



**PRESSURE VESSEL
VISUAL INSPECTION
REPORT**

Report #: **155741-MD-22**
 Inspect Date: 02/17/2012
 Page: 1 of 11
 Insp. Co. Job #: 155741

Criticality Designation:



Yellow

Insp. Comp: Matrix_Inspection District: Grande Prairie - North Field: South Hamburg
 Location: 12-29-096-11W6 Unit / Skid #: 7714 LSD: 12-29-096-11W6
 Jurisdiction #: A3090893 Equip Tag #: V-2200 Serial #: 95016C
 CRN #: M8243.2 Nat'l Bd #: _____ Year Built: 1995
 Manufacturer: DON BUCK FABRICATION CORP Equipment Description: Other: PROPANE SUCTION SCRUBBER
 Status: In Service - Equip. Type: Vessel: Separator Service: Sweet
 MAWP Shell: 285 Psi @ 413 °F Volume: _____ Code Stamp: Y N
 MAWP Tube: _____ @ _____ Height/Length: 58 in. Insulated: Y N
 MDMT: -18 °F RT: RT-3 Size/Diameter.: 24 in. O.D. PWHT: Y N
 Support: Skirt Vessel on Original CNRL Inventory List: Y N Manway: Y N
 C.A.: _____ Coated: No Clad: No J.E.: 0.85 Remote Access: - _____

Component	Material	Nominal Thk	Diameter	OD/ID	Tube Side	Shell Side
1 Main - Shell	SA- 516-70	0.383 in.	24.000 in.	OD	<input type="checkbox"/>	<input checked="" type="checkbox"/>
2 Top - Head	SA- 516-70	0.351 in.	24.000 in.	OD	<input type="checkbox"/>	<input checked="" type="checkbox"/>
3 Bottom - Head	SA- 516-70	0.351 in.	24.000 in.	OD	<input type="checkbox"/>	<input checked="" type="checkbox"/>
4 -					<input type="checkbox"/>	<input type="checkbox"/>
5 -					<input type="checkbox"/>	<input type="checkbox"/>

Static Data: Confirmed Changed (See Comments)

Comments:

Static data updated

PSV Static Data

PSV -1 Tag #: 77 Serial #: CE-42803 -1-A11 CRN: OG2369.5C
 Model #: 26JB10-120 Capacity: 6381 SCFM Set Pressure: 245 psi
 Manufacturer: Farris Service Company: Tyco
 Inlet Size & Type: 2.00 in. - Flanged Last Service Date: 06/13/2007
 Outlet Size & Type: 3.00 in. - Flanged Block Valve: N/A - -
 Carseal Intact: Yes Code Stamp: Yes
 Shell Side / Tube Side: Shell Side Out for Service During Insp.: N Location of PSV: On another vessel

PSV -2 Tag #: _____ Serial #: _____ CRN: _____
 Model #: _____ Capacity: _____ Set Pressure: _____
 Manufacturer: _____ Service Company: _____
 Inlet Size & Type: _____ Last Service Date: _____
 Outlet Size & Type: _____ Block Valve: _____
 Carseal Intact: _____ Code Stamp: _____
 Shell Side / Tube Side: _____ Out for Service During Insp.: _____ Location of PSV: _____

PSV Comments

PSV is due for service
 PSV located on A3061910



**PRESSURE VESSEL
VISUAL INSPECTION
REPORT**

Report #: **155741-MD-22**
 Inspect Date: 02/17/2012
 Page: 2 of 11
 Insp. Co. Job #: 155741

