



Grande Prairie, AB
T8V 4B5
Phone (780) 532-1160
Fax: (780) 532-1148

PURCHASE ORDER

5838

DATE FEBRUARY 10, 2005

REFERENCE _____

QC JOB # STOCK ORDER

UNIT # _____

PHONE 532-0739

LOCATION G.P. SHOP

QUANTITY	UNIT OF MEASURE	DESCRIPTION	UNIT PRICE	G.S.T.	TOTAL
40KG	1/8"	LINCOLN AWS A5.5 AND ASME 5.5 E11018.M 4HR E11018.M / E7610.M		✓	
3	0.035"	PROSTAR MILWIRE AWS SFA 5.18 CWB CSA W4B E17056		✓	
50LB	1/8"	LINCOLN F60TWEED SPT AWS A5.17 ASME SFA 5.17 E6010		✓	
10	0.035"	CONTACT TIP			
2	2"x4"	SHADE 4 LENSE			
4	2"x4"	SHADE 10 LENSE			
100	2"x4"	CLEAR LENSE			
1		500AMP GROUND CLAMP			
4	.035	5356 PROSTAR ALUM WIRE			
1		0-1-101 CUTTING TIP			
1		3-1-101 CUTTING TIP			
1		HEADGEAR ASSEMBLY			
5	6"	.025x5/32 11 KNOT WIRE WIREFIL			

JOB # 10252 BLUESTAR

QCI

DATE

QCM

DATE

VIA

PRAXAIR

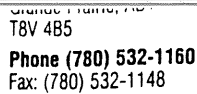
SUBTOTAL

GST

TOTAL

SHIP TO ADDRESS: _____

SIGNATURE Che



5830

LOCATION G.P. SHOP

PHONE 532-0171

JOB # 10252 BLUESTAIR

QCI _____ DATE _____

QCM 1/1/74 DATE Feb 28/05

SIG TURE

WENZES PRINTER, 1924

1128: - 39 AVENUE
GRANDE PRAIRIE AB T8V 5Z2
Phone: (780) 532-0171

Fax: (780) 539-3240

1529947

04-FEB-2005 15:57 (CST)

Page 1 of 1

SHIP TO: BLUESTAR WELDING
RR #2, SITE 7, BOX 20
GRANDE PRAIRIE AB T8V 2Z9
780-532-1160

SHIP TO: BLUESTAR WELDING
LIVRE À: RR #2, SITE 7, BOX 20
GRANDE PRAIRIE AB T8V 2Z9
780-532-1160

N° DU BON DE LIVRAISON

CUSTOMER NO. / DU CLIENT	PURCHASE ORDER NO. / DE COMMANDE / REQUISITION	ORDER DATE / DATE DE COMMANDE	REQUIRED DATE / DATE REQUISE	PURCHASER'S NAME / NOM DE L'ACHETEUR	ORDER TAKEN BY / COMMANDE PRI
071114-001	5830 / J008 10252 P	03-FEB-2005	04-FEB-2005	NOT ON FILE	KORDYBAN, BLAKE

ORDER METHOD / METHODE DE COMMANDE	SHIPPED VIA / EXPÉDIÉ PAR	DELIVERY ZONE / ZONE DE LIVRAISON	BL NO. DE CONNAISSEMENT	TOTAL WEIGHT / POIDS TOTAL	TERMS / TERMES
Phone	Customer Pickup				NET 30

ITEM NUMBER / NUMERO D'ARTICLE DESCRIPTION	ORDERED COMMANDE	SHIPPED EXPÉDIÉ	RETURNED RETOURNE	BACK ORDER EN SOUFFRANCE	TOTAL VOLUME	UOM / UDM	T X	PRICE / PRIX	EXTENDED P EXTENSION DU
00071005 ELECTRODE, LOW ALLOY, BLUESHIELD, 18-M, 2.5MM (3/32") 4 X 2.5KG. AWS D18-M, CSA E76018-M	60	60			BIN: WA30	KG	A	8.37	
WELCYL SURCHARGE. CYLINDER GASES AND ING PRODUCTS	1	1				EA	A	.00	
ESCOMHG LABORATORY COMPLIANCE SURCHARGE - 300%	1	1				EA	A	3.00	
WELCHARGESTEEL 3E. FILLER METAL. STEEL SURCHARGE	60	60				KG	A	.21	
PLEASE NOTE: FOR ACCOUNT ENQUIRIES PLEASE CONTACT FRANCA JACOBS @ 1-877-294- 00.									

RC 10 Feb 4/5

BY: SSE PAR

K.

DATE / DATE LIVREE

03 04/05

TOTAL
CYLINDERS / BOUTEILLES

A- GST and PST
B- GST or HST only
C- PST only
D- None

SUB TOTAL
SOUS-TOTAL

G.S.T. / T.P.S.
H.S.T.

P.S.T.
Q.S.T. / T.V.Q.

24-Hour No. (514) 878-1667 for spill, fire, explosion, accident.



DATE JANUARY 27, 2005

REFERENCE _____

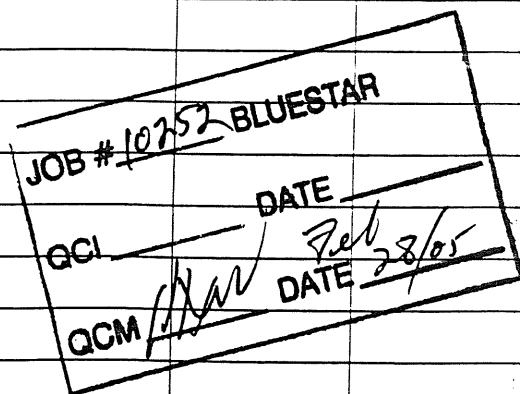
QC JOB # STOCK ORDER

UNIT # _____

PHONE 532-0778

LOCATION G.P. SHOP

QUANTITY	UNIT OF MEASURE	DESCRIPTION	UNIT PRICE	G.S.T.	TOTAL
50 LB	3/32	Lincoln AWS A5.5 : ASME SFA 5.5 E11018 M4HR		✓	
		E11013M/E7613M			
40 LB.	5/32	SAME AS ABOVE		✓	
60 LB.	3/16	SAME AS ABOVE		✓	
40 KG	1/8	Blueshield AWS A5.1 E7018-1 ASME SFA 5.1			
		E7018-1 9A FAN 4 AND NO1		✓	
20 KG	3/32	SAME AS ABOVE		✓	
20 KG	5/32	SAME AS ABOVE		✓	
20 KG	3/16	SAME AS ABOVE		✓	
1	.035	PROSTAR MIG WIRE 44" SPOOL AWS SFA 5.18 CWP CSA W48 FL 7036			
10	5/8"	MIG NOZZLE			
10	1/2"	MIG NOZZLE			
20	0.035	CONTACT TIP			
20	0.045	CONTACT TIP			
10		GAS DIFFUSER			
10		GAS DIFFUSER			
25	5"	7/8 80 GR SANDPAPER			
2		INSULATOR TIP			
1		250 AMP ELECTRODE HOLDER			
4	0.35	5356 ALUM 1# SPOOL WIRE			
100	2"x4"	CLEAR LENS PROTECTOR			
6	1/2"	.020 KNOT WIRE WHEEL			
2	5/8"	11 NC KNOT WIRE WHEEL			



SHIP TO ADDRESS: _____

VIA PRAXAIR

SIGNATURE [Signature]

SUBTOTAL

GST

TOTAL

SV
O L
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U
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O A

1. acknowledges receipt of the goods described on this Delivery Ticket;
2. agrees to the Terms of Cylinder Gas Agreement accompanying this Delivery Ticket (located on the reverse hereof); and
3. confirms that the Customer understands the safety bulletin (located on the reverse hereof) and has obtained or will obtain a current MSDS for the products described on this Delivery Ticket.

ci-dessous, le Client;
1. reconnaît avoir reçu les marchandises décrites sur ce Bulletin de livraison;
2. accepte les conditions de l'Entente de fourniture de gaz en bouteilles qui accompagne ce Bulletin de livraison (au verso des présentes); et
3. confirme avoir compris la portée du Bulletin de sécurité (au verso des présentes) et déclare qu'il a reçu ou qu'il recevra des fiches techniques santé-sécurité de chaque produit décrit sur ce Bulletin de livraison.

Customer's Signature:

Signature du Client:

Print Name:

Nom et capitales:

Date:

Print Title:

Fonctions en capitales:

6000188434

BLUE STAR WELDING (MASTER)*G*

BLUE STAR WELDING (MASTER)*G*

DIV OF 570147 AB LTD

RR 2 SITE 1 BOX 20

GRANDE PRAIRIE AB T8V 2Z9

RG 28-JAN-05 03:11PM CRT:TNA7746

REILLY RT# 530002 RRC

ER NO. (ANDE N°)	DATE	CUST. NO. N° DU CLIENT	CUSTOMER NAME/NOM DU CLIENT	CUSTOMER ORDER NO. N° DE BON DE COMMANDE DU CLIENT	TERR. TERRITOIRE	SALES VENTES	SHIP VIA/EXPÉDIE VIA	UPS	SHIP CODE D'EXPÉDITION	CELL PORT DU	PRO PORT PAYE	PAGE
5329-00	01/27/05	59348	BLUE STAR WELDING (MASTER)	5819	530	535	BRN 3RD PTY		0	71	X	1
NO. E DE	STOCK NUMBER N° DE STOCK	WE HT ST ER	STOCK DESCRIPTION/DESCRIPTION DES STOCKS	UNIT OF MEASURE UNITÉ DE MESURE	QTY. ORDERED QUANTITÉ COMMANDEE	QTY. SHIPPED QUANTITÉ EXPÉDIEE	QTY. BIN	LOC	WEIGHT	UNIT AMOUNT MONTANT UNITAIRE	EXTENDED AMOUNT MONTANT	
	Route Nbr 530002		Stop Nbr 000 Vehicle 00000 Driver 000									
	** Location:530 **											
1	HME 25125		MAG LENS 1.25 2X4 PLASTIC	EA	1	1	0	5B060	.0	4.44	4.44	
2	BER NS-5818B		MIG NOZZLE 5/8 ID 1/8 RECESS	EA	10	10	0	0507H	.0	7.13	71.30	
3	BER NS-1218B		MIG NOZZLE 1/2 ID 1/8 RECESS	EA	10	10	0	0507H	.0	7.13	71.30	
4	BER T-035		CONTACT TIP 035 CENTERFIRE	EA	20	20	0	0507H	.0	.88	17.60	
5	BER T-045		CONTACT TIP 045 CENTERFIRE	EA	20	20	0	0507H	.0	.88	17.60	
6	BER DS-1T		GAS DIFFUSER CENTERFIRE	EA	10	10	0	0507H	.0	7.28	72.80	
7	BER DS-1		GAS DIFFUSER SMALL CENTERFIRE	EA	10	10	0	0507H	.0	7.28	72.80	
8	UNI 50024		SAND DISC FIBER 2A 5X7/8 GR80	EA	25	25	0	0607F	.0	.92	23.00	
SAFETY DATA SHEET 926004												
9	ED015570		ELECTR MS 11018M 3/32 50# HSC	LB	50	0	50		.0	3.89	.00	
10	LIN ED511106		ELECTR MS 11018M 5/32 5 TD	KG	40	25	15	1204C	55.0	3.62	90.50	
11	LIN ED511107		ELECTR MS 11018M 3/16 5 TD	KG	60	0	60	1204C	.0	3.61	.00	
12	SID 56RN09P020		WIRE MS 7056 035 44# SP PRS	SD	4	4	0	1204A	176.0	51.92	207.68	
13	KOB E316LT1045		WIRE KOB E316LT-1 045 28LB SP	LB	56	0	56		.0	13.50	.00	
14	CLA 329717067		ELECTR MS 7018 3/32	KG	20	20	0	0702A	44.0	5.96	119.20	
			SURCHARGE APPLICABLE @ .21/KG									
			SUPPLEMENT APPLICABLE @.21/KG									
15	CLA 329717083		ELECTR MS 7018 1/8	KG	40	40	0	0702A	88.0	4.53	183.20	
			SURCHARGE APPLICABLE @ .21/KG									
			SUPPLEMENT APPLICABLE @.21/KG									
16	CLA 329717106		ELECTR MS 7018 5/32	KG	20	20	0	0702A	44.0	4.53	91.60	
			SURCHARGE APPLICABLE @ .21/KG									
			SUPPLEMENT APPLICABLE @.21/KG									
17	CLA 329717122		ELECTR MS 7018 3/16	KG	20	20	0	0702A	44.0	4.53	90.60	
			SURCHARGE APPLICABLE @ .21/KG									
			SUPPLEMENT APPLICABLE @.21/KG									

ITY FOR CUSTOMER TRANSPORT

er acknowledges that:

tion of industrial gas cylinders can be hazardous unless certain safety precautions are taken; and

s offered to transport gas cylinders to their destination for the Customer.

er represents that:

mer has read and understands the safety precautions outlined on the safety bulletin (located on the reverse

sign the authority to sign the acknowledgement and indemnity on behalf of the Customer.

er shall indemnify and hold Praxair harmless from and against any losses, claims, damages, judgements, or expenses (including legal fees and expenses) resulting from transportation and use of the cylinders by the

omer detects a leak, then the customer will immediately advise Praxair; and
mer will comply with all laws governing the transportation of compressed gases.

ENGAGEMENT À INDEMNISER

Le Client reconnaît que:

1. le transport de bouteilles de gaz peut être dangereux si les précautions de sécurité ne sont pas respectées;
2. Praxair lui a offert de livrer les bouteilles de gaz à destination.

Le Client déclare:

1. qu'il a lu et compris les précautions de sécurité faisant l'objet du bulletin de sécurité (au verso des présentes);
2. que le soussigné est autorisé à signer cette Reconnaissance au nom du Client.

Le Client s'engage à:

1. indemniser Praxair et à la tenir à l'abri des pertes, réclamations, dommages, jugements, responsabilités et frais (incluant tous les frais juridiques) résultant du transport et de l'utilisation des bouteilles par le Client;
2. informer immédiatement Praxair dès qu'il constate qu'une bouteille fuit;
3. se conformer à l'ensemble des lois et règlements régissant le transport de gaz comprimés.

s Signature/Signature du Client:

Date:

Print Name/Nom en capitales:

Print Title/Fonctions en capitales:

Witnessed by/Témoignage:

1. acknowledges receipt of the goods described on this Delivery Ticket;
 2. agrees to the Terms of Cylinder Gas Agreement accompanying this Delivery Ticket (located on the reverse hereof); and
 3. confirms that the Customer understands the safety bulletin (located on the reverse hereof) and has obtained or will obtain a current MSDS for the products described on this Delivery Ticket.

ci-dessous, le Client:
 1. reconnaît avoir reçu les marchandises décrites sur ce Bulletin de livraison;
 2. accepte les conditions de l'Entente de fourniture de gaz en bouteilles qui accompagne ce Bulletin de livraison (au verso des présentes); et
 3. confirme avoir compris la portée du Bulletin de sécurité (au verso des présentes) et déclare qu'il a reçu ou qu'il recevra les fiches techniques santé-sécurité de chaque produit décrit sur ce Bulletin de livraison.

