



## Column External Visual Inspection Report

Organization: Husky

Inspection Date: 06/05/2010 12:00:00AM

Plant: Foothills

Equipment ID: 66068139

Asset No: 66068139

System: 00001 Galloway Gas Plant 12-05-054-20

Operating Unit: FH-FW-014 Galloway

#0465811

### Background

Description:	Tower, Stabilizer
Asset Type:	

### Inspection

Inspector:	Bob Marchak	Company:	Husky Energy	Insulated:	N
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### External Location Categories

Barrier Penetrations:		Damaged Insulation:		Vessel Supports:		Insulation Rings:	
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### Inspection Comments

ID	Description	Condition	Location	NCR	Comments

### Inspection Summary

An external visual and ultrasonic thickness survey was carried out to determine the integrity of the condensate stabilizer tower. The nameplate is attached and legible with A# 465811 stamped on it. The tower is insulated and the insulation is in good condition with no tears or open seams noted. The roof seal at the vessel and piping penetrations are in good condition with no open areas noted.

The tower is protected by a PSV that is located on the piping. PSV data:

Serial# 437853-1-A11 Size: 38.1 mm x 76.2 mm, Set Pressure: 1586 kpa, Capacity: 102.6 m3/min, Manufacturer: Farris, Last Service Date: 06/2006.

The bottom head is welded to the skirt which is securely bolted to the skid floor. The skid is grounded. The tower appears to be level. There are no leaks noted and the level gauges appear to be in good working condition.

The overall condition of the condensate stabilizer tower is good and it is acceptable for continued service.

The external and internal inspection interval is to be set at 5 years as per ABSA AB-506 grade 2.

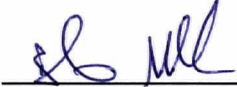
The PSV service interval is to be set at 5 years as per ABSA AB-506 grade 2.

## Column External Visual Inspection Report

### Inspection Planning

Date of Inspection: May 6, 2010 Date of last Inspection: \_\_\_\_\_ Date of Next Inspection: 05/2015


The signature below certify that the above is a true report of the inspection / test of the equipment specified and consider fit for service until the date of next inspection.

Competent Inspector:  Report Generation Date: May 21, 2010

### **Reviewed and Accepted by:**

Next Inspection Date: 05/2015

### **Approved by:**

Signature:  Date: May 21, 2010

Signature: \_\_\_\_\_ Date: \_\_\_\_\_

## NDE Report Column



Organization: Husky

Plant: Foothills

EquipmentID: 66068139

System ID: 00001 Galloway Gas Plant 12-05-054-20W5

Unit Name: FH-FW-014 Galloway

### Background

Description:	Tower, Stabilizer
Asset Type:	Column

### Summary

Component Type	Short Term Avg. Corrosion Rate	Long Term Avg. Corrosion Rate	Remaining Life

### NDE

Inspection Location	Location Description	Component Type	Status	Nominal Thickness	Minimum Thicknes	Initial Reading	Initial Date	Previous Rdg	Previous Date	Current Reading	Current Date	ST CR	LT CR	Remain Life
005	Head Btm	Bottom	Active	6.86	3.20	6.86	01/01/2001	6.86	01/01/2001	10.34	06/05/2010	-0.3723	-0.3723	
010	Shell Btm North	Bottom	Active	9.53	3.20	9.53	01/01/2001	9.53	01/01/2001	10.95	06/05/2010	-0.1519	-0.1519	

## NDE Report Column

### Inspection Planning

Date of Inspection: May 6, 2010      Date of last Inspection: \_\_\_\_\_      Date of Next Inspection: 05/2015

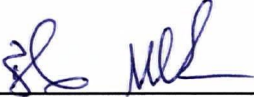
The signature below certify that the above is a true report of the inspection / test of the equipment specified and consider fit for service until the date of next inspection.

