

FORM U-1A MANUFACTURER'S DATA REPORT FOR PRESSURE VESSELS  
 (Alternative Form for Completely Shop-Fabricated Vessels Only)  
 As Required by the Provisions of the ASME Code Rules, Section VIII, Division 1

**A 2698238**  
 Jan 22/91

1. Manufactured and certified by Process Industries Inc., 803 24th Ave. S.E. Calgary, Alberta T2G 1P5  
(Name and address of manufacturer)

2. Manufactured for Westcoast Petroleum Ltd., 2200 - 700 6th Ave. S.W. Calgary, Alberta T2P 0T8  
(Name and address of purchaser)

3. Location of installation LSD # 7-32-12-13-W4M Grand Forks  
(Name and address)

4. Type Horizontal P90-0038-A K3252-2 C1374-A Rev. 1 N/A 1991  
(Mount or rest tank) (Mfg. serial No.) (CRN) (Drawing No.) (Net) (Gt. 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 1989  
Year

to A-89 2053 N/A  
Appendix (Date) Code Case No. Special Service per UG-120.6)

6. Shell: SA-516-70 .375 (9.53) .062 (1.6) 9'-11 1/2" (3029) 40'-0" (12192)  
Mat. (Spec. No., Grade) Nom. Thk. (in.) Corr. Allow. (in.) Diam. I.D. (ft. & in.) Length Overall (ft. & in.)

7. Seams: Db1. Butt Welded Full 100 Ni1 N/A Db1. Butt Welded Spot\* 4  
Long. (Welded, Db1., Spig., Lap, Butt) R.T. (Spot or Full) E.H. (%) H.T. Temp. (°F) Time (hr) Girth (Welded, Db1., Spig., Lap, Butt) R.T. (Spot, Parallel or Full) No. of Courses

8. Heads: (a) Matl. SA-516-70 (b) Matl. SA-516-70  
(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)	END	.607 (15.4)	.062 (1.6)	9'-0"	7.8"	FLANGED & DISHED				CONCAVE
(b)	END	" "	" "	" "	" "	" "	" "			CONCAVE

If removable, bolts used (describes other fastenings) N/A  
(Date, Spec. No., Gr., Size, No.)

9. MAWP 75 (517 kPa) psi at max. temp. 200 (93°C) °F  
 Min. design metal temp. -20 (-29°C) °F at 75 psi. Hydro. ~~XXXXXX~~ test pressure 113 (776 kPa) psi.

10. Nozzles, inspection and safety valve openings:

Purpose (Inlet, Outlet, Drain)	No.	Diam. or Size	Type	Matl.	Nom. Thk.	Reinforcement Matl.	How Attached	Location
MANWAY	M1	30"	API605	SA-516-70	.375"	Integral	Welded	End (a)
MANWAY	M2a	24"	FAB. FLC.	SA-106-B	.500"	SA-516-70	Welded	Shell
MANWAY	M2b	24"	FAB. FLC.	SA-106-B	.500"	SA-516-70	Welded	Shell
EMULS-INLET	N1	8"	RFWN	SA-106-B	.906"	Integral	Welded	Shell

11. Supports: Skirt NO Lugs 2 Legs 2 Other N/A Attached Heads, Shell - Welded  
(Yes or no) (No.) (No.) (Describe) (Where and how)

12. Remarks: Manufacturer's Partial Data Reports properly identified and signed by Commissioned Inspector have been furnished for the following items of the report: N/A  
(Name of part, item number, Mfg.'s name and identifying stamp)

VOLUME: 3254.3 CU. FT. (93.3 M<sup>3</sup>) Exempt from impact testing per UG-20 (c)  
VESSEL TYPE: Free Water Knockout Drum \*SPOT - UW 11A 5B

**CERTIFICATE OF SHOP 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 Code for Pressure Vessels, Section VIII, Division 1. "U" Certificate of Authorization No. 24898 1 WJ June 25, 1991  
 Date Jan 22/91 Co. name PROCESS INDUSTRIES INC. Signed [Signature]  
(Manufacturer) (Inspector)

**CERTIFICATE OF SHOP INSPECTION**

Vessel constructed by PROCESS INDUSTRIES INC. at CALCARY, ALBERTA, CANADA  
 I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State or Province of ALBERTA and employed by LABOUR - GENERAL SAFETY SERVICES DIVISION have inspected the component described in this Manufacturer's Data Report on Jan 22, 19 91, 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 this inspection.  
 Date Jan 22/91 Signed [Signature] Commissions [Signature]  
(Authorized Inspector) (National Board (and other) membership, State, Prov. and No.)

