

1.1-FRM-001VS Visual External Inspection Report

Report #:	PSV Service Report Avail. <input checked="" type="checkbox"/> Y <input type="checkbox"/> N MDR Avail. <input checked="" type="checkbox"/> Y <input type="checkbox"/> N UT Verified <input checked="" type="checkbox"/> Y <input type="checkbox"/> N	<input checked="" type="checkbox"/> Installation <input checked="" type="checkbox"/> External <input checked="" type="checkbox"/> Internal
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Date:	2022-05-16	WO #:	V-0061	Proc. Used:	Cat 1 - Unfired Separator	Rec. Insp. Interval:	3
Inspected By:	Dwight Colp ISI-PVPP Cert# 000692, API 510 #43558, API 570 #45288			Radiography:	1		
Client:	Lyons Production Services			Heat Treatment:	Yes		
Coordinator:	Dave Macdonald			National Board Number:			
Region:	Alberta, N.E. BC	Area:	Peace	Notes: PSV Removed for service at time of inspection. PSV Service Report Reviewed. UT Report Reviewed.			
Facility:	Lyons Yard						
Location, LSD	Portable						
Description:	<input checked="" type="checkbox"/> Vessel <input type="checkbox"/> Exchanger <input type="checkbox"/> Tank <input type="checkbox"/> Heater						
Service Fluid:	<input type="checkbox"/> Sweet <input checked="" type="checkbox"/> Sour Fluid Name: Well Emulsion						
Unit Name / #:	SS-742	Equip#:	SS-742				
Equip. Name:	Horizontal Separator						
Jurisdiction #:	0489850	CRN:	P7055.21				
Manufacturer:	Dynacorp Fabricators Inc						
Year Built:	2004	S/N:	1J1668				

Components:	Diameter	Length	Material	Nominal t	CA	Comment
Shell:	54"	20'	SA-516-70N	1.125"	0.0625"	No Concerns
Head:	54"	2:1	SA-516-70N	1.077"	0.0625"	No Concerns
Channel:						
Tube:						
Other: Coil	4" NPS	NS	SA-333-6	0.674"		No Concerns

PSV Data: PSV Capacity Verified: ☐ Y ☒ N Block Valve(s) Installed: ☐ Yes ☒ No Car-sealed Open: ☐ Yes ☐ No ☒ N/A

Zones:	MDMT	Design T	MAWP	Set Press	Tag#	Model	Manf.	PSV CRN	Serial Number	In.	Out.	Capacity	Serv. Co.	Serv. Date
Shell Side:	50 F	200 F	740 PSI	740 PSI	SS-742	B3J0811342-61-60-0	Taylor	0G01316.2C	7202-1	3"	3"	17574 SCFM	Unified	2022-05-12
Tube Side:														
Other:														

Orientation: ☒ Hor. ☐ Ver. **Foundation:** ☐ Concrete ☐ Gravel ☐ Timbers ☒ Steel ☐ Other: Condition: Good

Support:	<input checked="" type="checkbox"/> Saddle: <input checked="" type="checkbox"/> Seal-welded <input type="checkbox"/> Free to move	Condition: No Concerns
	<input type="checkbox"/> Skirt: <input type="checkbox"/> Free of debris	Condition:
	<input type="checkbox"/> Hangers: <input type="checkbox"/> Secure	Condition:
	<input type="checkbox"/> Other (Specify):	Condition:

Overall:	General Condition: Good <input type="checkbox"/> Dead Legs Exist	Electrical Grounding: <input type="checkbox"/> None <input checked="" type="checkbox"/> Indirect <input type="checkbox"/> Direct <input type="checkbox"/> Secure
Ext. Surface:	<input checked="" type="checkbox"/> Painted <input type="checkbox"/> Fire-proofed <input type="checkbox"/> Cladded <input type="checkbox"/> Insulated <input type="checkbox"/> Other:	Condition: Good, No concerns
Ext. Fixtures:	<input type="checkbox"/> Ladder <input type="checkbox"/> Platform(s) <input type="checkbox"/> Other (Specify):	Condition:
Int. Surface:	<input type="checkbox"/> Coated <input type="checkbox"/> Weld Overlay <input type="checkbox"/> Cladded <input type="checkbox"/> Lined <input type="checkbox"/> Thermal Sprayed	Condition:
Int. Fixtures:	<input type="checkbox"/> Baffle <input type="checkbox"/> Vortex Breaker <input type="checkbox"/> Float <input type="checkbox"/> Weir <input type="checkbox"/> Impingement plate	Condition:

Nozzles:	<input checked="" type="checkbox"/> MW <input type="checkbox"/> Inspection port only MW Size: 1x20"	<input checked="" type="checkbox"/> Davit arm: <input checked="" type="checkbox"/> Greased <input type="checkbox"/> Double-nutted	Condition: Good
	<input checked="" type="checkbox"/> Reinforcement pads used <input checked="" type="checkbox"/> Weep holes visible	<input checked="" type="checkbox"/> No evidence of weeping	Comment:

Piping:	Well-coated	Proper joints	Free of leaks	Proper supports	Fluid is identified	Flow dir. shown	Drains properly	Comments:
<input checked="" type="checkbox"/> PSV piping:	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	PSV is mounted on Piping <input checked="" type="checkbox"/> or Vessel <input type="checkbox"/>
<input checked="" type="checkbox"/> Inlet piping:	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
<input checked="" type="checkbox"/> Outlet piping:	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
<input checked="" type="checkbox"/> Drain piping:	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
<input checked="" type="checkbox"/> Instrument piping:	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		

Valves:	<input checked="" type="checkbox"/> Manual isolation valves:	<input checked="" type="checkbox"/> Free from leaks	Comment:
	<input checked="" type="checkbox"/> Automated control valves:	<input checked="" type="checkbox"/> Free from leaks	Comment:
	<input checked="" type="checkbox"/> Vents and/or drains:	<input checked="" type="checkbox"/> Properly plugged	Comment:

Gauges:	<input checked="" type="checkbox"/> Pressure:	Range: 0 - 1000PSI	Reading: 0 PSI	Condition: Good
	<input type="checkbox"/> Temperature:	Range:	Reading:	Condition:
	<input checked="" type="checkbox"/> Sight Glass Level:		Reading: Empty	Condition: Good

Recommended Actions:	1. No recommendations at this time.	NCR#
	2.	
	3.	

