	C			
NSB	XX	D			
N6	S	C	3006	Nov 20/08	
N7	XX	D			
N7	S	C	3006	Nov 20/08	
N7	F	D			
N8	S	C	3006	Nov 20/08	
N8	XX	D			
N9A	H	C			
N9A	XX	D			
N9B	H	C			
N9B	V	D			

Q.C. VESSEL WELD MAPPING					
WELD#	WELDER ID	WELD TYPE	NDT REPORTS	DATE	WPS#
N10A	H	C			
N10A	T	D			
N10B	H	C			
N10B	XX	D			
N11	H	C			
N11	T	D			
N12	H	C			
N12	XX	D			
N13	H	C			
N13	T	D			
M1	S	C	3060	Nov 24/08	
M1	T	D			
M1	T	PAD OD			
CS1	W/K/LZ	B	3534/3535	DEC 20/08	
CS2	A/F/K	B	3056/3057	Nov 24/08	
CS3	F/W/A	B	3058/3059	Nov 24/08	
LS1	W/XX	A	3425/3500	DEC 10/08	
LS2	K/T	A	3060	Nov 24/08	



# DPH FOCUS JOB # 9971

LS  
08/06/02

WELDING PROCEDURE SPECIFICATION NO: PEC-11

WELDING PROCEDURE QUALIFICATION RECORD NO (S): PEC-10-3, PEC-10-4

## QUALIFIED FOR

Base Metal (Typical): P1 Groups 1 & 2 to P1 Groups 1 & 2 (SA 333 Gr.6, SA 420 WPL6, SA 350 Gr. LF2, SA 516 Gr.70 etc.)  
 Process(es): SMAW Weld Types: GROOVE & FILLET  
 Position: FLAT Diameter: ALL DIAMETERS  
 Filler Metal: E6010, E7018-1

## BASE METAL CONDITIONS & THICKNESS RANGE QUALIFIED:

### NOTCH TOUGHNESS APPLICATIONS WITH P.W.H.T.:

ASME B31.1	<u>12.7 to 203.2mm (0.500 to 8.00 in.) inclusive.</u>
ASME B31.3	<u>12.7 to 203.2mm (0.500 to 8.00 in.) inclusive.</u>
ASME SECT. VIII, DIV.1	<u>12.7 to 203.2mm (0.500 to 8.00 in.) inclusive.</u>

**ALBERTA  
LABOUR**

**BOILERS & PRESSURE VESSELS ACT  
WELDING PROCEDURE**

Reg. No. WP: 1688-Z

Spec No. PEC-11

Weld Process SMAW

Matl. Gr. P No. 1 Gr. 1Z to P No. 1 Gr. 1Z

Elec. Gr. F No. 3+4 A No. 1

Th. Qual. For. 12.7 to 203.2mm PWHT YES

CVR-46°C

Yr. 99 Mo. 9 Day 6 Signed R. Roseberg  
**R. ROSEBERG, P. ENG.  
WELDING SPECIALIST**

**PROVINCIAL REGISTRATION**

VENDOR CONTROL

RECEIVED  
 JUN 26 2008  
 DPH FOCUS CORP.

**VENDOR DRAWING REVIEW**

A. Reviewed without comment. Proceed. Provide As-Built drawing.

B. Reviewed with comments. Reissue For Construction. Proceed with fabrication.

C. Reviewed with comments. Reissue For Review. Proceed with material order only.

D. Reviewed with comments. Reissue For Review. DO NOT proceed with mat'l. or fabr.

E. \_\_\_\_\_

RETURN REPRODUCIBLE DWG. BY VIA

DATE July 7 SIGNED [Signature]



# DPH FOCUS JOB # 9971

LH  
08/06/02

PYRAMID CORPORATION  
2308-8 STREET  
NISKU, ALBERTA

WELDING PROCEDURE SPECIFICATION NO: PEC-22 Rev 1

WELDING PROCEDURE QUALIFICATION RECORD NO (S): PEC-22.1, PEC-22.2  
PEC-22.3, PEC-22.4

QUALIFIED FOR

Base Metal (Typical): P1 Gr 1&2 to P1 Gr 1&2 (SA 333 Gr.6, SA 350 Gr.LF2 C11,  
SA 420 WPL6, SA 516 Gr. 70, SA 516 Gr. 60 etc)  
Process(es): GMAW/SMAW/SAW Weld Types: GROOVE & FILLET  
Position: GMAW: ALL POSITIONS, SMAW & SAW: FLAT & HORIZONTAL  
Diameter: ALL DIAMETERS  
Filler Metal: ER-70S-2 OR 6 / E7018-1/F7A6-EM12K  
Application: NOTCH TOUGHNESS TO -50F WITH PWHT

BASE METAL CONDITIONS & THICKNESS RANGE QUALIFIED:

NOTCH TOUGHNESS APPLICATIONS TO -50F

ASME B31.1	0.125 to 0.75 in. inclusive.
ASME B31.3	0.125 to 0.75 in. inclusive.
ASME SECT. VIII, DIV.1	0.125 to 1.5 in. inclusive.

