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MANUFACTURED &
CERTIFIED BY:

BLUESTAR WELDING ®

GRANDE PRAIRIE, AB., CANADA
1-780-532-1160

A-NUMBER	Ⓐ514075
SERIAL No.	BSC10K2WM-03A
JOB No.	10252-P
DESIGN PRESSURE	10000 PSI
M.A.W.P.	10000 PSI
DESIGN TEMP. MINIMUM	-40°F
CORROSION ALLOWANCE	0.025 IN.
DESIGN TEMP. MAXIMUM	180°F
CRN No.	AL D-05-001
YEAR BUILT	2005
STEAM COIL M.A.W.P.	@ °F

RTI
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MANUFACTURED &
CERTIFIED BY:

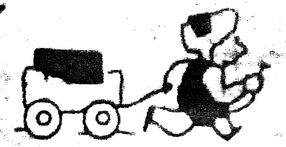
BLUESTAR WELDING

GRANDE PRAIRIE, AB., CANADA
1-780-532-1160

A-NUMBER	A 514076
SERIAL No.	BSC 10K2MM-03B
JOB No.	10252-P
DESIGN PRESSURE	10000 PSI
M.A.W.P.	10000 PSI
DESIGN TEMP. MINIMUM	-40°F
CORROSION ALLOWANCE	0.025 IN.
DESIGN TEMP. MAXIMUM	180°F
CRN No.	ALD-05-001
YEAR BUILT	2005
STEAM COIL M.A.W.P.	@ °F

BLUESTAR WELDING

GRANDE PRAIRIE, AB.
1-780-532-1160



®YR MANU 2004

A-NUMBER	
SERIAL NO.	BSFGS 227
DESIGN PRESSURE	150PSI
DESIGN TEMP.	-20°F / 100°F
SHELL THICKNESS	
HEAD THICKNESS	
REG. DESIGN NO.	
STRESS RELIEVED	NO
X-RAY	NO
DERATED	NO
HYDRO TEST	196 PSI
INSPECTOR	C.F.
CRN NO.	OH6510.2

AB-28 00/12

MANUFACTURER'S DATA REPORT FOR INDIRECT FIRED HEATER COILS

(A) No. 514075

Manufactured by **Bluestar Welding Ltd, RR 2, Site 7, Box 20 Grande Prairie, AB T8V 2Z9**

Manufactured for **Pure Energy Services Ltd, 300 1010 - 1 St SW, Calgary AB**

Ultimate Owner **Pure Energy Services Ltd, 300 1010 - 1 St SW, Calgary AB**

Location of Installation **Portable**

Mfg. Serial No. **BS10K2MM-03A** Code: ASME B31.3, Edition **2002** Addenda _____

Drawing Number **1931.06 Rev 2** Year Built **2005** Intended Service **Corrosive Hydrocarbons**

a. Material Specifications ASTM A-519 Grade 4130 / Grade 4130 - API 6A, Class L
Coil *Ends (Flanges/N.P.T.)* *Rating*

b. Material Specifications Elbows 90° Machined Grade 4130
Coil *Ends (Flanges/N.P.T.)* *Rating*

a. Diameter 4 1/2 in. Nom. Thickness 1 in. O/A Length **Varies: 112 in. 105 in.** C.A. 1/8"
b. Diameter _____ Nom. Thickness _____ O/A Length _____ C.A. _____

a. Maximum Working Pressure 10, 000 psi at Maximum Temperature 180°F °C
b. Maximum Working Pressure _____ kPa at Maximum Temperature _____ °C

a. Hydrostatic Test Pressure 15, 000 psi C.R.N. ALD-05-001
b. Hydrostatic Test Pressure _____ kPa C.R.N. _____

Heating Surface 86.53 Ft² Radiography 100 % (Random, % or Full)

Volume 10.01 Ft² P.W.H.T. 1150°F 4 Hr

Remarks _____

CERTIFICATE OF COMPLIANCE

We certify that the statements in this report are correct and that all details of design, material, construction, and workmanship of this coil bundle are in accordance with Registered Design No.