Summary: The vessel exterior and the associated piping are considered to be in Good condition. -

Additional notes are attached: ☐

Item ☒ is suitable for service.
☐ is **NOT**

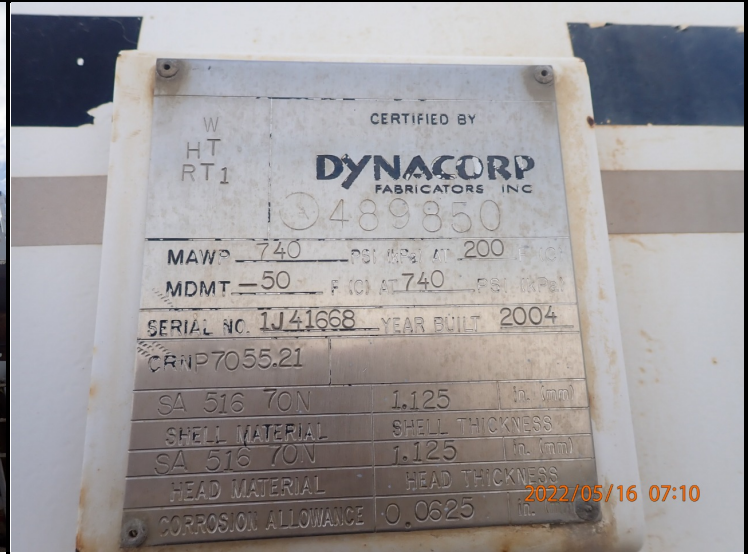
Inspector's Signature:



PHOTOS



Unit Overview



Vessel Nameplate



Inlet Piping



Drain Piping



Pressure Gauge



Gas Outlet Piping

PHOTOS



Meter Run Piping



Produced Oil Piping



PSV Discharge Piping



Clean Head and Vessel Piping



Vessel Manway



Dirty Side Level Gauge

Date:	2022-05-16	WO #:	V-0064	Proc. Used:	Cat 1 - Unfired Separator
Inspected By:	Dwight Colp ISI-PVPP Cert# 000692, API 510 #43558, API 570 #4528			Notes:	
Client:	Lyons Production Testing				
Coordinator:	Dave MacDonald				
Region:	Alberta, N.E. BC	Area:	Peace		
Facility:	Portable				
Location, LSD	Portable				
Description:	<input checked="" type="checkbox"/> Vessel <input type="checkbox"/> Exchanger <input type="checkbox"/> Tank <input type="checkbox"/> Heater				
Service Fluid:	<input type="checkbox"/> Sweet <input checked="" type="checkbox"/> Sour Fluid Name: Well Emulsion				
Unit Name / #:	SS-742	Equip#:	SS-742		
Equip. Name:	Horizontal Separator SS-742				
Jurisdiction #:	0489850	CRN:	P7055.21		
Manufacturer:	Coral Oilfield Services				
Year Built:	2004	S/N:	J41668		
Scope:	A visual internal (VI) inspection was performed on all accessible shell and head surfaces, nozzles, welds, etc.				
Manway:	Gasket Surfaces:	<input checked="" type="checkbox"/> Compliant with code	Comment:		
	Manway Nozzle:	<input checked="" type="checkbox"/> No pitting, erosion, etc.	Comment:		
Shell and Head Surfaces:	<input type="checkbox"/> Coated	<input type="checkbox"/> Continuous and well-adhered	Comment:		
	Uniform Corrosion:	<input checked="" type="checkbox"/> Insignificant amount	Comment:		
	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:		
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:		
NDT:	<input checked="" type="checkbox"/> NDT was performed by: PIMS		Type: <input type="checkbox"/> MPI (<input type="checkbox"/> WF <input type="checkbox"/> B&W <input type="checkbox"/> Dry) <input type="checkbox"/> LPI <input checked="" type="checkbox"/> UT <input type="checkbox"/> RT <input type="checkbox"/> Other: _____		
	Extent: External Head, Shell and Piping				
	Results: No concerns				
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 checked="" type="checkbox"/> Internal Piping	<input checked="" type="checkbox"/> Secure <input checked="" type="checkbox"/> Good condition	Comment: No concerns		
	<input checked="" type="checkbox"/> Demister	<input checked="" type="checkbox"/> Secure <input checked="" type="checkbox"/> Good condition	Comment: No Concerns		
	<input checked="" type="checkbox"/> Heating Coil	<input checked="" type="checkbox"/> Secure <input checked="" type="checkbox"/> Good condition	Comment: No concerns		
	<input checked="" type="checkbox"/> Wier	<input checked="" type="checkbox"/> Secure <input checked="" type="checkbox"/> Good condition	Comment: No concerns		
	<input checked="" type="checkbox"/> Inlet Diffuser	<input checked="" type="checkbox"/> Secure <input checked="" type="checkbox"/> Good condition	Comment: No concerns		
	<input type="checkbox"/>	<input type="checkbox"/> Secure <input type="checkbox"/> Good condition	Comment:		
	<input type="checkbox"/>	<input type="checkbox"/> Secure <input type="checkbox"/> Good condition	Comment:		
Notes:					
Recommended Actions:	1. There are no recommendations at this time				
	2.				
	3.				

