

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

A433 616

1. Manufactured and certified by Opsco'92 Industries Ltd. 2601 Centre Avenue East, Calgary, Alberta, T2P 2L1
(Name and address of manufacturer)

2. Manufactured for SUNCOR INC. RESOURCES GROUP, 112-4TH AVE. SW, CALGARY, AB.
(Name and address of purchaser)

3. Location of installation LSD:11-28-74-10 W6M
(Name and address)

4. Type VERT., BLOWCASE V-2699B N7407.2 V-97-2699-1513 R.2 N/A 1997
(Horizontal or vert. tank) (Mfg's serial No.) (CRN) (Drawing No.) (Nat'l Bd No.) (Year)

5. The chemical and physical properties of all parts meet the requirements of material specification of the ASME BOILER AND PRESSURE VESSEL CODE. The design, construction, and workmanship conform to ASME Rules, Section VIII, Division 1
1995
(Year)

to 1995 N/A N/A
Addenda (date) Code Case Nos. Special service per UG-120(d)

6. Shell: SA-516-70N 1.5" .125" 2'-3" 8'-0"
Mat'l (Spec. No., Grade) Nominal Thk. (in.) Corr. Allow. (in.) Diameter I.D. (ft. & in.) Length (overall) (ft. & in.)

7. Seams: TYPE 1 FULL 100% 1150 F 1.5 HRS TYPE 1 FULL 1
Long (Weld Dbl. Singl., Lap, Butt) R.T. (Spot or Full) Eff. (%) H.T. Temp (F) Time (hr) Girth (Welded Dbl., Singl., Lap, Butt) R.T. (Spot, Partial or Full) No. of Courses

8. Heads: (a) Mat'l SA-516-70N (b) Mat'l 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 Pres (Circ/Conv)
(a)	TOP	1.445	.125			2:1				CONC
(b)	BTM	1.445	.125			2:1				CONC

if removable, bolts used (describe other fasteners)

9. MAWP: 1435 psi at max. temp 130 F °F
Min. Des. Met. Temp. -20 F °F at 1435 psi Hydro. pres. / Comb. test pressure 2153 psi

10. Nozzles, inspection and safety valve openings:

Purpose (Inlet, Outlet, Drain)	No.	Diam. or Size	Type	Mat.	Nom. Thk.	Reinforcement Material	How Attached	Location
LSH/LS/INSP	2	4"	600#-RFLWN	SA-105N	1"	INTEGRAL	WELDED	SHELL
W/DRAIN/LT	4	2"	600#-RFLWN	SA-105B	.343"	INTEGRAL	WELDED	
PSV	1	1"	600#-RFLWN	SA-105N	.500"	INTEGRAL	WELDED	
LG/R/I	6	.75"	600#-RFLWN	SA-105N	.570"	INTEGRAL	WELDED	

11. Supports: Skirt YES Lugs NO Legs NO Other NO BTM HD & WELDED
(Yes/no) (No.) (No.) (Describe) (Where and how)

12. Remarks: Manufacturer's Partial Data Reports properly identified and signed by Commissioned Inspectors have been furnished for the following the report:

(Name of part, item number, Mfg's name and identifying stamp)

Impact Testing: EXEMPT AS PER UCS-66

Radiography per: UW-11a

Tag No.: V-410

Volume: 1.02 CU.M

CRN DN: V-97-2699-1513 R.P/Q

CERTIFICATE OF SHOP COMPLIANCE

We certify that the statements made in this report are correct and that all details of design, material, construction and workmanship of this vessel conform to the ASME Code for Pressure Vessels, Section VIII, Division 1, "U" Certificate of Authorization No. 21356 expires July 21, 1998

Date July 25/97 Co. Name Opsco'92 Industries Ltd. Signed [Signature]
(Manufacturer) (Representative)

CERTIFICATE OF SHOP INSPECTION

Vessel constructed by Opsco'92 Industries Ltd. at CALGARY, ALBERTA, CANADA
I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and / or the State or Province of ALBERTA and employed by ABSA, Alberta Boilers Safety Association

have inspected the component described in the Manufacturer's Data Report on 25 JULY 1997, 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 the 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 97 8 25 Signed [Signature] Commissions ALBERTA #85
(Authorized Inspector) (Nat'l Bld (incl. endorsements), State, Prov. and No.)