Work Order No.

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

1 2 0 2023

(Alternative Form for Single Chamber, Completely Shop or Field Fabricated Vessels Only)

AN 2 0 2023

As Required by the Provisions of the ASME Boiler and Pressure Vessel Code Rules, Section VIII, Division 1 Page 1 of 2

Cocation of Interpretation of	IS Seption of the sep	paratorical, tank) ion VIII A-516 I spec. nu ID Type 1 d, dbl., sn	(Ma , Division -70N mber, grade OD N/A	22-1. nufacturer's 1 1 [E	mpion X Ult	U6 / N/A a, if applicable ness) Ma	(Na .C, 261088 5559.213 (CRN) e (date)] 0.12 (Corr. Body Flange	(Co (Co 25 in allow.)	Vess of Purcha Vheel Cres e and address) 24-1440-RE (Drawing r 3042 le Case numbers	G Rev.10	/iew, Albert (Natio	1307 nal Board numt N/A cial service per [Length	2 er) (Ye	023 ar built)
ype Vertica (Horizonte ASME Code) Shell: Type N/A Seams: [Long Heads: (a) Location (Top Bottom, Ends	N/A	paratorical, tank) ion VIII A-516. I spec. nu ID Type 1 d, dbl., sn	(Ma , Division -70N mber, grade OD N/A N/A 1gl., lap, but -516-70	22-1. nufacturer's n 1 [E	37 s serial number) 2021. dition and Addenda 1.000 in (Nominal thick) Min Hub Thk N/A Full	/ N/A a, if applicable n ness) Ma	.C, 261088 (559.213 (CRN) e (date)] 0.12 (Corr. Body Flance	(Name	Vheel Crese e and address) 24-1440-RE (Drawing r 3042 le Case numbers	G Rev.10 umber)	(Natio	1307 nal Board numb N/A tial service per 1 {Lengt	20° (Ye	
(Horizonta ASME Code Shell: Type N/A Geams: [Long Heads: (a) Location (Top Bottom, Ends	Section Sectio	ical, tank) ion VIII A-516 I spec. nu ID A Type 1 d, dbl., sn SA erial spec	(Ma , Division -70N mber, grade OD N/A N/A 1gl., lap, but -516-70	nufacturer's 1 1 [E	2021. dition and Addenda 1.000 in (Nominal thick) Min Hub Thk N/A Full	/ N/A a, if applicable n ness) Ma	e (date)] 0.12 (Corr. Body Flange	(Con 25 in allow.) es on Sheil How	24-1440-RE (Drawing r 3042 le Case numbers	G Rev.10 umber) 24" (OD)	[Spec	N/A N/A Sial service per Lengt	ver) (Ye UG-120(d)] 20"	
ASME Code Shell: Type N/A Seams: [Long Heads: (a) Location (Tog Bottom, Ends	Section S (Material N/) (Welder (Material N/) (Material N/)	A-516 I spec. nu ID A Type 1 d, dbl., sa	-70N mber, grade OD N/A -516-70	Flange Thk N/A	2021 dition and Addenda 1.000 fit (Nominal thicks) Min Hub Thk N/A Full	/ N/A a, if applicable n ness) Ma	e (date)] 0.12 (Corr. Body Flange	25 in allow.) ss on Shell How	3042 le Case numbers	24" (OD)	[Spec	N/A cial service per 1 (Lengt	UG-120(d)]	ar ount)
Type N/A Seams: [Long Heads: (a) Location (Tog Bottom, Ends	Material N/. (Welde (Mater),	ID A Type 1 d, dbl., sr SA erial spee	OD N/A Igl., lap, but -516-70 c. number	Flange Thk N/A ti)] [R.1	1.000 in (Nominal thicks Min Hub Thk N/A	n ness) Ma	0.12 (Corr. Body Flange	25 in allow.) ss on Shell How	le Case numbers	24" (OD)		cial service per 1 (Lengt	20"	
Type N/A Seams: [Long leads: (a) Location (Tog Bottom, Ends	Materia N/	ID Type 1 dd, dbl., sn SA erial special special	OD N/A gl., lap, but -516-70 ec, numbe	Flange Thk N/A	(Nominal thicks Min Hub Thk N/A Full	Ma	(Corr. Body Flangs terial	allow.) es on Shell How	((Lengt		
Type N/A Seams: [Long leads: (a) Location (Top Bottom, Ends	N/. (welde	Type 1 d, dbl., sn SA erial spe	OD N/A Igl., lap, but -516-70	Flange Thk N/A	Min Hub Thk	Ma N/A	Body Flange terial	es on Shell How		Tires diameter)			n (overali)j	
N/A Seams: [Long Heads: (a) Location (Tog Bottom, Ends	(Welde	Type 1 d, dbl., sn	N/A 	Thk N/A t)] [R.1	N/A Full	N/A					В	oltina		
N/A Seams: [Long Heads: (a) Location (Tog Bottom, Ends	(Welde	Type 1 d, dbl., sn	N/A 	N/A t)] [R.1	N/A Full	N/A		Attached	Location		Bolting Bolting Washer (OD, I		5 15 T 141-1	
Seams: [Long Heads: (a) Location (Top Bottom, Ends	(Welde	Type 1 d, dbl., sn SA- erial spe	gl., lap, but -516-70 ec. numbe	(i)] [R.1 N - 115(Full					Num & Size	Material	thk)	Mate	
Location (Top Bottom, Ends	(Mate	d, dbl., sn SA- erial spe	ngl., lap, but -516-70 ec. numbe	N - 1150				N/A	N/A	N/A	N/A	N/A	N/A	
Location (Top Bottom, Ends),	erial spe	c. numbe	N - 1150		100 (Eff.,%)	1150°F (H.T. temp)	1.0 (Time, hr)		Type 1 led, dbl., sngl., lap,		uff ot or full)}	100 (Eff., %) (No.	1 of courses)
Bottom, Ends),			r. grade (OF for 60 Min or type) (H.T t	nutes	mn.)		(b)	SA-516-7 aterial spec. num	ON - 1150F	for 60 Min	utes	
TOP) [ickness		Radiu	_	Elliptical	Conical Ap			ide to Pressure		Category A	
		Min.			Crown	Knuckle	Ratio	Angle	Radius	Diameter	Convex Concave			Eff.
DUIIŲM	_					N/A	2:1	N/A	N/A	N/A	Х	N/A	None	N/A
		1.9313	0.12	19	N/A	1				N/A	X	N/A	None	N/A
					1			s on Heads			В	olting	,	
Location			ID	OD	Flange Thk	Thk	Materia	ial H	ow Attached	Num & Size	1	washer (OD. Washer M	aterial
N/A I	I/A	1	N/A	N/A	N/A	N/A	N/A	N/A			N/A	N/A	N/A	
in. design m		(Internal))	 -	(Ex	temal)			·	130 °F (Internal) omb. test pres	sure	N/A (External) HYDRO a	t 2160 psi	·
roof test								N/A						
		and sat	fety valv	e openir	ngs:									
se (Inlet, Outle	t, No.			vpe				Nozz	e Thickness		Attachme	ent Details	Location (Insp	Open)
rain, etc.)	+		<u> </u>			le						Flange		. Орол.,