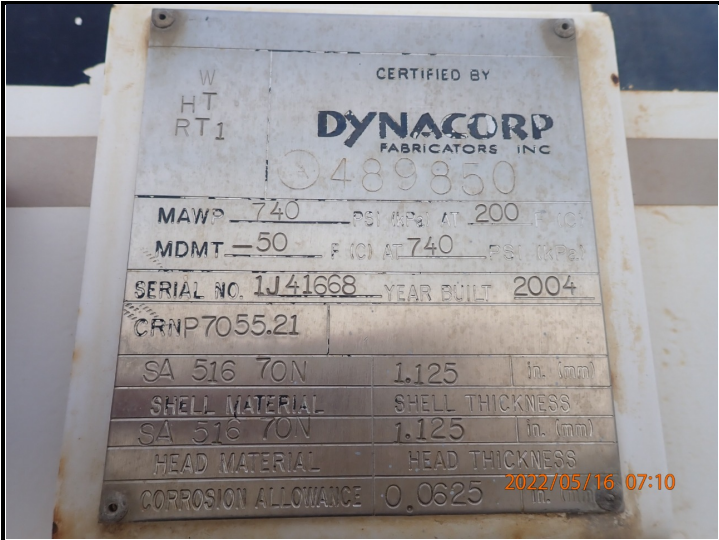
Additional notes are attached: ☐

Item ☒ is suitable for service.
☐ is **NOT**

Inspector's
Signature:



PHOTOS



Vessel Nameplate



Unit Overview



Inlet Diffuser



Internal Overview



Typical Nozzle Condition



Coil Piping

PHOTOS



Sparge Piping



Clean End and Shell Overview



Demister



Lower Sparge Piping



PRV INSPECTION AND TEST REPORT

BRANCH: Grande Prairie

UVL ID#: 62779G

Work Order: W15005780

Customer PO#:

Customer: LYONS PRODUCTION SERVICES LTD
Facility: GRANDE-PRAIRIE
A#: LSD: SS-742
Cust. Ref.: Vessel SN:
Cust. WO#: Valve PO:
Cust AFE#:

Date: 05/12/2022
PSV Location:
Cust Id:
PO LINE#:
Cost Centre#:

VALVE DATA

Man.: TAYLOR Model: 83J0811342-61-60-0 Serial: 7202-1 Seat: SOFT
Conn. Flanged Inlet: 3" 300 RF Orifice: J Outlet: 3" 150 RF Vacuum:
Set Press. 740 PSI Back Press.: N/A PSI CDTP: N/A PSI Temp: N/A F Cap: 17,574 SCFM
Lift Lever ☐ Cap Assembly: Closed RFID: Code Symbol: UV CRN#: 0G1316.2C

CUSTOMER INSTRUCTIONS

Instructions: Full Service Pretest Required? ☒ Reset Required? ☐

CONDITION AS RECEIVED

Visual Condition: Fair Data Plate Condition: OK Date of last service: 05/2019
Seal Condition: Top: Intact Bottom: N/A Insignia: UVL Fittings Attached: Inlet: ☐ Outlet: ☐
Inlet: Rusty Inlet Plugged: ☐ Outlet: Rusty Outlet Plugged: ☐ Initial Insp. Signoff: Don Meneses

PRETEST 1

Simmer: 728 PSI Set Press: 731 PSI Reseat: 627 PSI Leakage: 5 BPM Test Gauge: GP5K-1/2
Tested By: Duane Groth Pretest Comments:

PRETEST 2

Simmer: Set Press: Reseat: Leakage: Test Gauge: GP5K-1/2
Tested By: Pretest Comments:

COMPONENTS INSPECTION

(0 Like New / 1 Minor / 2 Medium / 3 Major)

ITEM	CLEAN	OLLY	RUSTY	CARBON	PITTED	CORRODED	SCALE	VIBRATION	GROOVED	DENTED	GALLING	GOUGED	OTHER	Machined	Lapped	Polished	Replaced	Next Service	Replace	COMMENTS
DISC			1						1					<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NOZZLE			1											<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
CAP-LEVER ASSY			1											<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
COMP SCREW and LOC			1											<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
AS FOUND: .67MM AS LEFT: .67MM																				
SPRING and BUTTONS			1											<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
SPINDLE / STEM														<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
STEM RETAINER														<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
DISC HOLDER														<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
GUIDE / UPPER RING			1											<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
LOWER RING														<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
RING PIN(S)														<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
BELLOWS														<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
GASKET / SEALS			1										2	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	TORN
CONNECTION ENDS			1				1							<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
OTHER														<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	

DISC: Min: N/A ACT - NOZZLE: Min: N/A ACT - SPRING NUMBER: NO#
Disassembly: DJ McBrearty Inspection: Rob Murdoch Reassembly: DJ McBrearty

FINAL TEST

Test Medium: Air Simmer: 737 PSI Set Pressure: 740 PSI
Reseat: 588 PSI Leakage Acceptable: ☒ B.P. Test: 60 PSI Vacuum:
ADJ. RING SETTING (NOTCHES): Upper: Lower: Test Gauge: GP5K-1/2 Set Press Def: POP
Tested by: Jasper Piezas Date Final Tested:

FINAL INSPECTION:

SEAL: Top: ☒ Bottom: ☐ End Protectors Installed: ☒ Painted: ☒ Palletized: ☐ Ship Container: ☒ Flex Gaskets Supplied: ☐
Final Inspection: DJ McBrearty Customer Inspection:
Comments: INSPECTION: Inlet showing signs of corrosion
- SERVICE RATING: ROUTINE



PRV INSPECTION AND TEST REPORT

BRANCH: Grande Prairie

UVL ID#: 81340G

Work Order: W15005780

Customer PO#:

Customer: LYONS PRODUCTION SERVICES LTD
Facility: GRANDE-PAIRIE LSD: SS-742
A#: Vessel SN:
Cust. Ref.: Valve PO:
Cust. WO#: Cust AFE#:

Date: 05/12/2022
PSV Location:
Cust Id:
PO LINE#:
Cost Centre#:

VALVE DATA

Man.: TAYLOR Model: 82E4351341 Serial: 039453-17 Seat: SOFT
Conn. Threaded Inlet: 1" MNPT Orifice: E Outlet: 1" FNPT Vacuum:
Set Press. 150 PSI Back Press.: N/A PSI CDTP: N/A PSI Temp: 70 F Cap: 582 SCFM
Lift Lever ☐ Cap Assembly: Closed RFID: Code Symbol: UV CRN#: 0G01316.2C

