

A 634486

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

1. Manufactured and certified by Kootenay Industries Ltd. 5982-86 Avenue. S.E. Calgary, AB T2C 4L7 Canada  
(Name and address of Manufacturer)

2. Manufactured for Nexen Inc. 2900, 801-7 Avenue S.W. Calgary, AB T2P 3P7 Canada  
(Name and address of Purchaser)

3. Location of installation c-64-1/94-N-9  
(Name and address)

4. Type HORIZONTAL 13-125FKOD W3723.21 13-125-A REV.2 N/A 2014  
(Horiz. or vert., tank) (Mfg.'s serial No.) (CRN) (Drawing No.) (Natl. Bd. No.) (Year Built)

5. The chemical and physical properties of all parts meet the requirements of material specifications of the ASME BOILER AND PRESSURE VESSEL CODE. The design, construction, and workmanship conform to ASME Rules Section VIII, Div. 1 2010  
Year

to 2011 N/A N/A  
Addenda(date) Code Case No. Special Service per UG-120(d)

6. Shell: SA-516-70N 0.50" 0.0625" 5'-6" 15'-0" S/S  
Matl. (Spec. No., Grade) Nominal Thickness (Corr. Allow) (Inner Diameter) (Length overall)

7. Seams: TYPE 1 FULL 100% N/A N/A TYPE 1 SPOT 70% 2  
(Long. welded, dbl., singl., lap, butt) R.T. (spot or full) (Eff. %) (H.T. temp.) (Time, hr) [Girth, (welded, dbl., singl., lap, butt)] R.T. (Spot, or Full) (Eff. %) No. of courses

8. Heads: (a) Material SA-516-70N (b) Material SA-516-70N  
(Spec. No., Grade) (Spec. No., Grade)

	Location (Top Bottom, Ends)	Minimum Thickness	Corrosion Allowance	Crown Radius	Knuckle Radius	Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure (Convex or Concave)
(a)	END	0.4375"	0.0625"	-	-	2:1	-	-	-	CONCAVE
(b)	END	0.4375"	0.0625"	-	-	2:1	-	-	-	CONCAVE

If removable, bolts used (describe other fastening) N/A  
(Mat'l Spec. No., Grade, Size, No.)

9. MAWP 50 PSIG 15 PSIG at max. temp. 230°F 230°F  
(Internal) (External) (Internal) (External)

Min. design metal temp -49°F at 50 PSIG Hydro, pneu., or comb. test pressure 65 PSIG Proof test N/A

nozzles, inspection, and safety valve openings:

Purpose (Inlet, Outlet, Drain)	No.	Diameter or Size	Type	Material		Nozzle Thickness		Reinforcement Material	Attachment Details		Location (Insp. Open.)
				Nozzle	Flange	Nom.	Corr.		Nozzle	Flange	
		SEE	ATTACHED	SUPPLEMENTARY		FORM	U-4				

11. Supports: Skirt NO Lugs NO Legs NO Other SADDLES Attached BTM / WELDED  
(Yes or No) (Number) (Number) (Describe) (Where and how)

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

VOL. 407.8 Cu. Ft. (1.6 Cu. M.) FLARE KNOCK OUT DRUM RADIOGRAPHY AS PER PARA UW-11(a)5(b)  
IMPACT TEST EXEMPT AS PER UCS-66 (g) (SWEET SERVICE)  
MANUFACTURE DRAWING# 13-125-A REV.2 4-2"CL150 Blind Flanges c/w 32-5/8" Studs & 64-Nuts, 2-3"CL150 Blind Flanges c/w 16-5/8" Studs & 32-Nuts, 2-4"CL150 Blind Flanges c/w 16-5/8" Studs & 32-Nuts, 1-24"CL150 Blind Flange c/w 20-1 1/4" Studs and 40-Nuts, SA-193-B7M & SA-194-2HM UNC.

**CERTIFICATE OF SHOP/FIELD COMPLIANCE**

We certify that the statements made in this report are correct and that all details of design, material, construction, and workmanship of this vessel conform to the ASME Code for Pressure Vessels, Section VIII, Division 1, "U" Certificate of Authorization Number 38,258 Expires February 11, 2015

Date Jan. 6/14 Co. Name Kootenay Industries Ltd. Signed [Signature]  
(Manufacturer) (Representative)

**CERTIFICATE OF SHOP/FIELD INSPECTION**

Vessel constructed by Kootenay Industries Ltd. at 5982-86 Avenue. S.E. Calgary, AB T2C 4L7 Canada

I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State or Province of Alberta and employed by ABSA have inspected the component described in this Manufacturer's Data Report on JAN 06 2014 and state that, to the best of my knowledge and belief, the Manufacturer has constructed this pressure vessel in accordance with ASME Code, Section VIII, Division 1. By signing this certificate, neither the Inspector nor his employer makes any warranty, expressed or implied, concerning the pressure vessel described in this Manufacturer's Data Report. Furthermore, neither the Inspector nor his employer shall be liable in any manner for any personal injury or property damage or a loss of any kind arising from or connected with this inspection.

Date JAN 06 2014 Signed [Signature] Commissions AB 242 NB 12860 A, B  
(Authorized Inspector) (Natl Board incl. endorsement, State, Province and No.)



**FORM U-4 MANUFACTURER'S DATA REPORT SUPPLEMENTARY SHEET**  
As Required by the Provisions of the ASME Code Rules, Section VIII, Division 1

A 634 486

1. Manufactured and certified by Kootenay Industries Ltd. 5982-86 Avenue S.E. Calgary, AB T2C 4L7 Canada  
(Name and Address of Manufacturer)

2. Manufactured for Nexen Inc. 2900, 801-7 Ave. S.W. Calgary, AB T2P 3P7 Canada  
(Name and Address of Purchaser)

3. Location of installation c-64-1/94-N-9  
(Name and Address)

4. Type HORIZONTAL FLARE KNOCK OUT DRUM 13-125FKOD  
(Horiz., vert., or sphere) (Tank, separator, heat exch., etc.) (Mfg's Serial No.)