ALBERTA BOILERS SAFETY ASSOCIATION  
PROVINCE OF ALBERTA  
SAFETY CODES ACT  
WELDING PROCEDURE

Reg. No. WP 1688.2  
Spec No. PEC-22 (REV.2)  
Weld Process GMAW/SMAW/SAW  
Matl. Gr. P No. 1 Gr. 1&2 to P No. 1 Gr. 1&2  
Elec. Gr. F No. 6+4+6 A No. 1  
Th. Qual. For 38.1mm PWHT YES  
MIN Th. Qual 3.2mm FOR CVN-46C

Yr. 07 Mo. 03 Day 25 Signed [Signature]  
R. ROSEBERG, P.ENG.  
WELDING SPECIALIST

PROVINCIAL REGISTRATION

VENDOR CONTROL

RECEIVED  
JUN 26 2008  
DPH FOCUS CORP.

VENDOR DRAWING REVIEW

- A. Reviewed without comment. Proceed. Provide As-Built drawing.
- B. Reviewed with comments. Reissue For Construction. Proceed with fabrication.
- C. Reviewed with comments. Reissue For Review. Proceed with material order only.
- D. Reviewed with comments. Reissue For Review. DO NOT proceed with mat'l. or fabr.
- E. \_\_\_\_\_

RETURN REPRODUCIBLE DWG. BY NIA  
DATE July 2 SIGNED [Signature]

QW-482 WELDING PROCEDURE SPECIFICATION (WPS)

## Certificate of Compliance

Customer PYRAMID CORPORATION	PO 613278-00	Work Order C75199	Date 2008/06/13	CofC# 1916	Page 1 of 1
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Item#	Description	Qty	Heat#	Certified Min Thk	Form. Proc.
H75199-1	HEAD(S) - Semi-Elliptical 2:1 - 0.7500" NOM (0.6875"_MIN) X 78" ID (Material Spec: SA 516-70 Normalized) Conforms to NACE MR0175 / ISO 15156-2 2003 Annex A	2	G2500-872031310	0.6900"	1

**Forming Procedure:**  
 1. Hot Formed @ 1650F/899C and Air Cooled

**Brinell Equipment:** Newage Calibrated Pin  
 Brinell Hardness Tester

### Supplementary Requirements

**Normalized Material Identification Marking:**  
 'MT' indicates normalized by the mill per ASME Code Section II, part A, SA 20, para. 13.1.1.  
 'GMT' indicates normalized by Edmonton Exchanger per ASME Code Section II, part A, SA 20, para. 13.1.2.  
 'GT' indicates normalized by Edmonton Exchanger per ASME Code Section VIII Div. 1, UG-85 or ASME Code Section I, PG-77.4.

The heads listed above (if applicable) comply with the requirements of ASME Code Section I, PG-29 and Section VIII, Div. 1, UCS-79(d), UG-79 & UG-81. All welders and procedures are qualified to ASME Code Section IX. For tacking carbon steel items, roundbar used is 1018 Cold Rolled. Material being supplied conforms to the latest ASME Code Section II, Part A, 2007 Edition, Addenda July 1, 2007.

Steve Zubryckj (QAM)

### Supplementary Examination - Items









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新日本製鐵株式会社  
Nippon Steel Corporation

鋼材検査証明書  
INSPECTION CERTIFICATE

社 100-8071 東京都千代田区大手町二丁目6番3号  
HEAD OFFICE 2-6-3, OTEMACHI, CHIYODA-KU, TOKYO 100-8071, JAPAN  
君津製鐵所 〒299-1141 千葉県君津市君津1番地  
KIMITSU WORKS 1, KIMITSU, KIMITSU-CITY, CHIBA-PREF, 299-1141, JAPAN

注文者: HANWA CO., LTD.  
注文者照合番号: 228-38571030  
契約番号: 7-831-H1-5-0-A101  
商品名: HOT ROLLED STEEL PLATES  
規格: ASME SA-516 GRADE 70 / SA-537 CLASS 1-E (AS PER EN 10204 CERTIFICATE ON MATERIAL TESTS 3.1)  
文書番号: EDIMONTON EXCHANGER GROUP OF C-CUSTOMER : OMPANIES

証明書番号: P-91465 PAGE 19E  
発行年月日: 2007-11-22  
DATE OF ISSUE: 1001

需要家管理番号: E3001P04Q1 E07  
CUSTOMER'S CONTROL No.

Table with columns: 寸法 (DIMENSION), 質量 (MASS), 製鋼番号 (CAST No.), 試験番号 (TEST No.), 製品番号 (PLATE No.), 引張試験 (TENSILE TEST), 衝撃試験 (IMPACT TEST), 化学成分 (CHEMICAL COMPOSITION %). Includes detailed test results and chemical composition data.