CUSTOMER INSTRUCTIONS

Instructions: Full Service Pretest Required? ☒ Reset Required? ☐

CONDITION AS RECEIVED

Visual Condition: Fair Data Plate Condition: OK Date of last service: 05/2019
Seal Condition: Top: Intact Bottom: N/A Insignia: UVL Fittings Attached: Inlet: ☐ Outlet: ☐
Inlet: Rusty Inlet Plugged: ☐ Outlet: Rusty Outlet Plugged: ☐ Initial Insp. Signoff: Don Meneses

PRETEST 1

Simmer: 157 PSI Set Press: 161 PSI Reseat: 142 PSI Leakage: 3 BPM Test Gauge: GP5K-1/2
Tested By: Duane Groth Pretest Comments:

PRETEST 2

Simmer: Set Press: Reseat: Leakage: Test Gauge: GP5K-1/2
Tested By: Pretest Comments:

COMPONENTS INSPECTION

(0 Like New / 1 Minor / 2 Medium / 3 Major)

ITEM	CLEAN	OLY	RUSTY	CARBON	PITTED	CORRODED	SCALE	VIBRATION	GROOVED	DENTED	GALLING	GOUGED	OTHER	Machined	Lapped	Polished	Replaced	Next Service	Replace	COMMENTS
DISC			1						1					<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
NOZZLE			1											<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
CAP-LEVER ASSY			1											<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
COMP SCREW and LOC			1											<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
AS FOUND: .29MM AS LEFT: .29MM																				
SPRING and BUTTONS			1											<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
SPINDLE / STEM														<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
STEM RETAINER														<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
DISC HOLDER														<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
GUIDE / UPPER RING			1											<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
LOWER RING														<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
RING PIN(S)														<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
BELLOWS														<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
GASKET / SEALS			1										2	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>		TORN
CONNECTION ENDS			1											<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
OTHER														<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		

DISC: : N/A ACT - NOZZLE: N/A ACT - SPRING NUMBER: NO#
Disassembly: DJ McBrearty Inspection: Duane Groth Reassembly: DJ McBrearty

FINAL TEST

Test Medium: Air Simmer: 147 PSI Set Pressure: 150 PSI
Reseat: 110 PSI Leakage Acceptable: ☒ B.P. Test: 60 PSI Vacuum:
ADJ. RING SETTING (NOTCHES): Upper: Lower: Test Gauge: GP5K-1/2 Set Press Def: POP
Tested by: Duane Groth Date Final Tested:

FINAL INSPECTION:

SEAL: Top: ☒ Bottom: ☐ End Protectors Installed: ☒ Painted: ☒ Palletized: ☐ Ship Container: ☒ Flex Gaskets Supplied: ☐

Final Inspection: DJ McBrearty Customer Inspection:

Comments: - SERVICE RATING: ROUTINE

PSV Service Reports reviewed, Passed Pre-pop

Contract Chief Inspector - Dwight Colp API 510 #43558, ABSA ISIPV-PP #000692

ALBERTA MUNICIPAL AFFAIRS

Alberta Boilers Safety Association

200, 4208 - 97 Street

Edmonton AB T6E 5Z9

Partial/ Partiel ☐

A# 489850

AB-25 (side 1) 00/07

MANUFACTURER'S DATA REPORT

FOR PRESSURE VESSEL

DÉCLARATION DE CONFORMITÉ DU CONSTRUCTEUR

D'APPAREILS SOUS PRESSION

Upon shipment of a pressure vessel, this form fully and correctly filled in must be mailed to the office of the Chief Inspector in the province of installation in accordance with the regulations under the Act, governing the construction and installation of pressure vessels.

Au moment de l'expédition d'un appareil sous pression, ce formulaire complété correctement, doit être envoyé au bureau de l'inspecteur en chef de la province d'installation tel que prévu dans les règlements de la loi sur les appareils sous pression.

Manufactured by Construit par	Name and address of Manufacturer/ Nom et adresse du constructeur Dynacorp Fabricators Inc. 8600-92St. Grande Prairie, AB; T8V 7S3
Manufactured for Construit pour	Name and address of Purchaser or Consignee/ Nom et adresse du client ou de son représentant Lyons Production Services; Box 327; Grande Prairie, AB; T8V 3A5
Ultimate owner Utilisateur	Name and address/ Nom et adresse Lyons Production Services; Box 327; Grande Prairie, AB; T8V 3A5
Location of installation Lieu d'installation	Address/ Adresse Portable

Pressure vessel/ Appareil

Type/ Genre 54" 740psi Horizontal Test Vessel	Overall Length/Longueur totale 20'	Serial No./ N° de série 1J41668	Year built/Année de fabrication 2004
Provincial Registration No. - C.R.N./N° d'enregistrement provincial - N.E.C. P7055.21		National Board No./ N° National Board	Drawing No./ N° de dessin 5100-05 R00

The chemical and physical properties of all parts meet the requirements of material specifications of the A.S.M.E. Code.
Les propriétés chimiques et physiques de toutes les composantes respectent les exigences des spécifications de matériaux de code ASME.

The design, construction and workmanship conform to CSA B51. La conception, la construction et la façon sont conformes à ACNOR B51.	ASME Section VIII	Division 1	Addenda/Supplément A03	Code case No. N° de cas
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Manufacturer's partial data reports properly identified and signed by authorized inspectors have been furnished for the following items of the report, and attached to this report:

Les rapports partiels du constructeur adéquatement identifiés et signés par les inspecteurs autorisés ont été produits pour les items suivants du rapport, et attachés à ce rapport:

Names of parts/ Nom de la composante	Item No./ N° d'item	Manufacturer's Name/ Nom du constructeur	Identifying Stamp/ Estampe d'identification