Competent Inspector:       Report Generation Date: May 21, 2010

### **Reviewed and Accepted by:**

Next Inspection Date: 05/2015

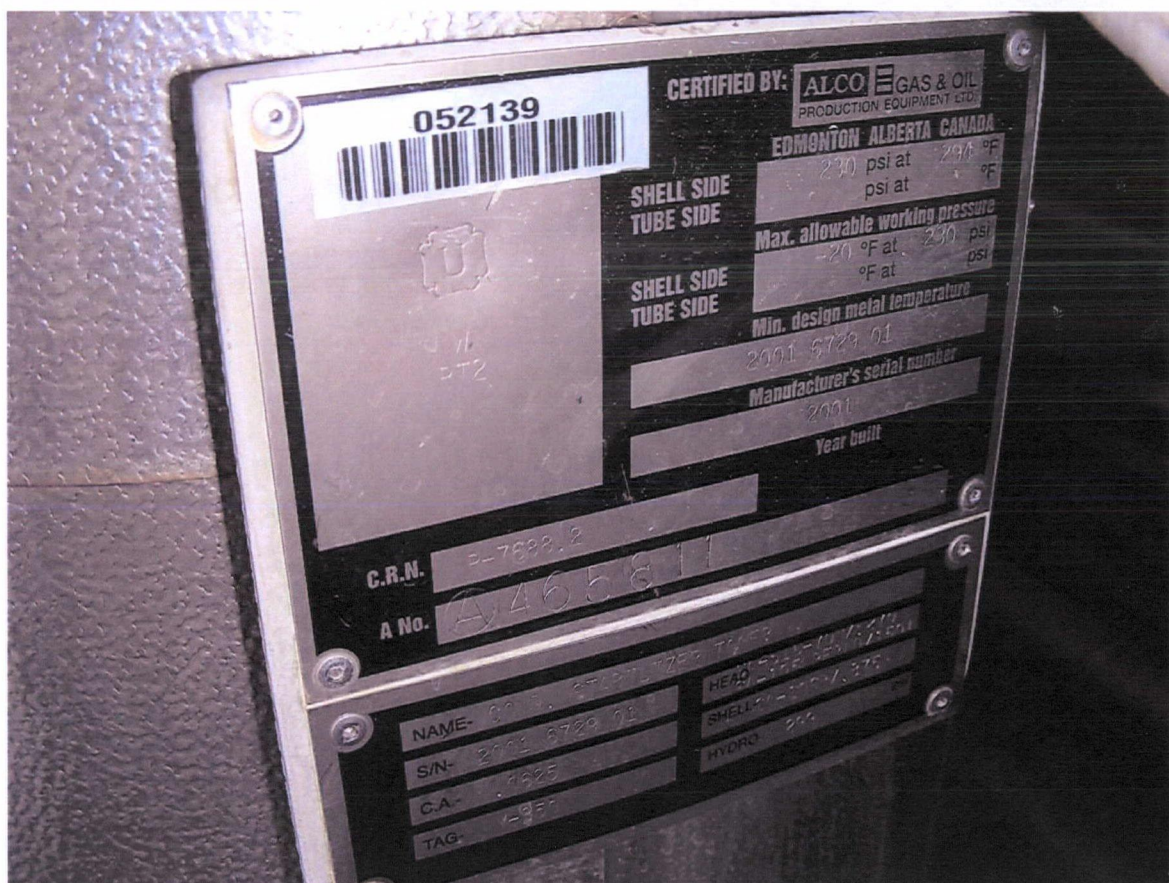
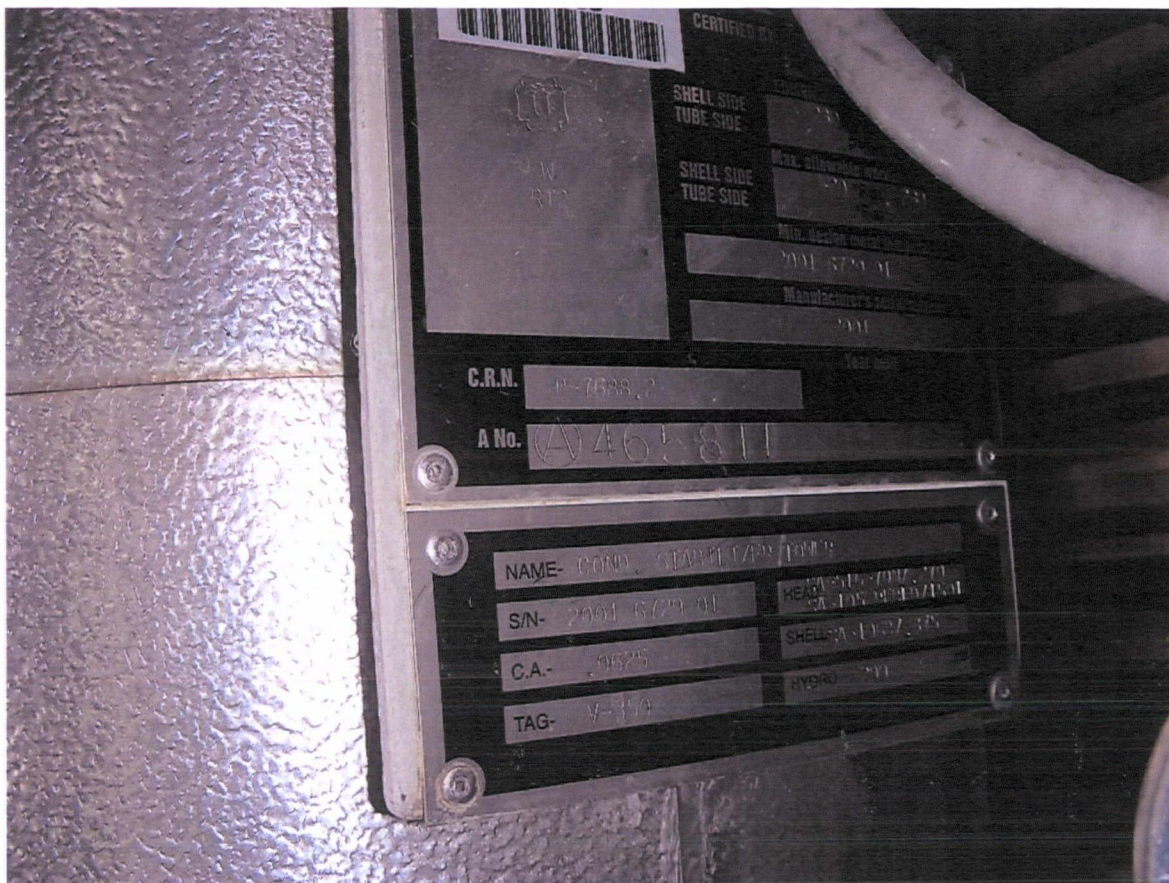
### **Approved by:**