Date FEBRUARY 24, 2005 Signed _____ For Bluestar Welding Ltd.
(Representative) *(Manufacturer)*

CERTIFICATE OF SHOP INSPECTION

I, the undersigned, a duly authorized Safety Codes Officer employed by The Alberta Boilers Safety Association have inspected the above Heater Coils and state that, to the best of my knowledge and belief, the construction is in accordance with the Alberta Safety Codes Act and Regulations.

Date Feb 24/15 Signed _____

AB-28 00/12

ABSA

MANUFACTURER'S DATA REPORT FOR INDIRECT FIRED HEATER COILS

(A) No. 514076

Manufactured by **Bluestar Welding Ltd, RR 2, Site 7, Box 20 Grande Prairie, AB T8V 2Z9**

Manufactured for **Pure Energy Services Ltd, 300 1010 - 1 St SW, Calgary AB**

Ultimate Owner **Pure Energy Services Ltd, 300 1010 - 1 St SW, Calgary AB**

Location of Installation **Portable**

Mfg. Serial No. BS10K2MM-03B Code: ASME B31.3, Edition **2002** Addenda _____

Drawing Number **1931.06 Rev 2** Year Built **2005** Intended Service Corrosive Hydrocarbons

a. Material Specifications ASTM A-519 Grade 4130 / Grade 4130 - API 6A, Class L
Coil *Ends (Flanges/N.P.T.)* *Rating*

b. Material Specifications Elbows 90° Machined Grade 4130
Coil *Ends (Flanges/N.P.T.)* *Rating*

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b. Diameter _____ Nom. Thickness _____ O/A Length _____ C.A. _____

a. Maximum Working Pressure 10, 000 psi at Maximum Temperature 180°F °C
b. Maximum Working Pressure _____ kPa at Maximum Temperature _____ °C

a. Hydrostatic Test Pressure 15, 000 psi C.R.N. ALD-05-001
b. Hydrostatic Test Pressure _____ kPa C.R.N. _____

Heating Surface 86.53 Ft² Radiography 100 % (Random, % or Full)

Volume 10.01 Ft³ P.W.H.T. 1150°F 4 Hr

Remarks _____

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(Representative) *(Manufacturer)*

CERTIFICATE OF SHOP INSPECTION

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Date Feb 24/05 Signed _____

EXHIBIT 9.4 TRAVEL SHEET (FRONT)

DO NOT START CONSTRUCTION WITHOUT AI REVIEW

AI REVIEW: Harvey A Wikle — REVIEW DATE: Jul 10/05

SERIAL NO:BS10K2MM-03A — JOB NO: 10252-P — VESSEL TYPE: Heater Coil

DRAWING NO: 1931-06 — REVISION NO: 1

Seq.	Item	Comments	Q.C.	Date	A.I. Hold Points	A.I.	Date	Owner	Date
1.	Calculations in File		C.7	02/10/05					
2.	Release of App'd		C.7	02/10/05		HAW	Jul 24/05		
3.	Heat Numbers Recorder		C.7	02/10/05					
4.	MTRs Checked		C.7	02/10/05		HAW	Jul 24/05		
5.	W.P.S. Checked		C.7	02/10/05					
6.	Welders Quality		C.7	02/10/05					
7.	Thicknesses Recorded		C.7	02/10/05					
8.	Shell & Head Fitted								
9.	Nozzles & Fittings Fitted		C.7	02/10/05					
10.	Nozzle Orientation		C.7	02/10/05					
11.	Nozzle & Flange Rating Checked		C.7	02/10/05					
12.	Impact Tests								
13.	Internals Checked								
14.	Final Internal Inspection	Shell side / Tube side							
15.	Weld Size Checked		C.7	02/10/05					
16.	Welder I.D. Checked		C.7	02/10/05					
17.	Final External Inspection		C.7	02/24/05					
18.	Radiography		C.7	02/10/05		HAW	Jul 10/05		
19.	Other N.D.E.								
20.	Final Ext. Prior to P.W.H.T.		C.7	02/10/05	X	HAW	Jul 10/05		
21.	PWHT Chart Checked		C.7	02/10/05		HAW	Jul 24/05		
22.	Hydrostatic Test	Shell side / Gauge # / Tube side / Gauge #			X	HAW	Jul 24/05		
23.	CRN Drawing	CRN#	C.7	02/22/05					
24.	N.C.R. #				X	HAW	Jul 24/05		
25.	Nameplate Stamping		C.7	02/24/05	X	HAW	Jul 24/05		
26.	Mfg Data Report		C.7	02/24/05					
27.	Nameplate Installation		C.7	02/24/05					