W3723.21 13-125-A Rev.2 N/A 2014  
(CRN) (Drawing No.) (Nat'l Bd. No.) (Year built)

10. Nozzles, inspection, and safety valve openings continued




Purpose (Inlet, Outlet, Drain, etc.)	No.	Diameter or Size	Type	Material		Nozzle Thickness		Reinforcement Material	Attachment Details		Location (Insp. Open.)
				Nozzle	Flange	Nom.	Corr.		Nozzle	Flange	
INLET	1	16" CL150	PIPE/ RFWN	SA-333-6	SA-350-LF2 CL.1	0.50"	1/16"	INHERENT	UW-16.1(c)	TYPE 1	SHELL
OUTLET	1	16" CL150	PIPE/ RFWN	SA-333-6	SA-350-LF2 CL.1	0.50"	1/16"	INHERENT	UW-16.1(c)	TYPE 1	SHELL
TRUCK OUT	1	3" CL150	PIPE/ RFWN	SA-333-6	SA-350-LF2 CL.1	0.438"	1/16"	INHERENT	UW-16.1(c)	TYPE 1	SHELL
LIQUID OUT	1	3" CL150	PIPE/ RFWN	SA-333-6	SA-350-LF2 CL.1	0.438"	1/16"	INHERENT	UW-16.1(c)	TYPE 1	SHELL
SPARE	1	3" CL150	PIPE/ RFWN	SA-333-6	SA-350-LF2 CL.1	0.438"	1/16"	INHERENT	UW-16.1(c)	TYPE 1	SHELL
FUEL GAS INLET	1	3" CL150	PIPE/ RFWN	SA-333-6	SA-350-LF2 CL.1	0.438"	1/16"	INHERENT	UW-16.1(c)	TYPE 1	SHELL
ANODE	1	4" CL150	PIPE/ RFWN	SA-333-6	SA-350-LF2 CL.1	0.674"	1/16"	INHERENT	UW-16.1(c)	TYPE 1	SHELL
SPARE	1	4" CL150	PIPE/ RFWN	SA-333-6	SA-350-LF2 CL.1	0.531"	1/16"	INHERENT	UW-16.1(c)	TYPE 1	SHELL
SPARE	1	4" CL150	PIPE/ RFWN	SA-333-6	SA-350-LF2 CL.1	0.531"	1/16"	INHERENT	UW-16.1(c)	TYPE 1	SHELL
PI	1	2" CL150	PIPE/ RFWN	SA-333-6	SA-350-LF2 CL.1	0.344"	1/16"	INHERENT	UW-16.1(c)	TYPE 1	SHELL
TT	1	2" CL150	PIPE/ RFWN	SA-333-6	SA-350-LF2 CL.1	0.344"	1/16"	INHERENT	UW-16.1(c)	TYPE 1	SHELL
LG / LT	2	2" CL150	PIPE/ RFWN	SA-333-6	SA-350-LF2 CL.1	0.344"	1/16"	INHERENT	UW-16.1(c)	TYPE 1	SHELL
LS	2	2" CL150	PIPE/ RFWN	SA-333-6	SA-350-LF2 CL.1	0.344"	1/16"	INHERENT	UW-16.1(c)	TYPE 1	SHELL
PIPE SUPP'T	1	2"	CPLG	SA-350-LF2 CL.1	N/A	CL3000	1/16"	INHERENT	UW-16.1(c)	TYPE 1	SHELL
MANWAY c/w DAVIT	1	24 "CL150	RF'HB	SA-350-LF2 CL.1	N/A	1.75"	1/16"	INHERENT	UW-16.1(c)	N/A	HEAD

Certificate of Authorization: Type "U" No. 38,258 Expires February 11, 2015

Date Jan. 6/14 Name Kootenay Industries Ltd. Signed [Signature]  
(Manufacturer) (Representative)

JAN 06 2014 Name Nilanjan Nag Commissions AB 242 NB 12860 A, B  
(Authorized Inspector) (Nat'l Board incl. endorsement, State, Province and No.)



	CERTIFIED BY	
		
	MAWP <u>50</u>	PSI AT <u>230</u> °F
	MDMT <u>-49</u>	°F AT <u>50</u> PSI
MAEWP <u>15</u> PSI AT <u>-49/230</u> °F		
SERIAL NO. <u>13-125FK02</u>		YEAR BUILT <u>2014</u>
CRN <u>W3723.20</u>		 <u>634486</u>
VESSEL TYPE <u>FLARE KNOCK OUT DRUM</u>		
SHELL <u>SA-516-70N</u>		
THICKNESS <u>0.50</u> INCHES		
TAG <u>V-621</u>		
5982-86 AVE. S.E. CALGARY, CANADA PH: 403-720-2722		

Job #13-125





CERTIFIED BY

**Kootenay**  
INDUSTRIES LTD

MAWP 50 PSI AT 230 °F  
MDMT -49 °F AT 50 PSI

MAWP 15 PSI AT -49/230°F

SERIAL NO. 13-125EKO YEAR BUILT 2014

(A) 634486

CRN W3723.20

VESSEL TYPE FLARE KNOCK OUT DRUM

SHELL SA-516-70N

THICKNESS 0.50 INCHES

TAG V-621

5982 - 86 AVE. S.E. CALGARY, CANADA PH: 403-720-2722

Job #13-125