Shell/ Virole

Description	Material Matériau	Thickness Épaisseur	Corr. Allow. Surépais. de corr.	Diameter Diamètre	Longitudinal Joints Joints longitudinaux			P.W.H.T. Traitement therm		Girth Joints Joints de circonférence		Number of courses Nombre de sections
					Type	R.T. Radiog.	Efficiency Efficacité	Temp.	Time Durée	Type	R.T. Radiog.	
54" ID Shells	SA516-70N	1.125"	.0625"	54" ID	1	Full	100%	1150F	68min	1	Full	2

Heads/ Têtes

Description	Material Matériau	Min. Thickn. Épais minim.	Corr. Allow Surép. Corr.	Crown Radius Rayon couron.	Knuckle Radius Petit rayon	Ellipse Ratio Repp. ellipse	Conical Apex Angle Angle conique	Hemisph. Radius Ray. Hémisph	Flat Diameter Diem. plat	Side to pressure Côté sous pression
54" Heads	SA516-70N	1.077"	.0625"			2:1 S.E.				Concave

Removable bolts used (describe other fastenings)
Boulons amovibles utilisés (décrire tout autre attache)

Mat'l Spec./ Spéc. du mat.

Grade

Size/ Dimension

Pressure - Temperature/ Pression - température

Pressure Vessel Part Partie de l'appareil	Constructed for max. allowable working pressure Construit pour une pression maximale de marche permise	At max. temp. A une temp. max.	Min. Temp. (when less than -29°C) Temp. min. (inférieure à -29°C)	Test pressure (hydro-pneumatic or combination) Pression d'épreuve (hydro-pneumatique ou combinaison)
Vessel	740psi	200F	-50F	1125psi

Tube Section/ Faisceau tubulaire

489850

AB-25 (side 2) 00/07

Tube sheet/ Plaque tubulaire	Material/ Matériau	Diameter/ Diamètre	Nominal Thickness Épaisseur nominale	Corr. Allow. Surépais. corrosion	Attachment Mode d'attachement
Tube material/ Matériau des tubes	Diameter/ Diamètre	Nominal Thickness (gauge) Épaisseur nominale (calibre)	Number/ Nbre	Type (Straight or U) Type (Droit ou U)	Heating Surface Surface de chauffe

Jacket/ Chemise

Type of jacket/ Genre de chemise	Jacket closure Fermeture de chemise	Proof Test Pression d'épreuve	Heating Surface Surface de chauffe	Sketch/ Schéma
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Safety Valve Outlets/ Soupapes de sûreté

Number/ Nombre 2	Dimension 3"	Location/ Endroit Top of shell B; Near top of Head B
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Nozzles and Openings/ Tubulures et ouvertures

Purpose/ But	Number Nombre	Dimension	Type	Material Matériau	Nominal Thickness Épaisseur nominale	Reinforcement material Matériau de renfort	How attached Genre d'attaches	Location/ Endroit
Inlet/Outlet	2	6"	RFWN	SA333-6	.864"		UW16.1c	Shell A&B
Steam coil	1	4"	RFWN	SA333-6	.674"		UW16.1c	Head A
Drain	1	4"	RFWN	SA333-6	.674"	SA516-70N	UW16.1c	Shell A
Drain	2	3"	RFWN	SA333-6	.600"	SA516-70N	UW16.1c	Shell A&B
Drain	2	3"	RFWN	SA333-6	.600"		UW16.1c	Shell B
PSV	2	3"	RFWN	SA333-6	.600"		UW16.1c	Head B, Shell B
See AB25A Supp. Sheet								

Supports/ Supports

Skirt/ Jupe Yes/ Oui No/ Non <input type="checkbox"/> <input checked="" type="checkbox"/>	Lugs/ Oreilles No./ Nbre N/A	Legs/ Pieds No./ Nbre N/A	Other/ Autres (Description) 2-Saddles	Attached/ Attaches (Where and How/ Méthode et endroit) Welded to Shells A&B with repads
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Remarks/ Observations (Cubical capacity/ Volume)

Impact tests required on head to shell, shell to shell, and shell long seam production welds as per UG-84 to-50F
Vessel construction Drawing: 5100-05 R03
Vessel Volume: 9.83 cubic meters
PSV to be supplied

Certificate of Compliance/ Certificat de conformité

We certify that the statements made in this data report are correct and that the said vessel has been constructed in accordance with the Provincial Registered design below and the requirements of standard CSA B51.

Nous certifions que les données de la déclaration de conformité sont correctes et que l'appareil a été construit en accord avec l'enregistrement provincial ci-dessous et les exigences de la norme ACNOR B51.

Provincial Registered Design
Enregistrement provincial R7055.21

Manufacturer
Constructeur Dynacorp Fabricators Inc.

Signature [Signature] Date June 25/04

Certificate of Compliance - Field Work/ Certificat de conformité - Installation au chantier

We certify that the field installation of all parts of the vessel conforms with the requirements of Provincial Regulations.

Nous certifions que l'installation au chantier de toutes les composantes de l'appareil est conforme aux règlements provinciaux.

Installer's Name
Nom de l'installateur _____

Signature _____

Date _____

Certificate of Shop Inspection/ Certificat d'inspection en usine

I, the undersigned, a duly authorized Boiler and Pressure Vessel Inspector
Je, soussigné, inspecteur autorisé de chaudières et appareil sous pression
employed by
employé par Alberta Boilers Safety Association

of/ de Alberta

have inspected the above vessel and state that to the best of my knowledge and belief, the manufacturer has constructed the vessel in accordance with the Provincial registration CRN R7055.21 and the requirements of standard CSA B51.

ai inspecté l'appareil précité et autant que je sache, crois que le constructeur a construit l'appareil en accord avec l'enregistrement provincial NEC et les exigences de la norme ACNOR B51.

Inspector's Name

Nom de l'inspecteur GARY BUREX 177A

Signature [Signature] Date June 25/04

Certificate of Field Inspection/ Certificat d'inspection - Installation au chantier

I, the undersigned, a duly authorized Boiler and Pressure Vessel Inspector
Je, soussigné, inspecteur autorisé de chaudières et appareil sous pression
employed by

have inspected the items not covered by the Shop Inspection Certificate and the installation of the items and state that to the best of my knowledge and belief the construction and assembly of the items are in accordance with the Provincial Regulations.

ai inspecté les composantes non couvertes par le certificat d'inspection en usine et l'installation de l'appareil et, autant que je sache, la construction et l'assemblage de l'appareil sont en accord avec les règlements provinciaux.