Customer's Signature:

Signature du Client:

Date:

Print Name:

Nom et capitales:

Print Title:

Fonctions en capitales:

6000189356

BLUE STAR WELDING (MASTER)*G*

BLUE STAR WELDING (MASTER)
 DIV OF 570147 AB LTD
 RR 2 SITE 7 BOX 20
 GRANDE PRAIRIE AB T8V 2Z9

HRG

28-JAN-05 03:11PM CRT:TN47746

REILLY RT# 530002 RRC

ORDER NO. N° DE COMMANDE	DATE	CUST. NO. N° DU CLIENT	CUSTOMER NAME/NOM DU CLIENT	CUSTOMER ORDER NO. N° DE BON DE COMMANDE DU CLIENT	TERR. TERRITOIRE	SALES VENTES	SHIP VIA/EXPEDIE VIA	UPS	SHIP CODE D'EXPEDITION	COLL PORT DU	PRO PORT PAYE	PAGE
06529-00	01/27/05	59342	BLUE STAR WELDING (MASTER)	5819	530	535	BRN 3RD PTY	0	71		X	2
E NO. DE ME	STOCK NUMBER N° DE STOCK	WEIGHT Poids	STOCK DESCRIPTION/DESCRIPTION DES STOCKS	UNIT OF MEASURE UNITE DE MESURE	QTY ORDERED QUANTITE COMMANDEE	QTY SHIPPED QUANTITE EXPEDIEE	QTY BIN AKORD	LOC.	WEIGHT	UNIT AMOUNT MONTANT UNITAIRE	EXTENDED AMOUNT MONTANT	
	Route Nbr 530002		Stop Nbr 000 Vehicle 00000 Driver 000									
18	TWE 9910-2102		INSULATOR TIP W/SCREW A-532-1P	EA	2	2	0	0308H	.0	8.16	16.32	
19	TWE 9110-1102		ELEC HOLDER 250A A-316 TONG	EA	1	1	0	SB020	.0	33.09	33.09	
20	LIN ED702618		WIRE ALLUM 5356 035 1# SP PRS	LB	4	4	0	0701C	.0	4.992	19.97	
21	HWE 240933		LENS CLEAR 2X4 CR39 PLASTIC PRS	EA	100	100	0	SB060	.0	.30	30.00	
22	OSB 26761		WIRE WHEEL 6-1/2X.020 KNOT	EA	6	6	0	SD020	.0	11.74	70.44	
23	OSB 26744		WIRE WHEEL 6X.025 5/8-11NC KNOT	EA	2	2	0	SD020	.0	11.38	22.76	
24	MSC HAZMAT		HAZARDOUS MATERIAL CHARGE	EA	1	1	0	ZZZZZZ	.0	4.95	4.95	
26	MSC HDGSUR		STEEL PRICE SURCHARGE DUE TO THE GLOBAL STEEL SHORTAGE, WE ARE FORCED TO IMPLEMENT A SURCHARGE PASSED ON FROM OUR VENDORS.	EA	100	100	0	ZZZZZZ	.0	210000	21.00	
Total Weight 451.0										Subtotal	1350.35	
PRANAIR GST 89753 6637 AT										GST Tax:	94.73	
										Tax:	.00	
										Total Sale	1445.08	
OK JAN 28												

NOTICE FOR CUSTOMER TRANSPORT

Praxair acknowledges that transportation of industrial gas cylinders can be hazardous unless certain safety precautions are taken; and Praxair offers to transport gas cylinders to their destination for the Customer. The Customer represents that: Praxair has been advised and understands the safety precautions outlined on the safety bulletin (located on the reverse hereof) and authorizes Praxair to sign the acknowledgement and indemnity on behalf of the Customer.

Praxair agrees to indemnify and hold Praxair harmless from and against any losses, claims, damages, judgments, or expenses (including legal fees and expenses) resulting from transportation and use of the cylinders by the Customer. If the Customer detects a leak, then the customer will immediately advise Praxair; and the customer will comply with all laws governing the transportation of compressed gases.

ENGAGEMENT À INDEMNISER

Le Client reconnaît que:
 1. le transport de bouteilles de gaz peut être dangereux si les précautions de sécurité ne sont pas respectées;
 2. Praxair lui a offert de livrer les bouteilles de gaz à destination.
 Le Client déclare:
 1. qu'il a lu et compris les précautions de sécurité faisant l'objet du bulletin de sécurité (au verso des présentes);
 2. que le soussigné est autorisé à signer cette Reconnaissance au nom du Client.
 Le Client s'engage à:
 1. indemniser Praxair et à la tenir à l'abri des pertes, réclamations, dommages, jugements, responsabilités et frais (incluant tous les frais juridiques) résultant du transport et de l'utilisation des bouteilles par le Client;
 2. informer immédiatement Praxair dès qu'il constate qu'une bouteille fuit;
 3. se conformer à l'ensemble des lois et règlements régissant le transport de gaz comprimés.

Signature/Signature du Client:

Date:

Print Name/Nom en capitales:

Print Title/Fonctions en capitales:

Witnessed by/Témoin:

Ok
 JAN 28/05
 Stock



T8V 485
Phone (780) 532-1160
Fax: (780) 532-1148

5810

DATE JANUARY 20, 2005

REFERENCE _____

QC JOB #

87000 CROCK

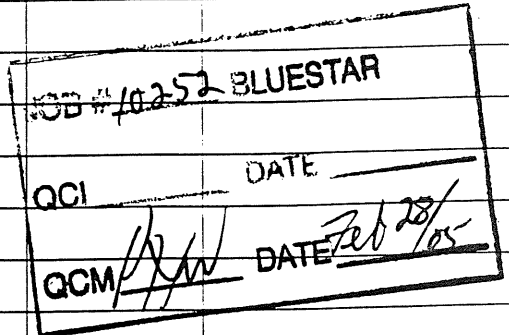
UNIT # _____

PHONE 532-0738

LOCATION

G.P. SHOP

QUANTITY	UNIT OF MEASURE	DESCRIPTION	UNIT PRICE	G.S.T.	TOTAL
5	0.35	44# PROSTAR MIG WIRE SPOOLS AWS SFA 5.18		✓	
		CWB CSA WYR EL 7056			
40 KG	1/8	BLUESHIELD AWS AS.1 E7018-1 ASME SFA 5.1		✓	
		E7018-1gr F No 4 AN A NO. 1			
20 KG	5/32	SAME AS ABOVE		✓	
20 KG	3/16	SAME AS ABOVE		✓	
40 KG	1/4	SAME AS ABOVE		✓	
50 LB	1/8	LINCOLN WELD SPT AWS AS.17 ASME SFA 5.17	E6010		
50 LB	5/32	SAME AS ABOVE			
LB	5/32	LINCOLN AWS 5.5 AND ASME SFA 5.5 E11018 4HR			
		E11018-M / E7618M			
60 LB	3/16	SAME AS ABOVE			
20 KG	0.045	HOBART 71T 4271 FLUX-CORE WIRE			
10 LB	3/16	LINCOLN WELD SPT AWS AS.1 ASME SFA 5.1 E6010			
100	2x4	CLEAR LENSE PROTECTOR			
5		*1 #2 HAMMER ON LUG			
10	0.045	14H45 CONTACT TIP			
4	0.035	1AB 5356 ALUMINUM WIRE SPOOL			
1	5/32	MIG NOZZLE - INSULATOR			
2	2x4	10 SHADE LENSE			
2	2x4	10 SHADE G260 LENSE			
4	16.02	AF2202 MIG SPATTER			



SHIP TO ADDRESS: _____

VIA

REILLY TRANSFER

SIGNATURE

CPL

SUBTOTAL

GST

TOTAL



represent (the "Customer"). By signing below, the Customer:

1. acknowledges receipt of the goods described on this Delivery Ticket;
2. agrees to the Terms of Cylinder Gas Agreement accompanying this Delivery Ticket (located on the reverse hereof); and
3. confirms that the Customer understands the safety bulletin (located on the reverse hereof) and has obtained or will obtain a current MSDS for the products described on this Delivery Ticket.

société ou à l'entreprse que le représente (le "Client"). En ci-dessous, le Client:

1. reconnaît avoir reçu les marchandises décrites sur ce Bulletin de livraison;
2. accepte les conditions de l'Entente de fourniture de gaz bouteilles qui accompagne ce Bulletin de livraison (au verso des présentes); et
3. confirme avoir compris la portée du Bulletin de sécurité (au verso des présentes) et déclare qu'il a reçu ou qu'il recevra les fiches techniques santé-sécurité de chaque produit décrit sur ce Bulletin de livraison.

Customer's Signature:

Signature du Client:

Date:

Print Name:

Print Title:

Nom et capitales:

Fonctions en capitales:

BLUE STAR WELDING (MASTER) SA

BLUE STAR WELDING (MASTER) SA

10000 PLYMOUTH RD LTD

10000 PLYMOUTH RD LTD

10000 PLYMOUTH RD LTD

CHRG 00-10-05 00:50PM CRT TMSRMP

RECEIVED BY 000000 000

ORDER NO. N° DE COMMANDE	DATE	CUST. NO. N° DU CLIENT	CUSTOMER NAME/NOM DU CLIENT	CUSTOMER ORDER NO. N° DE BON DE COMMANDE DU CLIENT	TERR. TERRITOIRE	SALES VENTES	SHIP VIA/EXPEDIE VIA	UPS	SHIP CODE EXPEDITION	COLL PORT DU	PPD PORT PAYE	PAGE
550463-00	01/00/03	50362	BLUE STAR WELDING (MASTER)	5010	501	500	0001 000 000	0	01	Y	Y	1
LINE NO. N° DE LIGNE	STOCK NUMBER N° DE STOCK	WE HNT STER	STOCK DESCRIPTION/DESCRIPTION DES STOCKS	UNIT OF MEASURE UNITE DE MESURE	QTY. ORDERED QUANTITE COMMANDEE	QTY. SHIPPED QUANTITE EXPEDIEE	UNIT PRICE	TAX	NET WT	UNIT AMOUNT MONTANT UNITAIRE	EXTENDED AMOUNT MONTANT	
	Route Nbr 530002		Step Nbr 000 Vehicle 00000 Brown 000									
	* Location 1536 *											
-	CLD 329717002		WIRE MS 7018 035 446 SP PRE	KG	10	10	220.0		220.0	220.00	220.00	
-	CLD 329717003		ELECTR MS 7018 1/8	KG	10	10	10.0		10.0	10.00	10.00	
			SURCHARGE APPLICABLE 0.21/KG									
			SUPPLEMENT APPLICABLE 0.21/KG									
-	CLD 329717106		ELECTR MS 7018 5/32	KG	10	10	44.0		44.0	44.00	44.00	
			SURCHARGE APPLICABLE 0.21/KG									
			SUPPLEMENT APPLICABLE 0.21/KG									
-	CLD 329717122		ELECTR MS 7018 3/16	KG	10	10	44.0		44.0	44.00	44.00	
			SURCHARGE APPLICABLE 0.21/KG									
			SUPPLEMENT APPLICABLE 0.21/KG									
-	CLD 7018-14		ELECTR MS 7018 1/4	KG	10	10	35.0		35.0	35.00	35.00	
			SURCHARGE APPLICABLE 0.21/KG									
			SUPPLEMENT APPLICABLE 0.21/KG									
-	LIN EDR10275		ELECTR MS 6010 1/8 FWEP- 50% HFC	KG	10	10	10.0		10.0	10.00	10.00	
			SURCHARGE APPLICABLE 0.21/KG									
			SUPPLEMENT APPLICABLE 0.21/KG									
-	LIN EDR10285		ELECTR MS 6010 5/32 FWEP- 50% HFC	KG	10	10	30.0		30.0	30.00	30.00	
			SURCHARGE APPLICABLE 0.21/KG									
			SUPPLEMENT APPLICABLE 0.21/KG									
-	LIN EDR11185		ELECTR MS 11010N 5/32 5 TO	KG	10	10	33.0		33.0	33.00	33.00	
-	HW 240833		LENS CLEAR 2/4 CR29 PLASTIC 004	EA	10	10	3.0		3.0	3.00	3.00	
-	PEE HL-21		LUG CAPLE 41 MS HAMMER ON	EA	10	10	1.0		1.0	1.00	1.00	
-	OKI NS-16		SOAPSTONE FLAT	PC	10	10	0.0529		0.0529	0.529	0.529	
-	HOB 071-12-2035		WIRE FC 711 045 ALTI 20KG SP	KG	10	10	44.0		44.0	44.00	44.00	

OK

INDemnITY FOR CUSTOMER TRANSPORT

Praxair acknowledges that transportation of industrial gas cylinders can be hazardous unless certain safety precautions are taken; and has offered to transport gas cylinders to their destination for the Customer.

The Customer acknowledges that:

Praxair represents and warrants that the safety precautions outlined on the safety bulletin (located on the reverse hereof) are correct and that the Customer understands the safety precautions outlined on the safety bulletin (located on the reverse hereof).

The Customer acknowledges that the authority to sign the acknowledgement and indemnity on behalf of the Customer.

The Customer shall indemnify and hold Praxair harmless from and against any losses, claims, damages, judgements, or expenses (including legal fees and expenses) resulting from transportation and use of the cylinders by the Customer.

ENGAGEMENT À INDEMNISER

Le Client reconnaît que:

1. le transport de bouteilles de gaz peut être dangereux si les précautions de sécurité ne sont pas respectées;
2. Praxair lui a offert de livrer les bouteilles de gaz à destination.

Le Client déclare:

1. qu'il a lu et compris les précautions de sécurité faisant l'objet du bulletin de sécurité (au verso des présentes);
2. que le soussigné est autorisé à signer cette Reconnaissance au nom du Client.

Le Client s'engage à:

1. indemniser Praxair et à la tenir à l'abri des pertes, réclamations, dommages, jugements, responsabilités et frais (incluant tous les frais juridiques) résultant du transport et de l'utilisation des bouteilles par le Client;
2. informer immédiatement Praxair dès qu'il constate qu'une bouteille fuit;
3. se conformer à l'ensemble des lois et règlements régissant le transport de gaz comprimés.

Customer's Signature/Signature du Client:

Date:

Print Name/Nom en capitales:

Print Title/Fonctions en capitales:

Witnessed by/Témoin:

S
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represent (the Customer). By signing below, the Customer:
1. acknowledges receipt of the goods described on this Delivery Ticket;
2. agrees to the Terms of Cylinder Gas Agreement accompanying this Delivery Ticket (located on the reverse hereof); and
3. confirms that the Customer understands the safety bulletin (located on the reverse hereof) and has obtained or will obtain a current MSDS for the products described on this Delivery Ticket.

société ou à l'entreprise que le représente (le «Client»). En ci-dessous, le Client:
1. reconnaît avoir reçu les marchandises décrites sur ce Bulletin de livraison;
2. accepte les conditions de l'Entente de fourniture de gaz bouteilles qui accompagne ce Bulletin de livraison (au verso des présentes); et
3. confirme avoir compris la portée du Bulletin de sécurité (au verso des présentes) et déclare qu'il a reçu ou qu'il recevra les fiches techniques sante-sécurité de chaque produit décrit sur ce Bulletin de livraison.

