



# ULTRASONIC PHASED ARRAY EXAMINATION REPORT

### CLIENT INFO

CUSTOMER / CLIENT:	Enerplus	CLIENT JOB NO.:		REPORT NO. :	PAHT-200806-1
PROJECT:	Creep wave on Propane Bullet SN_A5880A	CLIENT CODING:		PAGE:	1 OF 8
LOCATION / LSD:	Joarcam LSD 06-29-49-21 W4			DATE:	4-Aug-20
PROCEDURE(S):	Issue 6 Revision 1			TECHNICIAN:	Han Thai
CODE / CLIENT SPEC:	ASME VIII DIV 1 / ASME V, ART. 4	APPROVER:	Jeff Crabbe	ASSISTANT:	Jessie Van Der Velde

### COMMENTS

UT PHASED ARRAY CREEP WAVE INSPECTION WAS COMPLETED ON BULLET SN\_A8550A CIR SEAMS, LONG SEAMS AND NOZZLE WELDS (WITH NO REPADS) AS REQUESTED BY CLIENT TO INSPECT FOR BACK WALL BREAKING IN-SERVICE DEFECTS.

#### AN ENCODED SCANNE CARRIED OUT ON:

- CIRC SEAMS (CS) NUMBERED EAST TO WEST 1-8 LENGTHS 11710mm, LOOKING EAST, START IS AT BOTTOM 6:00 O'CLOCK AND SCANNED CLOCKWISE .  
 CS\_1, SK 270 ONLY, 420-5620mm; 6270-8848mm; 9800-11530mm  
 CS\_2, 0-5015mm; 6175-7290mm; 8105-11710mm  
 CS\_3, 0-5890mm; 6390-11710mm  
 CS\_4,5,6,7, 0-11710mm  
 CS\_8, SK 90 ONLY, 0-11710mm
- LONG SEAMS (LS) NUMBERED EAST TO WEST 1-7, LENGTH 2875mm; LS 7 SCAN EAST TO WEST REMAINDER SCAN WEST TO EAST  
 LS\_1, 3, 4, 5, 6, 7, 0-2875mm  
 LS\_2, 0-1720mm
- EAST HEAD LONG SEAM (EHLS) 12, 1.5, 3, 4.5, 6, 7.5, 9, 10.5 (CLOCK POSITION), LENGTH 1785mm; SCAN FROM CENTER CIRCLE TOWARD SHELL  
 EHL\_12, 1.5, 3, 4.5, 6, 7.5, 10.5, 0-1785mm  
 EHLS\_9, 0-465mm; 980-1785mm
- WEST HEAD LONG SEAM (WHLS) 12, 1.5, 3, 4.5, 6, 7.5, 9, 10.5 (CLOCK POSITION), LENGTH 1785mm; SCAN FROM CENTER CIRCLE TOWARD SHELL  
 WHLS\_12, 1.5, 3, 4.5, 6, 7.5, 9, 10.5, 0-1785mm
- EAST HEAD CENTER CIRCLE (EHCC) 0-6120mm. START IS AT TOP 12:00 O'CLOCK AND SCANNED CLOCKWISE .
- WEST HEAD CENTER CIRCLE (WHCC) 0-6120mm. START IS AT TOP 12:00 O'CLOCK AND SCANNED CLOCKWISE .

#### MANUAL NON-ENCODED CREEPWAVE INSPECTION WAS DONE ON THE FOLLOWING AREAS DUE TO OBSTRUCTIONS TO ENCODED SCANNER:

- All Accessible Tee's  
 CS\_1, SK 270, 5620-6270mm; 8848-9800mm; 11530-11710mm; SK90 0-11710mm  
 CS\_2, 5015-6175mm; 7290-8105mm  
 CS\_3, 5890-6390mm  
 CS\_8, SK 270 0-11710mm  
 LS\_2, 1720-2875mm  
 WHLS\_9, 465-980mm

#### MANUAL NON-ENCODED INSPECTION WAS DONE ON THE FOLLOWING WELDS

- Top Side 2" X 1; 1.5" X3 Nozzles  
 Bottom Side 1.315" x 1 Nozzle  
 South West Shell 1" X 3 Nozzles