注釈 (NOTES): 1. Location Orientation 位置・方向, 2. 底面 Bottom, L: 圧延方向 Longitudinal, C: 直方向 Transverse, Z: 縦厚方向 Through Thickness, R: 45° 方向 45Deg. to the Longitudinal Axis... 5. 合格 Acceptable, 6. 欠り Reduction of Area, Y.R.: 降伏比 Yield Ratio, 7. N: 焼正 Normalized, Q: 焼入 Quenched, T: 焼戻し Tempered, CR: Controlled Rolled, N I C: NIG Process/TMC Process, C.L.C: CLC Process/TMC Process, A.R: As Rolled, T.M.R: TMR Process/TMC Process, N.R: Normalizing Rolled, S.H: 粒性基準 Shear Fracture, C.F: 粒性基準 Crystallinity Fracture, L.E: 横断出 Lateral Expansion, A.G.S: オーステナイト程度 Austenite Grain Size, F.G.S: フェライト程度 Ferrite Grain Size, S.R: Stress Relieved/Post Weld Heat Treatment

上記注文品は御指定の規格または仕様に従って製造され、その要求事項を満足していることを証明します。

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN MADE IN ACCORDANCE WITH THE RULES OF THE CONTRACT.



J. Adachi

君津製鐵所厚板管理グループリーダー  
GROUP MANAGER  
PLATE QUALITY CONTROL DEPT.  
KIMITSU WORKS



# Edmonton Exchanger & Manufacturing Ltd.

5545-89 Street, Edmonton, Alberta T6E 5W9  
 Telephone (780) 468-6722 Fax (780) 466-5155

QCC-004  
 Rev.4  
 Date: April 1, 2005  
 Approved By: S.Z.

## Certificate of Compliance

Customer PYRAMID CORPORATION	PO 613278-00	Work Order C75199	Date 2008/07/02	CofC# 2315	Page 1 of 1
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Item#	Description	Qty	Heat#	Brinell Hardn.	Weld Proc.	Form. Proc.
S75199-2-1	SHELL(S) - 0.7500" NOM X 78" ID X 120" (Material Spec: SA 516-70 Normalized) <b>Conforms to NACE MR0175 / ISO 15156-2 2003 Annex A</b>	1	414807-8321193300	138	WP-600	4
S75199-2-2	SHELL(S) - 0.7500" NOM X 78" ID X 120" (Material Spec: SA 516-70 Normalized) <b>Conforms to NACE MR0175 / ISO 15156-2 2003 Annex A</b>	1	414807-8321190300	145	WP-600	4
S75199-3	COUPON(S) - 0.7500" NOM X 24" X 6" (Material Spec: SA 516-70 Normalized) <b>Conforms to NACE MR0175 / ISO 15156-2 2003 Annex A</b>	1	414807-8321190300	145	-	-

**Forming Procedure:**

4. Cold Formed

**Brinell Equipment:** Newage Calibrated Pin  
 Brinell Hardness Tester

**Supplementary Requirements**

**STRONGBACKS USED FOR SUPPORT. TACK WELD PROCEDURE WP-2 APPLIES. SA 516-70N MAT'L.**

**Normalized Material Identification Marking:**

- 'MT' indicates normalized by the mill per ASME Code Section II, part A, SA 20, para. 13.1.1.
- indicates normalized by Edmonton Exchanger per ASME Code Section II, part A, SA 20, para. 13.1.2.
- icates normalized by Edmonton Exchanger per ASME Code Section VIII Div. 1, UG-85 or ASME Code Section I, PG-77.4.

**The items listed above (if applicable) comply with the requirements of ASME Code Section I, PG-80 and Section VIII, Div. 1, UCS-79(d), UG-79 & UG-80. All welders and procedures are qualified to ASME Code Section IX. For tacking carbon steel items, roundbar used is 1018 Cold Rolled. Material being supplied conforms to the latest ASME Code Section II, Part A, 2007 Edition, Addenda July 1, 2007.**

Steve Zubryckyj (QAM)

**Supplementary Examination - Items**







HEAT NUMBER : 13145  
 TRANS AM PIPING PRODUCTS - REV'D BY: *AB*  
 Shipment/Seq #: 5 8 - 1487 28

2" CL 150 W/N FLANGE RF  
 SCH 160 BORE A105N



SAN ENG STEEL FORGING CO LTD  
 311, Jen Hsin Road, Jen Wu Hsiang,  
 Kaohsiung Hsien, Taiwan, R.O.C.  
 TEL: 07-3724249; FAX: 07-3712923  
 URL: www.saneng.com.tw  
 e-mail: saneng@ksis.seed.net.tw

PRODUCT

MILL TEST CERTIFICATE  
 EN10204-3.1(B/DIN50049/3.1B)  
 Customer: SEYBOLD INTERNATIONAL CORP  
 Order No.: 8122(1)TRANS AM  
 MATERIAL SPECIFICATIONS

DIMENSIONAL SPECIFICATIONS

FORGED CARBON STEEL FLANGES

ASTM A105-05/ASME SA105-07

ASME B16.5-03  
 CSA Z245.12

Certificate No.: SE-8122A  
 Date: 10/15/2008  
 Page: 1 OF 1

Item No.	CUSTOMER P/N	DESCRIPTION	QUANTITY	CHEMICAL COMPOSITION (%)											CE(%)		
				C	Si	Mn	P	S	Cu	Cr	Ni	Mo	V	Nb		N	
1		150 WNRF STD 5" A105N	Max	0.350	0.100	0.600	0.035	0.040	0.400	0.300	0.400	0.120	0.080	0.020	-	-	0.418
2		150 WNRF S120 4" A105N	Min	0.210	0.160	1.130	0.007	0.010	0.050	0.050	0.050	0.005	0.003	0.005	0.009	-	0.420
3		150 WNRF S160 2" A105N	Max	0.210	0.200	1.120	0.013	0.017	0.090	0.050	0.050	0.005	0.003	0.005	0.010	-	0.420
4		150 WNRF XXS 3" A105N	Min	0.200	0.190	1.150	0.007	0.013	0.040	0.050	0.030	0.009	0.003	0.005	0.011	-	0.407
5		300 WNRF S160 4" A105N	Max	0.200	0.230	1.120	0.007	0.011	0.050	0.070	0.030	0.005	0.003	0.005	0.008	-	0.407