The Authorized Inspector shall be presented with the travel sheet prior to construction so that he can designate additional inspection points and/or Hold Points.

*** Denotes an A.I. Inspection Point** **** Denotes an A.I. Hold Point**

EXHIBIT 9.4 TRAVEL SHEET (FRONT)

DO NOT START CONSTRUCTION WITHOUT AI REVIEW

AI REVIEW: Harvey A Waddle REVIEW DATE: Feb 10/05

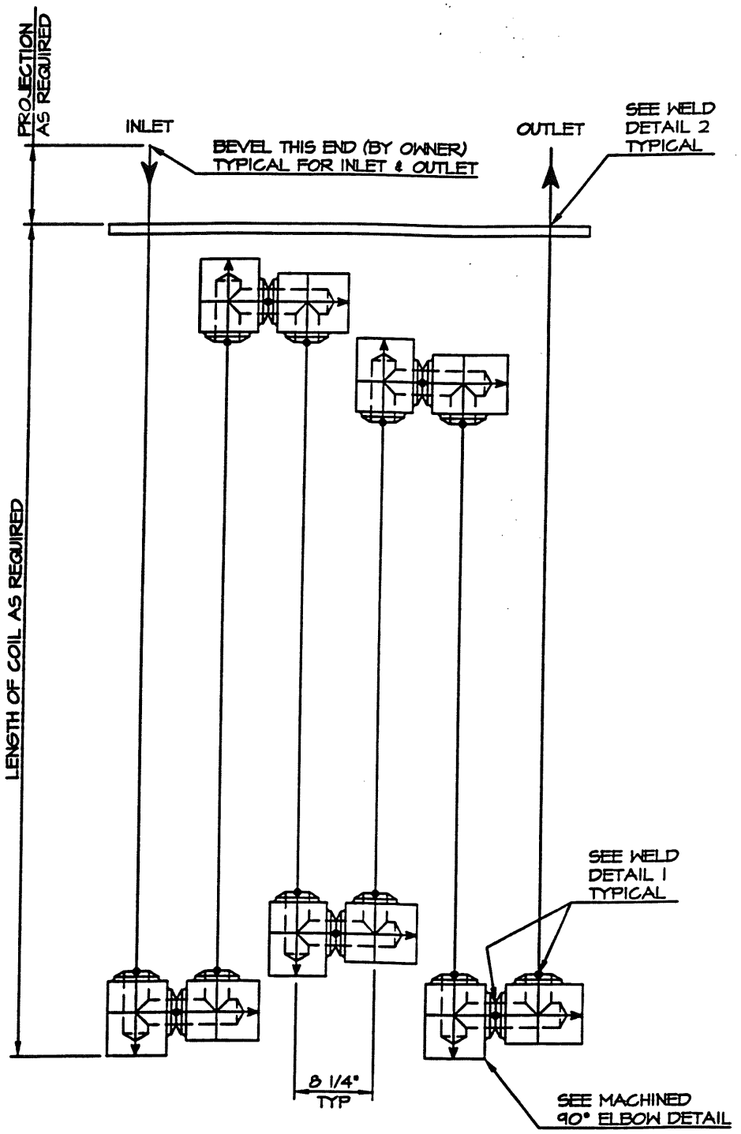
SERIAL NO:BS10K2MM-03B JOB NO: 10252-P VESSEL TYPE: Heater Coil