Customer's Signature:

Signature du Client:

Print Name:

Nom et capitales:

Date:

Print Title:

Fonctions en capitales:

5956645879

BLUE STAR WELDING (MASTER) ***

BLUE STAR WELDING (MASTER) ***
DIV OF 570147 AD LTD
PR 2 SITE 7 800 400
GRANDE PRAIRIE AB T0N 1L0

PRG 20-JAN-85 01:59PM CRT:TRN3678

FEEL: 85-53000 ART

ORDER NO N° DE COMMANDE	DATE	CUST. NO. N° DU CLIENT	CUSTOMER NAME/NOM DU CLIENT	CUSTOMER ORDER NO. N° DE BON DE COMMANDE DU CLIENT	TERR TERRITOIRE	SALES VENTES	SHIP VIA/EXPEDIE VIA	UPS	SHIP CODE EXPEDITION	COLL PORT DU	PRO PORT PAYE	PAGE
5956645879	01/20/85	59248	BLUE STAR WELDING (MASTER)	5910	53A	535	BRN 3P DT					
LINE NO. N° DE LIGNE	STOCK NUMBER N° DE STOCK	WEIGHT PES	STOCK DESCRIPTION/DESCRIPTION DES STOCKS	UNIT OF MEASURE UNITE DE MESURE	QTY ORDERED QUANTITE COMMANDEE	QTY SHIPPED QUANTITE EXPEDIEE	QTY	BIN	UNIT AMOUNT MONTANT UNITAIRE	EXTENDED AMOUNT MONTANT		
	Route Nor 53000		Stop Nor 000 Vehicle 00000 Driver 000									
			SAFETY DATA SHEET 418024									
1	ONE 450535		CONTACT TIP 1/8-45 045 HD PRS	EA	10	10	0	05027				
1	555 55764		WIRE WHEEL 4-7/8X20 5/8-11 KNOT	EA	1	1	0	50020				
1	LIN ED511110		ELECTR MS 6010 3/16 FWP- 5 TD	KE	10	10	0	94020				
			SAFETY DATA SHEET 540210									
1	LIN 50705518		WIRE ALUM 5356 035 1# 3P PRS	LB	4	4	0	07010				
			SAFETY DATA SHEET 541020									
1	ONE 450535		MIG NOZZLE 24A-02 5/8 PRS	EA	1	1	0	05062				
1	ONE 450535		MIG NOZZLE INSULATOR 24A PRS	EA	1	1	0	05061				
1	ONE 450535		LENS SH10 2X4 GLASS PRS	EA	2	2	0	38082				
2	ONE 450535		LENS SH10 2X4 GOLD POLYCARB	EA	2	2	0	58082				
2	ONE 450535		ANTI SPAT 16 OZ AEROSOL PRS	EA	4	4	0	50070				
			SAFETY DATA SHEET 538029									
2	LIN ED511107		ELECTR MS 11010 3/16 5 TD	KE	60	0	60	12040				
2	ONE 450535		HAZARDOUS MATERIAL CHARGE	EA	1	1	0	77777				
			** Location: ETO **									
2	MSC HDGSUP		STEEL PRICE SURCHARGE DUE TO THE GLOBAL STEEL SHORTAGE. WE ARE FORCED TO IMPLEMENT A SURCHARGE PASSED ON FROM OUR VENDORS.	EA	120	120	0	77777				

OK STOCK
JAN 21/85

OK STOCK
JAN 21/85

WARRANTY FOR CUSTOMER TRANSPORT

Praxair Inc. warrants that the transportation of industrial gas cylinders can be hazardous unless certain safety precautions are taken; and Praxair Inc. has offered to transport gas cylinders to their destination for the Customer.
The Customer acknowledges that: Praxair Inc. and understands the safety precautions outlined on the safety bulletin (located on the reverse hereof) and the authority to sign the acknowledgement and indemnity on behalf of the Customer.
The Customer shall indemnify and hold Praxair Inc. harmless from and against any losses, claims, damages, judgements, or expenses (including legal fees and expenses) resulting from transportation and use of the cylinders by the Customer.
If the Customer detects a leak, then the customer will immediately advise Praxair Inc.; and the customer will comply with all laws governing the transportation of compressed gases.

ENGAGEMENT A INDEMNISER

Le Client reconnaît que:
1. le transport de bouteilles de gaz peut être dangereux si les précautions de sécurité ne sont pas respectées;
2. Praxair Inc. a offert de livrer les bouteilles de gaz à destination.
Le Client déclare:
1. qu'il a lu et compris les précautions de sécurité faisant l'objet du bulletin de sécurité (au verso des présentes);
2. que le soussigné est autorisé à signer cette Reconnaissance au nom du Client.
Le Client s'engage à:
1. indemniser Praxair Inc. à la fin de la période de garantie, des pertes, réclamations, dommages, jugements, responsabilités et frais (incluant tous les frais juridiques) résultant du transport et de l'utilisation des bouteilles par le Client;
2. informer immédiatement Praxair Inc. dès qu'il constate qu'une bouteille fuit;
3. se conformer à l'ensemble des lois et règlements régissant le transport de gaz comprimés.

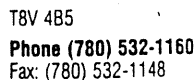
Customer's Signature/Signature du Client:

Date:

Print Name/Nom en capitales:

Print Title/Fonctions en capitales:

Witnessed by/Témoin:



société ou à l'entreprise que je représente (le « Client »). Et si :

1. ci-dessous, le Client;
2. reconnaît avoir reçu les marchandises décrites sur ce Bulletin de livraison;
3. accepte les conditions de l'Entente de fourniture de gaz en bouteilles qui accompagne ce Bulletin de livraison (au verso des présentes); et
4. confirme avoir compris la portée du Bulletin de sécurité (au verso des présentes) et déclare qu'il a reçu ou qu'il recevra les Fiches techniques santé-sécurité de chaque produit décrit ce Bulletin de livraison.

Customer's Signature:

Signature du Client:

Date:

Print Name: _____

Print Title:

Nom et capitales:

Fonctions en capitales:

5917166993

BLUE STAR WELDING (MASTER) *G*

BLUE STAR WELDING (MASTER) 404

DIV OF 570147 AB LTD

RR 2 SITE 7 BOX 20

GRANDE PRAIRIE AB T8V 273

SOLD TO
VENDU À

12-JAN-65 04:25PM CRT:JNA1391

~~NONE~~ RT# 310802 FRC

ORDER NO. COMMANDE N° 06805-00	DATE 01/12/05	CUST. NO. N° DU CLIENT 59342	CUSTOMER NAME/NOM DU CLIENT BLUE STAR WELDING (MASTER	CUSTOMER ORDER NO. N° DE BON DE COMMANDE DU CLIENT 5797	TERR. TERRITOIRE 530	SALES VENTES 535	SHIP VIA/EXPEDIE VIA PICK UP	UPS 0	SHIP CCK DEPENSEMENT 71	COLL PORT DU X	PRO PORT PAYE 1	PAGE
STOCK NUMBER N° DE STOCK	STOCK DESCRIPTION/DESCRIPTION DES STOCKS	UNIT OF MEASURE UNITE DE MESURE	QTY ORDERED QUANTITE COMMANDEE	QTY SHIPPED QUANTITE EXPEDIEE	QTY BKORD	BIN LOC	WEIGHT	UNIT AMOUNT MONTANT UNITAIRE	EXTENDED AMOUNT MONTANT			
Rouge Nbr 530002 ** Location:530	Stop Nbr 000 Vehicle 00000 Driver 000											
ATO P4331	MIG NOZZLE 5/8 BRASS BER PRS	EA	5	5	0	0507E	.0	4.40	22.00			
SID 56R09P020	WIRE MS 70S6 035 44# SP PRS	SO	6	6	0	1204A	264.0	51.32	311.52			
	SAFETY DATA SHEET 250001											
LIN ED511105	ELECTR MS 11018M 1/8 5 TD	KG	25	25	0	1204C	55.0	3.69	97.25			
	SAFETY DATA SHEET 540349											
TWE 202135	GROUND CLAMP 500A NSGC-500 PRS	EA	3	3	0	SB010	.0	8.34	25.02			
ARM 55R200	SOAPSTONE HOLDER ROUND 11/CHUCK	EA	3	3	0	SB050	.0	1.54	4.62			
WYP 400-1	SOAPSTONE HOLDER FLAT PRS	EA	2	2	0	SB050	.0	1.04	2.08			
ARD 6108-2208	CARBON TORCH K4000 7" EXTREME	EA	1	1	0	SA050	.0	242.30	242.80			
196255	TRIGGER SWITCH FOR M-15/M-25	EA	2	2	0	0506J	.0	22.14	44.28			
MSC HAZMAT	HAZARDOUS MATERIAL CHARGE	EA	1	1	0	ZZZZZZ	.0	4.95	4.95			
Total Weight 319.0							Subtotal	734.20				
PRAXAIR GST 85753 6637 RT							GST Tax:	51.82				
							Tax:	.00				
							Total Sale	807.42				
OK STOCK JAN 12 05												

ABILITY FOR CUSTOMER TRANSPORT

Praxair hereby warrants that the use of industrial gas cylinders can be hazardous unless certain safety precautions are taken; and is offered to transport gas cylinders to their destination for the Customer.

The Customer hereby acknowledges that:

1. The Customer understands the safety precautions outlined on the safety bulletin (located on the reverse side of this document).

2. The Customer has the authority to sign the acknowledgement and indemnity on behalf of the Customer.

3. The Customer shall indemnify and hold Praxair harmless from and against any losses, claims, damages, judgements, or expenses (including legal fees and expenses) resulting from transportation and use of the cylinders by the Customer.

4. If the Customer detects a leak, then the customer will immediately advise Praxair; and

5. The Customer will comply with all laws governing the transportation of compressed gases.

ENGAGEMENT À INDEMNISER

Le Client reconnaît que:

1. le transport de bouteilles de gaz peut être dangereux si les précautions de sécurité ne sont pas respectées;
2. Praxair lui a offert de livrer les bouteilles de gaz à destination.

Le Client déclare:

1. qu'il a lu et compris les précautions de sécurité faisant l'objet du bulletin de sécurité (au verso des présentes);
2. que le soussigné est autorisé à signer cette Reconnaissance au nom du Client.

Le Client s'engage à:

1. indemniser Praxair et à la tenir à l'abri des pertes, réclamations, dommages, jugements, responsabilités et frais (incluant tous les frais juridiques) résultant du transport et de l'utilisation des bouteilles par le Client;
2. informer immédiatement Praxair dès qu'il constate qu'une bouteille fuit;
3. se conformer à l'ensemble des lois et règlements régissant le transport de gaz comprimés.

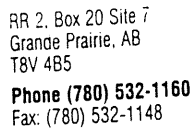
s Signature:/Signature du Client:

Date:

Print Name: / Nom en capitales:

Print Title/Fonctions en capitales:

Witnessed by: /Témoin:



5723

ACADEMY PETROLEUM INDUSTRIES
4066-78 AVE
EDMONTON AB. T6B-3M8

PHONE (730) 466-6360 (730) 466-6390

DATE JANUARY 15, 2005

REFERENCE _____

QC JOB # 10252-P

UNIT # _____

LOCATION G.P. SHOP

JOB # 18252 BLUESTAR

QCI _____ DATE _____

QCM [Signature] DATE 28/05

SHIP TO ADDRESS:

VIA CANADIAN FREIGHTWAY

	SUBTOTAL	100.00
--	----------	--------

GST

TOTAL

SIGNATURE

WHITE - SUPPLIER

YELLOW - OFFICE

PINK - QUALITY CONTROL

6769

12/2/200

7 12 DSA-4 06-10X3.06-10

0

DOUBLE STUDDED ADAPTER
4 1/16" 10,000 BX155 X 3 1/16" 10,000 BX154 X 3.50" THICK
C/W L7M/2HM STUDS AND NUTS
2 For 1356 10x2mm 03 A/B

Piece

\$925.00

\$11,100.00

☐ API 6A ☐ API 16A ☒ ISO ☐ ABPVS

C-3911

Canadian Dollars

Amount:

\$123,300.00

GST:

\$8,631.00

Total:

\$131,931.00

Leslie Larsson

L. Larsson

All prices quoted are F.O.B. Academy Yard, dui and taxes extra unless otherwise noted.

Quote valid for 30 days unless otherwise noted.

☐ API 6A ☐ API 16A ☒ ISO ☐ ABPVS



6A LIC. - 0380
16A LIC. - 0077
API 16C LIC. - 0028

ACADEMY PETROLEUM INDUSTRIES

4066-78 AVENUE, EDMONTON, ALBERTA T6B 3M8
PHONE: (780) 466-6360 FAX: (780) 466-6380
E-mail: acadpet@telusplanet.net



ISO-9001:2000

A B S A REGISTERED

Certificate of Compliance

Date: February 17, 2005	Customer: Bluestar Welding	Academy W/O #: 42543
Part Description: SPECIAL WELD NECK FLANGE 3 1/16 -10,000 BX 154 X 3.50 POW X 2.00 BORE		Cust. P.O. #: WADE
Quantity: 10	Serial #'s: 41078-2	S/O Item #: 2

This is to certify that the above noted part has been:

- Manufactured in accordance with all in-house policies and procedures and in compliance with the customer's requirements and/or specifications and;
- Inspected in accordance with Academy Petroleum Industries Inspection Procedure AP-10 Revision M and found to be acceptable.

The following indicated procedures have been performed and documentation is attached as required:

Procedure		Comments
Dimensional Verification	✓	As per all applicable drawings.
Visual Inspection	✓	
Hardness Testing		See attached report.
Non-Destructive Examination		MPI performed, see attached reports.
Stress Relieving		See attached report.
Hydrostatic Testing		See attached report.
Material Test Reports	✓	See attached reports.

Notes: 9 Pcs. 4130- Heat No. 16089, 1 Pc. 4130-Heat No. W5783


Quality Assurance

Academy Petroleum Industries



API Licensed
Spec 6A-0380
Spec 16A-0077

ACADEMY PETROLEUM INDUSTRIES

4066-78 AVENUE, EDMONTON, ALBERTA T6B-3M8
TELEPHONE: (780) 466-6360 FAX: (780) 466-6380
E-mail: acadpet@telusplanet.net



ISO 9001
Registered
Firm 93-17

ABSA REGISTERED

10252
02/18/05
CPL

Certified Material Test Report

Date: February 3, 2005		Academy W/O #: 42543		Mill Test Report No.: 26796	
Customer: Bluestar Welding				Customer P.O. No.: WADE	
Description: <u>SPECIAL WELD NECK FLANGE 3 1/16 -10,000 BX 154 X 3.50 POW X 2.00 BORE</u>					
API 6A PSL: 1		API Temp Class: K		API Fluid Rating: DD	
API Mat'l Designation: 75K					
Mat'l Grade: <u>AISI 4130</u>		Heat #: <u>16089</u>		Academy Mat'l APP #: 301 E	
Size:					
Mat'l Form: Bar ☐		Casting ☐		Forging ☒	
Other:					

Heat Treatment Specifications

Austenitized: 1600 Deg F for 3 hours
Agitated Water Quench: Start 64 Deg F; Finish 89 Deg F
Tempered: 1200 Deg F for 5 hours

Mechanical Test Results

Property	Results
Yield Strength @ 0.2% Offset (psi)	77,000
Tensile Strength (psi)	103,000
Elongation (% in 2 inches)	23.0
Reduction Of Area (%)	68.0

Property	Results
CVN Impact @ -75°F (ft-lb)	41/44/47
Linear Expansion	
Shear (%)	
Brinell Hardness	228/235

NACE MR0175- compliant: ☒ Yes ☐ No

Chemical Analysis

C	Mn	P	S	Si	Cr	Ni	Mo	Cu	V	Sn	Al			
.30	.53	.010	.015	.23	1.02	.11	.18	.27			.026			

Comments

All mechanical properties are as per Qualification Test Coupon.