RG 120 mths VE UT + Phased Array UT

### RESULTS:

**NO BACKWALL BREAKING INDICATIONS WERE FOUND AT TIME OF INSPECTION,  
 ALL WELDS INSPECTED ARE ACCEPTABLE.**

### QUANTITIES

REGULAR TIME:		FILM:	
OVERTIME:		CONSUMABLES:	View
SHIFT PREMIUM:		EQUIPMENT:	CHT-200804-1
KILOMETERS:		EXPENSES:	
SUBSISTENCE:		MISCELLANEOUS:	

HAN THAI  
 CGSB # 19212 SNT-TC-1A UTII / MTII / PTII / ET II

### CLIENT APPROVAL:



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CODE / CLIENT SPEC:	ASME VIII DIV 1 / ASME V, ART. 4	APPROVER:	Jeff Crabbe	ASSISTANT:	Jessie Van Der Velde

## RESULTS

DRAWING NO.:		SPOOL/CONTROL NO.:	
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### WELD INFORMATION

### INDICATION INFORMATION (mm)

WELD NO.	WELDER ID	CAP WIDTH	SCAN LENGTH (mm)	SCAN START	90 SKEW THICKNESS	270 SKEW THICKNESS	START	LENGTH	DEPTH	HEIGHT	AXIAL POSITION	AMPLITUDE (%FSH)	EVALUATION	REMARKS
CS1		30	11710	0	33	18							Acceptable	No In-service Indication Noted
CS2		35	11710	0	33	33							Acceptable	No In-service Indication Noted
CS3		35	11710	0	33	33							Acceptable	No In-service Indication Noted
CS4		35	11710	0	33	33							Acceptable	No In-service Indication Noted
CS5		35	11710	0	33	33							Acceptable	No In-service Indication Noted
CS6		35	11710	0	33	33							Acceptable	No In-service Indication Noted
CS7		35	11710	0	33	33							Acceptable	No In-service Indication Noted
CS8		40	11710	0	18	33							Acceptable	No In-service Indication Noted
LS1		35	2875	0	33	33							Acceptable	No In-service Indication Noted
LS2		35	2875	0	33	33							Acceptable	No In-service Indication Noted
LS3		35	2875	0	33	33							Acceptable	No In-service Indication Noted
LS4		35	2875	0	33	33							Acceptable	No In-service Indication Noted
LS5		35	2875	0	33	33							Acceptable	No In-service Indication Noted
LS6		35	2875	0	33	33							Acceptable	No In-service Indication Noted
LS7		35	2875	0	33	33							Acceptable	No In-service Indication Noted
E/WHLS1		20	1785	0	18	18							Acceptable	No In-service Indication Noted
E/WHLS2		20	1785	0	18	18							Acceptable	No In-service Indication Noted
E/WHLS3		20	1785	0	18	18							Acceptable	No In-service Indication Noted
E/WHLS4		20	1785	0	18	18							Acceptable	No In-service Indication Noted
E/WHLS5		20	1785	0	18	18							Acceptable	No In-service Indication Noted
E/WHLS6		20	1785	0	18	18							Acceptable	No In-service Indication Noted
E/WHLS7		20	1785	0	18	18							Acceptable	No In-service Indication Noted
E/WHLS8		20	1785	0	18	18							Acceptable	No In-service Indication Noted
EHCC		20	6120	0	18	18							Acceptable	No In-service Indication Noted
WECC		20	6120	0	18	18							Acceptable	No In-service Indication Noted

### QUANTITIES

REGULAR TIME:		FILM:	
OVERTIME:		CONSUMABLES:	View
SHIFT PREMIUM:		EQUIPMENT:	CHT-200804-1
KILOMETERS:		EXPENSES:	
SUBSISTENCE:		MISCELLANEOUS:	

