

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

\* (Corrected Copy)

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

1. Manufactured and certified by Patrick Fabricating & Welding Enterprises, Inc. , 22216 Prats Dairy Road Abita Springs, LA. 70420  
(Name and address)

2. Manufactured for Process Services, Inc. 9552 - 26<sup>th</sup> Avenue Edmonton, AB T6N 1H8 Canada  
(Name and address)

3. Location of Installation Unknown  
(Name and address)

4. Type Vertical 08V763-01 U8910.2 08V763-10-01 Rev 4 471 2009  
(Hoiz. or vert., tank) (Mfg'r's serial No.) (CRN) (Drawing No.) (Nat'l Bd. No.) (Year built)

5. The chemical and physical properties of all parts meet the requirements of material specifications of the ASME BOILER AND PRESSURE VESSEL CODE. The design, construction, and workmanship conform to ASME Rules, Section VIII, Division 1

to N/A N/A N/A  
Addenda (Date) Code Case Nos. Special Services per UG-120(d)

6. Shell SA-516-70N 0.625" / 15.9mm 0.125" / 3.2mm 5'-10 3/4" / 1797.1mm 20'-0" / 6096mm S/S  
Mat'l. (Spec. No., Grade) Nom. Thk. (In.) Corr. Allow. (In.) Diam. I.D. (Ft. & in.) Length (overall) (Ft. & in.)

7. Seams Welded Full 100% 1150 1 Type-1 Full 100% 2  
Long. (Welded, Dbl., Sngl., Lap, Butt) R.T. (Spot or Full) Eff (%) H.T. Temp. (° F) Time (hr) Girth (Welded, Dbl., Sngl., Lap, Butt) R.T. (Spot, Partial, or Full) Eff (%) No. Of Courses

8. Heads: (a) Mat'l. SA-516-70N (b) Mat'l. SA-516-70N  
(Spec. No., Grade) (Spec. No., Grade)

	Location (Top, Bottom, Ends)	Minimum Thickness	Corrosion Allowance	Crown Radius	Knuckle Radius	Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure (Convex or Concave)
(a)	Top	0.625"	0.125"	-	-	2:1	-	-	-	Concave
(b)	Bottom	0.625"	0.125"	-	-	2:1	-	-	-	Concave

If removable, bolts used (describe other fastenings)

9. MAWP 1765 kPa / 256 PSIG N/A psi at max. temp. 100°C / 212°F N/A ° F  
(internal) (external)

Min. design metal temp. -46°C / -50°F at 1765 kPa / 256 PSIG psi Hydro., pneu., or comb. test pressure 2296 kPa / 333 PSIG psi  
(internal) (external)

10. Nozzles, inspection and safety valve openings:

Purpose (Inlet, Outlet, Drain)	No.	Diam or Size	Type	Mat'l.	Nom. Thk.	Reinforcement Mat'l.	How Attached (Per UW 16.1)	Location
Inlet / Outlet	2	3"	RFLWN	SA-350LF2CL1	0.625	Inherent	Fig. C	Side
TG	1	2"	RFLWN	SA-350LF2CL1	0.530"	Inherent	Fig. C	Side
PG/Vent	1	2"	Pipe	SA-333Gr6	0.344"	SA-516-70N	Fig. H	Top
	1	2"	RFWN	SA-333Gr6	150#	Inherent	Type 1	Pipe

11. Supports: Yes Lugs Legs Other Skirt Attached Head B/Welded  
(Yes or No) (No.) (No.) (Describe) (Where and How)

12. Remarks:

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

## Certificate of Shop Compliance

We certify 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 Code for pressure vessels, Section VIII, Division 1. "U" Certificate of Authorization No. 31.373 expires June 20, 20 11.

Date 7/30/09 Co. Name Patrick Fabricating & Welding Ent. Inc. Signed [Signature]  
(Manufacturer) (Representative)

## Certificate of Shop Inspection

Vessel constructed by Patrick Fabricating & Welding Ent. Inc. at 22216 Prats Dairy Road, Abita Springs, LA. 70420

I, the undersigned, holding a valid commission by the National Board of Boiler and Pressure Vessel Inspectors and/or the State or Providence of Louisiana and employed by OneBeacon America Insurance Company have inspected the component described in this Manufacturer's Data Report on 6/29 20 09, and state that, to the best of my knowledge and belief, the Manufacturer has constructed this pressure vessel in accordance with ASME Code, Section VIII, Division 1. By signing this certificate, neither the Inspector nor his employer makes any warranty, expressed or implied, concerning the pressure vessel described in this Manufacturer's Data Report. Furthermore, neither the Inspector nor his 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 inspection.