We certify that the foregoing is a true and correct report of the values obtained and/or as is contained on file in our records and that they comply with the requirements of the specifications unless noted.

Signed: [Signature] Date: February 3, 2005
Academy Quality Assurance



API 6A LIC - 0380
API 16A LIC - 0077
API 16C LIC - 0028

ACADEMY PETROLEUM INDUSTRIES

4066-78 AVENUE, EDMONTON, ALBERTA T6B 3M8
PHONE: (780) 466-6360 FAX: (780) 466-6380
E-mail: acadpet@telusplanet.net



ISO-9001:2000

A B S A REGISTERED

Certificate of Compliance

Date: February 3, 2005	Customer: Bluestar Welding	Academy W/O #: 42543
Part Description: 3" WELD TEES C/W 3 1/2 POW X 2" BORE C/W CUSHION		Cust. P.O. #: WADE
Quantity: 12	Serial #'s: 42543-4	S/O Item #: 4

This is to certify that the above noted part has been:

- Manufactured in accordance with all in-house policies and procedures and in compliance with the customer's requirements and/or specifications and;
- Inspected in accordance with Academy Petroleum Industries Inspection Procedure AP-10 Revision M and found to be acceptable.

The following indicated procedures have been performed and documentation is attached as required:

Procedure		Comments
Dimensional Verification	✓	As per all applicable drawings.
Visual Inspection	✓	
Hardness Testing		See attached report.
Non-Destructive Examination		MPI performed, see attached reports.
Stress Relieving		See attached report.
Hydrostatic Testing		See attached report.
Material Test Reports	✓	See attached reports.

Notes:


Quality Assurance

Academy Petroleum Industries



API Licensed
Spec 6A-0380
Spec 16A-0077

ACADEMY PETROLEUM INDUSTRIES

4066-78 AVENUE, EDMONTON, ALBERTA T6B-3M8
TELEPHONE: (780) 466-6360 FAX: (780) 466-6380
E-mail: acadpet@telusplanet.net

ABSA REGISTERED



ISO 9001
Registered
Firm 93-17

10252-P
02/04/05
C266

Certified Material Test Report

Date: February 3, 2005		Academy W/O #: 42543		Mill Test Report No.: 26159	
Customer: Bluestar Welding				Customer P.O. No.: WADE	
Description: 3" WELD TEES C/W 3 1/2 POW X 2" BORE C/W CUSHION					
API 6A PSL: 1		API Temp Class: L		API Fluid Rating: DD	
API Mat'l Designation: 75K					
Mat'l Grade: 4130		Heat #: LV9399		Academy Mat'l APP #: 301 E	
Size:					
Mat'l Form:		Bar ☐		Casting ☐	
		Forging ☐		Other: SQ	

Heat Treatment Specifications

Normalized @ 1650 F / 17.00 hrs Air Cool
Austenitized @ 1600 F / 21.00 hrs
Tempered @ 1225F / 20.00 hrs Air Cool
Water Quench Start @ 84F, End @ 98 F

Mechanical Test Results

Property	Results
Yield Strength @ 0.2% Offset (psi)	87,400
Tensile Strength (psi)	104,500
Elongation (% in 2 inches)	25.0
Reduction Of Area (%)	68.0

Property	Results
CVN Impact @ -75°F (ft-lb)	30/34/34
Linear Expansion	18/22/22
Shear (%)	20/25/25
Brinell Hardness	212/223

NACE MR0175 compliant: ☒ Yes ☐ No

Chemical Analysis

C	Mn	P	S	Si	Cr	Ni	Mo	Cu	V	Sn	Al	Ti		
.30	.48	.01	.008	.24	1.00	.17	.19	.14	.038		.024	.019		

Comments

All mechanical properties are as per Qualification Test Coupon.
Electric Furnace - Fine Grain

We certify that the foregoing is a true and correct report of the values obtained and/or as is contained on file in our records and that they comply with the requirements of the specifications unless noted.

igned: [Signature] Date: February 3, 2005
Academy Quality Assurance



API 6A LIC. - 0380
API 16A LIC. - 0077
API 16C LIC. - 0028

ACADEMY PETROLEUM INDUSTRIES

4066-78 AVENUE, EDMONTON, ALBERTA T6B 3M8
PHONE: (780) 466-6360 FAX: (780) 466-6380
E-mail: acadpet@telusplanet.net



ISO-9001 2000

A B S A REGISTERED

Certificate of Compliance

Date: February 14, 2005	Customer: Bluestar Welding	Academy W/O #: 42543
Part Description: 3" WELD TEES C/W 3 1/2 POW X 2" BORE		Cust. P.O. #: 37555
Quantity: 6	Serial #'s: 42543-5-ACD	S/O Item #: 5

This is to certify that the above noted part has been:

- Manufactured in accordance with all in-house policies and procedures and in compliance with the customer's requirements and/or specifications and;
- Inspected in accordance with Academy Petroleum Industries Inspection Procedure AP-10 Revision M and found to be acceptable.

The following indicated procedures have been performed and documentation is attached as required:

Procedure		Comments
Dimensional Verification	✓	As per all applicable drawings.
Visual Inspection	✓	
Hardness Testing		See attached report.
Non-Destructive Examination		MPI performed, see attached reports.
Stress Relieving		See attached report.
Hydrostatic Testing		See attached report.
Material Test Reports	✓	See attached reports.

Notes:


Quality Assurance

Academy Petroleum Industries



API Licensed
Spec 6A-0380
Spec 16A-0077

ACADEMY PETROLEUM INDUSTRIES

4066-78 AVENUE, EDMONTON, ALBERTA T6B-3M8
TELEPHONE: (780) 466-6360 FAX: (780) 466-6380
E-mail: acadpet@telusplanet.net

ABSA REGISTERED



ISO 9001
Registered
Firm 93-17

Certified Material Test Report

Date: February 14, 2005		Academy W/O #: 42543		Mill Test Report No.: 26159	
Customer: Academy Petroleum Industries				Customer P.O. No.: WADE	
Description: 3" WELD TEES C/W 3 1/2 POW X 2" BORE					
API 6A PSL: 1		API Temp Class: L		API Fluid Rating: DD	
API Mat'l Designation: 75K					
Mat'l Grade: 4130		Heat #: LV9399		Academy Mat'l APP #: 301 E	
Size:					
Mat'l Form:		Bar ☐		Casting ☐	
		Forging ☐		Other: SQ	

Heat Treatment Specifications

Normalized @ 1650 F / 17.00 hrs Air Cool
Austenitized @ 1600 F / 21.00 hrs
Tempered @ 1225F / 20.00 hrs Air Cool
Water Quench Start @ 84F, End @ 98 F

Mechanical Test Results

Property	Results
Yield Strength @ 0.2% Offset (psi)	87,400
Tensile Strength (psi)	104,500
Elongation (% in 2 inches)	25.0
Reduction Of Area (%)	68.0

Property	Results
CVN Impact @ -75°F (ft-lb)	30/34/34
Linear Expansion	18/22/22
Shear (%)	20/25/25
Brinell Hardness	212/223

NACE MR0175 compliant: ☒ Yes ☐ No

Chemical Analysis

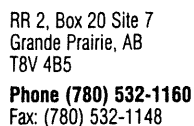
C	Mn	P	S	Si	Cr	Ni	Mo	Cu	V	Sn	Al	Ti		
.30	.48	.01	.008	.24	1.00	.17	.19	.14	.038		.024	.019		

Comments

All mechanical properties are as per Qualification Test Coupon.
Electric Furnace - Fine Grain

We certify that the foregoing is a true and correct report of the values obtained and/or as is contained on file in our records and that they comply with the requirements of the specifications unless noted.

Red:  Date: February 14, 2005
Academy Quality Assurance



5725

DATE FEBRUARY 1, 2005

REFERENCE

QC JOB # 10252-P

UNIT #

PHONE 532-1160

LOCATION G.P. SHOP

JOB # 10252 BLUESTAR

QCI _____ DATE _____

QCM [Signature] DATE Feb 28/05

TO ADDRESS: _____ VIA BLUESTAR

SIGNATURE _____

SUBTOTAL	
GST	
TOTAL	



PH (780) 532-1160
FAX (780) 532-1148

RR #2, SITE 7, BOX 20
GRANDE PRAIRIE, AB
T8V 2Z9
www.bluestarwelding.com

Bill To: BLUESTAR WELDING

Date: FEBRUARY 1, 2005

P.O. / AFE #: 5725

Ship To:
Puri ENERGY
JOB #10252-P

Quantity	Description
20'	3 1/2" ⁰⁰ X 2.0" ID. SEAMLESS PIPE API AISI 4130 HT# 4M 46839
	JOB #10252-BLUESTAR QCI _____ DATE _____ QCM <i>[Signature]</i> DATE <i>Feb 28 / 05</i>

e: 1 of 4
 1 Singleton (CS)
 ESTAR WELDING
 5715
 30499



PLYMOUTH TUBE CO- MATERIAL TEST REPORT

572 W. State Road 14 Winamac, IN 46996 CS FORM #12 Date 9/26/03
 voice: 574-946-3125 fax: 574-946-3154
 ISO/TS 16949:2002 Quality Management System Registered thru ABS Quality Eval.
 ABS Certificate # 74162 IATF Certificate # 6017842 (9/8/03)

Date: 07/28/04		Customer P.O.: 97773-PB		Order No: 35-15422		Signature: <i>[Signature]</i>		Lab Tech		Page: 1 of 1											
Customer: TUBE SUPPLY, INC. 5169 ASHLEY COURT HOUSTON TX 77041				Specification(s): ASTM A-519-03 GR:4130 Grade: 4130				Melt Source: MACSTEEL Method of Manufacture: ELECTRIC ARC FURNACE MELTED AIRCRAFT QUALITY CONTINUOUS CAST NOT FINISHED SEAMLESS													
Product Description: 3.500" OD X .765" AW								AS ROLLED													
CHEMICAL COMPOSITION (% WT.)																					
Heat No.	Sample	C	Mn	P	S	Si	Al	Cr	Mo	Ni	Pb	Cu	V	Ti	Sn	Zn	Nb	Te	Ca	O	N
AM46839	Ladle	.29	.57	.012	.008	.19	.017	.37	.19	.13		.23	.003		.008		.002		.0002		.0068
	Product 1	.32	.60	.0122	.0021	.20	.0161	.38	.19	.13		.21	.0026	.0100	.0019						
	Product 2	.32	.58	.014	.0102	.22	.0184	.38	.19	.14		.24	.0026	.0100	.0019						
MECHANICAL PROPERTIES																					
Heat No.	Tensile (ksi)	Yield (ksi)	Elong (in 2")	RA/A	Tensile (ksi)	Yield (ksi)	Elong (in 2")	RA/A	Hardness (Hb)	Flat	Rev. Flat	Flare	Flange	Expand	Bend	Crash					
AM46839	107.4	80.9	27						217 217												
METALLURGICAL PROPERTIES																					
Heat No.	J1	J2	J3	J4	J5	J6	J7	J8	J9	J10	J11	J12	Macroetch Results			Grain Size		Decarburization			
AM46839	50	50	48	45	41	37	35	33	32	30	28	27	S	R	C	1	1	2	7	CO	ID
Heat No.	AT	AN	BT	BN	CT	CN	DT	DN	ET	EN	FT	FN	Mag. Particle Cleanliness		Frequency		Severity				
AM46839													0.000		0.000						

Material was manufactured in accordance with the Winamac Quality System Manual 1st Edition, Revision 02, Dated 9/29/03. We certify this material to be Mercury-free.
 We hereby certify that the described material has been manufactured, inspected, and tested in accordance with the above specification(s) and satisfies the requirements.

4M46839

P# 1

10252-P
 FEB 1. 2005
 C/M

TEXAS STEEL CONVERSION, INC

QUALITY TEST REPORT

CUSTOMER: TUBE SUPPLY

TEST # 71507-B

SO# 269/1629A SIZE : 3.500X0.765

LOT # 269019

PO# 98449

UPSET: PE

HEAT # 4M46839

MILL: PLIMOUTH-

GRADE: N/L80

.5% EUL

MFG. PROC. : SMLS

MACSTEEL

SPEC : API:5CT(7th edition)

HEAT TREAT: OQT

ISO:11960(2001)

JTS/LOT : 29

T.S.

TENSILE TEST

DIMENSIONS (Inches)	AREA (Sq. In.)	YIELD STRENGTH (lbs/Sq. In.)	TENSILE STRENGTH (lbs/Sq. In.)	% ELONG (IN 2")	ROA (%)
0.752x0.760	0.580	83500	100600	32.6	72.0

BODY TYPE: LONGITUDINAL STRIP

UPSET HARDNESS VARIATION (HRC)

QUADRANT	1	2	3	4
O.D. VALUE	17.5	17.0	17.0	17.7
M.I. VALUE	15.9	17.2	17.0	17.5
I.D. VALUE	15.6	15.6	15.8	15.4



CHARPY IMPACT TEST

CHARPY TYPE	IMPACT (ft/lbs)	LATERAL EXPANSION (mil.)	FRACTURE (% D/F)
LOCATION: BODY-MID WALL	96.0	57	90
TESTED AT -50°F	95.0	55	95
SIZE: 10X10 mm	99.0	59	95
ORIENTATION: LONGITUDINAL	96.7		
Average			

CHEMICAL PRODUCT ANALYSIS

	C	Si	Mn	P	S	Cr	Mo	Ni	V	Al	Nb	Sn	Ti	Cu	Ca	B
1	.32	.19	.56	.013	.009	.95	.19	.12	.004	.019	.002	.008	.003	.22	.0022	.0004

Daniel M.
 Daniel Mendoza
 Lab Technician

DATE

10-15-04

3101 Holmes Road, Houston, TX 77051-1199, Tel: (713) 733-6013, FAX: (713) 733-9248, Form OCTO. 05/27/03, Rev. 15

TEXAS STEEL CONVERSION, INC

QUALITY TEST REPORT

CUSTOMER: TUBE SUPPLY

TEST # 71507-F

SO# 269/1629A SIZE : 3.500X0.765 LOT # 269019
 PO# 98449 UPSET: PE HEAT # 4M46839
 MILL: PLYMOUTH- GRADE: N/L80 .5% EUL MFG. PROC. : SMLS
 MACSTEEL SPEC : API:5CT(7th edition) HEAT TREAT: Q&T
 ISO:11960(2001) # JTS/LOT : 29
 T.S.