Inspector's Name

Nom de l'inspecteur _____

Signature _____ Date _____

Inspector's
Signature Henry P. Rubin



CLIENT NAME:		LYONS PRODUCTION SERVICES LTD.					PROJECT NAME:			SS-742			
Client Address:		9301 78 Ave Clairmont AB T8X 0M2					Client Job No.:			NA			
Client Contact Information:		Name:		Dave MacDonald			Purchase Order Number:			NA			
		Phone:		780-538-3400			AFE Number:			NA			
Work Dates:		May 16, 2022					Other:			NA			
Work Location:		Grande Prairie Yard					Report Page Number:			Page 1 of 16			
UT Procedure #		UT-001		Rev: 1	Client Specs:		N/A			Acc. Std.:			
EQUIPMENT													
UT Instrument:		Olympus			Calibration Date:		February 7, 2022						
UT Instrument Model:		Epoch 650						Material Thickness:			Various		
UT Instrument Serial:		160160802			Calibration Blocks:		Step Wedge		DWG. #:		N/A		
Cable Type	Cable Length	Test Angle		Probe S/D	Freq.(MHZ)	Serial No.	Dia.	Transfer Value	Test From	dB	% FSH	Scan Sens.	Range
Coaxial	36"	0 DEG		S	5MHZ	A924D	0.25 0"	-	-	60	80	-	20mm
Inspection Data													
Scope:		Report Package for SS-742 (0489850)				Area to be Inspected:		Vessel					
Results:		See attached UT reports for results.											
		Note: Flag Thickness for ASME B31.3 Piping is Nom-12.5%. ASME Sec VIII Div. 1 flags established at Nom-(CA/2) unless otherwise specified by client.											
Photo						Report							
This Certificate or Report is valid only for that work which was specifically requested. The company is not responsible for any views expressed by employees performing this work which falls outside the exact terms of reference. All certificates and/or reports are the result of work performed in conformance with applicable specifications and standards to the best of our ability and intent. However, the company will not be responsible for deviations within normal limits of accuracy in accordance with the standard practices. Final Code acceptance shall require Client/Manufacture representative signature.													
UT Technician: Jeremy Kerr					Certification: CGSB REG: 20506					Level: CGSB Level 1			
Reviewed By: Steve Gillingham					Certification: CGSB REG: 11441					Level: CGSB Level 2			
Client Representative:					Signature: 					Date: May 16, 2022			



Location Name:	Grande Prairie AB	LSD:	Portable
Jur #:	0489850	Equipment/Tag No.	SS-742
Equipment Description:	Horizontal Test Vessel		
Manufacturer:	Dynacorp Fabricators Inc.		
Serial Number:	1J41668	CRN:	P7055.21
Shell MAWP:	740	PSI	Shell Design Temp: 200 °F
Tube MAWP:	-	PSI	Tube Design Temp: - °F
Shell Material:	SA-516-70N	Head Material:	SA-516-70N
Shell Thickness:	28.6	mm	Head Thickness: 27.4 mm
Corrosion Allowance:	1.4	mm	Date Built: 2004
Size:	54	in	Pipe / Rolled Plate: Plate
RT:	RT1	Client DWG #:	-