HAN THAI

CGSB # 19212 SNT-TC-1A UTII / MTII / PTII / ET II

CLIENT APPROVAL:

signature here



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## RESULTS

DRAWING NO.:		SPOOL/CONTROL NO.:	
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### WELD INFORMATION

### INDICATION INFORMATION (mm)

WELD NO.	WELDER ID	CAP WIDTH	SCAN LENGTH (mm)	SCAN START	90 SKEW THICKNESS	270 SKEW THICKNESS	START	LENGTH	DEPTH	HEIGHT	AXIAL POSITION	AMPLITUDE (%FSH)	EVALUATION	REMARKS
UT1	18" Manway	25mm			18mm								REPAD	No Inspection
UT2	1" Nozzle	25mm			33mm								Acceptable	No In-service Indication Noted.
UT3	1" Nozzle	25mm			33mm								Acceptable	No In-service Indication Noted.
UT4	1" Nozzle	25mm			33mm								Acceptable	No In-service Indication Noted.
UT5	3" Nozzle	25mm			33mm								REPAD	No Inspection
UT6	1.3" Nozzle	25mm			33mm								Acceptable	No In-service Indication Noted.
UT7	18" Manway	25mm			33mm								REPAD	No Inspection
UT8	4" Nozzle	25mm			33mm								REPAD	No Inspection
UT9	3" Nozzle	25mm			33mm								REPAD	No Inspection
UT10	2" Nozzle	25mm			33mm								Acceptable	No In-service Indication Noted.
UT11	4" Nozzle	25mm			33mm								REPAD	No Inspection
UT12	3" Nozzle	25mm			33mm								REPAD	No Inspection
UT13	1.5" Nozzle	25mm			33mm								Acceptable	No In-service Indication Noted.
UT14	1.5" Nozzle	25mm			33mm								Acceptable	No In-service Indication Noted.
UT15	1.5" Nozzle	25mm			33mm								Acceptable	No In-service Indication Noted.
UT16	4" Nozzle	25mm			33mm								REPAD	No Inspection
UT17	4" Nozzle	25mm			33mm								REPAD	No Inspection



