

Travel Sheet

Authorized Inspector to be given travel sheet prior to construction so that he can indicate hold points and inspection Points.

"A"-Hold Point, "I"- Inspection Point, "R"-Revision, "W"- Witness Point

Hold Points established - Sign & Date

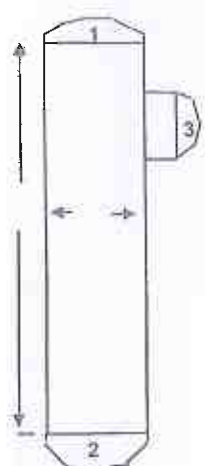
J.P.H. APRIL 30/13
(Authorized Inspector)

Vessel Range 12863 to 12865

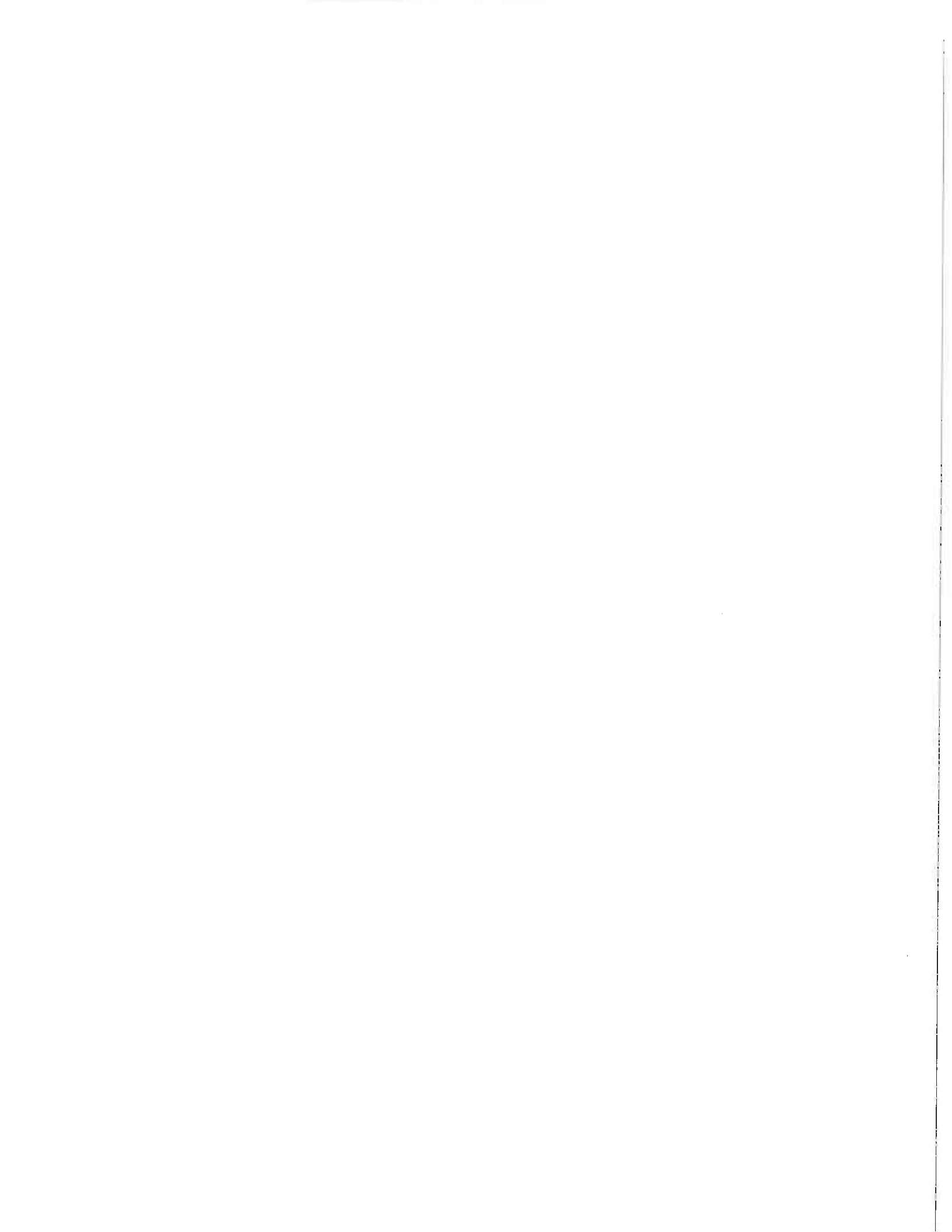
Vessel Serial # **12865** DWG # **V01-381-R1** (A) # **622779**

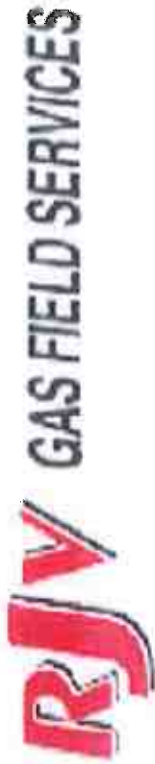
Vessel Title: **16" 3 Phase Separator** CRN # **P7217.231**