DRAWING NO: 1931-06 REVISION NO: 1

Seq.	Item	Comments	Q.C.	Date	A.I. Hold Points	A.I.	Date	Owner	Date
1.	Calculations in File		C.Z.	02/10/05					
2.	Release of App'd		C.Z.	02/10/15		Feb 24/05	HAW		
3.	Heat Numbers Recorder		C.Z.	02/10/05					
4.	MTRs Checked		C.Z.	02/10/05		HAW	Feb 24/05		
5.	W.P.S. Checked		C.Z.	02/10/05					
6.	Welders Quality		C.Z.	02/10/05					
7.	Thicknesses Recorded		C.Z.	02/10/05					
8.	Shell & Head Fitted								
9.	Nozzles & Fittings Fitted		C.Z.	02/10/05					
10.	Nozzle Orientation		C.Z.	02/10/05					
11.	Nozzle & Flange Rating Checked		C.Z.	02/10/05					
12.	Impact Tests								
13.	Internals Checked								
14.	Final Internal Inspection	Shell side / Tube side							
15.	Weld Size Checked		C.Z.	02/10/05					
16.	Welder I.D. Checked		C.Z.	02/10/05					
17.	Final External Inspection		C.Z.	02/24/05					
18.	Radiography		C.Z.	02/10/05		HAW	Feb 10/05		
19.	Other N.D.E.								
20.	Final Ext. Prior to P.W.H.T.		C.Z.	02/10/05	**	HAW	Feb 10/05		
21.	PWHT Chart Checked		C.Z.	02/19/05		HAW	Feb 24/05		
22.	Hydrostatic Test	Shell side Gauge # / Tube side Gauge #			**	HAW	Feb 24/05		
23.	CRN Drawing	CRN#	C.Z.	02/22/05					
24.	N.C.R. #								
25.	Nameplate Stamping		C.Z.	02/24/05	**	HAW	Feb 24/05		
26.	Mfg Data Report		C.Z.	02/24/05	**	HAW	Feb 24/05		
27.	Nameplate Installation		C.Z.	02/28/05					

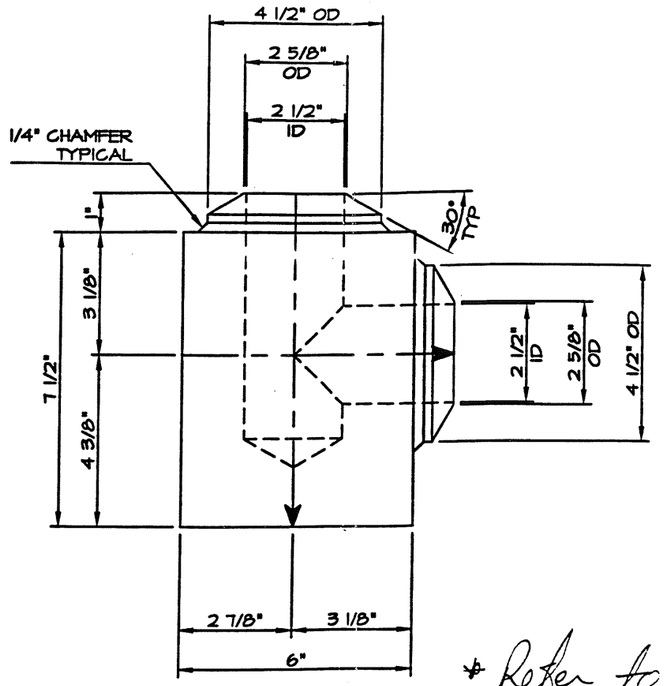
The Authorized Inspector shall be presented with the travel sheet prior to construction so that he can designate additional inspection points and/or Hold Points.