Insp. Company: Matrix_Inspection LSD: 12-29-096-11W6 Jurisdiction #: A3090893

External Inspection Results – VE External Inspection Performed

Item	N/A	Condition	Comment (Check Status Bar or Press F1 for Help)	NCR	Action Item Integrity	Action Item Maintenance
Nameplate	<input type="checkbox"/>	Accept	Firmly affixed and legible	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Foundation and Supports	<input type="checkbox"/>	Accept	Acceptable condition	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Anchor Bolts	<input type="checkbox"/>	Accept	Secure & tight	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Grounding	<input type="checkbox"/>	Accept	Grounded by skid	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Insulation Condition	<input checked="" type="checkbox"/>		No insulation	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
PSV	<input type="checkbox"/>	Reject	Due for service	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
Shell Heads & Nozzles	<input type="checkbox"/>	Accept	Dirt & dust	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Metal Surfaces (Paint)	<input type="checkbox"/>	Accept	Chipped exposing the base metal	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
Aux Equipment	<input checked="" type="checkbox"/>		No auxiliary equipment	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Cathodic Protection	<input checked="" type="checkbox"/>		No external anode	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Alignment	<input type="checkbox"/>	Accept	Vertical and upright	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Flange Connections	<input type="checkbox"/>	Accept	Adequate thread engagement	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Pressure Gauge	<input type="checkbox"/>	Accept	0-600 psi: acceptable range	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Temperature Gauge	<input type="checkbox"/>	Reject	-40-120° F : not within range	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
Sight Glass	<input type="checkbox"/>	Accept	Clear and visible liquid levels	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Ladder / Platform	<input checked="" type="checkbox"/>		No ladders or platforms	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Leaks	<input type="checkbox"/>	No	No evidence of leaks noted	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Piping from Vessel	<input type="checkbox"/>	Accept	Adequately supported and insulated			
Previous UT Survey	<input type="checkbox"/>	Yes	Locations marked, no history provided	UT Company: N/A		

External Visual Observations

The temperature gauge is not within an acceptable range of the vessel. At the time of inspection the temperature noted was ~ -28° F

Dirt and dust noted on the vessel top head and shell.

The outlet flange is taped which may accelerate corrosion between the flanges due to entrapped moisture.

There is minor surface corrosion build-up noted between the flanged connections.

The PSV is due for service

A UT corrosion survey was performed with no significant wall loss recorded at the time of inspection

Recommendations:

- Remove tape from flange
- Service the PSV
- Clean and touch-up coating to aid in corrosion protection
- Confirm with operations that the temperature does not exceed gauge rating; if so, replace as required



**PRESSURE VESSEL
VISUAL INSPECTION
REPORT**

Report #: **155741-MD-22**
 Inspect Date: 02/17/2012
 Page: 3 of 11
 Insp. Co. Job #: 155741

Insp. Company: Matrix_Inspection LSD: 12-29-096-11W6 Jurisdiction #: A3090893

Internal Inspection Results – VI N/A (Not Applicable)

Item	N/A	Condition	Comment (Check Status Bar or Press F1 for Help)	NCR	Action Item Integrity	Action Item Maintenance
Shell	<input type="checkbox"/>		No Internal Inspection Carried Out	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Heads	<input checked="" type="checkbox"/>		No Internal Inspection Carried Out	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Manway	<input checked="" type="checkbox"/>		No Internal Inspection Carried Out	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Gasket Surfaces	<input checked="" type="checkbox"/>		No Internal Inspection Carried Out	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Welds	<input checked="" type="checkbox"/>		No Internal Inspection Carried Out	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Refractory	<input checked="" type="checkbox"/>		No Internal Inspection Carried Out	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Heating Coils	<input checked="" type="checkbox"/>		No Internal Inspection Carried Out	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Demister Pad	<input checked="" type="checkbox"/>		No Internal Inspection Carried Out	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Vane Pack	<input checked="" type="checkbox"/>		No Internal Inspection Carried Out	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Baffles	<input checked="" type="checkbox"/>		No Internal Inspection Carried Out	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Trays	<input checked="" type="checkbox"/>		No Internal Inspection Carried Out	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Filter	<input checked="" type="checkbox"/>		No Internal Inspection Carried Out	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Internal Coating	<input checked="" type="checkbox"/>		No Internal Inspection Carried Out	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Tubesheet	<input checked="" type="checkbox"/>		No Internal Inspection Carried Out	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Tube Bundle	<input checked="" type="checkbox"/>		No Internal Inspection Carried Out	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

Internal Visual Observations

No Internal Inspection Carried Out

Recommendations:

No Internal Inspection Carried Out



**PRESSURE VESSEL
VISUAL INSPECTION
REPORT**

Report #: **155741-MD-22**
 Inspect Date: 02/17/2012
 Page: 4 of 11
 Insp. Co. Job #: 155741

Insp. Company: Matrix_Inspection LSD: 12-29-096-11W6 Jurisdiction #: A3090893

Firetube Static Data N/A (Not Applicable)

Diameter: Not Applicable Nom Thickness: Not Applicable Bend: Not Applicable
 Length: Not Applicable Firetube Description: Not Applicable

Firetube NDE Performed: UT Report#: Not Applicable ET Report#: Not Applicable
 MT Report#: Not Applicable RT Report#: Not Applicable
 PT Report#: Not Applicable Other Report#: Not Applicable