Photos



View of Nameplate

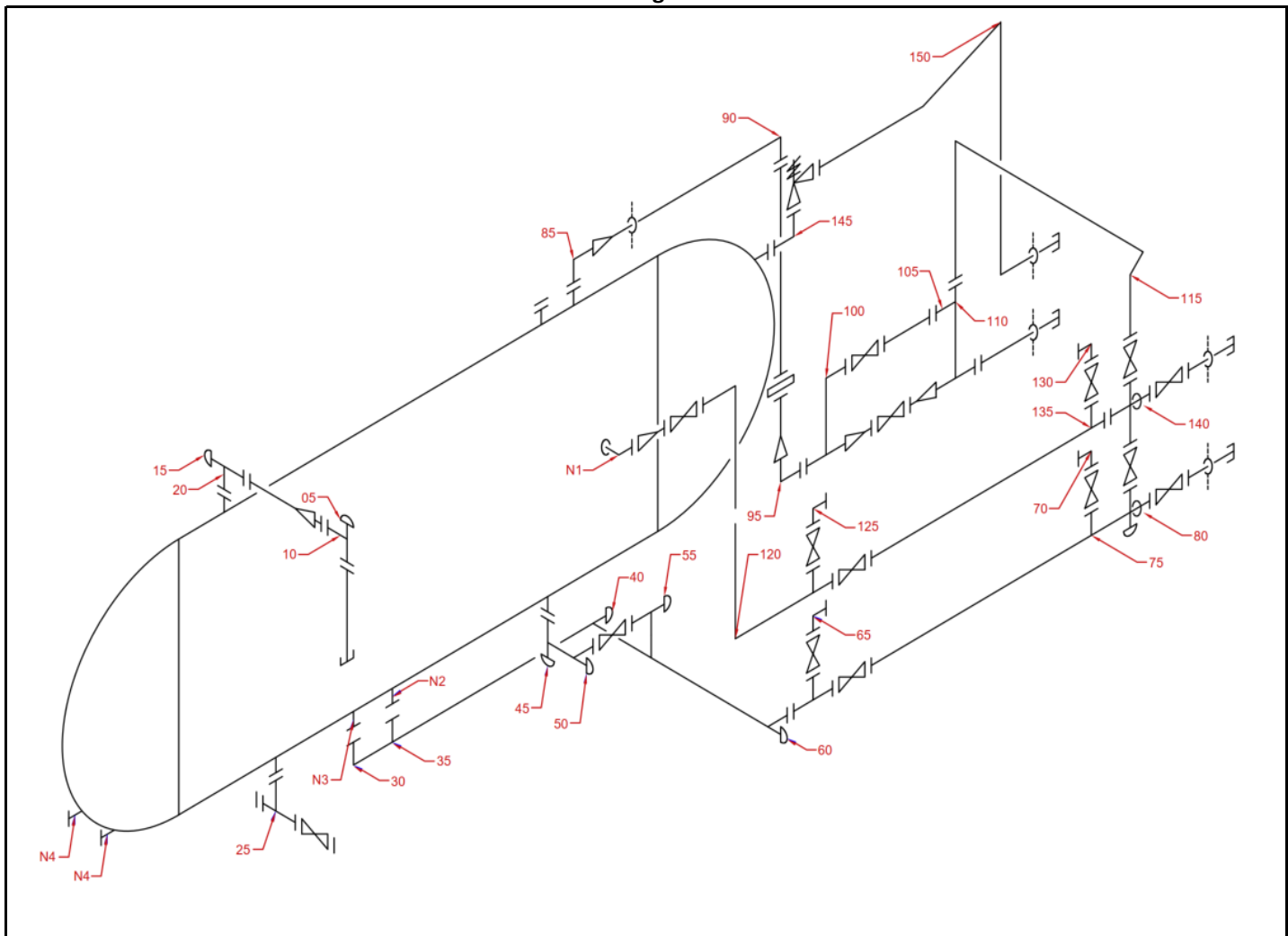


Overall view of Equipment



Location Name:	Grande Prairie AB	LSD:	Portable
Jur #:	0489850	Equipment/Tag No.	SS-742
Equipment Description:	Horizontal Test Vessel		
Manufacturer:	Dynacorp Fabricators Inc.		
Serial Number:	1J41668	CRN:	P7055.21
Shell MAWP:	740	PSI	Shell Design Temp: 200 °F
Tube MAWP:	-	PSI	Tube Design Temp: - °F
Shell Material:	SA-516-70N	Head Material:	SA-516-70N
Shell Thickness:	28.6	mm	Head Thickness: 27.4 mm
Corrosion Allowance:	1.4	mm	Date Built: 2004
Size:	54	in	Pipe / Rolled Plate: Plate
RT:	RT1	Client DWG #:	-

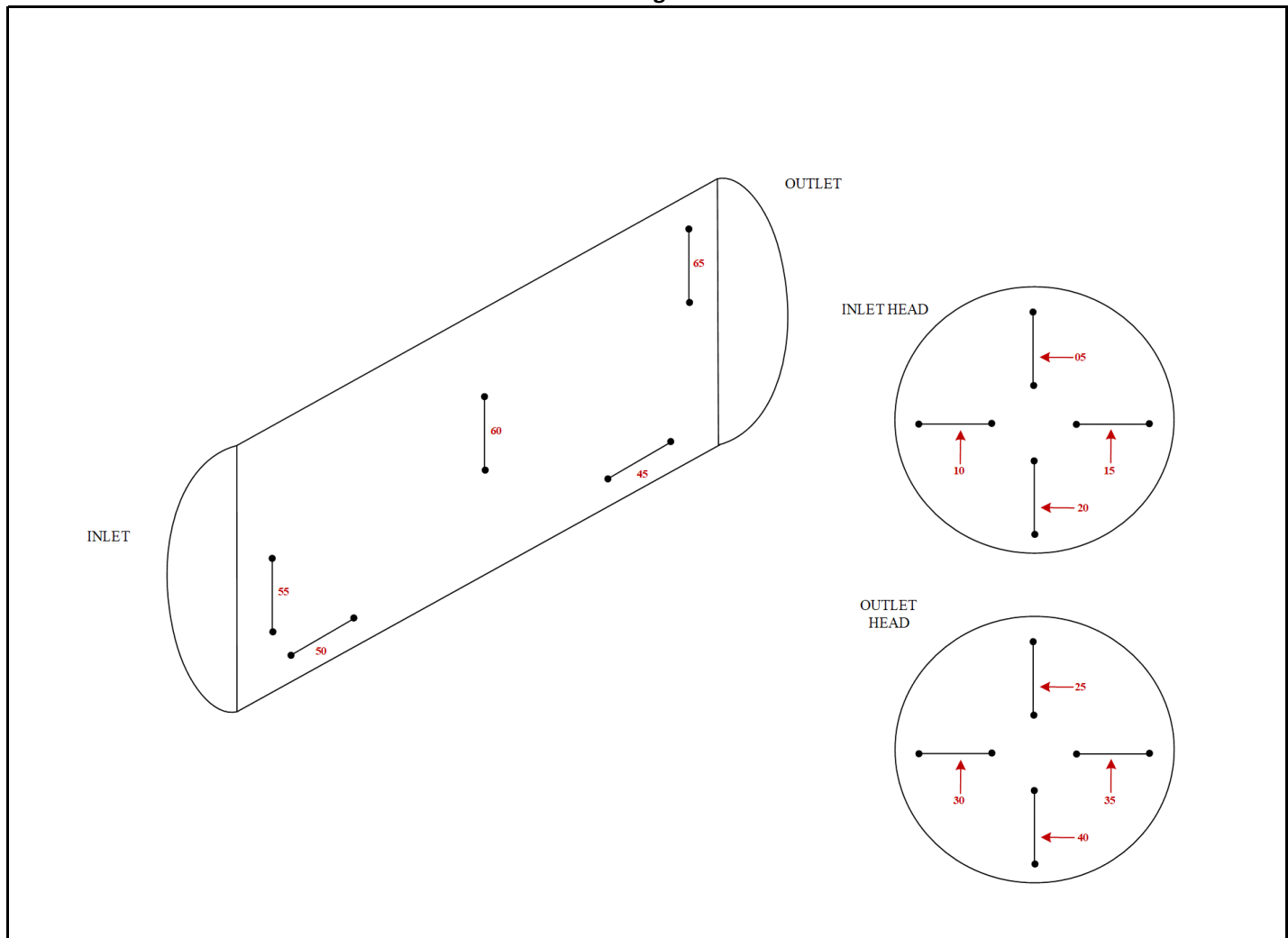
ISO Drawing of TML's





Location Name:	Grande Prairie AB	LSD:	Portable
Jur #:	0489850	Equipment/Tag No.	SS-742
Equipment Description:	Horizontal Test Vessel		
Manufacturer:	Dynacorp Fabricators Inc.		
Serial Number:	1J41668	CRN:	P7055.21
Shell MAWP:	740	PSI	Shell Design Temp: 200 °F
Tube MAWP:	-	PSI	Tube Design Temp: - °F
Shell Material:	SA-516-70N	Head Material:	SA-516-70N
Shell Thickness:	28.6	mm	Head Thickness: 27.4 mm
Corrosion Allowance:	1.4	mm	Date Built: 2004
Size:	54	in	Pipe / Rolled Plate: Plate
RT:	RT1	Client DWG #:	-