TENSILE TEST
 DIMENSIONS AREA YIELD STRENGTH TENSILE STRENGTH % ELONG ROA
 (Inches) (Sq. In.) (lbs/Sq. In.) (lbs/Sq. In.) (in 2") (%)
 0.776X0.730 0.574 83600 101300 32.9 72.8

BODY TYPE: LONGITUDINAL STRIP

TENSILE SPECIMEN HARDNESS VALUES (HRC)

O.D. 16.2
 MID. 15.7
 I.D. 15.5



CHEMICAL PRODUCT ANALYSIS

	C	Si	Mn	P	S	Cr	Mo	Ni	V	Al	Nb	Sn	Ti	Cu	Ca	B
%	.32	.19	.56	.015	.010	.95	.19	.13	.003	.018	.001	.009	.003	.22	.0022	.0005

Daniel H. 10-15-04
 Daniel Mendoza
 Lab Technician DATE

3101 Holmes Road, Houston, TX 77031-1199. Tel: (713) 733-6013. Fax: (713) 733-9248. Form QC10. 05/27/03. Rev 65



I 6A LIC - 0380
API 16A LIC - 0077
API 16C LIC - 0028

ACADEMY PETROLEUM INDUSTRIES

4066-78 AVENUE, EDMONTON, ALBERTA T6B 3M8
PHONE: (780) 466-6360 FAX: (780) 466-6380
E-mail: acadpet@telusplanet.net



ISO-9001:2000

A B S A REGISTERED

Certificate of Compliance

Date: February 17, 2005	Customer: Bluestar Welding	Academy W/O #: 42543
Part Description: DOUBLE STUDDED ADAPTER 4 1/16" 10,000 BX155 X 3 1/16" 10,000 BX154 X 3.50" THICK		Cust. P.O. #: 37555
Quantity: 4	Serial #'s: 42543-7-ACD-7 to 10	S/O Item #: 7

This is to certify that the above noted part has been:

- Manufactured in accordance with all in-house policies and procedures and in compliance with the customer's requirements and/or specifications and;
- Inspected in accordance with Academy Petroleum Industries Inspection Procedure AP-10 Revision M and found to be acceptable.

The following indicated procedures have been performed and documentation is attached as required:

Procedure		Comments
Dimensional Verification	✓	As per all applicable drawings.
Visual Inspection	✓	
Hardness Testing		See attached report.
Non-Destructive Examination		MPI performed, see attached reports.
Stress Relieving		See attached report.
Hydrostatic Testing		See attached report.
Material Test Reports	✓	See attached reports.

Notes:


Quality Assurance

Academy Petroleum Industries



1 6A LIC. - 0380
16A LIC. - 0077
16C LIC. - 0028

ACADEMY PETROLEUM INDUSTRIES

4066-78 AVENUE, EDMONTON, ALBERTA T6B 3M8

PHONE: (780) 466-6360 FAX: (780) 466-6380

E-mail: acadpet@telusplanet.net



ISO-9001 2000

A B S A REGISTERED

Certified Material Test Report

Date: February 16, 2005	Academy W/O #: 42543	Mill Test Report No.: 28428
Customer: Bluestar Welding		Customer P.O. No.: WADE
Description: D. S. A 4 1/16" 10,000 BX155 X 3 1/16" 10,000 BX154 X 3.50" THICK		
API 6A PSL: 1	API Temp Class: L	API Fluid Rating: DD
API Mat'l Designation: 75K		
Mat'l Grade: 4130	Heat #: 308554	Academy Mat'l APP #: 301 E
Size: 13.25		
Mat'l Form:	Bar ☒	Casting ☐
Forging ☒		Other:

Heat Treatment Specifications

Normalize 1650 F / 8Hrs Air Cool

Austenitize 1575 F / 12 Hrs

Temper 1200 F / 14 Hrs

Mechanical Test Results

Property	Results
Yield Strength @ 0.2% Offset (psi)	92700
Tensile Strength (psi)	113700
Elongation (% in 2 inches)	23.8
Reduction Of Area (%)	69.7

Property	Results
CVN Impact @ -75°F (ft-lb)	45-46-41
Linear Expansion	24.6-26.3-24.5
Shear (%)	40-40-30
Brinell Hardness	223/229

NACE MR0175 compliant: ☒ Yes ☐ No

Chemical Analysis

C	Mn	P	S	Si	Cr	Ni	Mo	Cu	V	Sn	Al			
0.320	0.600	0.010	0.010	0.230	0.980	0.160	0.230	0.120	0.010	-	0.014			

Comments

All mechanical properties are as per Qualification Test Coupon.

We certify that the foregoing is a true and correct report of the values obtained and/or as is contained on file in our records and that they comply with the requirements of the specifications unless noted.

Signature: _____ Date: February 16, 2005
Academy Quality Assurance



1 6A LIC. - 0380
1 16A LIC. - 0077
1 6C LIC. - 0028

ACADEMY PETROLEUM INDUSTRIES

4066-78 AVENUE, EDMONTON, ALBERTA T6B 3M8

PHONE: (780) 466-6360 FAX: (780) 466-6380

E-mail: acadpet@telusplanet.net



ISO-9001:2000

A B S A REGISTERED

Certified Material Test Report

Date: February 17, 2005		Academy W/O #: 42543		Mill Test Report No.: 28618	
Customer: Bluestar Welding				Customer P.O. No.: WADE	
Description: (D. S. A. 4 1/16" 10,000 BX155 X 3 1/16" 10,000 BX154 X 3.50" THICK (Qty. 1 Pc))					
API 6A PSL: 3		API Temp Class: L		API Fluid Rating: DD	
API Mat'l Designation: 75K					
Mat'l Grade: 4130		Heat #: 22217-4T		Academy Mat'l APP #: 301 F	
Size: 12.71					
Mat'l Form: Bar ☒ Casting ☐ Forging ☐ Other: ☐					

Heat Treatment Specifications

Normalizing 1650 Deg. F / 18 hrs
Quenching 1600 Deg. F / 16 hrs
water Quench temp. @ start 38 Deg. F / @ end 57 Deg. F
Tempering 1200 Deg. F / 24 hrs

Mechanical Test Results

Property	Results
Yield Strength @ 0.2% Offset (psi)	87600
Tensile Strength (psi)	106750
Elongation (% in 2 inches)	23.5
Reduction Of Area (%)	65.9

Property	Results
CVN Impact @ -75°F (ft-lb)	36-32-30
Linear Expansion	
Shear (%)	30-30-30
Brinell Hardness	217/223

NACE MR0175 compliant: ☒ Yes ☐ No

Chemical Analysis

C	Mn	P	S	Si	Cr	Ni	Mo	Cu	V	Sn	Al			
0.310	0.510	0.012	0.005	0.230	1.060	0.140	0.230	0.140	0.021	-	0.012			

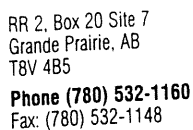
Comments

All mechanical properties are as per Qualification Test Coupon.

We certify that the foregoing is a true and correct report of the values obtained and/or as is contained on file in our records and that they comply with the requirements of the specifications unless noted.

igned:  Date: February 17, 2005

Academy Quality Assurance



5849

A. R. THOMPSON

DATE FEBRUARY 22, 2005

REFERENCE BSC 10K 2mm - 03 A/B.

QC JOB # 10252-P

UNIT #

LOCATION G.P. SHOP

JE 538-1792

[illegible]

TO DRESS:

VIA BLUESTAR

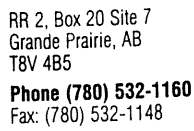
NATURE

CLL

WHITE - SUPPLIER

YELLOW - OFFICE

PINK - QUALITY CONTROL



5843

BARON OILFIELD SUPPL

REFERENCE

UNIT #

LOCATION G.P. SHOP

JOB # 10252 **BLUESTAR**

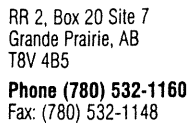
QCI _____ DATE _____

QCM/ gfw _____ DATE Feb 28 / 25

VIA BLUNSTAD

C. L. L.

TOTAL



5980

ACADEMY PETROLEUM INDUSTRIES

4066-79 AVE

EDMONTON T6B-3MB

(790)

PHONE

~~52-10000~~ 466-6360

DATE FEB 12-2005

REFERENCE

QC JOB #

10252-P

UNIT #

LOCATION

G.P. SHOP

SHIP TO ADDRESS: ABOVE ADDRESS

VIA CANADIAN FREIGHTWAY

SIGNATURE

WHITE - SUPPLIER

YELLOW - OFFICE

PINK - QUALITY CONTROL



API Licenced Spec 6A-0380 Spec 16A-0077
ABSA Registered

Academy Petroleum Industries

4066-78 Ave, Edmonton, AB, T6B 3M8
Telephone: (780) 466-6360 Fax: (780) 466-6380
Email: acadpet@telusplanet.net



ISO 9001 Registered Firm
ABSA Registered

Packing List #

13644

Packing List

Date:

2/28/2005

Sold To: **Bluestar Welding**
Box 20, site 7, R.R. # 2

Ship To:

Grande Prairie AB T8V 2Z9
Phone: (780)532-1160 Ext
Fax: (780)532-1148 Ext

Phone:
Fax:

Delivery Date	Orig Order Date	Shipped Via	Ship Date	Ord Taken/Sh	W/O #	SO #	Customer	Payment Term	Contract	Customer PO
---------------	-----------------	-------------	-----------	--------------	-------	------	----------	--------------	----------	-------------

RUSH 2/12/2005 Customer 2/28/2005 Syed Rizvi **42760 37776** BLU002

WADE

#	Part#	Qnts/Yours	Ord	Ship	B/O	Description	Unit	S/Unit	Total
1	XWECO-3.06-10X2-1502M	3	1	2		FLANGED X WECO 3 1/16" 10,000 BX154 X 2" FIG. 1502 MALE C/W NUT, SEGMENTS & SNAP RING 75K PSL 1 L DD NACE MRO175-99 HYDRO-TESTED 15,000 PSI	Loc:		Bin:
2	XWECO03.06-10X2-1502F	3	1	2		FLANGED X WECO 3 1/16" 10,000 BX154 X 2" FIG. 1502 FEMALE C/W SEAL RING 4130 75K PSL 1 L DD API 6A NACE MRO175-99 HYDRO-TESTED 15,000 PSI	Loc:		Bin:

General Notes: This Document Generated from SalesOrder 37776

Ship Notes:

Picked Up by:

(Please Print)

Signature:

PickUp Date:

Approved By: Syed Rizvi

Signature:



API 6A LIC. - 0380
API 16A LIC. - 0077
API 16C LIC. - 0028

ACADEMY PETROLEUM INDUSTRIES

4066-78 AVENUE, EDMONTON, ALBERTA T6B 3M8
PHONE: (780) 466-6360 FAX: (780) 466-6380
E-mail: acadpet@telusplanet.net



ISO-9001 2000

A B S A REGISTERED

Certified Material Test Report

Date: February 23, 2005		Academy W/O #: 42760		Mill Test Report No.: 28188-1	
Customer: Bluestar Welding				Customer P.O. No.: N/A	
Description: FLANGED X WECO 3 1/16" 10,000 BX154 X 2" FIG. 1502 MALE					
API 6A PSL: 3		API Temp Class: L		API Fluid Rating: DD	
API Mat'l Designation: 75K					
Mat'l Grade: 4130		Heat #: A3989		Academy Mat'l APP #: 301 E	
Size: 10.71					
Mat'l Form: Bar ☒ Casting ☐ Forging ☐ Other: ☐					

Heat Treatment Specifications

Water Quench @ 1652 F / 6.50 hrs
Temper @ 1238 F / 9.00 hrs
Stress Relieved @ 1184 F / 10.75 Hrs
Starting And Ending Water Quench Temperature Do Not Exceed 100F

Mechanical Test Results

Property	Results
Yield Strength @ 0.2% Offset (psi)	77,140
Tensile Strength (psi)	100,630
Elongation (% in 2 inches)	24.0
Reduction Of Area (%)	51.0

Property	Results
CVN Impact @ -75°F (ft-lb)	54.2/52.4/50
Linear Expansion	
Shear (%)	
Rockwell C Hardness	18.1/19.3

NACE MR0175 compliant: ☒ Yes ☐ No

Chemical Analysis

C	Mn	P	S	Si	Cr	Ni	Mo	Cu	V	Sn	Al			
.314	.541	.009	.007	.277	1.068	.172	.232	.142	.004					

Comments

All mechanical properties are as per Qualification Test Coupon.
Electric furnace - VD

We certify that the foregoing is a true and correct report of the values obtained and/or as is contained on file in our records and that they comply with the requirements of the specifications unless noted.

Signed: _____ Date: February 23, 2005

Academy Quality Assurance



API 6A LIC. - 0380
API 16A LIC. - 0077
API 16C LIC. - 0028

ACADEMY PETROLEUM INDUSTRIES

4066-78 AVENUE, EDMONTON, ALBERTA T6B 3M8
PHONE: (780) 466-6360 FAX: (780) 466-6380
E-mail: acadpet@telusplanet.net



ISO-9001:2000

A B S A REGISTERED

Hardness Inspection Report

Date: February 28,2005	Customer: Bluestar Welding	Academy W/O #: 42760
Part Description: FLANGED X WECO 3 1/16" 10,000 BX154 X 2" FIG. 1502 MALE C/W NUT, SEGMENTS & SNAP RING		Cust. P.O. #: N/A
Reference Drawing/Sheet: ☐ Attached ☐ N/A		Part #/ Serial #: 42760-1-ACD-1

Examination Standard: ASTM E-10 or ASTM E-18

Acceptance Standard: ☒ API Specification 6A 19th Edition (see Table 11 for applicable section)
☐ API Specification 16A Third Edition (Section 8.5.1.4)
☐ API Specification 16C First Edition (Section 6.3.6.4.1)
☒ NACE MR0175 Latest Edition

Dwg Ref. # or Location	Brinell Hardness					Comments
	Parent Metal	HAZ	Weld Metal	HAZ	Parent Metal	
ACD-1	230					

Interpretation is done in accordance with the above mentioned standards. As this is a subjective analysis the final interpretation of these measurements is the responsibility of the customer.


Quality Assurance

Academy Petroleum Industries



API 6A LIC. - 0380
API 16A LIC. - 0077
API 16C LIC. - 0028

ACADEMY PETROLEUM INDUSTRIES

4066-78 AVENUE, EDMONTON, ALBERTA T6B 3M8
PHONE: (780) 466-6360 FAX: (780) 466-6380
E-mail: acadpet@telusplanet.net



ISO-9001:2000

A B S A REGISTERED

Certificate of Compliance

Date: February 28, 2005	Customer: Bluestar Welding	Academy W/O #: 42760
Part Description: FLANGED X WECO 3 1/16" 10,000 BX154 X 2" FIG. 1502 MALE C/W NUT, SEGMENTS & SNAP RING		Cust. P.O. #: N/A
Quantity: 1	Serial #'s: 42760-1-ACD-1	S/O Item #: 1

This is to certify that the above noted part has been:

- Manufactured in accordance with all in-house policies and procedures and in compliance with the customer's requirements and/or specifications and;
- Inspected in accordance with Academy Petroleum Industries Inspection Procedure AP-10 Revision M and found to be acceptable.