<u> </u>	+					-234-WPB								nad .
PSV	1	4"								-			Shell	-
upports: Sk	irt	Yes (Yes or no	Lug	(Numb	er)	N/A (Number)	Other		N/A (Describe)			(Whe		ed
	Cities	i Loi fiai (Data Nepu	irs biohai	iy ideniiled and	signed by C	JOHNING STONEO	irispectors, i	iave been iurni:	sned for the tollow	ing items of the	report:		
					(Name o	of part, item n	number, Manufac	turer's name a	nd identifying sta	np)				_
Construct PSV by Ot JDR not a Impact Te JCS-66 Cu Length Me Jessel te	ion l hers pplic stine rve l asure sted	per cable g Exe B, UC ement at p	ng: 2 UG-151 mpt Pe S-66 N is s/ iping	2-137 cr UCS lote C	Shts 1-3	Rev.1					b), UCS-60	6 (b) (3) ,	_	
	Location N/A MAWP in. design more of test pozzles, inspected in the control of test pozzles, inspected in	TOP BOTTOM Location N/A N/A N/A N/A N/A N/A N/A N/	Bottom, Ends) Min. TOP 0.9375" BOTTOM 0.9375" Location Type N/A N/A I MAWP 1440 p. (Internal in. design metal temp. Toof test Dizzles, inspection and sa se (Inlet, Outlet, No. Diamete or Size t, Gas Outlet 2 10" Drain 1 2" PSV 1 4" Jional Nozzles - See Attached upports: Skirt Yes (Yes or no marks: Manufacturer's Partial II //A Volume: 28.01 cu Construction Drawi PSV by Others per JOR not applicable Impact Testing Exe Ucsneth Measurement Vessel tested at p	Bottom, Ends) Min. Co TOP 0.9375" 0.12 BOTTOM 0.9375" 0.12 Location Type ID N/A N/A N/A N/A MAWP 1440 psl (Internal) in. design metal temp20 °F roof test Description and safety valves (Inlet, Outlet, No. Diameter or Size or Size) t, Gas Outlet 2 10" CL600 ID Train 1 2" CL600	Bottom, Ends) Min. Corr. TOP 0.9375" 0.125" BOTTOM 0.9375" 0.125" Location Type ID OD N/A N/A N/A N/A N/A AAWP 1440 psl (Internal) in. design metal temp20 °F roof test Description and safety valve opening or Size (Inlet, Outlet, No. Diameter or Size (Inlet, Outlet, Orain, etc.) Type or Size Type or Size type of Size (Inlet, Outlet, No. Diameter or Size (Inlet, Outlet	Bottom, Ends) Min. Corr. Crown TOP 0.9375" 0.125" N/A BOTTOM 0.9375" 0.125" N/A Location Type ID OD Flange Thk N/A N/A N/A N/A N/A N/A AAWP 1440 psl (Internal) (E) in. design metal temp20 °F at roof test Dozztes, inspection and safety valve openings: Se (Inlet, Outlet, No. Diameter or Size Type Nozz t, Gas Outlet 2 10" CL600 RFHBWN - Drain 1 2" CL600 RFWN SA-106B / SA PSV 1 4" CL600 RFLWN - SA-106B / SA PSV 1 4" CL600 RFLWN - SA-106B / SA ional Nozzles - See Attached U-4 upports: Skirt Yes Lugs 2 Legs (Number) pranarks: Manufacturer's Partial Data Reports properly identified and MA (Name of Construction Drawing: 22-137 Shts 1-3 PSV by Others per UG-151 TOR not applicable Impact Testing Exempt Per UCS-66 Curve Bressure as Measurement is s/s Fessel tested at piping test pressure as Measurement is s/s Fessel tested at piping test pressure as Measurement is s/s	Bottom, Ends) Min. Corr. Crown Knuckle TOP 0.9375" 0.125" N/A N/A BOTTOM 0.9375" 0.125" N/A N/A Location Type ID OD Flange Thk Min Hub Thk N/A N/A N/A N/A N/A N/A N/A N/A AAWP 1440 psl (Internal) (External) in. design metal temp20 °F at 1440 psi roof test Description and safety valve openings: Se (Inlet, Outlet, Oralia, etc.) No. Diameter or Size Type Materia Drain, etc.) Type Materia Drain 1 2" CL600 RFHBWN - Drain 1 2" CL600 RFHBWN SA-106B / SA-234-WPB PSV 1 4" CL600 RFLWN	Bottom, Ends) Min. Corr. Crown Knuckle Ratio TOP 0.9375" 0.125" N/A N/A 2:1 BOTTOM 0.9375" 0.125" N/A N/A 2:1 Body Flange Location Type ID OD Flange Thk Min Hub Thk Mater N/A AAWP 1440 psl N/A (External) in. design metal temp20 °F at 1440 psl roof test Dozzles, inspection and safety valve openings: se (Inlet, Outlet, Or Size Type Nozzle Flange Nozzle, inspection and safety valve openings: se (Inlet, Outlet, Or Size Type Nozzle Flange Nozzle Flange Nozzle Flange Nozzles, inspection and safety valve openings: se (Inlet, Outlet, Or Size Type Nozzle Flange Nozzle Flange Nozzles Sea Attached U-4 upports: Skirt Yes Lugs 2 Legs N/A Other (Number) imarks: Manufacturer's Partial Data Reports properly identified and signed by Commissioned (A (Name of part, item number, Manufactures) TOR not applicable Impact Testing Exempt Per UCS-66 Curve D, UG-20 (£), UCS-66 Curve B, UCS-66 Note Cength Measurement is s/s	Min. Corr. Crown Knuckle Ratio Angle	Soltom, Ends Min. Corr. Crown Knuckle Ratio Angle Radius	Sottom, Ends Min. Corr. Crown Knuckle Ratio Angle Radius Diameter TOP 0.9375" 0.125" N/A N/A N/A 2:1 N/A N/A	Bottom, Ends) Min. Corr. Crown Knuckle Ratio Angle Radius Diameter Corrext Corext TOP 0.9375* 0.125* N/A N/A N/A 2:1 N/A N/A N/A N/A X BOTTOM 0.9375* 0.125* N/A N/A N/A 2:1 N/A N/A N/A N/A X BOTTOM 0.9375* 0.125* N/A N/A N/A N/A N/A N/A N/A N/A X Location Type ID OD Flange Thk Min Hub Thk Material How Attached Num & Size Botting Material (Internal) (Internal) (Internal) (Internal) (Internal) -20 °F at 1440 psi N/A at max. temp. 130 °F (Internal) (Internal) -20 °F at 1440 psi N/A	Bottom, Ends Min. Corr. Crown Knuckle Ratio Angle Radius Diameter Correx Concave Type	Bottom, Ends Min. Corr. Crown Knuckle Ratio Angle Radius Diameter Correst Correst

