



VISUAL INSPECTION REPORT-PRESSURE VESSEL

Inspection Type <input checked="" type="checkbox"/> External <input checked="" type="checkbox"/> Internal												
Date:	2025-02-03				Description:	<input checked="" type="checkbox"/> Vessel <input type="checkbox"/> Exchanger <input type="checkbox"/> Furnace <input type="checkbox"/> Boiler						
Inspector:	Ryan Hogg				Unit #:			Equip #:				
Agent Co:	101292687 Saskatchewan LTD.				Equip. Name:	Treater (96" X 30' Horizontal)						
Location/LSD	Fast Trucking Yard Carnduff				CRN #:	N7780.123						
Province:	Saskatchewan				Manufacturer:	Sivalls Inc.						
Area:	To be moved to new location				Year Built:	2010		S/N:	117025			
Subarea:					Jurisdiction #:	NB 16539		PWHT	No			
Service	<input type="checkbox"/> Sweet <input checked="" type="checkbox"/> Sour <input type="checkbox"/> Other: _____				PSV Location	Top of shell			MDMT	-20 F		
Vessel MAWP	75 PSI				Vessel MAWT	230 F			RT			
PSV Data	Set P	TAG#	Manufacturer	S/N	In. Sz.	Out. Sz.	Serv. Co.	Serv. Date	IV	CSO	Capacity	
Shell Side	75PSI	6759	Taylor	03316 2-40	3"	3"	EMS	Requires service	N	N	2822scfm	
Shell Side	75PSI	6760	Taylor	03316 2-41	3"	3"	EMS	Requires service	N	N	2822scfm	
Other									Y/N	Y/N		
Components		Material	Nominal t	CA	Retire t	Lowest t	t OK?	Calc. t-min	Comment			
	Shell	Sa-516-70	0.3125"	0			<input type="checkbox"/> Y <input type="checkbox"/> N		UT reports to be completed by Sonictec			
	Head	Sa-516-70	0.4375"	0			<input type="checkbox"/> Y <input type="checkbox"/> N					
	Channel						<input type="checkbox"/> Y <input type="checkbox"/> N					
	Tube						<input type="checkbox"/> Y <input type="checkbox"/> N		Firetube inspection completed by Sonictec on other location			
Other							<input type="checkbox"/> Y <input type="checkbox"/> N		Specify:			
External Visual Inspection												
Orientation	<input checked="" type="checkbox"/> Hor. <input type="checkbox"/> Ver.	Foundation	<input type="checkbox"/> Concrete <input type="checkbox"/> Gravel <input type="checkbox"/> Timbers <input checked="" type="checkbox"/> Steel <input type="checkbox"/> Other:					Condition Secure to skid				
Support	<input checked="" type="checkbox"/> Saddle	<input checked="" type="checkbox"/> Seal-welded	<input type="checkbox"/> Free to Move					Condition Bolted to skid floor, skid and building				
	<input type="checkbox"/> Skirt	<input type="checkbox"/> Free of debris Comment:					Condition					
	<input type="checkbox"/> Hangers	<input type="checkbox"/> Secure Comment:					Condition					
	<input type="checkbox"/> Other	Specify:					Condition					
Overall	General Condition Firetube head outside building							Electrical grounding: <input type="checkbox"/> Direct <input checked="" type="checkbox"/> Indirect <input type="checkbox"/> None				



