

**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**

(A) 507848

1. Manufactured and certified by Bilton Welding & Manufacturing Ltd., 5815 - 37th Street, Innisfail, AB T4G 1S8  
(Name and address of manufacturer)

2. Manufactured for XXL Engineering Ltd., #101, 807 Manning Road N.E., Calgary, AB T2E 7M8  
(Name and address of purchaser)

3. Location of installation ARC Resources Ltd. 2100 - 440 2 Ave SW, Calgary, AB T2P 5E9 LSD: 07 - 16 - 75 - 9 W6M  
(Name and address)

4. Type Horizontal Knockout 13309 R6386.2 BWM-102-04 R0 2004  
(Horiz. or vert. tank) (Mfrg'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, Division 1 2001  
Year

to 2003

Addenda (Date)		Code Case Nos				Special Service per UG 120(d)		
<u>6. Shell:</u>	<u>SA-516-70N</u>	<u>3/8"</u>	<u>1/8"</u>	<u>4' - 0"</u>	<u>10' - 0"</u>			
		<small>Matl. (Spec. No., Grade)</small>	<small>Nom. Thk. (in.)</small>	<small>Corr. Allow. (in.)</small>	<small>Diam. I.D. (ft. &amp; in.)</small>	<small>Length (overall) (ft. &amp; in.)</small>		
<u>7. Seams:</u>	<u>Single Butt</u>	<u>None</u>	<u>0.7</u>	<u>N/A</u>	<u>N/A</u>	<u>Single Butt</u>	<u>None</u>	<u>1</u>
		<small>Long (Welded, Dbl., Sngl., Lap, Butt)</small>	<small>R.T. (Spot or Full)</small>	<small>Eff. (%)</small>	<small>H.T. Temp. (F)</small>	<small>Time (hr)</small>	<small>Girth, (Welded, Dbl., Sngl., Lap, Butt)</small>	<small>R.T (Spot, Partial, No. of Courses or Full)</small>
<u>8. Heads: (a) Matl.</u>	<u>SA-516-70N</u>				<u>(b) Matl.</u>	<u>SA-516-70N</u>		
	<small>(Spec. No., Grade)</small>					<small>(Spec. No., Grade)</small>		
<u>(a)</u>	<u>LEFT</u>	<u>0.313"</u>	<u>1/8"</u>	<u>42"</u>	<u>3"</u>	<u>N/A</u>		<u>CONCAVE</u>
<u>(b)</u>	<u>RIGHT</u>	<u>0.313"</u>	<u>1/8"</u>	<u>42"</u>	<u>3"</u>	<u>N/A</u>		<u>CONCAVE</u>

If removable, bolts used (describe other fastenings) 1 1/8" STUDS: SA-193-B7, NUT: SA-194-2H

(Mat'l, Spec. No., Gr., Size, No.)

9. MAWP 50 psi at max. temp. 100 °F.  
 Min. design metal temp. -40 °F at 50 psi. Hydro., pneu., or comb. test pressure 75 psi.

10. Nozzles, inspection and safety valve openings:

Purpose (Inlet, Outlet, Drain)	No.	Diam. or Size	Type	Matl.	Nom. Thk.	Reinforcement Matl.	How Attached	Location
N1, N2, N3 - INLET, OUTLET, GAUGE	3	4"	150# RFWN	SA106B/SA105N	0.337"	N/A	UW-16 1(c)	SHELL
N4 - TRUCKOUT	1	3"	150# RFWN	SA106B/SA105N	0.300"	N/A	UW-16 1(c)	SHELL
M1 - MANWAY	1	20"	150# RFSS	SA106B/SA105N	0.375"	N/A	UW-16 1(c)	SHELL

11. Supports: Skirt NO (Yes or no) Lugs NO (No.) Legs NO (No.) Other NO (No.) Saddles (Describe) Attached SHELL & WELDED (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, Mfrg's. name and identifying stamp)

CONSTRUCTION DRAWING: A952-1 REV.1, PSV ON PIPING AS PER UG-125, VOLUME: 141.5 FT^3 (4.0 m^3)

IMPACTS EXEMPT PER UG-20(f)(1-5), NO RADIOGRAPHY AS PER UW-11(c)

**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 No. 33.470  
 expires AUGUST 16, 2005.

Date 03/31/04 Co. name BILTON WELDING & MANUFACTURING LTD. Signed J. J. Mylrea (Representative)

**CERTIFICATE OF SHOP/FIELD INSPECTION**

Vessel constructed by BILTON WELDING & MANUFACTURING LTD. at 5815 - 37th Street, Innisfail, AB T4G 1S8

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 Alberta Boiler Safety Association

have inspected the component described in this Manufacturer's Data Report on Mar 31, 2004, 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 Mar 31, 2004 Signed Dan Warkentin Commissions A/ta #70A (Name Board (incl. endorsements), State, Prov. and No.)