Item No.	Heat No.	T.S.(*) (MPA)	Y.S.(*) (MPA)	E.L.(*) (%)	Hardness (HB)	R.A.(*) (%)	Impact Test			Material Supplier
							Temp: Minimum	Joule	3	
1	21530	519.8	335.4	36.0	154	66.8	1			DEMK
2	44039	527.3	309.7	32.4	157	65.9	2			DEMK
3	13145	521.7	317.7	34.4	153	67.7	3			DEMK
4	21520	513.9	337.3	34.2	153	66.8	1			DEMK
5	41367	535.4	348.1	33.8	154	65.9	2			DEMK

\*1: T.S. = Tensile Strength, Y.S. = Yield Strength, E.L. = Elongation, R.A. = Reduction of Area  
 \*2: N=Normalized, A=Annealed, Q=Quenched, T=Tempered, S.T=Solution Treated, S.R=Stress Relieved, A.C=Air Cooled, F.C=Furnace Cooled, W.C=Water Cooled, O.C=Oil Cooled.  
 \*3: C.E. Value = C + (Mn/6) + (Cr + Mo + V) / 5 + (Ni + Cu) / 15

REMARKS  
 HEAT TREATMENT(2)  
 N  
 880CX3HRS  
 CONFORMS WITH NACE MR01-75/03 AND MR01-03/07/ISO15156.2  
 CONFORMS WITH Z245.12 CAT I GR.248 SOUR SERVICE-05

Manager of Quality Assurance Dept

Benteler Stahl/Rohr GmbH  
Postfach 13 40  
33043 Paderborn  
Deutschland  
Tel.: +49.5254.81-0 Fax: +49.5254.13666

# BENTELER

## Stahl/Rohr

**ABNAHMEPRÜFZEUGNIS EN 10204-3.1**  
INSPECTION CERTIFICATE EN 10204-3.1  
CERTIFICAT DE RECEPTION EN 10204-3.1  
EN 10204:2005-01

Benteler Stahl/Rohr GmbH - Postfach 1340 - 33043 Paderborn - Deutschland  
Comco Pipe & Supply Co.  
PO Box 457  
EDMONTON, AB T5J 2K1  
KANADA

Dokument-Nr.: 65-251902/001/P

Prüf-Nr.:  
Inspection No.:  
No. du certificat: Blatt: 1 / 8  
Page:

Kunden-Bestell-Nr.: 04-5358

Hersteller:  
Manufacturer:  
Producteur: Warmrohrwerk Dinslaken  
ISO/TS 16949 (ISO 9001) DNV CERT-13785-2003  
PED 87/23/EC TÜV Cert 07 202 4111/Z/5001/1/H

No. de commande du client:

1121508

Herstellerzeichen:  
Manufacturer's brand:  
Marque du producteur:



6549549

Stempel des Abnahmebeauftragten: WA  
Stamp of the inspection representative:  
Timbre du contrôleur:

Versandanzeigen-Nr.:  
Dispatch Note No.:  
No. d'avis d'expédition:

Produkt: NAHTLOSE STAHLROHRE  
Product: SEAMLESS STEEL TUBES  
Produit: TUBES D'ACIER SANS SOUDURE

Stahlerschmelzungsverfahren:  
Steelmaking process:  
Procédé d'élaboration de l'acier: ELEKTROSTAHL  
ELECTRIC FURNACE  
FOUR ELECTRIQUE

Lieferbedingungen: CSA Standard Z245.1-02 Category I, API Specification 5L Forty-Third Edition, March 2004, PSL 1, ASTM-A 106-2002a, S5, ASME SA-106, ASME Section II Part A Edition 2004, S5, NACE MR0175-03

Terms of delivery:  
Conditions de livraison:

Maße - Toleranzen:  
Dimensions-tolerances:  
Dimensions-tolerances:

ASME B36.10M-1996, ASME SA-530, ASME Section II Part A Edition 2004, ASTM-A 530-2003

Stahlsorte:  
Steel grade:  
Nuance d'acier: GRADE 290, GRADE B, GRADE X 42

Lieferzustand:  
Delivery condition:  
État de livraison: Hot rolled

Produktkennzeichnung:  
Product marking: see attachment product marking

Marquage du produit:

Pos.	Stück Item Poste	Maße Dimensions Dimensions	Länge Length Longueur	Gewicht Weight Poids	Schmelzen-Nr. Heat No. No. de coulée	Prüfdruck Test pressure Pression d'épreuve	Rohr-Nr.-Gruppe Tube number group Série de no. des tubes	Vielfachlängen Multiple lengths Longueurs multiples
			feet	lbs		PSI		
0004	101	1" NPS * Sched. 160 18 FT - 22 FT	2116,96	6045	525191	3000	5	
0007	99	1 1/4" NPS * Sched. 80 18 FT - 22 FT	2111,68	6204	734252	3000	5	

Benteler Stahl/Rohr GmbH  
 Postfach 13 40  
 33043 Paderborn  
 Deutschland  
 Tel.: +49.5254.81-0 Fax: +49.5254.13666

**BENTELER**  
 Stahl/Rohr

**ABNAHMEPRÜFZEUGNIS EN 10204-3.1**  
 INSPECTION CERTIFICATE EN 10204-3.1  
 CERTIFICAT DE RECEPTION EN 10204-3.1

Dokument-Nr.: 65-251902/001/P  
 Document No.:  
 No. du document:

Prüf-Nr.:  
 Inspection No.:  
 No. du certificat:

Blatt: 2 / 8  
 Page:  
 Page:

Pos.	Stück Item	Maße Number	Dimensions	Länge Length	Gewicht Weight	Schmelzen-Nr. Heat No.	Prüfdruck Test pressure	Rohr-Nr.-Gruppe Tube number group	Vielfachlängen Multiple lengths
	Poste	Nombre	Dimensions	Longueur feet	Poids lbs	No. de coulée	Pression d'épreuve PSI	Série de no. des tubes	Longueurs multiples
0008	235	1 1/2" NPS * Sched. 80 18 FT - 22 FT		5004,10	17877	734288	3000	5	
0009	237	2" NPS * Sched. 40 18 FT - 22 FT		5038,75	18243	734199	3000	5	
0010	128	2" NPS * Sched. 40 38 FT - 42 FT		5239,60	18929	734201	3000	5	
0011	75	2" NPS * Sched. 160 38 FT - 42 FT		3093,73	22992	525191	3000	5	
0012	98	2" NPS * Sched. 160 18 FT - 22 FT		2004,23	15659	734309	3000	5	

Schmelzenanalyse [%] / Heat analysis [%] / Analyse sur coulée [%]

Pos.	Schmelzen-Nr. Heat No.	C	SI	MN	P	S	CR	MO	NI	CU	V	NB	TI	B
	Poste	No. de coulée												
0004	525191	0,130	0,190	0,82	0,009	0,004	0,16	0,05	0,14	0,20	0,001	0,010	0,003	0,0001
0007	734252	0,135	0,205	0,83	0,010	0,006	0,12	0,03	0,12	0,20	0,001	0,010	0,002	0,0001
0008	734288	0,140	0,225	0,84	0,009	0,005	0,13	0,04	0,11	0,18	0,001	0,010	0,003	0,0001
0009	734199	0,135	0,210	0,82	0,009	0,003	0,17	0,06	0,11	0,15	0,001	0,010	0,003	0,0001
0010	734201	0,135	0,190	0,81	0,009	0,005	0,18	0,07	0,12	0,18	0,001	0,010	0,003	0,0001
0011	525191	0,130	0,190	0,82	0,009	0,004	0,16	0,05	0,14	0,20	0,001	0,010	0,003	0,0001
0012	734309	0,135	0,203	0,82	0,009	0,004	0,13	0,03	0,09	0,17	0,001	0,010	0,003	0,0001

- Formel:  $CE\ IIW=C+(Mn/6)+((Cr+Mo+V)/5)+((Cu+Ni)/15)<=0,40\ %$
- Formel:  $CEV=C+F*((Mn/6)+(Si/24)+(Cu/15)+(Ni/20)+((Cr+Mo+V+Nb)/5)+(5*B))<=0,40$
- Formel:  $Mn/C>=3/1$
- Formel:  $Cr+Cu+Mo+Ni+V<=1,00\ %$

Benteler Stahl/Rohr GmbH  
 Postfach 13 40  
 33043 Paderborn  
 Deutschland  
 Tel.: +49.5254.81-0 Fax: +49.5254.13666



ABNAHMEPRÜFZEUGNIS EN 10204-3.1  
 INSPECTION CERTIFICATE EN 10204-3.1  
 CERTIFICAT DE RECEPTION EN 10204-3.1  
 Formelergesse / Formula results / Résultats des formules

Dokument-Nr.: 65-251902/001/P  
 Document No.:  
 No. du document:

PrüfNr.:  
 Inspection No.:  
 No. du certificat:

Blatt: 3 / 8  
 Page:

Pos.	Schmelzen-Nr	1. Formel	2. Formel	3. Formel	4. Formel
Item	Heat No.	1. Formula	2. Formula	3. Formula	4. Formula
Poste	No. de coulée	1. Formule	2. Formule	3. Formule	4. Formule
0004	525191	0,332	0,298	6,308	0,551
0007	734252	0,325	0,304	6,148	0,471
0008	734288	0,334	0,313	6,000	0,461
0009	734199	0,335	0,313	6,074	0,491
0010	734201	0,340	0,317	6,000	0,551
0011	525191	0,332	0,298	6,308	0,551
0012	734309	0,321	0,301	6,074	0,421

