

698581

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

(Alternative Form for Single Chamber, Completely Shop or Field Fabricated Vessels Only)
As Required by the Provisions of the ASME Boiler and Pressure Vessel Code Rules, Section VIII, Division 1 Page 1 of 2

AI: B
1/20/23

1. Manufactured and certified by Reece Custom Manufacturing Inc., 7013 Old TransCanada Highway, Redcliff, Alberta, T0J 2P0, CANADA
2. Manufactured for Champion X UltraFab ULC, 261088 Wagon Wheel Crescent, Rocky View, Alberta, T4A 0E2, CANADA
3. Location of Installation For Stock - Champion X UltraFab ULC, 261088 Wagon Wheel Crescent, Rocky View, Alberta, T4A 0E2, CANADA
4. Type Vertical Separator 22-137 U6559.213 24-1440-REG Rev.10 1307 2023
5. ASME Code, Section VIII, Division 1 2021/ N/A 3042 N/A
6. Shell: SA-516-70N 1.000 in 0.125 in 24" (OD) 120"

Table with 13 columns: No., Type, ID, OD, Flange Thk, Min Hub Thk, Material, How Attached, Location, Num & Size, Bolting Material, Washer (OD, ID, thk), Washer Material. All cells contain N/A.

7. Seams: Type 1 Full 100 1150°F 1.0 Type 1 Full 100 1
8. Heads: (a) SA-516-70N - 1150F for 60 Minutes (b) SA-516-70N - 1150F for 60 Minutes

Table with 14 columns: Location (Top, Bottom, Ends), Thickness (Min, Corr), Radius (Crown, Knuckle), Elliptical Ratio, Conical Apex Angle, Hemispherical Radius, Flat Diameter, Side to Pressure (Convex, Concave), Category A (Type, Full, Spot, None, Eff). Rows (a) TOP and (b) BOTTOM.

Table with 13 columns: Location, Type, ID, OD, Flange Thk, Min Hub Thk, Material, How Attached, Num & Size, Bolting Material, Washer (OD, ID, thk), Washer Material. Row (a) contains N/A.

9. MAWP 1440 psi at max. temp. 130 °F
Min. design metal temp. -20 °F at 1440 psi Hydro, pneu., or comb. test pressure HYDRO at 2160 psi
Proof test N/A

Table with 11 columns: Purpose (Inlet, Outlet, Drain, etc.), No., Diameter or Size, Type, Material (Nozzle, Flange), Nozzle Thickness (Nom., Corr), Reinforcement Material, Attachment Details (Nozzle, Flange), Location (Insp. Open.). Rows for Inlet, Gas Outlet; Drain; PSV.

11. Supports: Skirt Yes Lugs 2 Legs N/A Other N/A Attached Bottom Head & Shell/Welded

12. Remarks: Manufacturer's Partial Data Reports properly identified and signed by Commissioned Inspectors, have been furnished for the following items of the report:
N/A

Volume: 28.01 cu ft/0.79 cu m
Construction Drawing: 22-137 Shts 1-3 Rev.1
PSV by Others per UG-151
UDR not applicable
Impact Testing Exempt Per UCS-66 Curve D, UG-20 (f), UCS-66 (c) (1), USC-66 (b) (1) (b), UCS-66 (b) (3), UCS-66 Curve B, UCS-66 Note C
Length Measurement is s/s
Vessel tested at piping test pressure at 1.5
Additional Remarks - See Attached U-4...

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

expires March 2, 2024

Date 01/20/2023

Co. name

Reece Custom Manufacturing Inc.
(Manufacturer)

Signed


(Representative)

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 CODE, 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 this inspection.

Date 01/20/2023

Signed


(Authorized Inspector)

Commissions

16414

(National Board Authorized Inspector Commission number) 000009484

① 698581
FORM U-4 MANUFACTURER'S DATA REPORT SUPPLEMENTARY SHEET

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

1. Manufactured and certified by Reece Custom Manufacturing Inc., 7013 Old TransCanada Highway, Redcliff, Alberta, T0J 2P0, CANADA
(Name and address of Manufacturer)

2. Manufactured for Champion X UltraFab ULC, 261088 Wagon Wheel Crescent, Rocky View, Alberta, T4A 0E2, CANADA
(Name and address of Purchaser)

3. Location of installation For Stock - Champion X UltraFab ULC, 261088 Wagon Wheel Crescent, Rocky View, Alberta, T4A 0E2, CANADA
(Name and address)

4. Type Vertical Separator N/A 22-137
(Horizontal, vertical, or sphere) (Tank, separator, heat exch., etc.) (Manufacturer's serial number)

U6559.213 24-1440-REG Rev.10 1307 2023
(CRN) (Drawing number) (National Board number) (Year built)

Data Report Item Number Remarks

Additional Remarks:

N5ab: (24) 1" x 6-3/4" Studs SA193-B7M; (48) 1" Nut SA194-2HM

Additional nozzles, inspection and safety valve openings:

Purpose (Inlet, Outlet, Drain, etc.)	No.	Diameter or Size	Type	Material		Nozzle Thickness		Reinforcement Material	Attachment Details		Location (Insp. Open.)
				Nozzle	Flange	Nom.	Corr.		Nozzle	Flange	
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"	-	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 Authorization: Type "U" No. 38402 Expires March 2, 2024

Date 01/20/2023 Name Reece Custom Manufacturing Inc. Signed *David Selkirk*
(Manufacturer) (Representative)

Date 01/20/2023 Signed *Pandey* Commissions 16414 00009484
(Authorized Inspector) (National Board Authorized Inspector Commission number)