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Manufactured by Reece Custom Manufacturing Inc., 7013 Old TransCanada Highway, Redcliff, Alberta, T0J 2P0, CANADA Manufacturer's Serial No. 22-137 CRN U6559.213 National Board No. 1307 **CERTIFICATE OF SHOP/FIELD COMPLIANCE** We certify that the statements made in this report are correct and that all details of design, material, construction, and workmanship of this vessel conform to the ASME BOILER AND PRESSURE VESSEL CODE, Section VIII, Division 1. "U" Certificate of Authorization Number 38402 March 2, 2024 Date 01/20/2023 Co. name Reece Custom Manufacturing Inc. Signed (Manufacturer) CERTIFICATE OF SHOP/FIELD INSPECTION Vessel constructed by Reece Custom Manufacturing Inc. at 7013 Old TransCanada Highway, Redcliff, Alberta, T0J 2P0, CANADA I, the undersigned, holding a valid commission issued by The National Board of Boiler and Pressure Vessel Inspectors and employed by Alberta Boilers Safety Association (ABSA), of Edmonton, AB, Canada have inspected the component described in this Manufacturer's Data Report on January 20, 2023 and state that, to the best of my knowledge and belief, the Manufacturer has constructed this pressure vessel in accordance with ASME BOILER AND PRESSURE VESSEL CÓDE, Section VIII, Division 1. By signing this certificate neither the Inspector nor his/her employer makes any warranty, expressed or implied, concerning the pressure vessel described in this Manufacturer's Data Report. Furthermore, neither the Inspector nor his/her employer shall be liable in any manner for any personal injury or property damage or a loss of any kind arising from or connected with