*** Denotes an A.I. Inspection Point** **** Denotes an A.I. Hold Point**

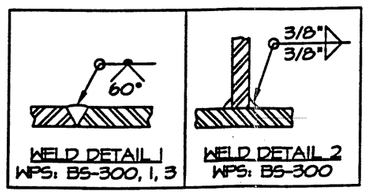


TYPICAL COIL SCHEMATIC

NUMBER OF PASSES AS REQUIRED



MACHINED 90° ELBOW



WELD DETAIL 1
WPS: BS-300, 1, 3

WELD DETAIL 2
WPS: BS-300

STANDARD TOLERANCES	
FABRICATION:	
GENERAL DEVIATION	± 1/8"
OVERALL LENGTH	± 1/4"
ANGULAR	± 1°
WELD PREPARATION:	
LAND (ROOT FACE)	1/16" ± 1/32"
ROOT GAP	1/8" ± 1/16"
ANGULAR	± 5°
MACHINING:	
0.XX	± 0.015"
0.XXX	± 0.005"
EXCEPT AS NOTED	

COIL DESIGN NOTES

DESIGN & FABRICATE TO: ASME B31.3, 2002 EDITION
MAXIMUM ALLOWABLE WORKING PRESSURE (MAWP): 10,000 PSIG
2 DESIGN TEMPERATURE: 180° F
MINIMUM DESIGN METAL TEMPERATURE (MDMT): -40° F AT 10,000 PSIG
IMPACT TESTS: EXEMPT
RADIOGRAPHY: 100%
PWHT: OPTIONAL, USE WELDING PROCEDURE BSW-4130.
TEMPERATURE AND TIME: 1150° F FOR 4 HOURS.
HYDROSTATIC TEST PRESSURE: 15,000 PSIG
CORROSION ALLOWANCE: 1/8"

GENERAL NOTES

1. QUALITY CONTROL PROGRAM NUMBER: AQP-1336
2. WELDING PROCEDURE REGISTRATION NUMBER: WP-1779.2
3. SERVICE: CORROSIVE HYDROCARBONS
4. SURFACE PREPARATION: HAND TOOL CLEAN (MIN)
5. PRIME AND PAINT: AS PER CLIENT SPECIFICATIONS
6. ALL BOLT HOLES TO STRADDLE CENTERLINES.
7. CLEAN AND COVER ALL OPENINGS FOR SHIPMENT.
8. MATERIAL INFORMATION:
   TUBING: ASTM A-519 GRADE 4130 - 4 1/2" OD x 1" THK
   90° ELBOW: 4130 - L6060 (ROCKWELL 18-22 MAXIMUM)
9. WELDING INFORMATION:
   PREHEAT TEMPERATURE: 450° F
   INTERPASS TEMPERATURE: 600° F
   WELDING ROD: 10018-D2

* Refer to the acceptance letter for the conditions of registration. — DD

2 SERIAL NUMBERS FOR 4 UNITS

BS-10K-2MM-03A
BS-10K-2MM-03B

BS-10K-2MM-04A
BS-10K-2MM-04B

BS-10K-4MM-05A
BS-10K-4MM-05B

BS-10K-2MM-06A
BS-10K-2MM-06B

APPROVED: _____

DATE: _____

ALBERTA BOILERS SAFETY ASSOCIATION
PROVINCE OF ALBERTA
SAFETY CODES ACT
REG. No. ALD-05-001
DWG. No. 1931-06, Rev. 2

MAWP kPa	Design Temp. °C
68948	-40/82

ACCEPTED As Noted*
FEB 10 2005 Signed Desai
Date B.C. DESAI, P. ENG.
DESIGN SURVEY ENGINEER

CANADIAN REGISTRATION NUMBER

NO.	DATE	REVISION	BY	APP
2	05-02-10	DESIGN TEMP WAS 200° F, ADD S/Ns	PJD...	WB
1	05-01-11	ISSUED FOR REGISTRATION	PJD...	WB
0	05-01-05	ISSUED FOR APPROVAL	PJD...	WB