Produktanalyse [%] / Product analysis [%] / Analyse sur produit [%]

Pos.	Schmelzen-Nr.	C	SI	MN	P	S	CR	MO	NI	CU	V	NB	TI	B
Item	Heat No.													
Poste	No. de coulée													
0004	525191	0,140	0,170	0,80	0,008	0,004	0,17	0,05	0,14	0,19	0,001	0,010	0,002	0,0002
0004	525191	0,140	0,180	0,80	0,009	0,003	0,17	0,05	0,15	0,19	0,001	0,010	0,002	0,0002
0007	734252	0,140	0,160	0,84	0,010	0,005	0,11	0,04	0,11	0,18	0,001	0,010	0,002	0,0002
0007	734252	0,140	0,160	0,83	0,010	0,005	0,11	0,04	0,11	0,19	0,001	0,010	0,002	0,0001
0008	734288	0,150	0,220	0,84	0,008	0,004	0,11	0,03	0,10	0,15	0,001	0,009	0,002	0,0001
0008	734288	0,140	0,220	0,83	0,008	0,004	0,11	0,03	0,10	0,15	0,001	0,008	0,002	0,0001
0009	734199	0,120	0,180	0,82	0,008	0,005	0,18	0,07	0,11	0,16	0,002	0,010	0,002	0,0002
0009	734199	0,120	0,180	0,82	0,008	0,005	0,18	0,07	0,12	0,16	0,002	0,010	0,002	0,0001
0010	734201	0,120	0,180	0,82	0,008	0,005	0,18	0,07	0,11	0,16	0,002	0,010	0,002	0,0002
0010	734201	0,120	0,180	0,82	0,008	0,005	0,18	0,07	0,11	0,16	0,002	0,010	0,002	0,0001
0011	525191	0,130	0,170	0,80	0,008	0,003	0,16	0,05	0,14	0,19	0,001	0,010	0,002	0,0001
0011	525191	0,130	0,170	0,81	0,008	0,003	0,16	0,05	0,15	0,19	0,001	0,010	0,002	0,0002
0012	734309	0,140	0,190	0,83	0,008	0,003	0,09	0,02	0,08	0,11	0,001	0,010	0,002	0,0002
0012	734309	0,140	0,190	0,83	0,008	0,003	0,09	0,02	0,08	0,11	0,001	0,010	0,002	0,0002

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**BENTELER**  
 Stahl/Rohr

ABNAHMEPRÜFZEUGNIS EN 10204-3.1  
 INSPECTION CERTIFICATE EN 10204-3.1  
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1. Formel:  $CE\ IIW = C + (Mn/6) + ((Cr + Mo + V)/5) + ((Cu + Ni)/15) \leq 0,40\%$
2. Formel:  $CEV = C + F * ((Mn/6) + (Si/24) + (Cu/15) + (Ni/20) + ((Cr + Mo + V + Nb)/5) + (5 * B)) \leq 0,40$
3. Formel:  $Mn/C \geq 3/1$
4. Formel:  $Cr + Cu + Mo + Ni + V \leq 1,00\%$

Formelergebnisse / Formula results / Résultats des formules

Pos. Item	Schmelzen-Nr. Heat No.	1. Formel 1. Formula		2. Formel 2. Formula		3. Formel 3. Formula		4. Formel 4. Formula	
		1. Formule	1. Formule	2. Formule	2. Formule	3. Formule	3. Formule	4. Formule	4. Formule
0004	525191	0,340	0,340	0,316	0,316	5,714	5,714	0,551	0,551
0004	525191	0,340	0,340	0,317	0,317	5,714	5,714	0,561	0,561
0007	734252	0,330	0,330	0,308	0,308	6,000	6,000	0,441	0,441
0007	734252	0,329	0,329	0,306	0,306	5,929	5,929	0,451	0,451
0008	734288	0,335	0,335	0,321	0,321	5,600	5,600	0,391	0,391
0008	734288	0,323	0,323	0,304	0,304	5,929	5,929	0,391	0,391
0009	734199	0,325	0,325	0,280	0,280	6,833	6,833	0,522	0,522
0009	734199	0,326	0,326	0,280	0,280	6,833	6,833	0,532	0,532
0010	734201	0,325	0,325	0,280	0,280	6,833	6,833	0,522	0,522
0010	734201	0,326	0,326	0,280	0,280	6,833	6,833	0,532	0,532
0011	525191	0,328	0,328	0,294	0,294	6,154	6,154	0,541	0,541
0011	525191	0,330	0,330	0,296	0,296	6,231	6,231	0,551	0,551
0012	734309	0,313	0,313	0,295	0,295	5,929	5,929	0,301	0,301
0012	734309	0,313	0,313	0,295	0,295	5,929	5,929	0,301	0,301

Prüfergebnisse / Test results / Résultats des essais

Die Rohre sind auf Dichtheit geprüft durch:  
 The tubes have been submitted to a leak tightness test by:  
 Les tubes ont passé un contrôle d'étanchéité par:

Hydrostatic test: acc. to CSA Z245.1, holding time min 5 seconds, Test  
 pressure/Time-record

PASSED

Augensichtkontrolle:  
 Visual inspection:  
 Examen visuel:

Biegeversuch:  
 Bending test:  
 Essai de cintrage:

Maßkontrolle:  
 Dimensions examination:  
 Vérification des dimensions:

PASSED

PASSED

PASSED

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Ergebnisse der mechanischen Prüfung / Results of mechanical testing / Résultats des essais mécaniques

Die Probenahme erfolgte an Vielfachlängen.  
 The sampling was carried out on multiple lengths.  
 L'echantillonnage était réalisé aux longueurs multiples.