The following indicated procedures have been performed and documentation is attached as required:

Procedure		Comments
Dimensional Verification	✓	As per all applicable drawings.
Visual Inspection	✓	
Hardness Testing	✓	See attached report.
Non-Destructive Examination		MPI performed, see attached reports.
Stress Relieving		See attached report.
Hydrostatic Testing	✓	See attached report.
Material Test Reports	✓	See attached reports.

Notes:


Quality Assurance

Academy Petroleum Industries

Rev.2



ACADEMY PETROLEUM INDUSTRIES

4066-78 AVENUE, EDMONTON, ALBERTA T6B 3M8

PHONE: (780) 466-6360 FAX: (780) 466-6380

E-mail: acadpet@telusplanet.net



ISO-9001:2000

API 6A LIC. - 0380
API 16A LIC. - 0077
6C LIC. - 0028

A B S A REGISTERED

Hydrostatic Pressure Test Certificate

Customer: Bluestar Welding		Cust. P.O. #: N/A	Academy W/O #: 42760
Part Description: FLANGED X WECO 3 1/16" 10,000 BX154 X 2" FIG. 1502 MALE C/W NUT, SEGMENTS & SNAP RING			
Part #:	Serial #: 42760-1-ACD-1	Working Pressure (psi): 10000	
Hydrostatic Test Spec:		☒ API 6A (Section 7.4.9.3.3) ☐ ASME B16.5 (Section 8.3) ☐ API 16A (Section 8.5.8.6) ☐ Other ☐ API 16C (Section 6.4.4) ☐ As per Customer Requirements	
Flange Type: ☒ API ☐ ANSI ☐ Other		API 6A PSL: ☒ 1 ☐ 2 ☐ 3 ☐ N/A	
Recording Device: Clif Mock Model MFG4587 (Serial #CS-081)			
Description of Tested Components			
Component (body, flange, EFSO, etc.)	Material Grade & Yield Strength	Heat #	
Body	4130-75K	A3989	
Hydrostatic Test			
Required Test Pressure (psi)	Actual Test Pressure (psi)	Req'd Test Duration (min.)	Actual Test Duration (min.)
15000	15100	3	3.5 min
15000	15200	3	3.5 min
Comments			
No visible leakage at time of test.			

We hereby certify that the above tests have been conducted and that the results satisfy the applicable specification at the time of testing.

Tested By: <i>[Signature]</i>	Date: Feb 28/05
Academy Quality Assurance:	Date:

American Block Mfg Co

PO Box 1245

Houston, TX

77251-1245

Phone: (800) 572-9087 Fax : (281) 820-3861

MILL TEST REPORT

Date: 02/17/05

10:12:19

Heat Code:

Mill Heat#:

Item Description:

Specification:

Raw Description:

4J7

4J7

2# FIG 1502 WING NUT

FORGING

4130

Chemical Analysis:

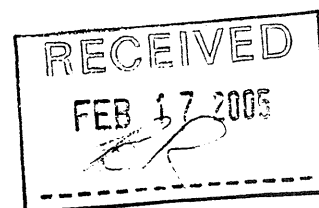
C:	0.330	MN:	0.530	P:	0.021	S:	0.025
SI:	0.210	CR:	1.030	NI:	0.000	CU:	0.000
MO:	0.170	CO:	0.000	AL:	0.000	V:	0.000
CB/NB:	0.000	TI:	0.000	W:	0.000	FE:	0.000
SR:	0.000	ZN:	0.000	SN:	0.000	CE:	0.658

Mechanical Tests:

Yield PSI:	86776	Yield MPA:	598
Tensile PSI:	109064	Tensile MPA:	752
Elongation:	21	Reduction:	59.0
BHN Hard:	234	Charpy Temp:	-50 C
Charpy 1:	40.0	Charpy 2:	38.0
Charpy 3:	38.0	Charpy 2:	38.7

Other Tests:

Heat Treatment Process Type: NQT

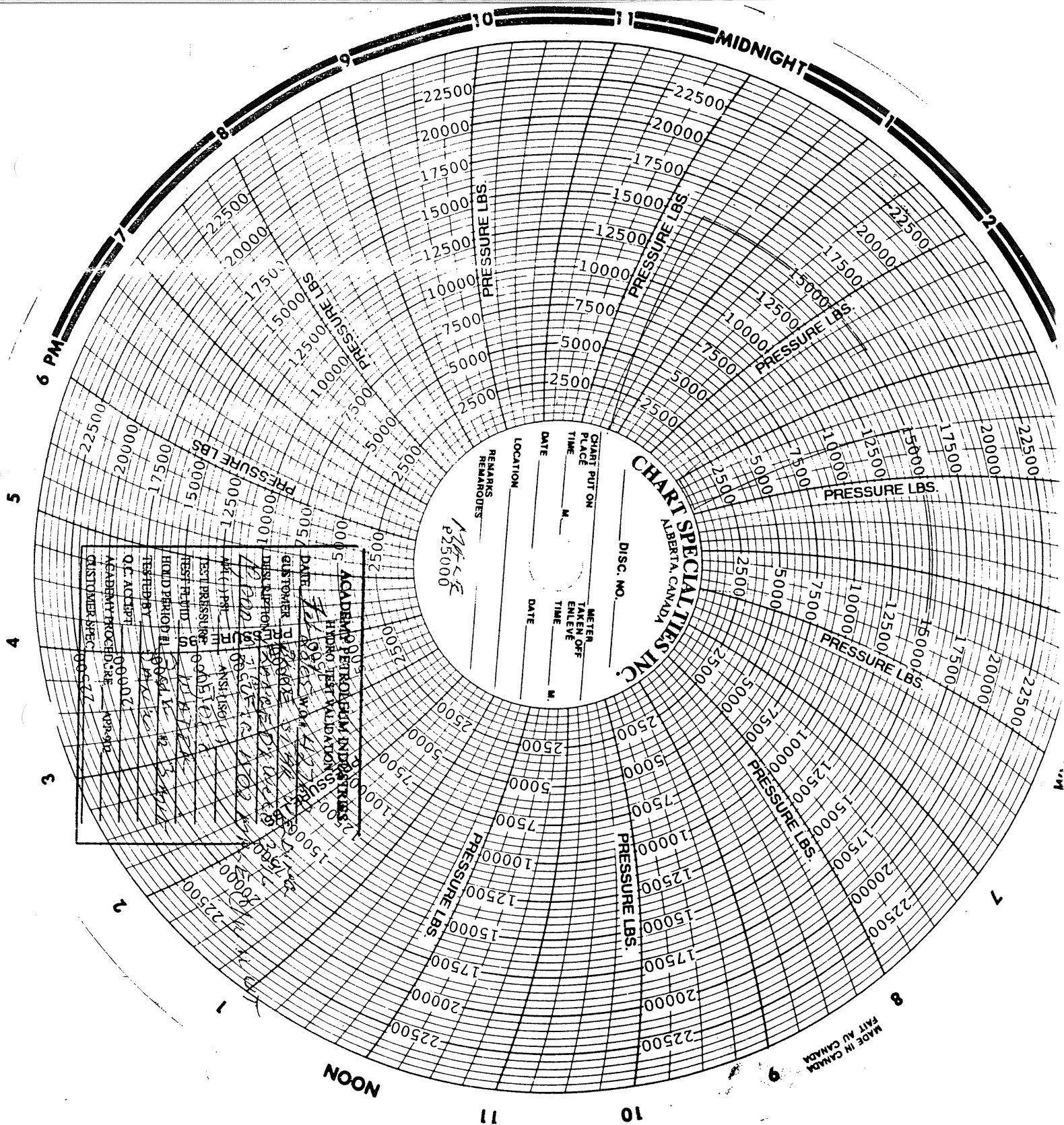
**Certification:**

Note: Specimen size 10 x 10 mm below the surface thickness up to 50 mm while at T/4 for greater thickness.

Heat Treat Condition: Normalized at 890 C for 3 Hrs. in air then cooling in still air from 890 C to 100 C temp.

We certify that this is a true & correct copy of the mill certificate, issued by the manufacturer of the steel employed or the laboratory which has determined it, as retained in the records of the company. ABCO makes no representation beyond those of the manufacturer or it's agent.

MTE 28810





API 6A LIC. - 0380
API 16A LIC. - 0077
API 16C LIC. - 0028

ACADEMY PETROLEUM INDUSTRIES

4066-78 AVENUE, EDMONTON, ALBERTA T6B 3M8

PHONE: (780) 466-6360 FAX: (780) 466-6380

E-mail: acadpet@telusplanet.net



ISO-9001:2000

A B S A REGISTERED

Certified Material Test Report

Date: February 23, 2005		Academy W/O #: 42760		Mill Test Report No.: 28188-1	
Customer: Bluestar Welding				Customer P.O. No.: N/A	
Description: FLANGED X WECO 3 1/16" 10,000 BX154 X 2" FIG. 1502 FEMALE					
API 6A PSL: 3		API Temp Class: L		API Fluid Rating: DD	
API Mat'l Designation: 75K					
Mat'l Grade: 4130		Heat #: A3989		Academy Mat'l APP #: 301 E	
Size: 10.71					
Mat'l Form: Bar ☒ Casting ☐ Forging ☐ Other:					

Heat Treatment Specifications

Water Quench @ 1652 F / 6.50 hrs

Temper @ 1238 F / 9.00 hrs

Stress Relieved @ 1184 F / 10.75 Hrs

Starting And Ending Water Quench Temperature Do Not Exceed 100F

Mechanical Test Results

Property	Results
Yield Strength @ 0.2% Offset (psi)	77,140
Tensile Strength (psi)	100,630
Elongation (% in 2 inches)	24.0
Reduction Of Area (%)	51.0

Property	Results
CVN Impact @ -75°F (ft-lb)	54.2/52.4/50
Linear Expansion	
Shear (%)	
Rockwell C Hardness	18.1/19.3

NACE MR0175 compliant: ☒ Yes ☐ No

Chemical Analysis

C	Mn	P	S	Si	Cr	Ni	Mo	Cu	V	Sn	Al			
.314	.541	.009	.007	.277	1.068	.172	.232	.142	.004					

Comments

All mechanical properties are as per Qualification Test Coupon.
Electric furnace - VD

We certify that the foregoing is a true and correct report of the values obtained and/or as is contained on file in our records and that they comply with the requirements of the specifications unless noted.

Signed: _____ Date: February 23, 2005

Academy Quality Assurance



API 6A LIC. - 0380
API 16A LIC. - 0077
API 16C LIC. - 0028

ACADEMY PETROLEUM INDUSTRIES

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ISO-9001:2000

A B S A REGISTERED

Certificate of Compliance

Date: February 28, 2005	Customer: Bluestar Welding	Academy W/O #: 42760
Part Description: FLANGED X WECO 3 1/16" 10,000 BX154 X 2" FIG. 1502 FEMALE C/W SEAL RING		Cust. P.O. #: N/A
Quantity: 1	Serial #'s: 42760-2-ACD-1	S/O Item #: 2

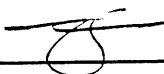
This is to certify that the above noted part has been:

- Manufactured in accordance with all in-house policies and procedures and in compliance with the customer's requirements and/or specifications and;
- Inspected in accordance with Academy Petroleum Industries Inspection Procedure AP-10 Revision M and found to be acceptable.

The following indicated procedures have been performed and documentation is attached as required:

Procedure		Comments
Dimensional Verification	✓	As per all applicable drawings.
Visual Inspection	✓	
Hardness Testing	✓	See attached report.
Non-Destructive Examination		MPI performed, see attached reports.
Stress Relieving		See attached report.
Hydrostatic Testing	✓	See attached report.
Material Test Reports	✓	See attached reports.

Notes:


Quality Assurance

Academy Petroleum Industries



API 6A LIC. - 0380
API 16A LIC. - 0077
API 16C LIC. - 0028

ACADEMY PETROLEUM INDUSTRIES

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PHONE: (780) 466-6360 FAX: (780) 466-6380
E-mail: acadpet@telusplanet.net



ISO-9001:2000

A B S A REGISTERED

Hardness Inspection Report

Date: February 28, 2005	Customer: Bluestar Welding	Academy W/O #: 42760
Part Description: FLANGED X WECO 3 1/16" 10,000 BX154 X 2" FIG. 1502 FEMALE C/W SEAL RING		Cust. P.O. #: N/A
Reference Drawing/Sheet: ☐ Attached ☐ N/A		Part #/ Serial #: 42760-2-ACD-1

Examination Standard: ASTM E-10 or ASTM E-18

Acceptance Standard: ☒ API Specification 6A 19th Edition (see Table 11 for applicable section)
☐ API Specification 16A Third Edition (Section 8.5.1.4)
☐ API Specification 16C First Edition (Section 6.3.6.4.1)
☒ NACE MR0175 Latest Edition

Dwg Ref. # or Location	Brinell Hardness					Comments
	Parent Metal	HAZ	Weld Metal	HAZ	Parent Metal	
ACD-1	229					

Interpretation is done in accordance with the above mentioned standards. As this is a subjective analysis the final interpretation of these measurements is the responsibility of the customer.