ITEM	COMMENTS	AUTH Insp., Hold Rev., Witness POINTS	DATE FUNCTION COMPLETE & INSPECTORS INITIALS	
			QC INSPECTOR	AUTHORIZED INSPECTOR
APPROVED DRAWING		X	April 22, 2013	(P) J.P.H. May 23/13
CALCULATIONS ON FILE		X	April 22, 2013	(P) J.P.H. May 23/13
MATERIAL CHECKED AGAINST DRAWING, MATERIAL LIST			April 22, 2013	(P)
MTR'S CHECKED		X	April 22, 2013	(P) J.P.H. May 23/13
VESSEL LAYOUT			April 22, 2013	(P)
NOZZLES & FITTINGS	ORIENTATION		April 23, 2013	(P)
	RATINGS	X	April 23, 2013	(P) J.P.H. May 23/13
FIT UP	NOZZLES & FITTINGS		April 23, 2013	(P)
	SHELL & HEAD		April 30, 2013	
INTERNALS (tray, baffles, etc)			April 29, 2013	(P)
INTERNAL INSPECTION		H	April 30, 2013	(P) J.P.H. APRIL 30/13
MATERIAL INSPECTION REPORT		X	April 24, 2013	(P) J.P.H. May 23/13
WELD SIZES		X	May 15, 2013	(P) J.P.H. May 23/13
WELDERS I.D.			May 15, 2013	(P)
EXTERNAL AFTER COMPLETION OF ALL WELDING		X	May 15, 2013	(P) J.P.H. May 23/13
INTERNAL ON TYPE 1 JOINTS			May 15, 2013	(P)
RADIOGRAPHS		X	May 16, 2013	(P) J.P.H. May 23/13
OTHER N.D.E.				
IMPACT TESTS				
POST WELD HEAT TREATMENT	YES: <input checked="" type="checkbox"/> NO: <input type="checkbox"/>			
EXTERNAL BEFORE PWHT				
PWHT CHART CHECKED				
NAMEPLATE		X	May 23, 2013	(P) J.P.H. May 23/13
HYDROSTATIC TEST		H	May 23, 2013	(P) J.P.H. May 23/13
DATA REPORT		X	May 23, 2013	(P) J.P.H. May 23/13
NONCONFORMANCES				



		SPECIFICATIONS	HEAT NUMBER	VERIFIED THICKNESS
SHELL	C1	SA-106-B	6704637 ✓	21.44mm
	1	SA-516-70	SF01246-PC78159801 -	20.63mm.
HEADS	2	SA-516-70	SF01246-PC78159801 -	20.63mm.
	3			
REPADS	1			
	2			
	3			
	4			
		SPECIFICATIONS	SIZE	SCHEDULE
NOZZLES		SA-106-B	2", 3"	Sch. 160
FITTINGS		SA-105	1/2", 3/4", 1", 2"	CL6000 cplg.
TUBES				





2999

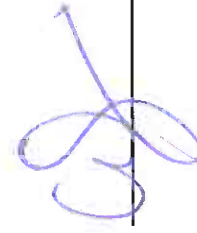
PURCHASE ORDER #

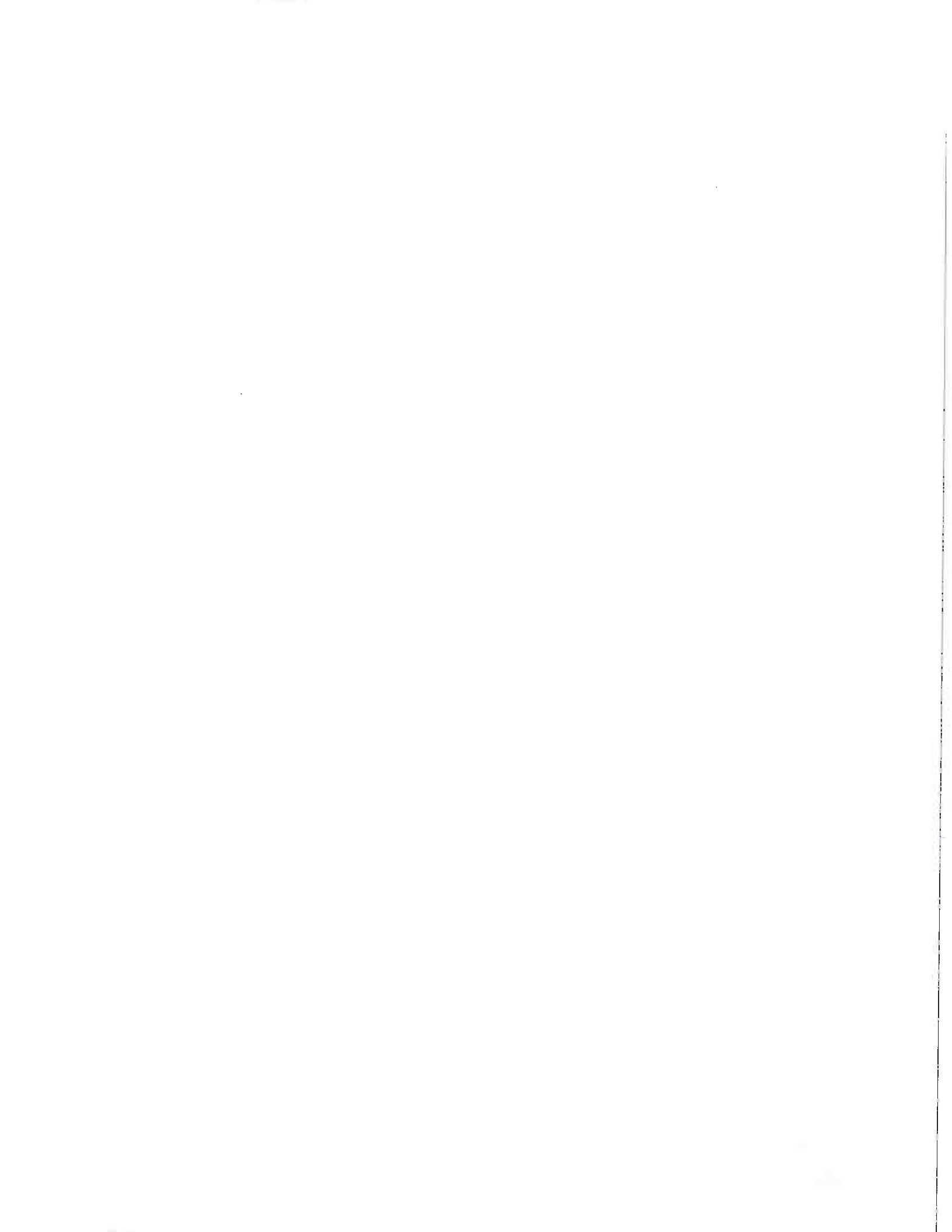
DATE May 3, 2013
 VENDOR V.E.G. Oilfield Supply
 CONTACT ALL
 DATE REQUIRED 30" Vessel
 JOB NUMBERS