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## EQUIPMENT DETAILS

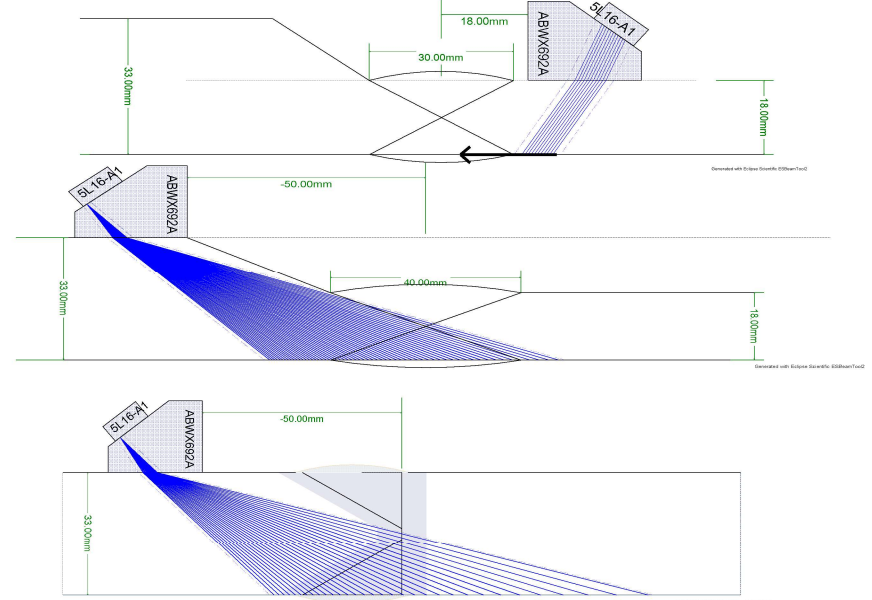
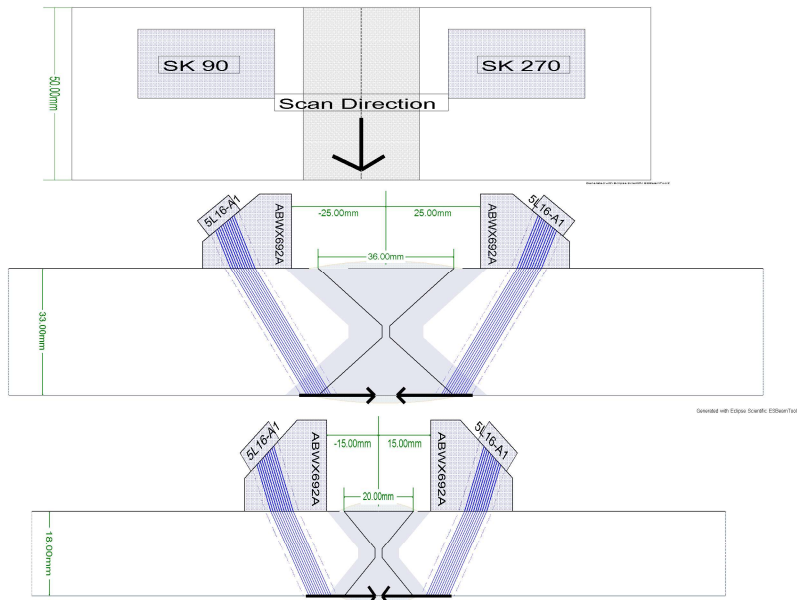
METHOD:	Contact	SURFACE & COND.:	OD, PAINTED	TYPE:	PAUT
MATERIAL DIA.:	3727mm OD	MATERIAL TYPE:	CS	NOMINAL THICKNESS:	H: 18 mm S: 33 mm
INSTRUMENT:	OLYMPUS	MODEL:	OMINISCAN MX2	CAL. DUE DATE:	4-Nov-20
SOFTWARE VERS.:	MXU-4.4R2	MODULE:	OMNI-M-PA16128/OMNI-2451	SERIAL NO.:	OMNI2-103773
COUPLANT:	Water	CAL. BLOCK SERIAL NO.:	30mm Creep 15mm Creep	REFERENCE REFLECTOR:	60%TWH, 1/4 T
SCANNER MAKE & MODEL:	NAVIC CRAWLER	SCANNER CALIBRATION (p/mm):	13.723	REFERENCE LEVEL:	80%
				ENCODER RESOLUTION (mm):	1

## SCAN PLAN

### PROBE INFO

### FOCAL LAW PARAMETERS

GROUP NAME	WEDGE MODEL NO.	WEDGE RETRACTED ANGLE	TRANSDUCER SERIAL NO.	TRANSDUCER MODEL	PROBE FREQ. (MHz)	NUMBER OF ELEMENTS	ELEMENT PITCH (mm)	ELEMENT SIZE (mm)	ELEMENT GAP (mm)	CABLE TYPE / LENGTH	LAW CONFIG.	WAVE TYPE	ELEMENT QTY.	FIRST ELEMENT	MIN ANGLE (°)	MAX ANGLE (°)	ANGLE STEPS (°)	FOCUSING PLANE	FOCUSING DEPTH (mm)	INDEX OFFSET (mm)	REF. LEVEL (dB)	SCANNING LEVEL (Db)
1	ABWX692A	39	J0135/J0553	5L16-A1	5	16	0.3		0.06	3 M	LINEAR	SHEAR	16	1	31.5°	31.5°	1	DEPTH	UNFO	Vary	34	+6
2	ABWX692A	39	J0135/J0534	5L16-A2	5	16	0.3		0.06	3 M	SECTORIAL	SHEAR	16	1	40°	75°	1	DEPTH	UNFO	-50	36	+6



Scan plan shows only one side for ease of viewing. Scans should be performed from both sides where accessible. If not accessible, it shall be noted on report.