Firetube Inspection Results

Item	N/A	Condition	Comment (Check Status Bar or Press F1 for Help)	NCR	Action Item Integrity	Action Item Maintenance
Burner	<input checked="" type="checkbox"/>		No Firetube Inspection Carried Out	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Stack	<input checked="" type="checkbox"/>		No Firetube Inspection Carried Out	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Flange (Throat)	<input checked="" type="checkbox"/>		No Firetube Inspection Carried Out	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Tube Sheet	<input checked="" type="checkbox"/>		No Firetube Inspection Carried Out	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Hot Side	<input checked="" type="checkbox"/>		No Firetube Inspection Carried Out	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Miter	<input checked="" type="checkbox"/>		No Firetube Inspection Carried Out	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Return Bend	<input checked="" type="checkbox"/>		No Firetube Inspection Carried Out	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Supports	<input checked="" type="checkbox"/>		No Firetube Inspection Carried Out	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Butt Welds	<input checked="" type="checkbox"/>		No Firetube Inspection Carried Out	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Fillet Welds	<input checked="" type="checkbox"/>		No Firetube Inspection Carried Out	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

Firetube Visual Observations

No Firetube Inspection Carried Out

Recommendations:

No Firetube Inspection Carried Out



PRESSURE VESSEL
VISUAL INSPECTION
REPORT

Report #: **155741-MD-22**
Inspect Date: 02/17/2012
Page: 5 of 11
Insp. Co. Job #: 155741

Insp. Company: Matrix_Inspection LSD: 12-29-096-11W6 Jurisdiction #: A3090893

Vessel NDE and Final Summary:

NDE Performed: UT Report#: _____ ET Report#: _____
MT Report#: _____ RT Report#: _____
PT Report#: _____ Other Report#: _____

Maxi-Trak Observations Summary (Summarize inspection results Max 255 Characters):

Tape on flanges
PSV due for service
Coating is chipped exposing base metal to minor surface corrosion
Temperature gauge is not within range

Maxi-Trak Recommendations Summary (Summarize Recommendations Max 255 Characters):

Remove tape from flange
Service the PSV
Clean and touch-up coating to aid in corrosion protection
Confirm with operations that the temperature does not exceed gauge rating; if so, replace as required

Actions Corrected at Time of Inspection: (If actions were corrected at the time of Inspection – note the corrected actions here.)

No actions were corrected at the time of inspection

Additional Visual Observations

No additional visual observations were made at the time of inspection

Any other safety concerns or observations from associated equipment: (for example associated piping, buildings, pumps etc...)

No safety concerns



**PRESSURE VESSEL
VISUAL INSPECTION
REPORT**

Report #: **155741-MD-22**
 Inspect Date: 02/17/2012
 Page: 6 of 11
 Insp. Co. Job #: 155741

Insp. Company: Matrix_Inspection LSD: 12-29-096-11W6 Jurisdiction #: A3090893

Thickness and Remaining Life Evaluation “ Must be Completed”

MUST BE COMPLETED AND RESOLVED WITH CNRL IMMEDIATELY UPON DISCOVERY OF LOW WALL THICKNESS AREAS

Step 1: Was any thickness measurement location found to be less than (Nominal WT – Corrosion Allowance)?: **No**

If YES, proceed to Step 2; if NO, proceed to “Crack Evaluation” and “CNRL Criticality Designation”.

Step 2: Which component(s) were found below (Nominal WT – Corrosion Allowance)?

Components found below Nom - CA:

Components
N/A - N/A
N/A - N/A
N/A - N/A
N/A - N/A
N/A - N/A

Perform Steps 3 – 8 for each component with actual thickness less than (Nominal WT – Corrosion Allowance).

Step 3: Describe Location and Extent of Corrosion:

Components	Location and Extent of Corrosion
N/A - N/A	Not Applicable for this Inspection
N/A - N/A	Not Applicable for this Inspection
N/A - N/A	Not Applicable for this Inspection
N/A - N/A	Not Applicable for this Inspection
N/A - N/A	Not Applicable for this Inspection

Notes:
 Not Applicable for this Inspection

Step 4:

- For shells and nozzles, calculate minimum required thickness (T-min) as per ASME Section VIII UG-27.
- For heads, calculate minimum required thickness (T-min) as per ASME Section VIII UG-32.