4901 Bruce Road Vegreville, Alberta T9C 1C3
 Phone: (780) 632-7774

Item	Quantity	Material Spec.	Description	Nom. Thickness	Min. Head	Will Test	Q.C. Check	Price
1	4	SA-105	4" CL600 RFLN		-	-		
1	4	SA-105	4" CL600 RFWN		-	-		
2	6	SA-105	2" NPT Cplg.	CL6000				
3	12	SA-105	3/4" N.P.T. Full Cplg.	CL6000		-		
4	2	SA-105	1/2" N.P.T. Full Cplg.	CL6000		-		
5	2	SA-234-WPB	2" 90° elbow	XXH		-		
7	2	SA-106-B	2" SMLS Pipe	XXH		Yes		
9	1	SA-106-B	4" SMLS Pipe	XXH		Yes		

- The above items are to be formed to meet the requirements of ASME Section VII, Div. 1 USC 79(d).
- Tack welds that are welded must use procedures and welders qualified to ASME Section IX
- On all code required material, Markings must be accurately transferred to formed material or cut pieces.


 Authorized Signature





PRESSURE TEST RECORD

Date:

Vessel Serial Number:

Vessel Design Pressure:

Hydro Test Pressure:

Temperature:

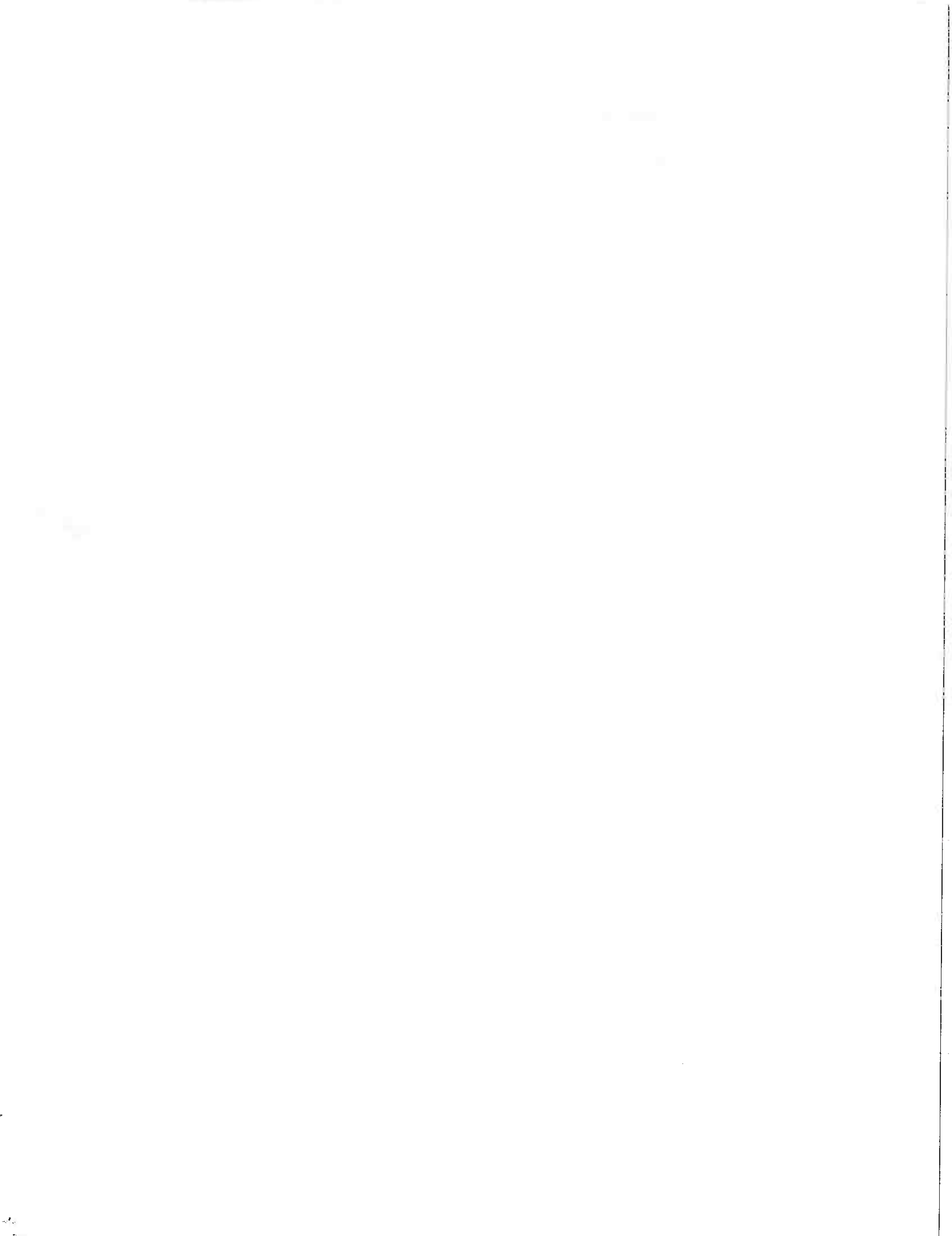
Test Gauge No.: # #

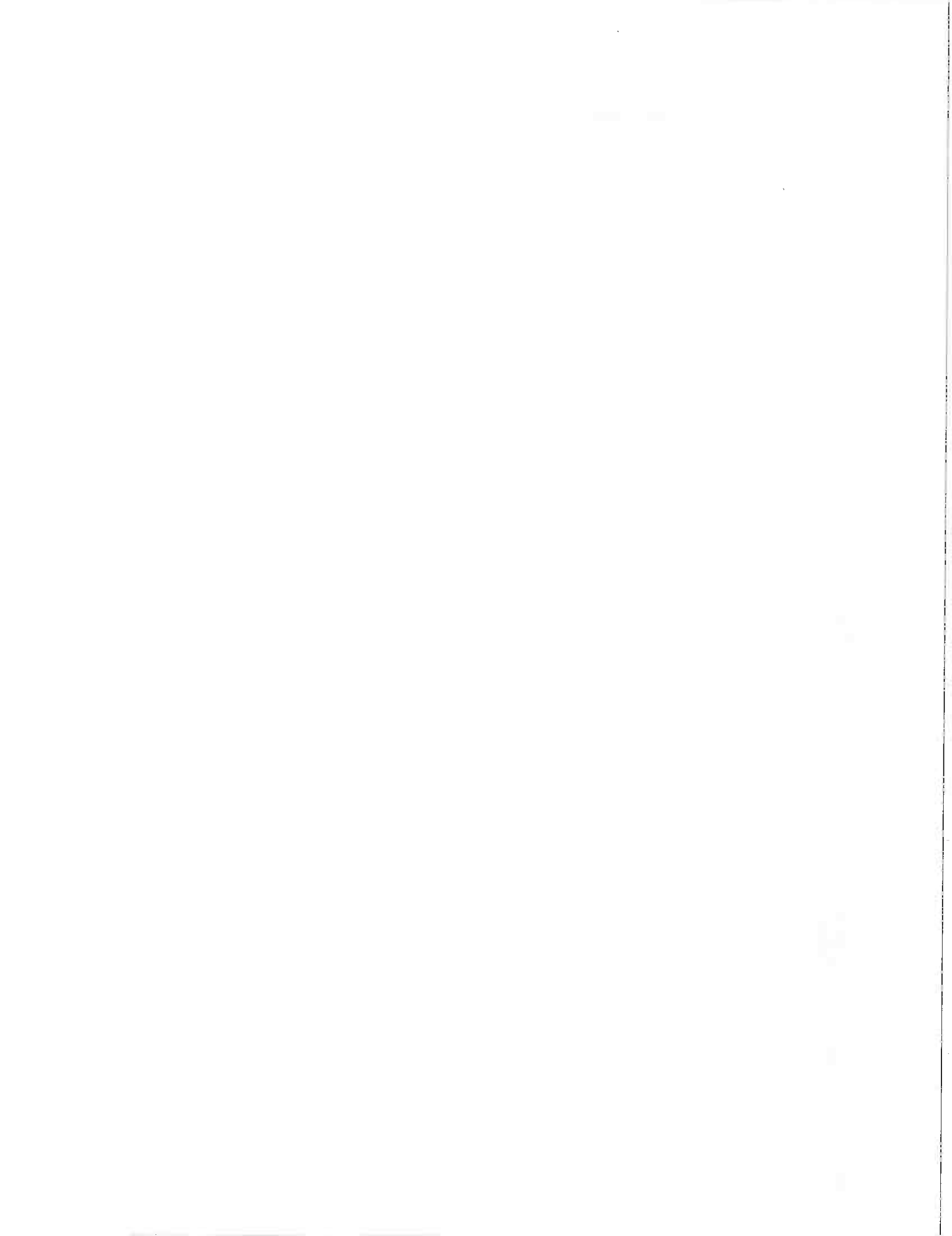
Hydro By:

Q.C. Signature:

Print Clearly

Original to be returned to Q.C. on completion of hydro.





