

Vendor Surveillance / Inspection Report – 01

Inspection item description Kelt Inlet Separator OAK Project 5486

PO #:	AFE 2106 0013L			Report #:	003		
Level of Inspection:	Periodic review			Date of Visit:	June 18 2021		
Equipment Description:	Inlet separator package			Tag #:			
Type of Inspection:	Visual surveillance of build final						
PO Delivery Date:				Estimated Delivery Date:	July 2021		
Project:	Oak Inlet Separator			LSD:			
Inspector:	Mark Copithorne			Phone/Email:			
CEL Quality Contact	403-844-3341			Phone/Email:			
Vendor:	Aspire Energy			Vendor Job No:	5486		
Vendor Main Contact Name:	David Street			Phone/Email:	403-314-5422		
Location of Equipment:	22 Mckenzie Dr Red Deer AB						
Applicable Codes, Standards, and Specifications:	<p>Please refer to the Engineered Design / Drawings, Fabrication and Assembly Codes / Standards and applicable Engineering Specifications utilized for the particular equipment / project for acceptance criteria and LIST THE DOCUMENTS IN THIS SECTION.</p> <ul style="list-style-type: none"> • ASME B31.3 • ASME Section 8 Div 1 • CSA B51 • PESR • Alberta Safety Codes Act • Standard Industry Practice • Specifications <p>The percentages below are based on Inspection dated:</p>						
Materials Received: 100%	Piping Spools: 100%	Structural: 100%	Assembly 100%	Building / Insulation: 0 %	Instrumentation / Electrical: 0%	Vessels: 100%	OVERALL PERCENTAGE COMPLETE: 90%

Engineering / Drawing Status

Reviewed IFC Drawings 5486-05 Rev 1; March 22 2021; 5486-08 April 5 2021, 5486-09 Rev 0, Apr 16 2021 All IFC stamped IFC
Reviewed weld procedure 2255.2

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Document Review

June 18 2021:

Final inspection of the vessel externally and last piping hydrotest following construction. Drawing 5486-01 rev 1
Pressure test to 1110 psi. Pass.
Gauges utilized CT-3002, 0-3000 psi, AE 3000c1 Calibration date Dec 4 2020, verified
PG-8156 , 0-3000 psi. Calibration date Dec 4 2021, AE 3000 D1
A# stamping and data plate have not been attached at time of inspection.

May 8 2021

Review drawings 5486-05 Rev 1; March 22 2021, Rev 0; 5486-08 April 5 2021, 5486-09 Rev 0, Apr 16 2021 All IFC stamped IFC
Review QC file to date
Validate heat numbers to material order for shell plate, SA 516-70, heat 512631722
Validate Manway head material and heat . SA 516-70, 2" thick material x 96" diameter. H1263171, 474832802701
Review RT reports and reshoot data for repairs to long and circ welds, porosity. ECHO Nde primary NDE supplier.

Material / Long Lead Equipment Delivery Status

No material delays expected

Assembly Details – Inspection

June 18 2021:

Inspection of completed vessel.
External painting incomplete at time of inspection
Building is not assembled at this time
Electrical is not complete at this time
All piping is complete and tested
Partial internal of the vessel. 100% internally coated with Davoe 253
Weir has a removable plate that will be left out. This will allow product flow approximately 1 foot below the 50% level in the vessel. Chris Henderson contacted June 18 2021 and verified by phone that the weir plate is to be left out.
Coating requires repair on the manway seal face, run in the coating will allow a potential leak. David Street to verify repairs to coating are completed.
The saddle support has had an 8 inch hole cut to allow the passage of a 2" line. The hole is reenforced with 0.375" wall pipe and is welded both sides. David Street to verify integrity of the saddle with material removed.
Building, paint, electrical are required to complete
Final sign off of QC documentation.

May 8 2021

The vessel is 85% completed
Internals installed and fit in position
Shell and head connections completed, reshoot of repaired welds occurring May 7 2021 after 5 pm
Nozzle installation proceeding N7 , N 4 , N8 and 9, N 18 and b under construction
Saddle is tacked into position
Vessel is scheduled for stress relief in Edmonton May 14 2021

Vessel skid welding is complete, no paint. Drip tray installed
Skid sump complete and welds visually acceptable.

Piping is ongoing with 20% fabrication completed for the skid proper

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Progress / Scheduling Comments / Concerns

No schedule delays expected at this time

General areas of Concern and / or Non-Conformances

June 18 2021

Verify hole in saddle support will not affect load bearing ability of the vessel with full hydrotest weight of water.
David Street to supply supporting engineering documentation

May 8 2021

No BC piping registration design documents are available to Aspire at this time to identify piping registration against the piping being built for the skid as per OGC and Tech safety requirements.

Recommend that the Technical Safety BC document FRM 1330, be filled out and certified by Aspire; as per D-BP-2011-01 Rev 1 Directive: Inspection requirements for piping systems and components.
Documents attached with email.

Dehy skid: A small dehy skid is being fabricated by Aspire for Kelt as well.
The skid is a collection of surplus vessels held by Aspire.

A large percentage of the 2" piping is threaded. No drawings were reviewed and not on inspection scope.
Internal inspection of the vessels did not indicate areas of concern with weld defects or internals out of position.

The glycol float chamber vessel (6" diameter, horizontal) has a float installed that cannot be removed thru the 2" threaded weldolet.
Client evaluation is required if vendor is to remove and replace with a float that can be serviced or continue with the non removable float assembly?

Photographic Documentation with Captions

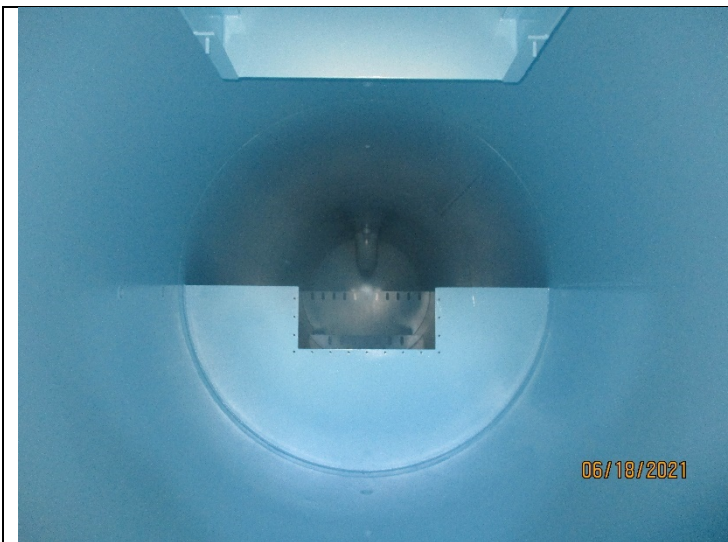


Figure 1 weir assembly as to be shipped



Figure 2. damage to manway coating, seal face. To be repaired by Aspire May 19 2021

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Hole thru saddle support, Aspire to confirm load bearing ability of saddle with full hydrotest weight



Hole is 8 inch diameter with a 0.375" wall reinforcement



Figure 5: Piping hydrotest at 1100 psi Gauge AE 3000-D1



Figure 6: Piping hydrotest at 1100 psi Gauge AE 3000-C1

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