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Ext. Surface	<input checked="" type="checkbox"/> Painted <input type="checkbox"/> Insulated <input type="checkbox"/> Fire-proofed <input type="checkbox"/> Cladded <input type="checkbox"/> Other : _____ Condition Acceptable with stains and minor scrapes on shell		
Ext. Fixtures	<input type="checkbox"/> Ladder <input type="checkbox"/> Platform(s) <input type="checkbox"/> Other: _____		Condition
Nozzles	<input checked="" type="checkbox"/> Manway <input type="checkbox"/> Port	Size: FTs and 18" MWs	<input type="checkbox"/> Reinforcement Pads used <input type="checkbox"/> Weep Holes Present Comment: No signs of leaks on manways
Davit Arm	<input checked="" type="checkbox"/> Present	<input checked="" type="checkbox"/> Greased	<input checked="" type="checkbox"/> Double Nut Condition Secure on side manway
Piping	<input checked="" type="checkbox"/> PSV	<input checked="" type="checkbox"/> Supported <input checked="" type="checkbox"/> Joined per code	<input checked="" type="checkbox"/> Drains Properly <input type="checkbox"/> Well Coated Comment
	<input checked="" type="checkbox"/> Inlet	<input checked="" type="checkbox"/> Supported <input checked="" type="checkbox"/> Joined per code	<input checked="" type="checkbox"/> Free from leaks <input type="checkbox"/> Well Coated Comment
	<input checked="" type="checkbox"/> Outlet	<input checked="" type="checkbox"/> Supported <input type="checkbox"/> Joined per code	<input checked="" type="checkbox"/> Free from leaks <input type="checkbox"/> Well Coated Comment
	<input checked="" type="checkbox"/> Drain	<input checked="" type="checkbox"/> Supported <input checked="" type="checkbox"/> Joined per code	<input checked="" type="checkbox"/> Free from leaks <input type="checkbox"/> Well Coated Comment
	<input checked="" type="checkbox"/> Instrumentation	<input checked="" type="checkbox"/> Supported <input checked="" type="checkbox"/> Joined per code	<input type="checkbox"/> Free from leaks/kinks Comment
	<input type="checkbox"/> Process Fluid Identified		<input type="checkbox"/> Flow direction marked Comment
Valves	<input checked="" type="checkbox"/> Manual Isolation Valve		<input checked="" type="checkbox"/> Free from leaks Comment
	<input type="checkbox"/> Automated Control Valve		<input type="checkbox"/> Free from leaks Comment
	<input type="checkbox"/> Vents and Drain plugged		<input type="checkbox"/> Free from leaks Comment
Gauges	<input checked="" type="checkbox"/> Pressure	Reading: 0	Condition Clean and readable
	<input checked="" type="checkbox"/> Temperature	Reading 0 F	Condition Clean and readable
Sight Glass	<input checked="" type="checkbox"/> Fluid Level	Reading:	Condition Low pressure site glass with plastic tube cover
External Inspection Notes: No external damages were noted during the external inspection. 8X30 HDX Treater. PSV off top head – will require servicing at the time of inspection. External stains on firetube head. Vessel is removed from service in FAST trucking yard. To be moved to new location.			
Internal Visual Inspection			
Date:	2025-02-03	Inspector	Ryan Hogg
Scope:	A visual internal (VI) inspection was performed on all accessible shell and head surfaces, nozzles, welds, etc.		
Access:	<input checked="" type="checkbox"/> Manway <input type="checkbox"/> Hand-hole <input type="checkbox"/> Inspection Nozzle Diameter: 18" and Firetube		
Opening	Gasket Surfaces:	<input type="checkbox"/> Compliant with code	Comment Minor coating marks and scrapes for repair
	Nozzle Tube:	<input type="checkbox"/> No pitting, erosion, etc.	Comment Minor pitting in firetube manway throat to 0.040" deep
	Uniform Corrosion:	<input checked="" type="checkbox"/> Insignificant amount	Comment



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Shell and Head Surfaces	Pitting Corrosion:	<input checked="" type="checkbox"/> None noted	Comment
	Erosion:	<input checked="" type="checkbox"/> None noted	Comment
	Mechanical Damage:	<input checked="" type="checkbox"/> None noted	Comment Previous devoe coating repairs throughout – intact.
Welds	Uniform Corrosion:	<input checked="" type="checkbox"/> Insignificant amount	Comment
	Pitting Corrosion:	<input checked="" type="checkbox"/> None noted	Comment
	Welding Defects:	<input checked="" type="checkbox"/> None noted	Comment
NDE	<input checked="" type="checkbox"/> NDT was performed by: Sonictec		Extent: Firetube
	Sonictec to provide report for firetube and UT		
Results:			
Nozzles	Obstructions:	<input checked="" type="checkbox"/> None noted	Comment
	Corrosion:	<input checked="" type="checkbox"/> None noted	Comment
	Erosion:	<input checked="" type="checkbox"/> None noted	Comment
Attachments	<input type="checkbox"/> Vortex breaker	<input type="checkbox"/> Secure <input type="checkbox"/> Good Condition	Comment
	<input type="checkbox"/> Impingement plate	<input type="checkbox"/> Secure <input type="checkbox"/> Good Condition	Comment
	<input type="checkbox"/> Suction tube	<input type="checkbox"/> Secure <input type="checkbox"/> Good Condition	Comment
	<input type="checkbox"/> Demister	<input type="checkbox"/> Secure <input type="checkbox"/> Good Condition	Comment
	<input checked="" type="checkbox"/> Other: Baffles	<input checked="" type="checkbox"/> Secure <input checked="" type="checkbox"/> Good Condition	Comment Internally coated, no damages
Detailed Inspection Summary	<p>Treater is in acceptable condition for continued service at the time of inspection. Minor coating repairs required on nozzle surfaces. South anode nozzle requires 2 areas of coating repairs; Shell 18" manway surfaces with 3 areas of devoe repairs. Firetube manway has multiple marks and scrapes in the throat and flange surfaces and require coating repairs. Minor pitt in firetube manway to 0.040" deep in throat on bottom LHS area. Coating Internals were 100% coated. Coating is getting at end of life – multiple areas of runs at application, and devoe repairs. Previous devoe repairs are intact in 30+ areas internally. Baffles, firetube supports, oil box and internal piping were all secure and in acceptable condition. All attachments were coated.</p> <p>KO section - attachments, welds, and piping were all secure and in acceptable condition. Welds, head, shell and manway were free from damages. Trays in center baffle have been previously removed. Repairs to coating throughout 10+ are intact will no visible further damages – all repaired with Devoe. Drain and bottom of shell had minor ice obstructions. Sample internal piping were in place on shell nozzles – internal heights identified on external of treater shell. Oil box was left in place, no visible damages to surfaces, manway and seal intact. Internals were oil covered with ice and debris in bottom. Manway cover was davit armed with no visible damages to surfaces, davit arm moved freely. Float and manway showed no signs of distortion or damages. Anodes and blinds were removed. South anode nozzle had minor coating scrapes and damages and was marked for coating repair. Large areas of coating – devoe – on head below and adjacent to manway – repairs are thick, but in place. Coating is heavily stained throughout.</p>		