**Zugversuch / Tensile test / Essai de traction**

Pos. Item	Proben-Nr. Specimen No.	Schmelzen-Nr. Heat No.	Probenabmessung Specimen dimensions	Streckgrenze Yield strength	Zugfestigkeit Tensile strength	Dehnung Elongation	Einschnürung Area reduction	Re/Rm
Poste	No. de l'éprouvette	No. de coulée	Dimensions de l'éprouv.	Limite élastique	Résistance à la traction	Allongement	Coefficient de striction	Re/Rm
Anforderungen Requirements Exigences	mm		ReH PSI	Rm PSI	A2" %	1. Formel 1. Formula 1. Formule		Re/Rm
				42061-71794	60191-110229	MIN 30		Re/Rm
0004	000001	525191	12,70 X 6,20	50763	69183	34,00		
0004	000002	525191	12,70 X 6,20	49893	69328	35,00		
0007	000001	734252	12,70 X 4,70	52069	68458	41,00		
0007	000002	734252	12,70 X 4,70	50038	68168	40,00		
0008	000001	734288	12,70 X 5,00	50328	70053	40,00		
0008	000002	734288	12,70 X 5,00	49603	70053	43,00		
0009	000001	734199	19,00 X 3,80	54679	69763	36,00		
0009	000002	734199	19,00 X 3,80	54244	69328	35,00		
0010	000001	734201	18,90 X 4,00	55985	69038	36,00		
0010	000002	734201	18,90 X 3,90	54244	69183	38,00		
0010	000003	734201	18,90 X 4,00	55695	69763	38,00		
0010	000004	734201	18,90 X 4,00	54534	70053	34,00		
0010	000005	734201	18,90 X 4,10	54099	69473	34,00		
0010	000006	734201	18,90 X 3,90	54244	69183	36,00		
0011	000001	525191	19,20 X 8,70	51198	68748	42,00		
0011	000002	525191	19,20 X 8,70	50763	69618	40,00		
0012	000001	734309	19,00 X 8,60	49313	68023	38,00		
0012	000002	734309	19,00 X 8,60	49893	68458	39,00		



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Härteprüfung / Hardness test / Essai de dureté

Pos.	Proben-Nr. Specimen No.	Schmelzen-Nr. Heat No.	Härte Hardness	HB	HV	HRB
Poste	No. de l'éprouv.	No. de coulée	Dureté			
Anforderungen Requirements			HRC	HB	HV	HRB
Exigences				MAX 200		
0004	000001	525191		138		
0004	000002	525191		139		
0004	000003	525191		139		
0007	000001	734252		146		
0007	000002	734252		146		
0007	000003	734252		146		
0008	000001	734288		146		
0008	000002	734288		146		
0008	000003	734288		147		
0009	000001	734199		139		
0009	000002	734199		139		
0009	000003	734199		140		
0010	000001	734201		140		
0010	000002	734201		139		
0010	000003	734201		142		
0010	000004	734201		143		
0010	000005	734201		141		
0010	000006	734201		139		
0011	000001	525191		145		
0011	000002	525191		143		
0011	000003	525191		144		
0012	000001	734309		137		
0012	000002	734309		133		

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Härteprüfung / Hardness test / Essai de dureté

Pos. Item	Proben-Nr. Specimen No.	Schmelzen-Nr. Heat No.	Härte Hardness
Poste	No. de l'éprouv.	No. de coulée	Dureté
			HRC HB HV HRB
<b>Anforderungen</b>			
<b>Requirements</b>			
<b>Exigences</b>			
0012	000003	734309	MAX 200 135

Restmagnetismus / Demagnetize / Démagnétiser

Pos. / Item / Poste: 0004, 0011, 0010, 0009, 0008, 0007, 0012  
 residual magnetic field intensity max 3,5 millitesla

Pos. Item Poste	Ihr Zeichen Your reference Votre référence	Kundenmaterial Customer's Material No. No. de matière du client	Kundenbestell-Nr. Purchase Order No. No. de commande du client
0004		E1005841	04-5358
0007		E1005841	04-5358
0008		E1005841	04-5358
0009		E1005841	04-5358
0010		E1005841	04-5358
0011		E1005841	04-5358
0012		E1005841	04-5358

Vermerk / Remark / Remarque

Pos. / Item / Poste: 0004, 0008, 0007, 0011, 0010, 0009, 0012,

NACE Standard: hardness acc. to NACE Standard MR0175 HRC max 22, The material meets the requirements of NACE MR0103; Certificate remarks: The seamless line pipes meet the requirement for micro hardness of max 248 HV 500; Bend test: mandrel diameter 12D, bending angle 90 degree