BLUESTAR WELDING LTD.
RR 2, SITE 7, BOX 20
GRANDE PRAIRIE, AB T8V 2Z9
TELEPHONE: (780) 532-1160 FAX: (780) 532-1148

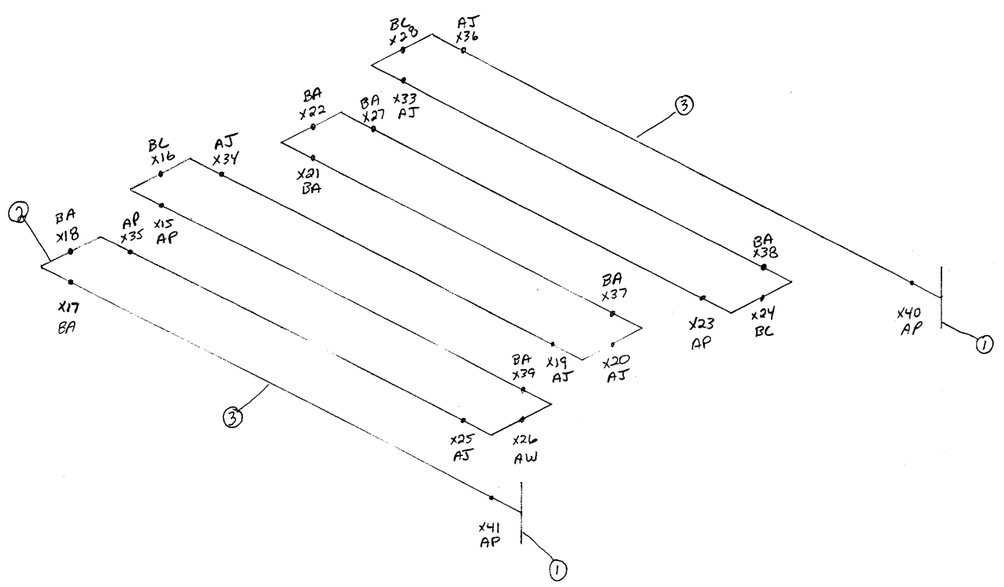
CLIENT:	
DATE:	05-01-05
BDD NO.:	1931 / 1943
CUST. NO.:	
SCALE:	NTS
DRAWN BY:	PJD...
CHECKED BY:	WB

HEATER COIL
4 1/2" OD c/w
MACHINED 90° ELBOWS

DWG NO.: REV.

BLUESTAR WELDING
DIVISION OF 570147 ALTA. LTD.

Bsc 10K2mm-03B



NOTE ② ALL WELD ELLS SAME HT#'s MATERIAL
③ ALL PIPE SAME HT#'s MATERIALS

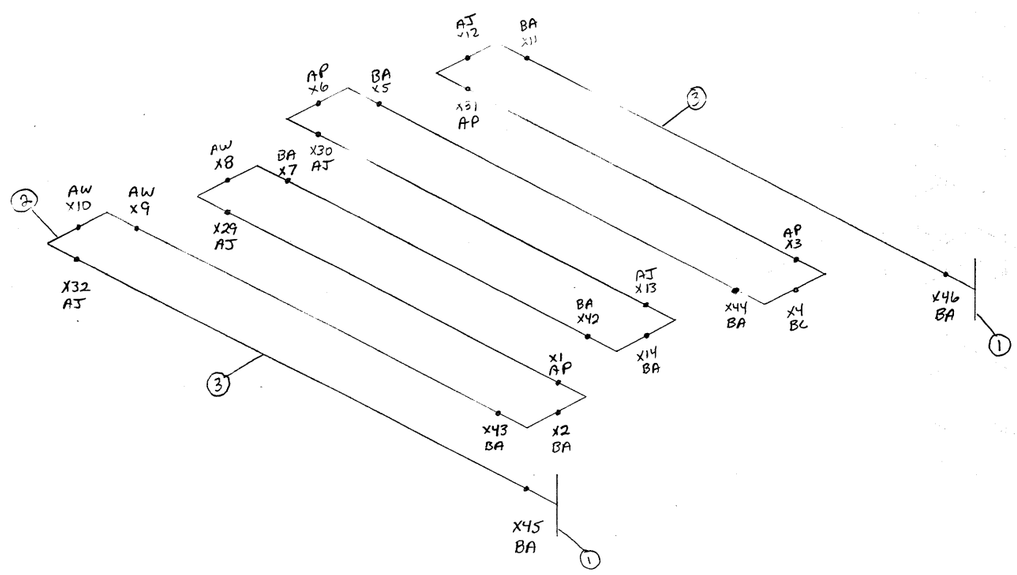
ITM	QTY		HEAT NUMBER
1	2	4½" 1.0" WALL RTJWN API FIG A1S14130	14133
2	14	4" x 1.0" WALL WELD ELL API A1S14130	17302
3		4½" OD 1.0" WALL SEAMLESS PIPE A1S1 4130	.242200