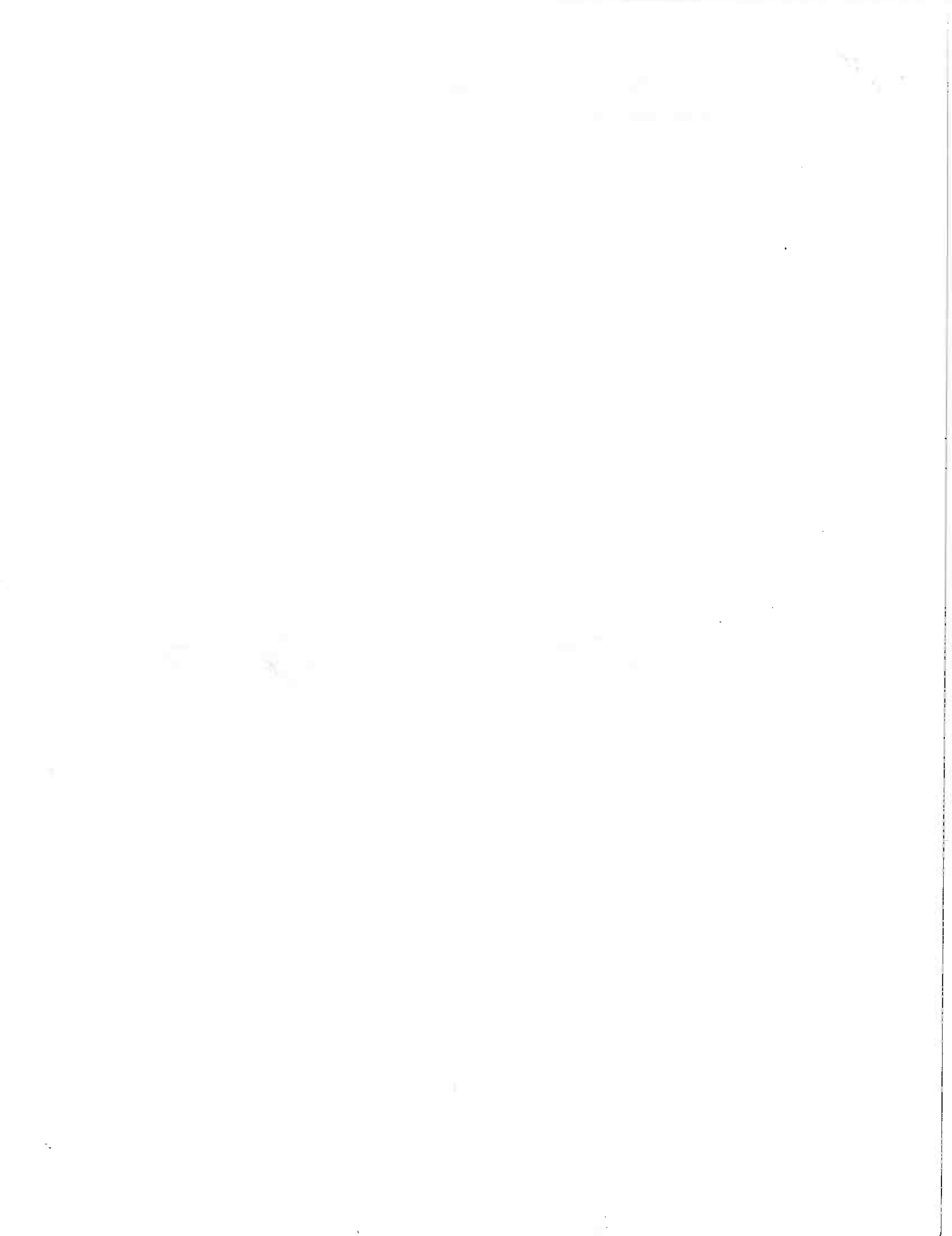


Vessel Name Plate Travel Sheet

Vessel Serial Number:	<input type="text" value="12865"/>		
Vessel Name:	<input type="text" value="Vertical 3 Phase Separator"/>		
Vessel DWG #:	<input type="text" value="V01-381-R1"/>		
Vessel C.R.N. #	<input type="text" value="P7217.231"/>		
Vessel Design Pressure:	<input type="text" value="1480 Psi."/>		
Hydro Pressure:	<input type="text" value="2220 Psi."/>		
Plate Originator:	<input type="text" value="Wes"/>	Date:	<input type="text" value="April 24,2013"/>
Engraved By:	<input type="text" value="CK"/>	Date:	<input type="text" value="Apr 1, 13"/>
Picked Up By:	<input type="text"/>	Date:	<input type="text"/>

Print Clearly

Original to be returned to Q.C.



W
RT - 2

Certified By

RJV **GAS FIELD SERVICES**

Vegreville, Alberta
Phone (780)632-7774

A# 622 779

UNIT NAME

Vertical 3 Phase Separator

M.A.W.P. Internal	AT	DESIGN TEMP.	M.A.W.P. External
10204 Kpa.	@	38 °C	Kpa.
1480 Psi.	@	100 °F	p.s.i.

MINIMUM DESIGN METAL TEMPERATURE			YEAR BUILT
-29 °C	@	10204 Kpa.	2013
-20 °F	@	1480 p.s.i.	

C.R. NUMBER	SERIAL NO.
P7217.231	12865

CORR. ALLOW.	HEAT TREATMENT	HYDRO TEST
1.6 mm	Nil	15307 Kpa.
SHELL THICK.	HEAD THICK.	2220 p.s.i.

21.44 mm	Top - 20.63 mm	WEIGHT
SHELL MAT'L	Bottom - 20.63 mm	685 Kg.
	HEAD MAT'L	SIZE

SA-106-B	Top- SA-516-70	406 X 2285
	Bottom- SA-516-70	

PTT 6604A

W
RT - 1

Certified By

RJV GAS FIELD SERVICES

Vegreville, Alberta
Phone (780)632-7774

A# 622 779

UNIT NAME

Vert. 3 Phase Separator

M.A.W.P. Internal	AT	DESIGN TEMP.	M.A.W.P. External
9928 Kpa.	@	56 °C	Kpa.
1440 Psi.	@	133 °F	p.s.i.

MINIMUM DESIGN METAL TEMPERATURE			YEAR BUILT
-29 °C	@	9928 Kpa.	2013
-20 °F	@	1440 p.s.i.	

C.R. NUMBER	SERIAL NO.
W1153.21	12866

CORR. ALLOW.	HEAT TREATMENT	HYDRO TEST
3.17 mm	NO	14892 Kpa.
SHELL THICK.	HEAD THICK.	2160 p.s.i.