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Beiblatt Produktkennzeichnung / Attachment product marking / Supplément marquage du produit

Pos.	Produktkennzeichnung
Item	Produktkennzeichnung
Poste	Marquage du produit

0004, 0007, 0008, 0009, 0010, 0011, 0012

FS: BENTELER Z.245.1, Spec.5L-PSL1, A5A-106 S5 B/X42/290 HEAT-NO. TEST PRESSUR E DIMENSIONS SCHEDULE WA GERMANY  
E1005841

FK = Farbkennzeichnung, colour marking, marquage par couleur FS = Farbschablonierung, paint stencilling, marquage par peinture FSD = Farbschablonier, colour jet printer, imprimante à jet d'encre de couleur LS = Längsschablonierung, longitudinal stencilling, marquage longitudinal par peinture PKE = Etikettenkennzeichnung, tag marking, marquage sur étiquette PS = Prägestempel, die stamp, marquage par poinçonnage TS = Tintenstahlkennzeichnung, ink jet spray marking, imprimante à jet d'encre

Verkäufer(in) / Salesman/ woman in charge / Personne chargée : Mr Seelbach, Tel.: 05254/81-4281, Fax: 4289



Dinslaken, 14.02.2005, TEL.: 02064.623-572 FAX: 02064.623-575

Abnahmebeauftragter  
Inspection representative

Contrôleur

JAN FREERKS / WAG

Es wird bestätigt, daß die gelieferten Erzeugnisse den techn. Lieferbedingungen des Auftrages entsprechen. Dieses Dokument wurde mittels EDV erstellt und ist ohne Unterschrift rechtsgültig.  
We certify that the supplied products comply with the order specification. This document was prepared by means of electronic data processing and is valid without signature.  
Nous attestons que les produits livrés sont conformes aux stipulations de la commande. Ce document a été établi par traitement électronique de l'information et est valide sans signature.



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WESTLUND



Distributore Joint  
Frezzo Caduti 6 luglio 1974, 1  
24044 Dolomite (Bg) Italy  
+ 39 035 560 111 14  
+ 39 035 560 382 1 fax

Program/Page  
06/20708 003/003  
Order Date 28/09/2006

Customer's Reference  
00032005 - 28/09/2006

Customer's Reference  
R102006PC002211

Localities/Town  
N6A 4N LONDON

Product/Description  
P.O. BOX 5300

Order Reference  
11590

Quantity	6	Weight	78.25	Weight	256.73	Weight	32813.5
Unit	kg	Unit	kg	Unit	kg	Unit	kg
Material	SA 106	Material	SA 106	Material	SA 106	Material	SA 106
Standard	ASTM A 106	Standard	ASTM A 106	Standard	ASTM A 106	Standard	ASTM A 106
Grade	SA 106	Grade	SA 106	Grade	SA 106	Grade	SA 106
Order	06/20708	Order	06/20708	Order	06/20708	Order	06/20708
Page	003/003	Page	003/003	Page	003/003	Page	003/003

NOTE/REMARKS  
 WITH SATISFACTORY RESULT  
 ALL PIPES HAVE BEEN TESTED FOR LAMINATION DETECTION, WITH SATISFACTORY RESULT  
 THE ENDS (FOR 150 mm.) AND BEVELS HAVE BEEN TESTED BY DRY MAGNETIC PARTICLES, WITH SATISFACTORY RESULT  
 AFTER INSPECTION OPERATION, THE MATERIAL HAS NOT A RESIDUAL MAGNETISM GREATER THAN 20 GAUSS  
 ALL PIPES HAVE BEEN ROLLED IN THE RANGE 780°C/950°C

Version/Standard	Year	Revision	Year
ASTM A 106	2004	Ed.	
ASTM A 106	2004	Ed.	
ASTM A 106	2004	Ed.	
ASTM A 106	2002	Ed.	
ASTM A 106	2003	Ed.	

EDIZIONE NORME/STANDARD EDITION  
 TUBI SENZA SALDATURA FINITI A CALDO  
 SEAMLESS HOT FINISHED PIPES  
 IL CONTROLLO VISIVO E DIMENSIONALE HA DATO ESITO SODDISFACENTE  
 VISUAL AND DIMENSIONAL CONTROL HAS BEEN CARRIED OUT WITH SATISFACTORY RESULT  
 L'ACCIAIO E' DI TIPO CALMATO, A GRANO FINE, PRODOTTO AL FORNO ELETTTRICO  
 STEEL IS FULLY KILLED AND PRODUCED BY ELECTRIC FURNACE TO A FINE GRAIN PRACTICE  
 IL MATERIALE FORNITO E' IN ACCORDO AI REQUISITI DELL'ORDINE  
 THE PRODUCT SUPPLIED IS IN COMPLIANCE WITH THE REQUIREMENTS OF THE ORDER.

QUALITY SYSTEM CERTIFIED  
 n.11095H01

FIRME/SIGNATURE

VERIFICAZIONE QUALITA'  
 QUALITY SERVICE MANAGER  
 Enzo Giorgio TASSO

RESPONSABILE SERVIZIO QUALITA'  
 QUALITY SERVICE MANAGER  
 Rosal FORATIERIS



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