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### DATA PLATE INFO

MANUFACTURE	Dominion Bridge Co. Ltd
DATE	June / 1981
SERIAL NO.	A5880A
CRN	D-9441.2
PROVINCIAL NO.	A0152767
SHELL THICKNESS	N/A
SHELL MATERIAL	N/A
HEAD THICKNESS	N/A
HEAD MATERIAL	N/A
MAWP	275 PSI @ 100°F
MWP EXT	412 PSI @ °F
NAT'L BOARD NO.	N/A
VESSEL DIAMETER OD	N/A
VESSEL LENGTH OAL	N/A
CAPACITY	N/A
VOL	N/A



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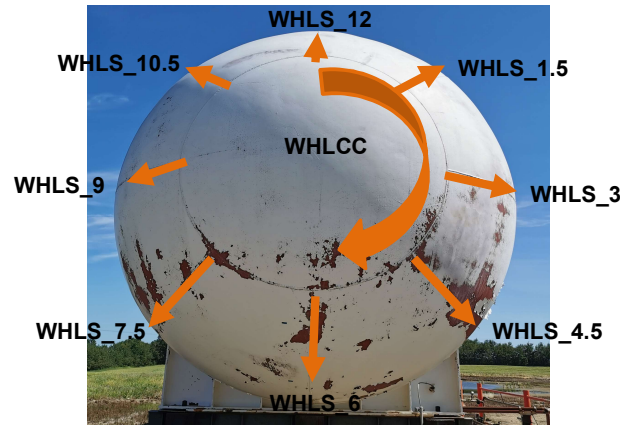
Long Seam 1-6, Scan West to East; LS 7 Scan East to West; LS 1, 2, 7 Showed, Remainder Typical



West End

Cir Seam 4 and Scan Direction Showed Remainder Typical

East End



West Head Scan Plan Showed East Head Typical





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## HAND SCANNED NOZZELS

East Head



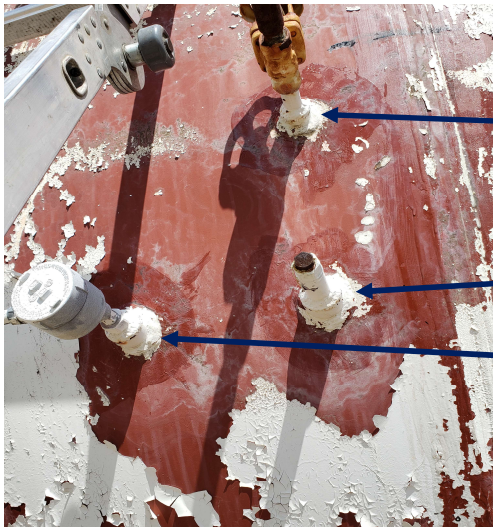
UT 1  
18" Manway With Repad  
No Inspection

Bottom Side



UT 5  
3" Nozzel with Repad  
No Inspection

Shell North East Side



UT 2  
1" Nozzel

UT 3  
1" Nozzel

UT 4  
1" Nozzel



UT 6  
1.3" Nozzel



UT 7  
18" Manway With Repad  
No Inspection

UT 8  
4" Nozzel with Repad  
No Inspection

UT 9  
3" Nozzel with Repad  
No Inspection



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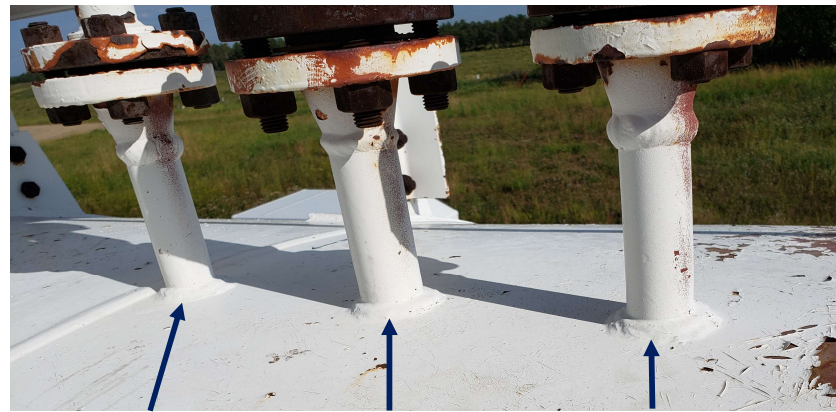
## HAND SCANNED NOZZELS Top Side