RT	ΔF	HYDRO	AREA CODE	INSULN.	DRAWN	DIA - INS
MPI	BHN	DES. PRESS.	LINE SPEC.	TRACING	DATE	
LPI	PWHT	DES. TEMP.	FAB. CODE	PAINT SPEC.	CHK.	WEIGHT
WELD PROCEDURES				REF. DWG.	APPR.	

JOB # CONTROL #
CLIENT P.O. #
PROJECT
SPOOL # REV Δ

BLUESTAR WELDING
DIVISION OF 570147 ALTA. LTD.

BSC 10K 2MM - 03A



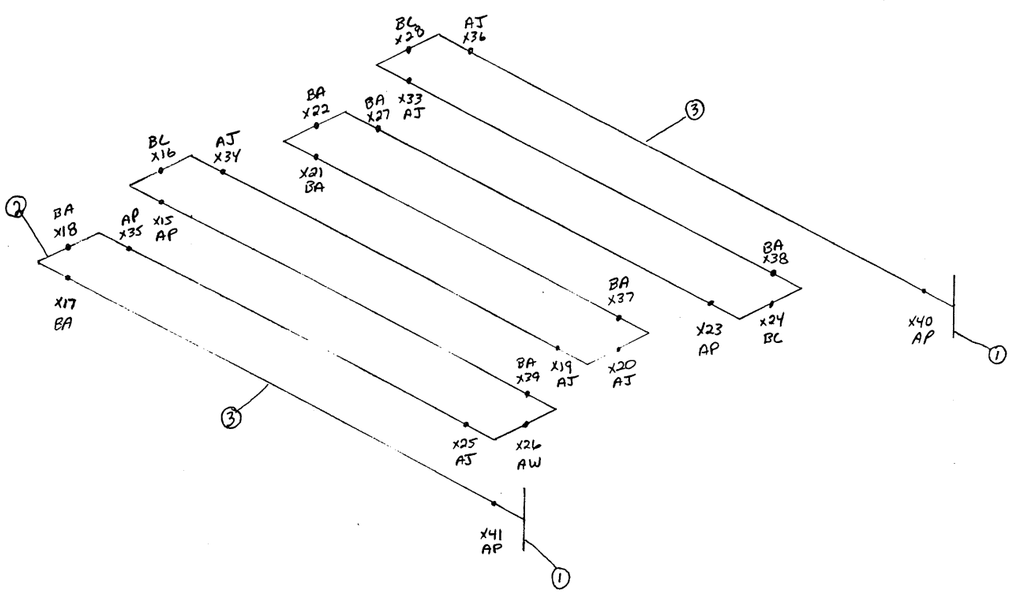
NOTE (2) ALL WELD ELLS SAME HT# & MATERIAL
(3) ALL PIPE SAME HT# & MATERIAL

ITM	QTY		HEAT NUMBER
1	2	4 1/16" I.D" WALL RTJ WN ADI FIG. A151 4130	14133
2	14	4" I.D" WALL WELD ELL A151 4130	L7032
3		4" OD I.D" WALL SEAMLESS PIPE A151 4130	242200

RT	ΔF	HYDRO	AREA CODE	INSULN.	DRAWN	DIA - INS	JOB # CONTROL #
MPI	BHN	DES. PRESS.	LINE SPEC.	TRACING	DATE		CLIENT P.O. #
LPI	PWHT	DES. TEMP.	FAB. CODE	PAINT SPEC.	CHK.	WEIGHT	PROJECT
WELD PROCEDURES				REF. DWG.	APPR.		SPOOL # REV Δ

BLUESTAR WELDING
DIVISION OF 570147 ALTA. LTD.