Signature:       Date: May 21, 2010  
Signature: \_\_\_\_\_      Date: \_\_\_\_\_



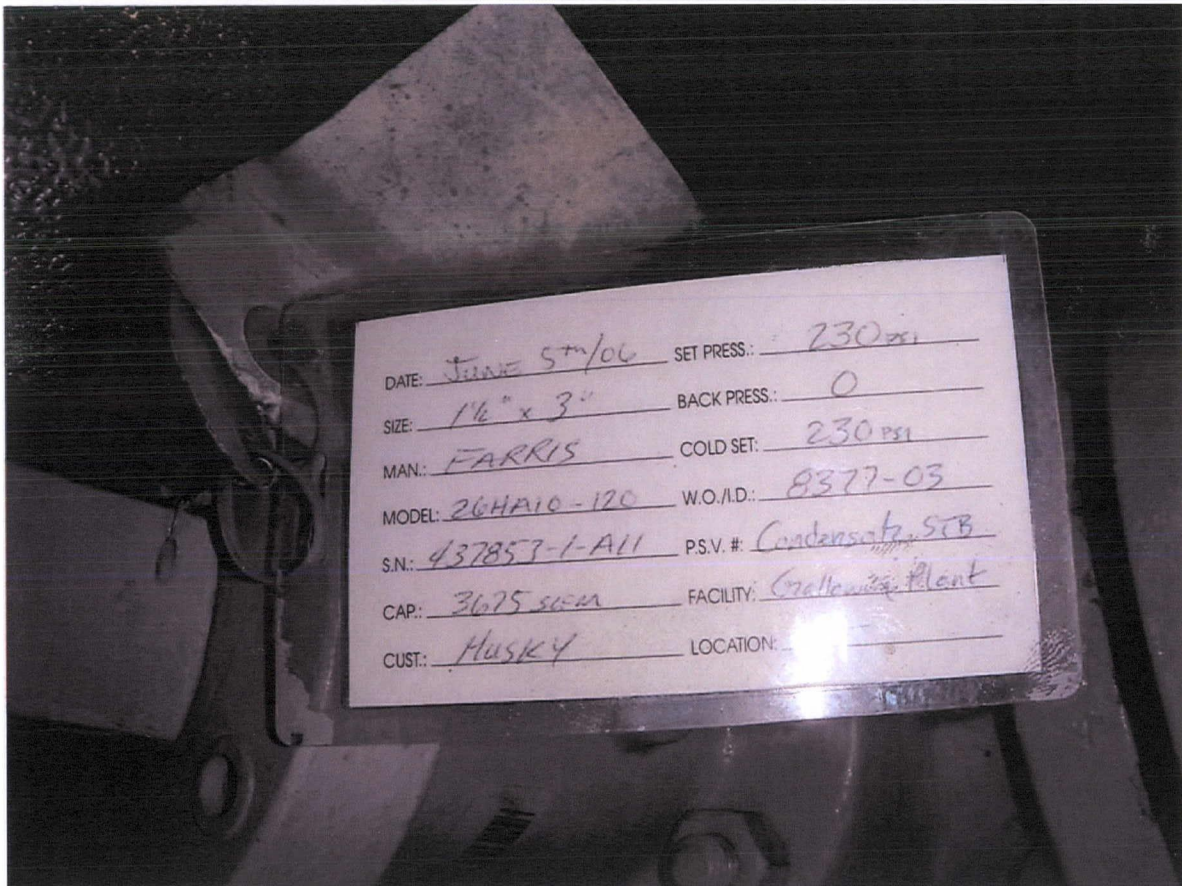
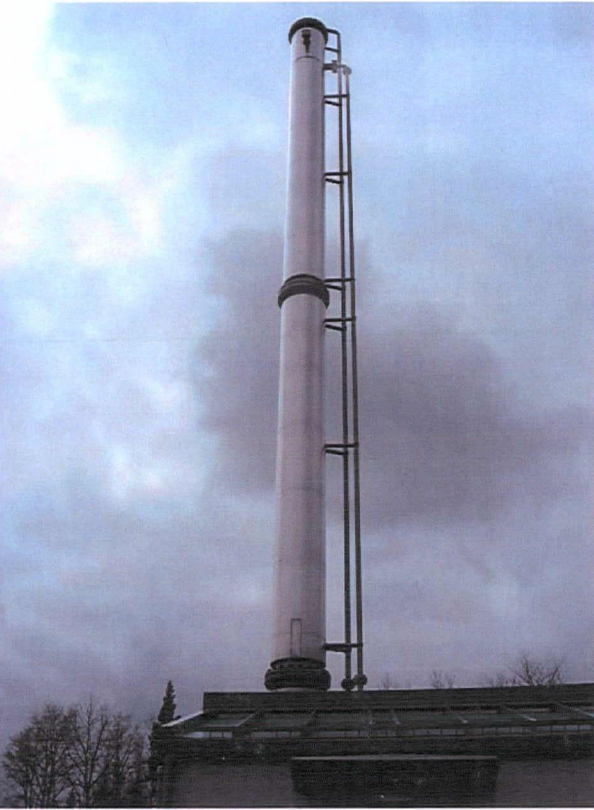
# Condensate Stabilizer Tower SAP# 66068139, A# 465811

12-05-054-20W5M Galloway Gas Plant





**Condensate Stabilizer Tower SAP# 66068139, A# 465811**  
**12-05-054-20W5M Galloway Gas Plant**



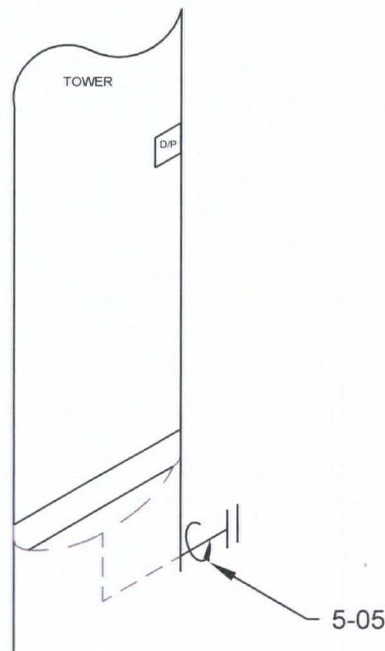


66068139

ITEM:

**TOWER CONDY STABILIZER DRAIN PIPING**

A 0465811



STETTLER, AB (403) 742-4868  
LACOMBE, AB (403) 782-7855  
BROOKS, AB (403) 501-8029  
GRANDE PRAIRIE, AB (866) 422-9732

TECHNICIAN:

STEPHEN KEELEY  
SNT LEVEL I  
CGSB 48.9712  
LEVEL I # 12288

DATE: **06/20/07**

DWG # **5**

CLIENT: **HUSKY ENERGY**

LSD: **12-05-054-20-W5M**

INSPECTOR : JEFF CRABBE

LOCATION : GALLOWAY GAS PLANT

DISTRICT UNIT : FH-FW

BLDG/SKID: -

PROCESS: SWEET

CODE: ASME SEC VIII DIV 1

SPECIFICATION: AS PER ASME SE 797

TECHNIQUE: UT-1-1, REV. 1

METHOD: UT CONTINUOUS / A SCAN

SURFACE COND: PAINTED

SURFACE TEMP: AMBIENT

### VESSEL INFORMATION

VESSEL # : **A 0465811**

CRN # : P7688.2

SERIAL # : 2001 672901

MANUFACTURER: ALCO GAS & OIL

DATE BUILT: 2001

CLIENT ID / TAG: 052139

M.A.W.P. : 230 PSI (50 PSI ON PIPING)

M.A.W.T. : 294 °F

JOINT EFFICIENCY/RT: N/A

STRESS RELIEVED: N/A

INSULATED : YES

MANWAY : NO

### VESSEL SPECIFICATIONS

	OD	NOMINAL	MATERIAL	CA
VESSEL HEAD	-	-	-	-
VESSEL SHELL	-	-	-	-
BOOT HEAD	-	-	-	-
BOOT SHELL	-	-	-	-

COMMENTS:

NO ACCESS TO BOTTOM 90° NOZZLE

PROJECT:

**C2620**



## ULTRASONIC CORROSION SURVEY

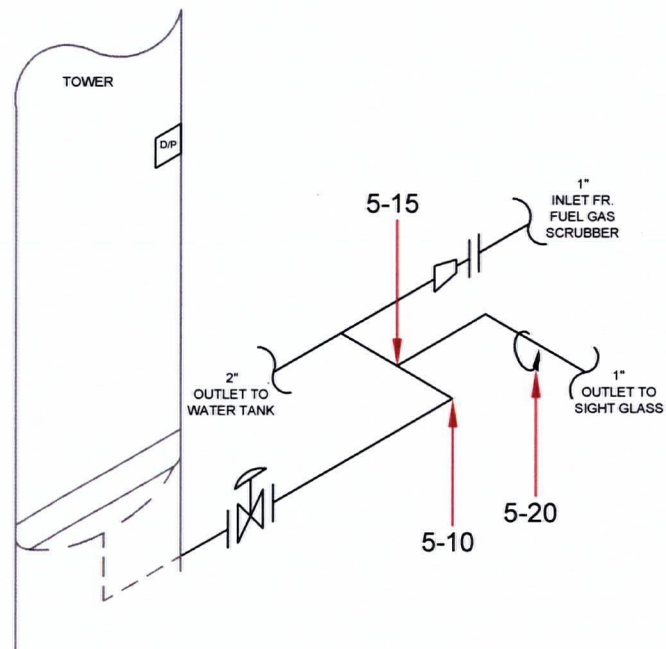
Survey Name: HUSKY ENERGY

LSD: 12-05-054-20W5 Dwg: 5 Vessel Number: A0465811 Manufacturer: ALCO GAS & OIL Survey Date: 6/20/07  
District Unit: FH-FW Vessel Name: TOWER CONDY STABILIZER DRAIN - PIPING Serial Number: 2001672901 Inspector: JEFF CRABBE  
Location: GALLOWAY GAS PLANT Year Built: 2001 Shell MAWP PSI: 230 MAWT F: 294 Project #: C2620  
Skid: - Tag Number: 052139 Tube MAWP PSI: 50 MAWT F: 294  
CRN: P7688.2 Vessel CA: 0.0000