Quality Assurance

Academy Petroleum Industries



API 6A LIC. - 0380
API 16A LIC. - 0077
API 16C LIC. - 0028

ACADEMY PETROLEUM INDUSTRIES

4066-78 AVENUE, EDMONTON, ALBERTA T6B 3M8

PHONE: (780) 466-6360 FAX: (780) 466-6380

E-mail: acadpet@telusplanet.net



ISO-9001:2000

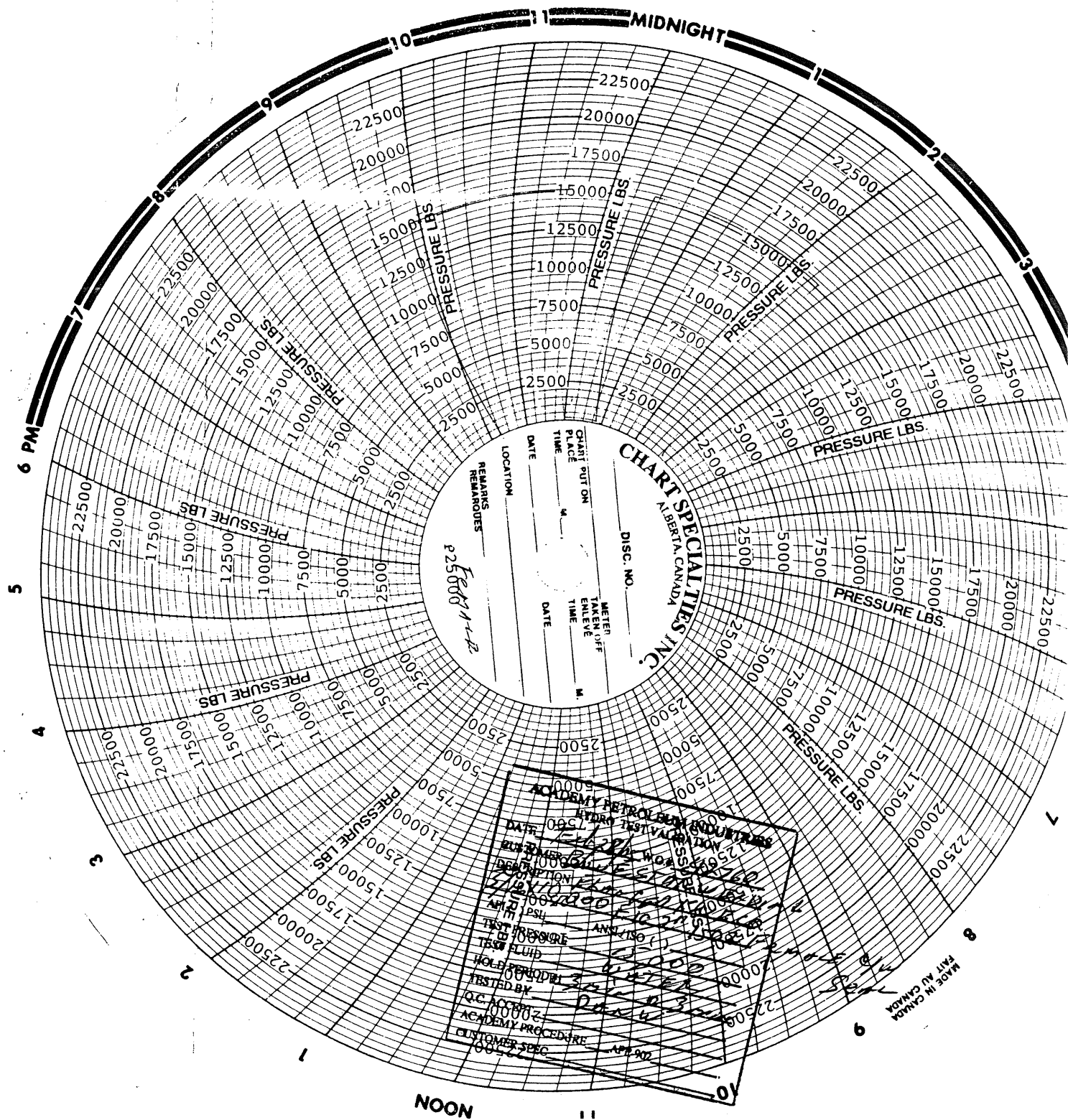
A B S A REGISTERED

Hydrostatic Pressure Test Certificate

Customer: Bluestar Welding		Cust. P.O. #: N/A	Academy W/O #: 42760
Part Description: FLANGED X WECO 3 1/16" 10,000 BX154 X 2" FIG. 1502 FEMALE C/W SEAL RING			
Part #:	Serial #: 42760-2-ACD-1	Working Pressure (psi): 10000	
Hydrostatic Test Spec: ☒ API 6A (Section 7.4.9.3.3) ☐ ASME B16.5 (Section 8.3) ☐ API 16A (Section 8.5.8.6) ☐ Other ☐ API 16C (Section 6.4.4) ☐ As per Customer Requirements			
Flange Type: ☒ API ☐ ANSI ☐ Other		API 6A PSL: ☒ 1 ☐ 2 ☐ 3 ☐ N/A	
Recording Device: Clif Mock Model MFG4587 (Serial #CS-081)			
Description of Tested Components			
Component (body, flange, EFSO, etc.)	Material Grade & Yield Strength		Heat #
Body	4130-75K		A3989
Hydrostatic Test			
Required Test Pressure (psi)	Actual Test Pressure (psi)	Req'd Test Duration (min.)	Actual Test Duration (min.)
15000	15,100	3	3.0 min
15000	15,300	3	3.0 min
Comments			
No visible leakage at time of test.			

We hereby certify that the above tests have been conducted and that the results satisfy the applicable specification at the time of testing.

Tested By: <i>[Signature]</i>	Date: Feb 28/05
Academy Quality Assurance:	Date:



RR 2, Box 20 Site 7
Grande Prairie, AB
T8V 4B5
Phone (780) 532-1160
Fax: (780) 532-1148

PURCHASE ORDER

5721

TO

PACIFIC VALUES

DATE DEC 10-04

REFERENCE

QC JOB # 9675-P-10976-P

UNIT #

PHONE

Donc Brown

LOCATION

[illegible]

SHIP TO ADDRESS:

VIA C FLEIGHTWAY

SIGNATURE

CLL

SUBTOTAL

GST

TOTAL

WHITE - SUPPLIER

YELLOW - OFFICE

PINK - QUALITY CONTROL



PACIFIC VALVE SERVICES INC.

9750 - 62 Avenue, Edmonton, Alberta T6E 0E3
24 Hr. Tel.: (780) 463-3972 • Fax: (780) 466-0492
Email: info@pacificvalve.com
Website: www.pacificvalve.com

NACE Verification Inspection Report

Customer: BLUE STAR WELDING Date February 14, 2005
P.O.# 5721 Rig # N/A Location PVS FACILITY
Equipment Description: 3-1/16" 10,000# QVM MANUAL GATE VALVE
Model: "Q-FC" PSL- 1 PR- 1 Temp.Class: "L-U" Material Class: "DD"
Engineering: QVM Serial # 5020702 Our W.O # 15223

NEW VALVE: SEE OEM CERTIFICATE OF CONFORMITY

Valve Conforms to NACE MR-01-75

Reviewed By:


RAVI MANI
Q.A. MANAGER

Performed By: QVM



PACIFIC VALVE SERVICES INC.

9750 - 62 Avenue, Edmonton, Alberta T6E 0E3
24 Hr. Tel.: (780) 463-3972 • Fax: (780) 466-0492
Email: info@pacificvalve.com
Website: www.pacificvalve.com

NACE Verification Inspection Report

Customer: BLUE STAR WELDING Date February 14, 2005
P.O.# 5721 Rig # N/A Location PVS FACILITY
Equipment Description: 3-1/16" 10,000# QVM MANUAL GATE VALVE
Model: "Q-FC" PSL- 1 PR- 1 Temp.Class: "L-U" Material Class: "DD"
Engineering: QVM Serial # 5020706 Our W.O # 15223

NEW VALVE: SEE OEM CERTIFICATE OF CONFORMITY

Valve Conforms to NACE MR-01-75

Reviewed By:

RAVI MANI
Q.A. MANAGER

Performed By: QVM



PACIFIC VALVE SERVICES INC.

9750 - 62 Avenue, Edmonton, Alberta T6E 0E3
24 Hr. Tel.: (780) 463-3972 • Fax: (780) 466-0492
Email: info@pacificvalve.com
Website: www.pacificvalve.com

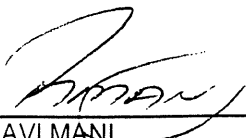
NACE Verification Inspection Report

Customer: BLUE STAR WELDING Date February 14, 2005
P.O.# 5721 Rig # N/A Location PVS FACILITY
Equipment Description: 3-1/16" 10,000# QVM MANUAL GATE VALVE
Model: "Q-FC" PSL- 1 PR- 1 Temp.Class: "L-U" Material Class: "DD"
Engineering: QVM Serial # 5020708 Our W.O # 15223

NEW VALVE: SEE OEM CERTIFICATE OF CONFORMITY

Valve Conforms to NACE MR-01-75

Reviewed By:


RAVI MANI
Q.A. MANAGER

Performed By: QVM

Quality VALVE & MACHINE WORKS, INC.

O: BOX 24727
27 CLINTON DR.

HOUSTON, TX 77229-4727
HOUSTON, TX 77029

(713) 675-7444
FAX: (713) 675-2518

CERTIFICATE OF CONFORMITY

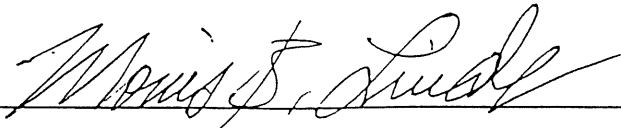
Quality Valve & Machine Works, Inc. is engaged in the manufacture of API Gate Valves and Chokes, API Fittings, Manifold Assemblies, and Rotary Drilling Equipment for Service Pressures from 3,000 PSI MSP to 20,000 PSI MSP. Equipment manufactured in these facilities meets or exceeds the applicable sections of API Specification 6A, API Specification 7, ANSI Standard B31.3, ANSI Standard B16.5, and Nace Standard MR-01-75 for (W.O.G.) AND Sour Service. Quality Valve and Machine Works, Inc. is authorized to apply the API Monogram to Equipment manufactured in accordance with API Specification 6A and API Specification 7.

The following equipment was manufactured on QVM Sales Order No. **31133 PACIFIC VALVE SERVICES INC.**

Customer's Purchase Order No. **PO002350** is hereby Certified to have been manufactured, tested and inspected in accordance with applicable specifications as listed above.

Description:

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	9	00	VALVE, GATE MANUAL 3-1/16" 10M D QVM TYPE Q-FC H2S TRIM C/W HANDWHEEL API 6A-17 th ; PSL-1; DD; LU; PR-1

Signed:  Date: 02 / 08 / 05

SN: 05020701 thru SN: 05020709.



PACIFIC VALVE SERVICES INC.

9750 - 62 Avenue, Edmonton, Alberta T6E 0E3
24 Hr. Tel.: (780) 463-3972 • Fax: (780) 466-0492
Email: info@pacificvalve.com
Website: www.pacificvalve.com

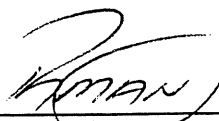
NACE Verification Inspection Report

Customer: BLUE STAR WELDING Date February 14, 2005
P.O.# 5721 Rig # N/A Location PVS FACILITY
Equipment Description: 3-1/16" 10,000# CORTEC ADJUSTABLE CHOKE c/w S.S. T.C. NEEDLE & SEAT
Model: "NH-2" PSL- 1 PR- 2 Temp.Class: "PU" Material Class: "EE"
Engineering: CORTEC Serial # 1003900-1-1012 Our W.O # 15223

NEW CHOKE: SEE OEM CERTIFICATE OF COMPLIANCE

Choke Conforms to NACE MR-01-75

Reviewed By:


RAVI MANI
Q.A. MANAGER

Performed By: CORTEC



208 Equity Blvd
P.O. Box 2217
Houma, LA 70361
Phone: (985) 223-1966
Fax: (985) 223-1936

This **Certificate Of Compliance** verifies that these products were produced in accordance with your Purchase Order and its requirements and the requirements of API 6A, 17TH ED., NACE MR0175, and CORTEC Fluid Control Quality Management System.

Customer: PACIFIC VALVE SERVICES

Customer P.O.#: PO002348

QUANTITY: 3

PART NUMBER: CN120-1004300-3000-1821-12PUDE

COMPONENTS: CORTEC MODEL NH2 AS ADJUSTABLE CHOKE ASSEMBLY WITH 3 1/16" 10,000 API RTJ FLANGES AND 2" SSTC STEM AND SEAT. (TFE PACKING).

SERIAL NO.: 1003900-1-1012 THRU 1003900-1-1014

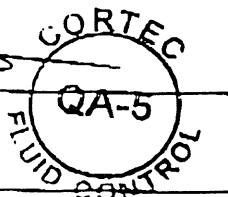
QUALITY LEVEL: PSL-1, MC-EE, TC-PU, PR-2

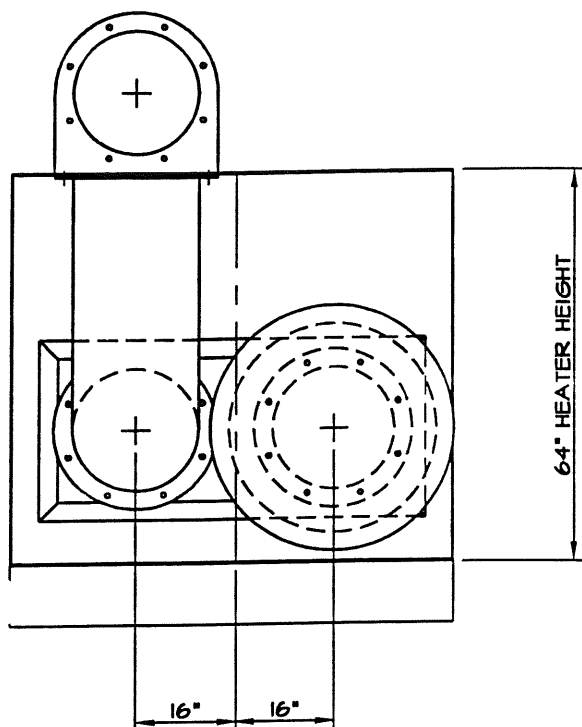
JOB NUMBER: CC040445

Q.A. MANAGER:


Randy Stein

DATE: 1-4-05

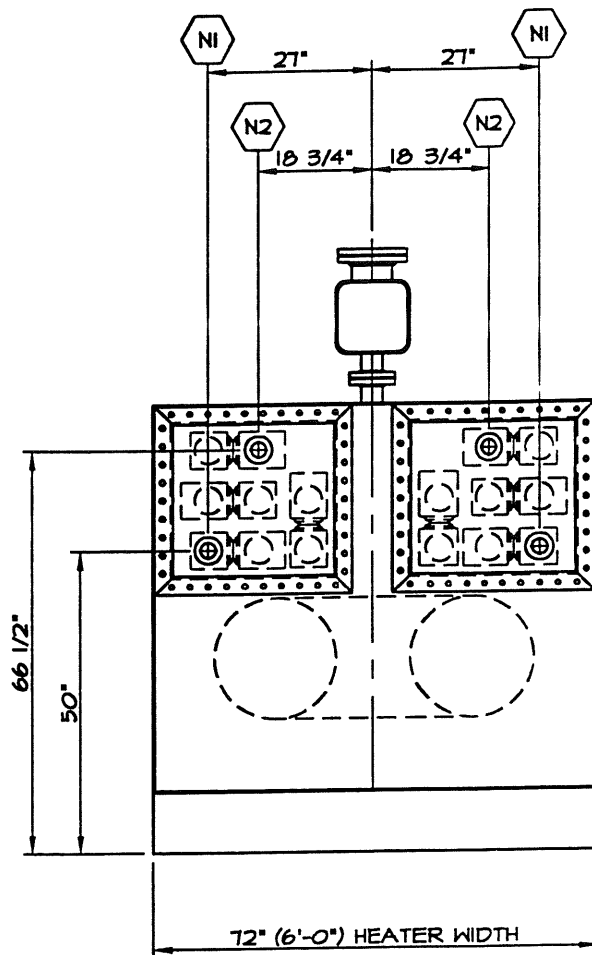
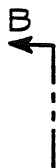




END VIEW A-A

100" (8'-4") MAXIMUM HEIGHT

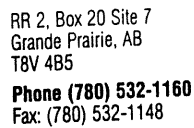
31-02



END VIEW B-B

0	05-01-07	ISSUED FOR APPROVAL	PJD...	WB
NO.	DATE	REVISION	BY	APP

BLUESTAR WELDING LTD. RR 2, SITE 7, BOX 20 GRANDE PRAIRIE, AB T8V 2Z9 TELEPHONE: (780) 532-1160 FAX: (780) 532-1148				
CLIENT:				
DATE:	05-01-07	2.0 MM HEATER GENERAL ARRANGEMENT (2) 4" COILS - 8 PASSES		
BDD NO.:	1931			
CUST. NO.:				
SCALE:	NTS			
DRAWN BY:	PJD...			
CHECKED BY:	WB	DWG NO.:	1931-01	REV. 0
APP BY:				



