



3867 Roper Road NW Edmonton Alberta T6B 3S5
Phone: (780) 486-7344 Fax: (780) 486-4685
www.buffaloinpection.com

Report No. 23-67184R001 **UT**
Ultrasonic Thickness Report | Mar 10, 2023



Client Name:	TBD	Project Name:		Procedure:	GP-UT-01/R9
Client Address:		Client Job No.:		Acceptance Standard:	Client Information Only
Contact Name:		Purchase Order No.:		Technique:	UT-1/R1
Contact Phone:		AFE No.:		Work Location:	Kitscoty
Contractor:					
Comments:	Random Spot Check Thickness Verification Readings taken on Horizontal Separator Vessel Serial # 02-179 HS				

Examination Surface Details					
Temperature:	5-52	Contaminants:	Coating	Cleaning Details:	Remove any Surface debris
Preparation:	Solvent Cleaned	Preparation Comments:	Solvent Cleaned	Cleaning Products:	SpotCheck SKC-S
				Couplant Type:	SonoGel

Equipment Details				Calibration Blocks							
Make/Model:	Panametrics/D790-SM	Serial Number:	547232	Calibration Due Date:		IIW:		Stepwedge:	11-4133	Other Calibration:	

Transducers/Probes/Cables												
Probe Serial No.	Cable Type	Test Angle	Probe S/D	Freq. (MHz)	Length	Diameter	Transfer Value	Test Surface	dB	%FSH	Scan Sensitivity	Range
652592	Fixed	0°	Double	5	5 ft	0.5 in	5 MHz	OD				

Examination Results							
	NDE	Nominal Thickness	Type	Nominal Thickness	Minimum Thickness	Actual Thickness	Comments †
				inches			

Client: N/A / WO #: N/A / Orban Industries Inc. / S/N: 02-179 HS / Year Completed: 2007 / A #: N/A / CRN: R2052.21T / Tag #: V-100 / Horizontal Separator							
1	UT - 1	1.3125"	Head	NA	NA	1.379"	UT-1 > UT-4 Thickness Verification Readings taken on Left Head at the Head to Shell Circ Seam at 90 degree Intervals at North, East, South, West Locations
2	UT - 2	1.3125"	Head	NA	NA	1.425"	
3	UT - 3	1.3125"	Head	NA	NA	1.415"	
4	UT - 4	1.3125"	Head	NA	NA	1.423"	
5	UT - 5	1.375"	Shell	NA	NA	1.365"	UT-5 > UT-9 Thickness Verification Readings taken on Left Shell at the Shell to Head Circ Seam at 90 degree Intervals at North, East, South, West Locations
6	UT - 6	1.375"	Shell	NA	NA	1.372"	
7	UT - 7	1.375"	Shell	NA	NA	1.368"	
8	UT - 8	1.375"	Shell	NA	NA	1.348"	
9	UT - 9	1.375"	Shell	NA	NA	1.367"	UT-9 > UT-12 Thickness Verification Readings taken on Shell at the Left Side Circ Seam at 90 degree Intervals at North, East, South, West Locations
10	UT - 10	1.375"	Shell	NA	NA	1.374"	
11	UT - 11	1.375"	Shell	NA	NA	1.372"	
12	UT - 12	1.375"	Shell	NA	NA	1.371"	
13	UT - 13	1.375"	Shell	NA	NA	1.391"	UT-13 > UT-16 Thickness Verification Readings taken on Shell at the Right Side Circ Seam at 90 degree Intervals at North, East, South, West Locations
14	UT - 14	1.375"	Shell	NA	NA	1.382"	
15	UT - 15	1.375"	Shell	NA	NA	1.382"	
16	UT - 16	1.375"	Shell	NA	NA	1.396"	
17	UT - 17	1.375"	Shell	NA	NA	1.397"	UT-17 > UT-20 Thickness Verification Readings taken on Right Shell at the Shell to Head Circ Seam at 90 degree Intervals at North, East, South, West Locations
18	UT - 18	1.375"	Shell	NA	NA	1.386"	
19	UT - 19	1.375"	Shell	NA	NA	1.384"	
20	UT - 20	1.375"	Shell	NA	NA	1.386"	
21	UT - 21	1.3125"	Head	NA	NA	1.431"	UT-21 > UT-24 Thickness Verification Readings taken on Left Head at the Head to Shell Circ Seam at 90 degree Intervals at North, East, South, West Locations

Buffalo Inspection Services Inc. does not warranty or imply warranty of services stated herein and shall not be held liable for services rendered as per established service agreements. At no time shall liability be placed upon Buffalo Inspection Services Inc. of which exceeds the amount paid for said services. Buffalo Inspection Services shall utilize appropriate quality assurance measures, technical training, and safety parameters to assure services are provided to meet or exceed established NDT/NDE procedures, practices, and standard industry expectations and at no time shall warranty excess NDT/NDE services except those established in writing beyond those established prior to the services provided herein. Note: SNT shall refer to the ASNT SNT-TC-1A Recommended Practice. Buffalo Inspection follows the SNT-TC-1A Recommended Practice that defines the criteria for SNT certification. Clocktape marker and start arrow marked on weldment; it is the customer's responsibility to map welds on drawing. Buffalo Inspection Services Inc. reserves the right to retract any and all reports issued or the results of any services performed, and furthermore, prohibit the reliance on any or all reports and the results of services performed, until the related Buffalo Inspection Services Inc. invoice(s) for these services are paid in full.