UT 10  
2" Nozzel

UT 11  
4" Nozzel with Repad  
No Inspection

UT 12  
3" Nozzel with Repad  
No Inspection



UT 13  
1.5" Nozzel

UT 14  
1.5" Nozzel

UT 15  
1.5" Nozzel



UT 16  
4" Nozzel with Repad  
No Inspection

UT 17  
4" Nozzel with Repad  
No Inspection



## OmniScan Report

<b>Report Date</b>	<b>Report Version</b>	<b>File Name</b>	<b>Inspection Date</b>	<b>Inspection Version</b>	<b>Save Mode</b>
2020 / 08 / 05	MXU - 4.4R5	H_33mm Creep.ops	2020 / 08 / 05	MXU - 4.4R5	Report
<b>OmniScan Type</b>	<b>OmniScan Serial #</b>	<b>Module Type</b>	<b>Module Serial #</b>	<b>Data File Name</b>	
OmniScan MX2	OMNI2-103773	OMNI-M-PA16128	OMNI-2451	A5880A_LS5_0_2875mm	

<b>Contractor</b>	ECHO NDE	<b>Technician</b>	Han Thai
<b>Customer</b>	Enerplus	<b>Project</b>	ID Creeping Wave Inspections
<b>Site</b>	LSD 6-29-49-21 W4	<b>Part Number</b>	SN_A5880A
<b>Procedure</b>	UT-10		

PA 1

Probe Characterization

<b>Probe Model</b>	<b>Probe Serial #</b>				
5L16-A1	5L16-A1				
<b>Probe Frequency</b>	<b>Peak Frequency</b>	<b>Wedge Model</b>	<b>Wedge Angle</b>	<b>Probe Aperture</b>	
5.00 MHz	N/A	ABWX692A	39.00°	N/A	
	<b>Lower Frequency</b>	<b>Higher Frequency</b>	<b>Center Frequency</b>	<b>Bandwidth (MHz)</b>	<b>Bandwidth (%)</b>
-6 dB	N/A	N/A	N/A	N/A	N/A
-20 dB	N/A	N/A	N/A	N/A	N/A
<b>Date</b>	<b>Time</b>	<b>Procedure</b>	<b>Calibration Block</b>	<b>Characterization Gain</b>	<b>A%</b>
N/A	N/A	N/A	N/A	N/A	N/A

Setup

<b>A:31.50 Sk:090 L:001</b>					
<b>Beam Delay</b>	<b>Start (Half Path)</b>	<b>Range (Half Path)</b>	<b>Max. Acq Rate</b>	<b>Type</b>	<b>Averaging Factor</b>
9.8 µs	-10.18 mm	105.55 mm	514	PA	1
<b>Scale Type</b>	<b>Scale Factor</b>	<b>Video Filter</b>	<b>Pretrig.</b>	<b>Rectification</b>	<b>Filter</b>
Compression	21	On	0.00 µs	FW	Band-pass 5.3 MHz (3.2 - 7.5MHz)
<b>Voltage</b>	<b>Gain</b>	<b>Mode</b>	<b>Wave Type</b>	<b>Sound Velocity</b>	<b>Pulse Width</b>
80 (High)	41.96 dB	PE (Pulse-Echo)	Shear	3240.0 m/s	100.00 ns
<b>Scan Offset</b>	<b>Index Offset</b>	<b>Probe Skew</b>	<b>C-Scan Time Resolution</b>	<b>Digitizing Frequency</b>	<b>A-Scan Time Resolution</b>
0.00 mm	-25.00 mm	90.0°	10.0 ns	100 MHz	210.0 ns
<b>Gate</b>	<b>Start</b>	<b>Width</b>	<b>Threshold</b>	<b>Synchro.</b>	<b>Peak Selection</b>
I	Off	Off	Off	Off	Off
A	21.00 mm	21.01 mm	40.00 %	Pulse	Max Peak
B	Off	Off	Off	Off	Off