31.75 mm	Top - 30.16 mm	WEIGHT
SHELL MAT'L	Bottom - 30.16 mm	2689 Kg.
	HEAD MAT'L	SIZE

SA-516-70N	Top- SA-516-70N	762 X 3048
	Bottom- SA-516-70N	

PTT 660 #A



ISO 9001:2008

RADIOGRAPHIC TESTING REPORT

R- 249849

PAGE 1 OF 1

MATERIAL TYPE P1

FILM BRAND Agfa

RADIATION SOURCE Ir 192 Co 60 X-RAY

KV 65 CI

MM / IN 0.142"

DATE May 16/13

ACUREN JOB # 231-71783-84

POWO # Serial # 12865

PROCEDURE # AGI RT-01

ACCEPTANCE ASME SEC VIII

STANDARD D:VI uWSa 2010

CLIENT RSJ

ATTENTION Dave

ADDRESS Vessel-Spot

PROJECT Vegreville

WORK LOCATION

Legend 1. Accept 2. Moderate 3. Reject *Weider Symbol

NO	IDENTIFICATION	PIPE DIA.	PIPE SCH	PIPE TYPE	REIN.	TECH #	SOD (D)	OFD (t)	# OF EXP	C R K	L I P S	U C R P	DEFECT LOCATION & REMARKS	ACC	REJ
1	SP1 0-6	16"	80	D5	.125"	1	8"	.844"	1				M, E	✓	✓
2															
3															
4															
5															
6															
7															
8															
9															
10															
11															
12															
13															
14															
15															
16															
17															
18															
19															
20															

REFER TO OPPOSITE SIDE FOR SCOPE OF SERVICES AND STANDARD OF CARE

SIGNATURES

CLIENT REPRESENTATIVE [Signature] SIGNATURE [Signature] DTR # 2391571

TECHNICIAN (SIGN) Brad Osmonov SIGNATURE [Signature] FILM USED 1 FILM SIZE 4 1/2 x 8 1/2

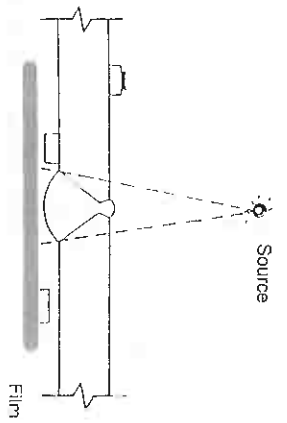
PRINT NAME: Brad Osmonov 1st TECHNICIAN CGSB LEVEL II SNT LEVEL II PCS PCS

M. Lederer 2nd TECHNICIAN/ASSISTANT CGSB LEVEL II SNT LEVEL II PCS PCS

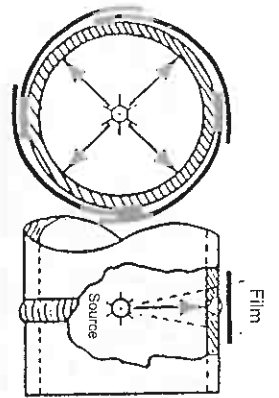
CGSB REGISTRATION # 3161 CGSB REGISTRATION # [Blank] PCS PCS

*Please note: Film that is not accepted by the client when the report is issued will be disposed of by Acuron unless otherwise notified and acknowledged in writing.

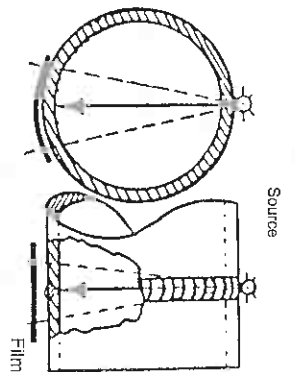
White - Client Copy Canary - Film Copy Pink - Office Copy Golden Rod - Office Copy Form Rev. date: April 2012



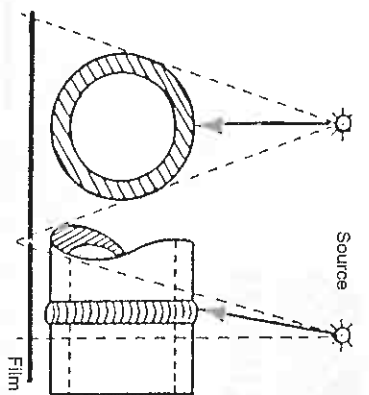
Technique
SWE-SWV



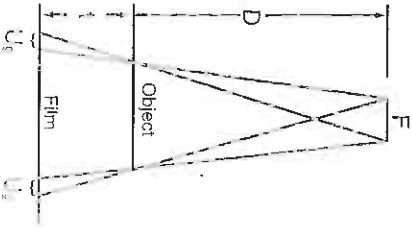
Technique
SWE-SWV



Technique
DWE-SWV



Technique
DWE-DWV



U_g = Geometric Unsharpness
 D = Source to object distance
 t = Object to film distance
 F = Focal Spot Size

$$U_g = F/D$$

Note: This is omitted from the Acuren
 Pipe Schedule 30A, 30B, 30C

DEFECT LEGEND		OTHER LEGENDS	
CRK	Crack	SWE	Single Wall Exposure
LF	Lack of Fusion	DWE	Double Wall Exposure
IP	Incomplete Penetration	SWV	Single Wall Viewing
P	Porosity	DWV	Double Wall Viewing
S	Slag	EXP	Exposures
UC	Undercut	REIN	Reinforcement
CR	Concave Root	DIA	Diameter
EP	Excessive Penetration	SOD	Source Object Distance
BT	Burn Through	OFD	Object to Film Distance
HB	Hollow Bead		
PH	Pinhole		

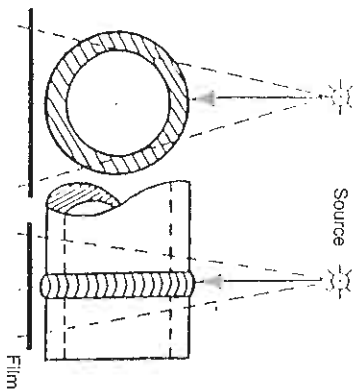
DISCLAIMERS

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THOSE TERMS ARE AVAILABLE AT: WWW.ACUREN.COM/SERVICETERMS, ARE EXPRESSLY INCORPORATED BY REFERENCE INTO THIS DOCUMENT AND SHALL SUPERSEDE ANY CONFLICTING TERMS IN ANY OTHER DOCUMENT

FINAL ACKNOWLEDGEMENT RECEIPT: Signature by the Client indicates acceptance of the report and the accompanying radiographic film, however, in the event the Client or Client's designated representative is not available or declines to take receipt of the report and the radiographic film, then for certainty, Acuren shall not be responsible for any loss or damage unless otherwise agreed to in writing.