Components	T-Min
N/A - N/A	N/A
N/A - N/A	N/A
N/A - N/A	N/A
N/A - N/A	N/A
N/A - N/A	N/A



PRESSURE VESSEL
VISUAL INSPECTION
REPORT

Report #: **155741-MD-22**
Inspect Date: 02/17/2012
Page: 7 of 11
Insp. Co. Job #: 155741

Insp. Company: Matrix_Inspection LSD: 12-29-096-11W6 Jurisdiction #: A3090893

Thickness and Remaining Life Evaluation (Continued)

Step 5: Is any measured thickness less than calculated minimum required thickness (T-min)? **N/A**

*If YES, complete Step 6
If NO, proceed to Step 7..*

Step 6: Is nature and extent of pitting acceptable as per API 510? **N/A**

Step 7: Calculate Remaining Life as per API 510. How? (Find last reading; use nominal thickness if nothing available). Short Term Corrosion Rates and Long Term Corrosion Rates.

Components	Remaining Life (Yrs)
N/A - N/A	N/A
N/A - N/A	N/A
N/A - N/A	N/A
N/A - N/A	N/A
N/A - N/A	N/A

Step 8: Contact CNRL Integrity Coordinator to discuss above results.

- Name of CNRL contact: Not Applicable for this Inspection
- Date and time of conversation: Not Applicable for this Inspection

Summary/results of conversation:
Not Applicable for this Inspection

Crack Evaluation by Magnetic Particle or Alternative Inspection “Must be Completed”

MUST BE COMPLETED AND RESOLVED WITH CNRL IMMEDIATELY UPON DISCOVERY OF CRACK-LIKE INDICATIONS

Were any indications found to suggest the vessel contained cracks? **N/A**

If NO, proceed to “CNRL Criticality Designation”.

If YES, Contact CNRL Integrity Coordinator to discuss results.

- Name of CNRL contact: Not Applicable for this Inspection
- Date and time of conversation: Not Applicable for this Inspection

Summary/results of conversation:
Not Applicable for this Inspection



**PRESSURE VESSEL
VISUAL INSPECTION
REPORT**

Report #: **155741-MD-22**
 Inspect Date: 02/17/2012
 Page: 8 of 11
 Insp. Co. Job #: 155741

Insp. Company: Matrix_Inspection LSD: 12-29-096-11W6 Jurisdiction #: A3090893

CNRL Criticality Evaluation – “MUST BE COMPLETED”

The CNRL In-Service Pressure Vessel Inspector MUST answer all the following questions

1. Is the vessel fit-for-service? : **Yes**
2. Was the measured thickness less than the calculated minimum required thickness (T-min) for any component?: **No**
3. Were MT indications found?: **N/A**
4. Was the remaining life less than 6 years for sour service vessels or less than 10 years for sweet service vessels?: **No**
5. Were NCR's or Action Items generated as a result of the inspection? : **Yes**
6. Were UT readings below (Nominal WT – Corrosion Allowance) found? : **No**

Information on CNRL Owner User Program - Criticality Designation and Required Review

RED – Vessel Inspection Results are deemed RED if one of the following occurred:

- The measured thickness was less than the calculated minimum required thickness (T-min) for any component.
- MT indications were found.
- The remaining life was calculated to be less than 6 years for sour-service vessels or less than 10 years for sweet-service vessels.

RED inspection reports must be signed off by the CNRL Chief Inspector.

YELLOW – Vessel Inspection Results are deemed YELLOW if one or more of the following occurred:

- The vessel was declared NOT fit-for-service by the 3rd Party In-Service PV Inspector.
- NCR's or Action Items were generated as a result of the inspection.
- UT readings below (Nominal WT – Corrosion Allowance) were found.

YELLOW inspection reports must be signed off by the CNRL Pressure Equipment Integrity Coordinator.

GREEN – Vessel Inspection Results are deemed GREEN if all of the following are true:

- The vessel was declared fit-for-service by the 3rd Party In-Service PV Inspector.
- UT readings below (Nominal WT – Corrosion Allowance) were NOT found.
- MT indications were NOT found.
- NCR's or Action Items were NOT generated as a result of the VE inspection.

GREEN inspection reports must be signed off by the 3rd Party In-Service Pressure Vessel Inspector.

Criticality Designation



Yellow

Vehicle #: 501 Kms: _____
 Time In: 00:00 Time Out: 00:00 Hrs _____
 Time In: 00:00 Time Out: 00:00 Hrs _____
 Personnel: BI, LP
 Billing Info: AFE :

Inspector (Name): Matthew B Dickinson PESL: 601
 Inspector (Signature): _____ API: 39483
 CNRL Coordinator (Name): _____
 CNRL Coordinator (Signature): _____
 CNRL Chief Inspector (Signature): _____
 (I am in full agreement with report contents) _____
 (I am in full agreement with report contents) _____

Equipment Photographs:



01 nameplate



02 overview



03 bottom head



04 minor surface corrosion



05 not within range



06 PSV overview