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Contractor:					
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Examination Results							
	NDE	Nominal Thickness	Type	Nominal Thickness	Minimum Thickness	Actual Thickness	Comments †
				inches			
22	UT - 22	1.3125"	Head	NA	NA	1.439"	
23	UT - 23	1.3125"	Head	NA	NA	1.421"	
24	UT - 24	1.3125"	Head	NA	NA	1.432"	
25	UT - 25	1.375"	Shell	NA	NA	1.364"	UT-25 > UT-28 Thickness Verification Readings taken on Shell around 8" Nozzle to Shell Weld Seam at North, East, South, West Locations
26	UT - 26	1.375"	Shell	NA	NA	1.358"	
27	UT - 27	1.375"	Shell	NA	NA	1.365"	
28	UT - 28	1.375"	Shell	NA	NA	1.341"	
29	UT - 29	1.375"	Shell	NA	NA	1.362"	UT-29 > UT-32 Thickness Verification Readings taken on Shell around 2" Threaded Collar Valve to Shell Weld Seam at North, East, South, West Location
30	UT - 30	1.375"	Shell	NA	NA	1.364"	
31	UT - 31	1.375"	Shell	NA	NA	1.363"	
32	UT - 32	1.375"	Shell	NA	NA	1.366"	
33	UT - 33	1.375"	Shell	NA	NA	1.395"	UT-33 > UT-36 Thickness Verification Readings taken on Shell around 1" Threaded Collar Valve to Shell Weld Seam at North, East, South, West Location
34	UT - 34	1.375"	Shell	NA	NA	1.394"	
35	UT - 35	1.375"	Shell	NA	NA	1.390"	
36	UT - 36	1.375"	Shell	NA	NA	1.387"	
37	UT - 37	1.375"	Shell	NA	NA	1.382"	UT-37 > UT-40 Thickness Verification Readings taken on Vessel Shell Topside of Left Saddle Shoe on the Frontside to Identify Locations
38	UT - 38	1.375"	Shell	NA	NA	1.376"	
39	UT - 39	1.375"	Shell	NA	NA	1.364"	
40	UT - 40	1.375"	Shell	NA	NA	1.375"	
41	UT - 41	1.375"	Shell	NA	NA	1.379"	UT-41 > UT-44 Thickness Verification Readings taken on Shell around 6" Nozzle to Shell Weld Seam at North, East, South, West Locations
42	UT - 42	1.375"	Shell	NA	NA	1.374"	
43	UT - 43	1.375"	Shell	NA	NA	1.375"	
44	UT - 44	1.375"	Shell	NA	NA	1.351"	
45	UT - 45	1.375"	Shell	NA	NA	1.374"	UT-45 > UT-48 Thickness Verification Readings taken on Shell around 3/4" Threaded Collar Valve to Shell Weld Seam at North, East, South, West Locations
46	UT - 46	1.375"	Shell	NA	NA	1.382"	
47	UT - 47	1.375"	Shell	NA	NA	1.379"	
48	UT - 48	1.375"	Shell	NA	NA	1.374"	
49	UT - 49	1.375"	Shell	NA	NA	1.382"	UT-49 > UT-52 Thickness Verification Readings taken on Shell around 1" Threaded Collar Valve to Shell Weld Seam at North, East, South, West Locations
50	UT - 50	1.375"	Shell	NA	NA	1.375"	
51	UT - 51	1.375"	Shell	NA	NA	1.336"	
52	UT - 52	1.375"	Shell	NA	NA	1.374"	

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Examination Results							Comments †
	NDE	Nominal Thickness	Type	Nominal Thickness	Minimum Thickness	Actual Thickness	
				inches			
53	UT - 53	1.375"	Shell	NA	NA	1.370"	UT-53 > UT-56 Thickness Verification Readings taken on Shell around 2" Threaded Collar Valve to Shell Weld Seam at North, East, South, West Locations
54	UT - 54	1.375"	Shell	NA	NA	1.374"	
55	UT - 55	1.375"	Shell	NA	NA	1.376"	
56	UT - 56	1.375"	Shell	NA	NA	1.359"	
57	UT - 57	1.375"	Shell	NA	NA	1.393"	UT-57 > UT-60 Thickness Verification Readings taken on Shell around 4" Nozzle to Shell Weld Seam at North, East, South, West Locations
58	UT - 58	1.375"	Shell	NA	NA	1.391"	
59	UT - 59	1.375"	Shell	NA	NA	1.392"	
60	UT - 60	1.375"	Shell	NA	NA	1.382"	

Examination Photos

Line 1

Line 1

Line 1

Line 1



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Contact Phone:		AFE No.:		Work Location:	Kitscoty
Contractor:					
Comments:	Random Spot Check Thickness Verification Readings taken on Horizontal Separator Vessel Serial # 02-179 HS				



Examination Photos



Technicians		Certifications (NRCAN)		Certifications (SNT)		Technician Signature		Client Signature	
Technician:	Kevin Krupich	CGSB Level:	1	Reg No.:	16981	SNT Level:	1	SNT No.:	16981
Assistant 1:	Seth Cousins	CGSB Level:		Reg No.:		SNT Level:		SNT No.:	TRAINEE
Assistant 2:	Morgan Hepworth	CGSB Level:		Reg No.:		SNT Level:		SNT No.:	TRAINEE
						Inspection Date:	Mar 10, 2023	Evaluation Date:	Mar 10, 2023
								See Client Signature On Approval	

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