Unless otherwise agreed to in writing, the client acknowledges receipt of film at the end of every day or shift, even when no representative is available to sign the report.



Technique
DWE-DWV

ALBERTA MUNICIPAL AFFAIRS

ABSA, the pressure equipment safety authority
 9410 – 20th Avenue
 Edmonton, AB T6N 0A4
 Partial/ Partiel

④622 779

**MANUFACTURER'S DATA REPORT
 FOR PRESSURE VESSEL
 DÉCLARATION DE CONFORMITÉ DU CONSTRUCTEUR
 D'APPAREILS SOUS PRESSION**

Upon shipment of a pressure vessel, this form fully and correctly filled in must be mailed to the office of the Chief Inspector in the province of installation in accordance with the regulations under the Act, governing the construction and installation of pressure vessels.

Au moment de l'expédition d'un appareil sous pression, ce formulaire complété correctement, doit être envoyé au bureau de l'inspecteur en chef de la province d'installation tel que prévu dans les règlements de la loi sur les appareils sous pression.

Manufactured by Construit par	Name and address of Manufacturer/ Nom et adresse du constructeur RJV Gasfield Services 4901 Bruce Road, Vegreville, Alberta T9C 1C3
Manufactured for Construit pour	Name and address of Purchaser or Consignee/ Nom et adresse du client ou de son représentant RJV Gasfield Services 4901 Bruce Road, Vegreville, Alberta T9C 1C3
Ultimate owner Utilisateur	Name and address/ Nom et adresse Stock
Location of installation Lieu d'installation	Address/ Adresse Stock

Pressure vessel/ Appareil

Type/ Genre Vertical 3 Phase Separator	Overall Length/Longueur totale 2285mm sm/sm	Serial No./ N° de série 12865	Year built/Année de fabrication 2013
Provincial Registration No. – C.R.N./N° d'enregistrement provincial - N.E.C. P7217.231		National Board No./ N° National Board N/A	Drawing No./ N° de dessin V01-381-R1

The chemical and physical properties of all parts meet the requirements of material specifications of the A.S.M.E. Code.
Les propriétés chimiques et physiques de toutes les composantes respectent les exigences des spécifications de matériaux de code ASME.

The design, construction and workmanship conform to CSA B51. <i>La conception, la construction et la façon sont conformes à ACNOR B51.</i>	ASME Section VIII	Division 1	Addenda/Supplément 2011a	Code case No. N° de cas N/A
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Manufacturer's partial data reports properly identified and signed by authorized inspectors have been furnished for the following items of the report, and attached to this report:
Les rapports partiels du constructeur adéquatement identifiés et signés par les inspecteurs autorisés ont été produits pour les items suivants du rapport, et attachés à ce rapport:

Names of parts/ Nom de la composante	Item No./ N° d'item	Manufacturer's Name/ Nom du constructeur	Identifying Stamp/ Estampe d'identification

Shell/ Virole

Description	Material Matériau	Thickness Épaisseur	Corr. Allow. Surépais. de corr.	Diameter Diamètre	Longitudinal Joints Joints longitudinaux			P.W.H.T. Traitement therm		Girth Joints Joints de circonférence		Number of courses Nombre de sections
					Type	R.T. Radiog.	Efficiency Efficacité	Temp.	Time Durée	Type	R.T. Radiog.	
Shell	SA-106-B	21.44 mm	1.6mm	406mm	Sml's	N/A	100%	N/A	N/A	1	Spot	1
				O.D.							70%	

Heads/ Tetes

Description	Material Matériau	Min. Thickn. Épals minim.	Corr. Allow Surép. Corr.	Crown. Radius Rayon couron.	Knuckle Radius Petit rayon	Ellipse Ratio Rapp. ellipse	Conical Apex Angle Angle conique	Hemisp. Radius Ray. Hémisp	Flat Diameter Diam.plat	Side to pressure Côte sous pression
Top	SA-516-70	20.63mm	1.6mm	-----	-----	2.1	-----	-----	-----	Concave
Bottom	SA-516-70	20.63mm	1.6mm	-----	-----	2.1	-----	-----	-----	Concave
Removable bolts used (describe other fastenings) <i>Boulons amovible utilisés (décrire tout autre attache)</i>					Mat'l Spec./ Spéc. du mat.			Grade		Size/ Dimension

Pressure - Temperature/ Pression - température

Pressure Vessel Part Partie de l'appareil	Constructed for max. allowable working pressure Construit pour une pression maximale de marche permise	At max. temp. A une temp. max.	Min. Temp. (when less than -29°C) Temp. min. (inférieure à -29°C)	Test pressure (hydro-pneumatic or combination) Pression d'épreuve (hydro-pneumatique ou combinaison)
Vessel	10,205 Kpa.	38°C	-29°C	15,307 Kpa.

