

A703919

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

Work Order No.

(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

AT: E 3/3/23

MAR 03 2023

- 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** **22-142** **U6559.213** **24-1440-REG Rev.10** **1323** **2023**
(Horizontal or vertical, tank) (Manufacturer's serial number) (CRN) (Drawing number) (National Board number) (Year built)
- 5. ASME Code, Section VIII, Division 1 **2021/ N/A** **3042** **N/A**
(Edition and Addenda, if applicable (date)) (Code Case numbers) (Special service per UG-120(d))
- 6. Shell: **SA-516-70N** **1.000 in** **0.125 in** **24" (OD)** **120"**
(Material spec. number, grade) (Nominal thickness) (Corr. allow.) (Inner diameter) (Length (overall))

Body Flanges on Shells													
No.	Type	ID	OD	Flange Thk	Min Hub Thk	Material	How Attached	Location	Bolting				
									Num & Size	Bolting Material	Washer (OD, ID, thk)	Washer Material	
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

- 7. Seams: **Type 1** **Full** **100** **1150°F** **1.0** **Type 1** **Full** **100** **1**
(Long, welded, dbl., sngl., lap, butt) (R.T.(spot or full)) (Eff. %) (H.T. temp) (Time, hr) (Girth, welded, dbl., sngl., lap, butt) (R.T. (spot or full)) (Eff. %) (No. of courses)

- 8. Heads: (a) **SA-516-70N - 1150F for 60 Minutes** (b) **SA-516-70N - 1150F for 60 Minutes**
(Material spec. number, grade or type) (H.T. - time and temp.) (Material spec. number, grade or type) (H.T. - time and temp.)

	Location (Top, Bottom, Ends)	Thickness		Radius		Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure		Category A		
		Min.	Corr.	Crown	Knuckle					Convex	Concave	Type	Full, Spot, None	Eff.
(a)	TOP	0.9375"	0.125"	N/A	N/A	2:1	N/A	N/A	N/A		X	N/A	None	N/A
(b)	BOTTOM	0.9375"	0.125"	N/A	N/A	2:1	N/A	N/A	N/A		X	N/A	None	N/A

Body Flanges on Heads													
	Location	Type	ID	OD	Flange Thk	Min Hub Thk	Material	How Attached	Bolting				
									Num & Size	Bolting Material	Washer (OD, ID, thk)	Washer Material	
(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

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

10. 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	
Inlet, Gas Outlet	2	10"	CL600 RFHBWN	--	SA-350LF2 CL1	2.72	0.125"	--	UW16.1(c)	--	Shell
Drain	1	2"	CL600 RFWN	SA-106B / SA-234-WPB	SA-105N	0.344"	0.125"	--	UW16.1(c)	Type 1	Bottom Head
PSV	1	4"	CL600 RFLWN	--	SA-350LF2 CL1	1.00"	0.125"	--	UW16.1(c)	--	Shell

Additional Nozzles - See Attached U-4...

- 11. Supports: Skirt **Yes** Lugs **2** Legs **N/A** Other **N/A** Attached **Bottom Head & Shell/Welded**
(Yes or no) (Number) (Number) (Describe) (Where and how)

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
(Name of part, item number, Manufacturer's name and identifying stamp)

Volume: 28.01 cu ft/0.79 cu m
Construction Drawing: 22-142 Shts 1-3 Rev.3
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 x M.A.W.P
 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.	22-142	CRN	U6559.213
		National Board No.	1323

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 03/03/2023 Co. name Reece Custom Manufacturing Inc. Signed [Signature]
(Manufacturer) (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 March 3, 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 03/03/2023 Signed [Signature] Commissions 16414
(Authorized Inspector) (National Board Authorized Inspector Commission number)

FORM U-4 MANUFACTURER'S DATA REPORT SUPPLEMENTARY SHEET

A 703919

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 22-142
(Horizontal, vertical, or sphere) (Tank, separator, heat exch., etc.) (Manufacturer's serial number)

U6559.213 24-1440-REG Rev.10 1323 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 CL1	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 03/03/2023 Name Reece Custom Manufacturing Inc. Signed *J. Lambert*
(Manufacturer) (Representative)

Date 03/03/2023 Signed *Pandey* Commissions 16414 00009484
(Authorized Inspector) (National Board Authorized Inspector Commission number)