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	<p>Internal FG Lines were intact and externally coated throughout the top of the treater,</p> <p>Firetube section piping was secure and in acceptable condition. Drain lines were coated internally. Internal ice in drain bottoms. Shell and head surfaces were coated throughout, previous coating repairs were intact. Coating is heavily stained throughout internals. Firetube supports are secure and in place with no damages – coating on supports scraped throughout. Nozzles were clean and free of damages. Anodes and blinds were removed. Inlet horseshoe baffle is in place on front end with no visible damages. Center baffle is secure with manway not removed – bolted in place. Minor coating chip – adjacent to front drain in shell.</p> <p>Firetube manway throat had minor scrapes along the surfaces edge, minor pitt ¼” diameter in front of firetube throat on bottom LHS to 0.040” deep. Previous devoe repairs were poor and partially intact. Areas of coating damages were marked for repairs.</p> <p>All areas of coating damages were marked for repair.</p> <p>Firetube was inspected by Sonictec at other location.</p>
Recommended Actions	<p>Treater was in acceptable condition for service. Vessel coating is deteriorating – previous repairs are intact, additional repairs to be completed on areas marked; 30+ areas of previous repairs throughout with some larger than 10"x10".</p> <p>Repair tube as per report from Sonictec. Tube repairs to be completed at TSASK QMS shop and supervised under TSASK. Inservice leak test will need to be completed on tube reinstall.</p> <p>Repair coating in areas:</p> <ol style="list-style-type: none"> 1. South Anode nozzle 2. Manway 18” on shell 3. Adjacent to Drain in North end of treater on shell 4. Firetube manway throat and flange areas
Integrity Status	<p>Suitable for Continued Service <input checked="" type="checkbox"/> Yes <input type="checkbox"/> No <input type="checkbox"/> Immediate Repairs Required <input checked="" type="checkbox"/> Future Repairs Required <input type="checkbox"/> Replace</p>
Inventory Status	<p><input type="checkbox"/> Active <input type="checkbox"/> Out of Service <input checked="" type="checkbox"/> Surplus <input type="checkbox"/> Rental <input type="checkbox"/> Scrap <input type="checkbox"/> Action Items Completed</p>

Visual External Inspection Interval: yrs OR Changed to: ____ yrs.

Visual Internal Inspection Interval: yrs OR Changed to: ____ yrs.

Ultrasonic Inspection Interval: yrs OR Changed to: ____ yrs.

PSV Interval: yrs OR Changed to: ____ yrs.

☐ Class 1 ☒ Class 2 IPV/IBPV Certificate #: PEI 128



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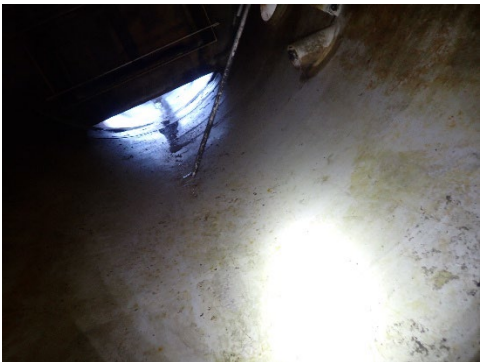
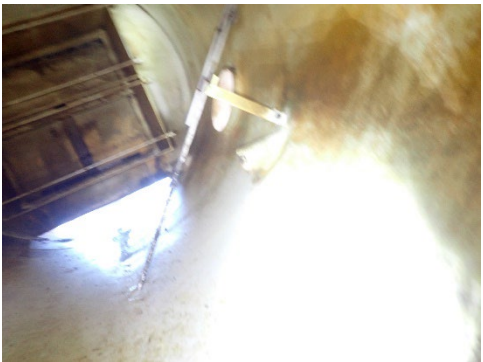


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