5720

PEACE STREET

10252-P

LOCATION

GP SHOP

539-3262

TOTAL

VIA FACE STREET

35: Wade Beall

MENZIES PRINTERS 65824

Ap:15-02 10:U4 From-PIPING RESOURCES

173044301

-70: P 01.06

1403 280 08:0

281 443 3643 P.05/14

NOV-28-2001 14:53 TAC

14 96247
DEC 11 2001

 Dalmine PLANT: DALMINE		INSPECTION CERTIFICATE (UNI EN 10204 3.1.8)		N. 00/08259 Page
CUSTOMER'S ORDER 00 HP 10736 MILL ORDER / ITEM 1900768/004 EMP REFERENCE C/17323		TAD USA INC. 1910, RANKIN ROAD 77073 HOUSTON, TEXAS USA		
PRODUCT HOT FINISHED SEAMLESS STEEL PIPES FOR HIGH TEMPERATURE SERVICE IN ACCORDANCE WITH ASTM/ASME A/SA 105, ASTM/ASME A/SA 53, API 5L - STEEL GR. B ASTM/ASME A/SA 105, 53, API 5L - BLACK INSIDE AND PROTECTED OUTSIDE WITH TEMPORARY DRY-PYLM MILL VARNISH - BEVELLED ENDS ACC. TO ASME B 16.25 FIG. 2A				
DIMENSIONS: SCH Lg. From Lg. To O.D. mm O.D. inch W.T. mm STD 11000 12800 508,000 20" 9,530 SHIPPING NOTE : E1200693 DATE 20/04/2000 QUANTITY : Mx 78 Mc 967,56 Nq 118294 Pc 3174' 5" Lbs 260793,3				
TEST N. L5177 HEAT N. 901676				
TENSION TEST + 20,0°C TEST SPEC. : LONGITUDINAL WIDTH 25,00 THICK. 10,10 SECTION 256,5 mm ² YIELD POINT 0,5% (KSI) : requir min 35 result 49,7 TENSILE STRENGTH (KSI) : requir min 60 result 73,1 ELONGATION : CALIBRATED ON 2" 50,0 mm result 42,0 (4) : requir. min 27,0 max 22,0 result 0,0 max 100,0 result 77,9 HARDNESS HRC requ. max 22,0 result 0,0 HARDNESS HB requ. max 100,0 result 77,9 TECHNOLOGICAL TESTS PERFORMED WITH SATISFACTORY RESULTS: FLATTENING TEST : TEST PERFORMED AT ONE END OF 1 PIPE OF THE LOT				
TEST N. L5177/10 HEAT N. 901676				
TENSION TEST + 20,0°C TEST SPEC. : LONGITUDINAL WIDTH 25,30 THICK. 10,00 SECTION 283,0 mm ² YIELD POINT 0,5% (KSI) : requir min 35 result 49,9 TENSILE STRENGTH (KSI) : requir min 60 result 73,1 ELONGATION : CALIBRATED ON 2" 50,0 mm result 41,3 (4) : requir. min 27,0 max 22,0 result 0,0 max 100,0 result 78,1 HARDNESS HRC requ. max 22,0 result 0,0 HARDNESS HB requ. max 100,0 result 78,1 TECHNOLOGICAL TESTS PERFORMED WITH SATISFACTORY RESULTS: FLATTENING TEST : TEST PERFORMED AT ONE END OF 1 PIPE OF THE LOT				
TEST N. L5177/20 HEAT N. 901676				
TENSION TEST + 20,0°C TEST SPEC. : TRANSVERSAL WIDTH 37,50 THICK. 10,30 SECTION 386,3 mm ² YIELD POINT 0,5% (KSI) : requir min 35 result 50,0 TENSILE STRENGTH (KSI) : requir min 60 result 72,2 ELONGATION : CALIBRATED ON 2" 50,0 mm				
DATE 20/04/2000		CHIEF OF QUALITY CERTIFICATION OPT Marco BELLOLI		QUALITY SERVICE MANAGER Angelo CIANCIOGI

HT"
901924TAD USA INC.
Q.A. APPROVED
GET M. 400

Follows

APR-16-02 10:04

From-PIPING RESOURCES

1750944100

1-704 P 01702

11-28-01 2:43PM SAT TUBULARS

NOV-28-2001 14:53

TAD

281 443 3543

P.02/14

Dalmine		INSPECTION CERTIFICATE (UNI EN 10204 3.1.B)		N. 00/00259 Page 2	
PLANT: DALMINE					
HARDNESS HRC HARDNESS HRB		requ. requ.		result result	
		(4) = requir. min 28,5 max 22,0 max 100,0		0,0 77,5	
TEST N. L5179		HEAT N. 901769			
TENSION TEST + 20,0°C		WIDTH 25,10 THICK. 10,10		SECTION 253,5 mm ²	
TEST SPEC. : LONGITUDINAL				result 52,1	
YIELD POINT 0,5% (KSI)		): requir. min 35		result 74,3	
TENSILE STRENGTH (KSI)		): requir. min 60			
ELONGATION		): CALIBRATED ON 2" 50,0 mm		result 43,0	
		(4) = requir. min 27,0 max 22,0 max 100,0		0,0 77,5	
HARDNESS HRC HARDNESS HRB		requ. requ.		result result	
TECHNOLOGICAL TESTS PERFORMED WITH SATISFACTORY RESULTS:		1 PIPE OF THE LOT			
FLATTENING TEST		: TEST PERFORMED AT ONE END OF			
TEST N. L5179/20		HEAT N. 901769			
TENSION TEST + 20,0°C		WIDTH 25,00 THICK. 9,90		SECTION 247,5 mm ²	
TEST SPEC. : LONGITUDINAL				result 51,7	
YIELD POINT 0,5% (KSI)		): requir. min 35		result 74,1	
TENSILE STRENGTH (KSI)		): requir. min 60			
ELONGATION		): CALIBRATED ON 2" 50,0 mm		result 42,3	
		(4) = requir. min 27,0 max 22,0 max 100,0		0,0 77,7	
HARDNESS HRC HARDNESS HRB		requ. requ.		result result	
TECHNOLOGICAL TESTS PERFORMED WITH SATISFACTORY RESULTS:		1 PIPE OF THE LOT			
FLATTENING TEST		: TEST PERFORMED AT ONE END OF			
TEST N. L5179/20		HEAT N. 901769			
TENSION TEST + 20,0°C		WIDTH 28,00 THICK. 10,40		SECTION 395,7 mm ²	
TEST SPEC. : TRANSVERSAL				result 51,0	
YIELD POINT 0,5% (KSI)		): requir. min 35		result 73,6	
TENSILE STRENGTH (KSI)		): requir. min 60			
ELONGATION		): CALIBRATED ON 2" 50,0 mm		result 41,7	
		(4) = requir. min 28,5 max 22,0 max 100,0		0,0 77,2	
HARDNESS HRC HARDNESS HRB		requ. requ.		result result	
TEST N. L5181		HEAT N. 901724			
TENSION TEST + 20,0°C		WIDTH 25,30 THICK. 9,80		SECTION 247,9 mm ²	
TEST SPEC. : LONGITUDINAL				result 49,1	
YIELD POINT 0,5% (KSI)		): requir. min 35		result 74,3	
TENSILE STRENGTH (KSI)		): requir. min 60			
ELONGATION		): CALIBRATED ON 2" 50,0 mm		result 41,0	
		(4) = requir. min 27,0 max 22,0		0,0	
HARDNESS HRC HARDNESS HRB		requ. requ.		result result	
DATE 20/06/2000		CHIEF OF QUALITY CERTIFICATION DEPT Marco BELLOLI		QUALITY SERVICE MANAGER Angelo CIANCIOSI	

TADUNA, Inc.
Q.A. APPROVED
GET 14 May 00

Follows

Apr-16-02 10:01

From-PIPING RESOURCES

1720944306

1-701 P 04/08 F-12

1403 290 0818

281 443 3643 P.07/14

11-20-01 2:43PM:EST TUBULARS

NDU-28-2001 14:54

TAD

 Dalmine PLANT: DALMINE		INSPECTION CERTIFICATE (UNI EN 10204 3.1.B)	N. 00/08259 Page 1
HARDNESS HRC requ. max 100,0 result 80,1 TECHNOLOGICAL TESTS PERFORMED WITH SATISFACTORY RESULTS: FLATTENING TEST : TEST PERFORMED AT ONE END OF 1 PIPE OF THE LOT			
TEST N. L9181/10		HEAT N. 901924	
TENSION TEST + 20,0°C TEST SPEC. : LONGITUDINAL WIDTH 25,20 THICK. 0,70 SECTION 244,4 mm ² YIELD POINT 0,5% (KSI) : requir min 35 result 48,7 TENSILE STRENGTH (KSI) : requir min 60 result 74,5 ELONGATION : CALIBRATED ON 2" 50,0 mm (3) : requir min 27,0 result 40,0			
HARDNESS HRC requ. max 22,0 result 0,0 HARDNESS HB requ. max 100,0 result 80,3 TECHNOLOGICAL TESTS PERFORMED WITH SATISFACTORY RESULTS: FLATTENING TEST : TEST PERFORMED AT ONE END OF 1 PIPE OF THE LOT			
TEST N. L5181/20		HEAT N. 901924	
TENSION TEST + 20,0°C TEST SPEC. : TRANSVERSAL WIDTH 38,00 THICK. 0,50 SECTION 361,0 mm ² YIELD POINT 0,5% (KSI) : requir min 35 result 48,2 TENSILE STRENGTH (KSI) : requir min 60 result 73,0 ELONGATION : CALIBRATED ON 2" 50,8 mm (3) : requir min 28,5 result 39,0			
HARDNESS HRC requ. max 22,0 result 0,0 HARDNESS HB requ. max 100,0 result 79,6			
HEAT N. 901876			
HEAT ANALYSIS % C 0,17 Mn 0,87 Si 0,20 P 0,014 S 0,002 Cu 0,13 Ni 0,10 Cr 0,19 Mo 0,03 V 0,004 (V + Ni + Cr + Mo + Cu) = 0,394			
PRODUCT ANALYSIS % TEST N. L5177 C 0,18 Mn 0,87 Si 0,27 P 0,013 S 0,002 Cu 0,13 Ni 0,10 Cr 0,13 Mo 0,03 V 0,003 (V + Ni + Cr + Mo + Cu) = 0,393			
PRODUCT ANALYSIS % TEST N. L5178 C 0,18 Mn 0,87 Si 0,27 P 0,014 S 0,002 Cu 0,13 Ni 0,10 Cr 0,13 Mo 0,03 V 0,003 (V + Ni + Cr + Mo + Cu) = 0,393			
DATE 20/04/2000		CHIEF OF QUALITY CERTIFICATION DPT Marco BELLOLI QUALITY SERVICE MANAGER Angela CIANCIOGI	

 TAD USA, INC.
 Q.A. APPROVED
 GFR M/May00

Apr-16-02 10:05 From-PIPING RESOURCES

178934480E1

T-705 F 05/08 F-678

11-28-01 2 430M:051 TUBULARS

1403 200 08:00

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TAD

281 443 3643 P.08/14

 Dalmine PLANT: DALMINE		INSPECTION CERTIFICATE (UNI EN 10204 3.1.B)		N. 00/08159 Page 4	
HEAT N. 901759					
HEAT ANALYSIS %					
C 0,16	Mn 0,27	Si 0,25	P 0,013	S 0,002	Cu 0,14
Ni 0,12	Cr 0,13	Mo 0,03	V 0,003		
(V + Ni + Cr + Mo + Cu) =		0,423			
PRODUCT ANALYSIS %					
C 0,16	Mn 0,26	Si 0,26	P 0,013	S 0,002	Cu 0,14
Ni 0,12	Cr 0,13	Mo 0,03	V 0,003		
(V + Ni + Cr + Mo + Cu) =		0,413			
TEST N. L5179					
PRODUCT ANALYSIS %					
C 0,15	Mn 0,26	Si 0,26	P 0,012	S 0,002	Cu 0,14
Ni 0,12	Cr 0,13	Mo 0,03	V 0,003		
(V + Ni + Cr + Mo + Cu) =		0,403			
TEST N. L5180					
HEAT N. 901924					
HEAT ANALYSIS %					
C 0,16	Mn 0,27	Si 0,25	P 0,017	S 0,004	Cu 0,15
Ni 0,09	Cr 0,18	Mo 0,03	V 0,004		
(V + Ni + Cr + Mo + Cu) =		0,454			
PRODUCT ANALYSIS %					
C 0,16	Mn 0,26	Si 0,24	P 0,018	S 0,003	Cu 0,15
Ni 0,09	Cr 0,18	Mo 0,03	V 0,004		
(V + Ni + Cr + Mo + Cu) =		0,454			
TEST N. L5181					
PRODUCT ANALYSIS %					
C 0,17	Mn 0,26	Si 0,24	P 0,016	S 0,002	Cu 0,15
Ni 0,09	Cr 0,18	Mo 0,03	V 0,004		
(V + Ni + Cr + Mo + Cu) =		0,444			
TEST N. L5182					
LEAK-TIGHTNESS TEST PERFORMED WITH SATISFACTORY RESULTS BY					
HYDRAULIC TEST PRESSURE 800,0 PSI FOR 5 Sec					
VISUAL AND DIMENSIONAL CONTROL HAS BEEN CARRIED OUT WITH SATISFACTORY RESULT					
STEEL IS FULLY KILLED AND PRODUCED BY ELECTRIC FURNACE					
REMARKS:					
WE HEREBY DECLARE THE TUBES ARE ACCORDING TO ASTM A 106/99 A 53/99B ASME SA 106 /63/98 API 5L 93 - STEEL GR. B " AT NO TIME DURING THE MANUFACTURE OF THIS REFERENCED PIPE WERE ANY WELDING PROCEDURES PERFORMED " HARDNESS DOES NOT EXCEED HRC 22, ACCORDING TO NACE MR-01-75 Ed.97. "MATERIALS MERCURY FREE" WE CERTIFY THAT OUR MATERIALS ARE FREE FROM OZONE.					
DATE		CHIEF OF QUALITY		QUALITY	
10/04/2000		CERTIFICATION SPT		SERVICE MANAGER	
		Marco BELLOLI		Angelo CIANCIOSI	

 TADIMA, INC.
 Q.A. APPROVED
 GEM/Myco

Follow

Apr-16-02 10:06 From-PIPING RESOURCES

17893442081

F-705 F.06/08 F-178

11-28-01 2:23:00:05 TUGS-ARS
NOV-28-2001 14:54 TAD:423 200 0612
281 443 3643 P.09/14

	Dalmine	INSPECTION CERTIFICATE	N. 00/08259
PLANT: DALMINE		(UNI EN 10204 3.1.B)	Page 5
DEPLETING CHEMICALS AND FULLY COMPLY IN ALL RESPECTS TO THE PACIAGE REQUIREMENTS FOR HEAVY METALS OF THE CONEG MODEL LEGISLATION.			
* CERTIFIED FACTORY UNI EN ISO 9001: I.G.Q. Nr. 8603 *			
TAD USA, INC. Q.A. APPROVED GERMAYO			
DATE 20/01/2000	CHIEF OF QUALITY CERTIFICATION DPT Marco BELLOLI	QUALITY SERVICE MANAGER Angelo CIANCIOBI	

End