Date 7/30/09 Signed [Signature] Commissions NBC1393 "A" LA1500  
(Authorized Inspector) (Nat'l Board (incl. endorsements) State Providence and No.)

**FORM U-4 MANUFACTURER'S DATA REPORT SUPPLEMENTARY SHEET**  
As Required by the Provisions of the ASME Code Rules, Section VIII, Division 1

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1. Manufactured and certified by Patrick Fabricating & Welding Enterprises, Inc., 22216 Prats Dairy Road, Abita Springs, LA. 70420  
(Name and Address of Manufacturer)

2. Manufactured for Process Services, Inc. 9552 - 26<sup>th</sup> Avenue Edmonton, AB T6N 1H8 Canada  
(Name and Address of Purchaser)

3. Location of Installation Unknown  
(Name and Address)

4. Type: Vertical Lean Amine Charcoal Filter 08V763-01  
(Horiz., vert., or sphere) (Tank, separator, heat exch., etc.) (Mfg's. Serial No.)

U8910.2 08V763-10-01 Rev 4 471 2009  
(CRN) (Drawing No.) (Nat'l Bd. No.) (Year Built)

Data Report  
Item Number

Remarks

10	Purpose	No.	Diam.	Type	Mat'l	Nom. Thk.	Reinf. Mat'l	How Attached (Per UW 16.1)	Location
	Dump	1	6"	RFLWN	SA-350LF2CL1	0.875"	Inherent	Fig. C	Side
	PSV	1	3"	Pipe	SA-333Gr6	0.438"	SA-516-70N	Fig. H	Top
		1	3"	RFWN	SA-333Gr6	150#	Inherent	Type 1	Pipe
	PDG	2	2"	RFLWN	SA-350LF2CL1	0.530"	Inherent	Fig. C	Side
	Drain	1	3"	Pipe	SA-333Gr6	0.438"	SA-516-70N	Fig. H	Bottom
		1	3"	Elbow	SA-420 WPL6	0.438"	Inherent	Type 1	Pipe
		1	3"	Pipe	SA-333Gr6	0.438"	Inherent	Fig. C	Elbow
		1	3"	RFWN	SA-333Gr6	150#	Inherent	Type 1	Pipe
	Purge	1	2"	Pipe	SA-333Gr6	0.344"	SA-516-70N	Fig. H	Top
		1	2"	RFWN	SA-333Gr6	150#	Inherent	Type 1	Pipe
	Flush	1	6"	RFLWN	SA-350LF2CL1	0.875"	SA-516-70N	Fig. H	Side
	Manway	1	24"	RFLWN	SA-350LF2CL1	1.125"	SA-516-70N	Fig. C	Side
	Manway	1	24"	Pipe	SA-333Gr6	0.500"	SA-516-70N	Fig. H	Top
		1	24"	RFWN	SA-333Gr6	150#	Inherent	Type 1	Pipe

M1A 24" Manway has 150#, SA-350LF2CL1, B16.5 RFBF, w/ (20) 1 1/4" x 7" Lg. SA-193B7M Bolts w/ 2 SA-1942HM, H.H. Nuts each

M1B 24" Manway has 150#, SA-350LF2CL1, B16.5 RFBF, w/ (20) 1 1/4" x 7" Lg. SA-193B7M Bolts w/ 2 SA-1942HM, H.H. Nuts each

\* Flanges are B16.5, SA-350LF2CL1, 150#, Vessel Hydro Tested in Horizontal Position, Over Pressure Protection to be Installed by Owner

Production Charpy @ -50 Deg F weld and HAZ. All material impact tested at -50 Deg F or colder.

Bolting exempt from impact testing per Fig. UCS-66 (c).

Certificate of Authorization: Type U No. 31,373 Expires June 20, 20 11

Date 7/30/09 Name Patrick Fabricating & Welding Ent. Inc. Signed [Signature]  
(Manufacturer) (Representative)

Date 7/30/09 Name [Signature] Commission NB11393-A LA1508  
(Authorized Inspector) (Nat'l Board incl. Endorsement, State, Province, and No.)