ISO Drawing of TML's



Location Name:	Grande Prairie AB		LSD:	Portable	
Jur #:	0489850		Equipment/Tag No.	SS-742	
Equipment Description:	Horizontal Test Vessel				
Manufacturer:	Dynacorp Fabricators Inc.				
Serial Number:	1J41668		CRN:	P7055.21	
Shell MAWP:	740	PSI	Shell Design Temp:	200	°F
Tube MAWP:	-	PSI	Tube Design Temp:	-	°F
Shell Material:	SA-516-70N		Head Material:	SA-516-70N	
Shell Thickness:	28.6	mm	Head Thickness:	27.4	mm
Corrosion Allowance:	1.4		Date Built:	2004	
Size:	54		Pipe/Rolled Plate:	Plate	
RT:	RT1		Client DWG #:	-	

TML#	Description	Shape	Size	Sch	Nom	Flag			2022-05-16 Min Avg	
VESSEL PIPING										
5	Pipe	Tee Cap	4"	80	8.56	7.49			7.91	8.19
10	Pipe	Tee Neck	4"	80	8.56	7.49			8.66	9.09
15	Pipe	Tee Cap	6"	80	10.97	9.60			10.31	10.65
20	Pipe	Tee Neck	6"	80	10.97	9.60			7.47	8.18
25	Pipe	Back of Tee	4"	80	8.56	7.49			5.09	6.00
30	Pipe	90° Elbow	3"	80	7.62	6.67			10.51	11.23
35	Pipe	Back of Tee	3"	80	7.62	6.67			6.47	6.76
40	Pipe	Tee Cap	3"	80	7.62	6.67			6.19	7.30
45	Pipe	Tee Cap	3"	80	7.62	6.67			6.93	7.46
50	Pipe	Tee Cap	3"	80	7.62	6.67			6.42	6.65
55	Pipe	Tee Cap	3"	80	7.62	6.67			6.50	6.89
60	Pipe	Tee Cap	3"	80	7.62	6.67			5.67	6.01
65	Pipe	90° Elbow	2"	40	3.91	3.43			5.16	5.64
70	Pipe	90° Elbow	2"	40	3.91	3.43			8.25	8.74
75	Pipe	Back of Tee	2" x 3"	80	7.62	6.67			10.23	10.62
80	Pipe	Cross	3"	80	7.62	6.67			6.64	6.80
85	Pipe	90° Elbow	6"	40	7.11	6.23			5.95	6.08
90	Pipe	90° Elbow	4"	40	6.02	5.27			7.14	7.56
95	Pipe	90° Elbow	6"	40	7.11	6.23			4.36	4.81
100	Pipe	90° Elbow	3"	40	5.49	4.81			5.12	5.88
105	Pipe	Tee Neck	3"	40	5.49	4.81			5.19	5.89
110	Pipe	Back of Tee	3"	40	5.49	4.81			5.61	5.80
115	Pipe	90° Elbow	2"	40	3.91	3.43			2.92	3.41
120	Pipe	90° Elbow	2"	40	3.91	3.43			5.46	5.74
125	Pipe	90° Elbow	2"	40	3.91	3.43			5.11	5.47
130	Pipe	90° Elbow	2"	40	3.91	3.43			8.80	9.04
135	Pipe	Back of Tee	2"	40	3.91	3.43			5.60	7.42
140	Pipe	Cross	2"	40	3.91	3.43			5.60	6.16
145	Pipe	90° Elbow	3"	40	5.49	4.81			3.07	3.50

150	Pipe	90° Elbow	3"	40	5.49	4.81			5.60	6.03
NOZZLES										
N1	Nozzle	Circ	3"	XXH	15.24	13.34			16.50	16.96
N2	Nozzle	Circ	3"	XXH	15.24	13.34			13.50	13.82
N3	Nozzle	Circ	3"	XXH	15.24	13.34			12.80	13.31
N4	Nozzle	Circ	4"	XXH	17.12	14.98			15.66	16.15
N5	Nozzle	Circ	1"	XXH	9.09	8.49			8.22	8.73
HEAD & SHELL										
5	Head	Ellipsodial	54"	NS	27.40	23.97			27.91	28.21
10	Head	Ellipsodial	54"	NS	27.40	23.97			28.50	29.02
15	Head	Ellipsodial	54"	NS	27.40	23.97			28.75	28.88
20	Head	Ellipsodial	54"	NS	27.40	23.97			28.90	29.35
25	Head	Ellipsodial	54"	NS	27.40	23.97			28.33	28.63
30	Head	Ellipsodial	54"	NS	27.40	23.97			29.08	29.44
35	Head	Ellipsodial	54"	NS	27.40	23.97			28.77	29.17
40	Head	Ellipsodial	54"	NS	27.40	23.97			28.41	28.79
45	Shell	Cylindrical	54"	NS	28.60	25.02			28.24	29.03
50	Shell	Cylindrical	54"	NS	28.60	25.02			28.10	28.57
55	Shell	Cylindrical	54"	NS	28.60	25.02			28.50	28.79
60	Shell	Cylindrical	54"	NS	28.60	25.02			28.40	28.67
65	Shell	Cylindrical	54"	NS	28.60	25.02			28.39	28.74