Tube Section/ Faisceau tubulaire

Tube material/ Matière des tubes	Diameter/ Diamètre	Nominal Thickness (gauge) Epaisseur nominale (calibre)	Number/ Nbre	Type (Straight or U) Type (Droit ou U)	Heating Surface Surface de chauffe
Tubesheet/ Plaque tubulaire	Material/ Matériau	Diameter/ Diamètre	Nominal Thickness Epaisseur nominale	Corr. Allow. Surépais. corrosion	Attachment Mode d'attachement

Jacket/ Chemise

Type of jacket/ Genre de chemise	Jacket closure Fermeture de chemise	Proof Test Pression d'épreuve	Heating Surface Surface de chauffe	Sketch/ Schéma
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Safety Valve Outlets/ Soupapes de sûreté

Number/ Nombre 1	Dimension 33.4mm	Location/ Endroit Shell
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Nozzles and Openings/ Tubulures et ouvertures

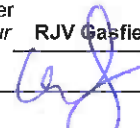
Purpose/ But	Number Nombre	Dimension	Type	Material Matériau	Nominal Thickness Epaisseur nominale	Reinforcement material Matériau de renfort	How attached Genre d'attaches	Location/ Endroit
Inlet/Outlet	2	60.3mm	CL600RFWN	SA-105/SA-106-B	8.74mm	N/A	UW16.1(c)	Top Head/Shell
L.L.S.D.	2	60.3mm	Coupling	SA-105	CL6000	N/A	UW16.1(c)	Shell/Bottom Head
P.S.V.	1	60.3mm	CL600RFWN	SA-105/SA-106-B/SA-234-WPB	8.74mm	N/A	UW16.1(c)	Shell
Sight Glass/Temp. Ind.	5	26.7mm	Coupling	SA-105	CL6000	N/A	UW16.1(c)	Shell
Pressure Indicator	1	21.4mm	Coupling	SA-105	CL6000	N/A	UW16.1(c)	Shell
Liquid out	2	33.4mm	Coupling	SA-105	CL6000	N/A	UW16.1(c)	Shell
LLC,HLSD	3	88.9mm	CL600RFWN	SA-105/SA-106-B		N/A	UW16.1(c)	Shell

Supports/ Supports


Skirt/ Jupe Yes/ Oui No/ Non <input checked="" type="checkbox"/> <input type="checkbox"/>	Lugs/ Oreilles No./ Nbre No	Legs/ Pieds No./ Nbre No	Other/ Autres (Description) N/A	Attached/ Attaches (Where and How/ Méthode et endroit) Welded to bottom head
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Remarks/ Observations (Cubical capacity/ Volume)

Volume=.262 Cubic Meters
Exempt from impact test requirements as per UG20(f) 1 to 5
Hydrostatically tested in the vertical position
Nozzel to shell weld full penetration

Certificate of Compliance/ Certificat de conformité
We certify that the statements made in this data report are correct and that the said vessel has been constructed in accordance with the Provincial Registered design below and the requirements of standard CSA B51.
Nous certifions que les données de la déclaration de conformité sont correctes et que l'appareil a été construit en accord avec l'enregistrement provincial ci-dessous et les exigences de la norme ACNOR B51.
Provincial Registered Design
Enregistrement provincial P7217.231
Manufacturer
Constructeur RJV Gasfield Services
Signature  Date MAY 23 2013

Certificate of Compliance - Field Work/ Certificat de conformité - Installation au chantier
We certify that the field installation of all parts of the vessel conforms with the requirements of Provincial Regulations.
Nous certifions que l'installation au chantier de toutes les composantes de l'appareil est conforme aux règlements provinciaux.
Installer's Name
Nom de l'installateur _____
Signature _____
Date _____

Certificate of Shop Inspection/ Certificat d'inspection en usine
I, the undersigned, a duly authorized boiler and pressure vessel inspector Je, soussigné, inspecteur autorisé de chaudières et appareil sous pression employed by (employé par) ABSA of (de) Alberta have inspected the above vessel and state that to the best of my knowledge and belief the manufacturer has constructed the vessel in accordance with Canadian Registration No. P7217.231 and the requirements of CSA Standard B51. By signing this certificate, neither the inspector nor his or her employer makes any warranty, expressed or implied, concerning the vessel described in this manufacturer's data report. Furthermore, neither the inspector nor his or her 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.
ai inspecté l'appareil précité et, autant que je sache, le constructeur a construit l'appareil en accord avec le numéro d'enregistrement canadien P7217.231 et les exigences de la norme CSA B51. En signant ce certificat, ni l'inspecteur ni son employeur ne donnent de garantie explicite ou implicite relativement à l'appareil décrit dans la présente déclaration. De plus, ni l'inspecteur ni son employeur ne doivent être tenus responsables de quelque manière que ce soit des dommages, matériels ou corporels, ou des pertes de quelque nature que ce soit pouvant résulter de cette inspection.
Inspector's Name
Nom de l'inspecteur Jason Reinhart AB 248 NB 12899 A
Signature  Date May 23/13

Certificate of Field Inspection/ Certificat d'inspection - Installation au chantier
I, the undersigned, a duly authorized boiler and pressure vessel inspector Je, soussigné, inspecteur autorisé de chaudières et appareil sous pression employed by employé par ABSA have inspected the items not covered by the Certificate of Shop inspection and the installation of the items and state that to the best of my knowledge and belief the construction and assembly of the items are in accordance with the provincial regulations. By signing this certificate, neither the inspector nor his or her employer makes any warranty, expressed or implied, concerning the vessel described in this manufacturer's data report. Furthermore, neither the inspector nor his or her 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.
ai inspecté les composantes non couvertes par le certificat d'inspection en usine et l'installation de l'appareil et, autant que je sache, la construction et l'assemblage de l'appareil sont en accord avec les règlements provinciaux. En signant ce certificat, ni l'inspecteur ni son employeur ne donnent de garantie explicite ou implicite relativement à l'appareil décrit dans la présente déclaration. De plus, ni l'inspecteur ni son employeur ne doivent être tenus responsables de quelque manière que ce soit des dommages, matériels ou corporels, ou des pertes de quelque nature que ce soit pouvant résulter de cette inspection.
Inspector's Name
Nom de l'inspecteur _____
Signature _____ Date _____