Calculator

<b>Element Qty. Used</b>	<b>First Element</b>	<b>Last Element</b>	<b>Resolution</b>	<b>Wave Type</b>	<b>Material Velocity</b>
6	1	16	1.0	Shear	3240.0 m/s
<b>Start Angle</b>	<b>Stop Angle</b>	<b>Angle Resolution</b>	<b>Focus Depth</b>	<b>Law Configuration</b>	<b>Beam Skew</b>
31.50°	N/A	N/A	1000.00 mm	Linear	0.00°



PA 2

Probe Characterization

<b>Probe Model</b>	<b>Probe Serial #</b>				
5L16-A1	5L16-A1				
<b>Probe Frequency</b>	<b>Peak Frequency</b>	<b>Wedge Model</b>	<b>Wedge Angle</b>	<b>Probe Aperture</b>	
5.00 MHz	N/A	ABWX692A	39.00°	N/A	
	<b>Lower Frequency</b>	<b>Higher Frequency</b>	<b>Center Frequency</b>	<b>Bandwidth (MHz)</b>	<b>Bandwidth (%)</b>
-6 dB	N/A	N/A	N/A	N/A	N/A
-20 dB	N/A	N/A	N/A	N/A	N/A
<b>Date</b>	<b>Time</b>	<b>Procedure</b>	<b>Calibration Block</b>	<b>Characterization Gain</b>	<b>A%</b>
N/A	N/A	N/A	N/A	N/A	N/A

Setup

<b>A:31.50 Sk:270 L:001</b>					
<b>Beam Delay</b>	<b>Start (Half Path)</b>	<b>Range (Half Path)</b>	<b>Max. Acq Rate</b>	<b>Type</b>	<b>Averaging Factor</b>
9.9 µs	-10.18 mm	105.55 mm	514	PA	1
<b>Scale Type</b>	<b>Scale Factor</b>	<b>Video Filter</b>	<b>Pretrig.</b>	<b>Rectification</b>	<b>Filter</b>
Compression	21	On	0.00 µs	FW	Band-pass 5.3 MHz (3.2 - 7.5MHz)
<b>Voltage</b>	<b>Gain</b>	<b>Mode</b>	<b>Wave Type</b>	<b>Sound Velocity</b>	<b>Pulse Width</b>
80 (High)	40.96 dB	PE (Pulse-Echo)	Shear	3240.0 m/s	100.00 ns
<b>Scan Offset</b>	<b>Index Offset</b>	<b>Probe Skew</b>	<b>C-Scan Time Resolution</b>	<b>Digitizing Frequency</b>	<b>A-Scan Time Resolution</b>
0.00 mm	25.00 mm	270.0°	10.0 ns	100 MHz	210.0 ns
<b>Gate</b>	<b>Start</b>	<b>Width</b>	<b>Threshold</b>	<b>Synchro.</b>	<b>Peak Selection</b>
I	Off	Off	Off	Off	Off
A	21.00 mm	21.00 mm	40.00 %	Pulse	Max Peak
B	Off	Off	Off	Off	Off

Calculator

<b>Element Qty. Used</b>	<b>First Element</b>	<b>Last Element</b>	<b>Resolution</b>	<b>Wave Type</b>	<b>Material Velocity</b>
6	1	16	1.0	Shear	3240.0 m/s
<b>Start Angle</b>	<b>Stop Angle</b>	<b>Angle Resolution</b>	<b>Focus Depth</b>	<b>Law Configuration</b>	<b>Beam Skew</b>
31.50°	N/A	N/A	1000.00 mm	Linear	0.00°

Part

<b>Material</b> STEEL, MILD	<b>Geometry</b> Plate	<b>Thickness</b> 31.00 mm
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Scan Area

<b>Scan Start</b> 0.00 mm	<b>Scan Length</b> 2875.00 mm	<b>Scan Resolution</b> 1.00 mm		
<b>Synchro.</b> Encoder	<b>Max. scan speed</b> 513.51 mm/s			
<b>Axis</b> Scan	<b>Encoder</b> 1	<b>Encoder Type</b> Quadrature	<b>Encoder Resolution</b> 13.72 step/mm	<b>Polarity</b> Normal

<b>Technician Name</b>	_____
<b>Technician Signature</b>	_____
<b>Contractor</b>	_____
<b>Date</b>	_____