Commissions

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01/20/2023

this inspection.

Date

exe: v6.3.126

Signed

Form and version:

(National Board Authorized Inspector Commission number)

U1A-20

FORM U-4 MANUFACTURER'S DATA REPORT SUPPLEMENTARY SHEET

	As Required by	the Provisions	S OF THE ASME BOILE	and Pressure Vesso	el Code Rules, Se	ection VIII, Division 1	1		
1. Manufactured and certified I	Reece Cus	tom Manufac	turing Inc., 7013 (Old TransCanada i	lighway, Redcl	iff, Alberta, T0J 2I	P0, CANADA		
2. Manufactured for Champi	on X UltraFab	ULC, 261088		escent, Rocky View		0E2, CANADA	<u></u>		
3. Location of installation Fo	or Stock - Char	npion X Ultra	Fab ULC, 261088	Wagon Wheel Cre (Name and address)		iew, Alberta, T4A	0E2, CANADA		
4. Type Vertical Se (Horizontal, vertical		(1	N/A ank, separator, heat exch.	etc.)	22-137 (Manufacturer's serial number)				
U6559.213 (CRN) Data Report			REG Rev.10		1307 (National Board num	nber)	2023 (Year built)		
Item Number		Remarks							
ditional Remarks: 5ab: (24) 1" x 6-3/4"	Studs SA19	3-B7M; (48)	1" Nut SA194	-2нм					
dditional nozzles, inspection ar	20	penings:	M-1-1-1	In					
Purpose (Infet, Outlet, Drain, etc.)	No. Diameter or Size	Туре	Material Nozzle Flance	Nozzle Thickness	Reinforcement Material	Attachment Details	—H ocation (Inso. Oc		

Purpose (Infet, Outlet, Drain, etc.)	No.	Diameter		Material		Nozzle Thickness		Reinforcement	Attachment Details		1
r arpose (mier, Odder, Drain, etc.)		or Size	Type	Nozzie	Flange	Nom.	Соп.	Material	Nozzle	Flange	Location (Insp. Open.
Cleanout/Inspection	2	6"	CL600 RFHBWN		SA-350LF2 Cls1	2.06"	0.125"	-	-	UW16.1(c)	Shell
Water LC, HC LC, HLSD, Inspection	4	2"	TOL	SA-105N		6M	0.125"	50	UW16.1(a)	- '	Shell, Top Head
Water Outlet, HC Outlet	2	1-1/2"	TOL	SA-105N		6M	0.125"	_	UW16,1(a)		Shell
Future LS Bridle	4	1"	TOL	SA-105N	_	6M	0.125"	**	UW16.1(a)	_	Shell
Ti, Water LG, HC LG	5	3/4"	TOL	SA-105N	-	6M	0.125"	**	UW16.1(a)	_	Shell
PI	1	1/2"	TOL	SA-105N	-	6M	0.125"	-	UW16.1(a)	-	Shell

Certificate of Authoriza	ation: Type <u>"l</u>	J" No. 38402		Expires March 2, 2	2024	
Date 01/20/2023	Name	Reece Custom Manufacturing In	ic	Signed	Dang	Velden
Date 01/20/2023	Signed	(Authorized Inspector)	Commissions	***************************************	16414	DOOOG484