BSC 10K2MM-038



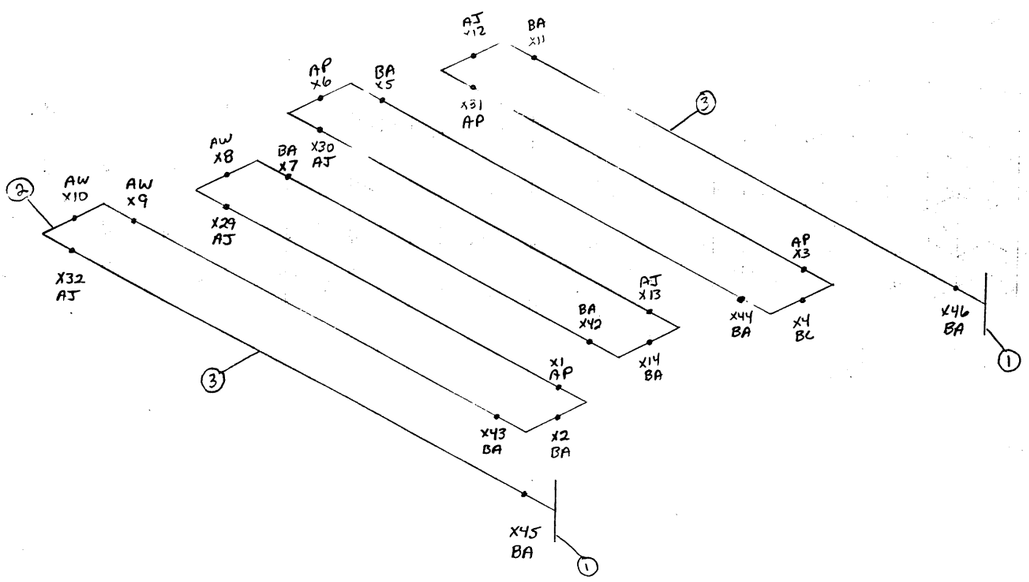
NOTE ② ALL WELD ELLS SAME HT#, MATERIAL
③ ALL PIPE SAME HT#, MATERIAL

ITM	QTY		HEAT NUMBER
1	2	4½" 1.0" WALL RTJWN API FLG A151413D	14133
2	14	4" x 1.0" WALL WELD ELL API A151413D	17302
3		4½" OD 1.0" WALL SEAMLESS PIPE A151413D	242200

RT	ΔF	HYDRO	AREA CODE	INSULN.	DRAWN	DIA - INS	JOB # CONTROL #
MPI	BHN	DES. PRESS.	LINE SPEC.	TRACING	DATE		CLIENT PO. #
LPI	PWHT	DES. TEMP.	FAB. CODE	PAINT SPEC.	CHK.		PROJECT
WELD PROCEDURES				REF. DWG.	APPR.	WEIGHT	SPOOL # REV Δ

BLUESTAR WELDING
DIVISION OF 570147 ALTA. LTD.

BSC 10K 2mm - 03A



NOTE (2) ALL WELD ELLS SAME HT# & MATERIAL
(3) ALL PIPE SAME HT# & MATERIAL

ITM	QTY		HEAT NUMBER
1	2	4 1/16" 1.0" WALL RTSWN ADJ FLG A1S14130	14133
2	14	4" 1.0" WALL WELD ELL A1S14130	L7032
3		4" OD 1.0" WALL SEAMLESS PIPE A1S14130	242200

RT	ΔF	HYDRO	AREA CODE	INSULN.	DRAWN	DIA - INS	JOB # CONTROL #
MPI	BHN	DES. PRESS.	LINE SPEC.	TRACING	DATE		CLIENT P.O. #
LPI	PWHT	DES. TEMP.	FAB. CODE	PAINT SPEC.	CHK.	WEIGHT	PROJECT
WELD PROCEDURES				REF. DWG.	APPR.		SPOOL # REV Δ