Band	Description			Readings						Year	Avg Inches	Min Inches	Nominal	CA	TMIN	Recommended Next Inspection	Recommended Retirement Date
				1	2	3	4	5	6								
5-05	Nozzle	Baseline		0.343	0.343	0.343	0.343	0.346	0.345	2007	0.344	0.343	0.3430	0.0000	0.0115	2008	2027
Shape	Cylindrical	Shell Side	Previous										Comments-->				
OD	2.375		Current	0.343	0.343	0.343	0.343	0.346	0.345	2007	0.344	0.343					
Spec.	VIII Div 1								ST Loss MPY				OK				
Material	SA 106 - B								LT Loss MPY		0.000						
5-10	Piping	Baseline		0.150	0.154	0.153	0.150	0.159	0.160	2007	0.154	0.150	0.1540	0.0192	0.0030	2008	2027
Shape	90° Elbow	Tube Side	Previous										Comments-->				
OD	2.375		Current	0.150	0.154	0.153	0.150	0.159	0.160	2007	0.154	0.150					
Spec.	B31.3								ST Loss MPY				OK				
Material	A 234 - WPB								LT Loss MPY		0.000						
5-15	Piping	Baseline		0.154	0.155	0.157	0.157	0.156	0.154	2007	0.156	0.154	0.1540	0.0192	0.0030	2008	2027
Shape	Cylindrical	Tube Side	Previous										Comments-->				
OD	2.375		Current	0.154	0.155	0.157	0.157	0.156	0.154	2007	0.156	0.154					
Spec.	B31.3								ST Loss MPY				OK				
Material	A 106 - B								LT Loss MPY		0.000						
5-20	Piping	Baseline		0.164	0.160	0.168	0.169	0.169	0.168	2007	0.166	0.160	0.1790	0.0224	0.0016	2008	2027
Shape	Cylindrical	Tube Side	Previous										Comments-->				
OD	1.315		Current	0.164	0.160	0.168	0.169	0.169	0.168	2007	0.166	0.160					
Spec.	B31.3								ST Loss MPY				OK				
Material	A 106 - B								LT Loss MPY		0.000						



**TOWER CONDY STABILIZER DRAIN - PIPING A 0465811**



**TECHNICIAN:**

STEPHEN KEELEY  
SNT LEVEL I  
CGSB 48.9712  
LEVEL I # 12288

**DWG #** **5A**

**CLIENT :** **HUSKY ENERGY**

**LSD :** 12-05-054-20-W5M

**INSPECTOR :** JEFF CRABBE

<b>LOCATION :</b>	GALLOWAY GAS PLANT
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<b>DISTRICT UNIT :</b>	FH-FW
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BLDG/SKID : -

<b>PROCESS :</b>	SWEET
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<b>CODE :</b>	ASME B31.3
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**SPECIFICATION :** AS PER ASME SE 797

**TECHNIQUE :** UT-1-1, REV.1

<b>METHOD :</b>	UT CONTINUOUS / A SCAN
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<b>SURFACE COND :</b>	PAINTED
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**SURFACE TEMP :** AMBIENT

## PIPING INFORMATION

[illegible]

PROJECT:  
**C2620**

Tel# 66068139

N# 6044035

✓ 7/1

<b>FACILITY</b>	Gallaway Gas Plant	<b>DATE</b>	May 12, 2005	<b>REPORT #</b>	IR050512MCSi
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**VESSEL STATIC DATA**

<b>Prov. Insp. #</b>	A 0465811	<b>CRN</b>	P-7688.2	<b>Equip Tag #</b>			
<b>Equipment Location (LSD)</b>	12-05-54-20 W5M			<b>Serial #</b>	2001-6729-01		
<b>Equipment Description</b>	Condensator Stabilizer Tower			<b>Vessel Class</b>			
<b>Manufacturer</b>	ALCO Gas&Oil Production Equipment Ltd. Edmonton			<b>Year Built</b>	2001		
<b>MAWP</b>	1586	<b>KPag</b>	@ 145	<b>MDMT</b>	-29 °C		
<b>CODE : UM</b>	<input type="checkbox"/>	<b>U</b>	<input checked="" type="checkbox"/>	<b>U2</b>	<input type="checkbox"/>		
<b>RT : 1</b>	<input type="checkbox"/>	<b>2</b>	<input checked="" type="checkbox"/>	<b>3</b>	<input type="checkbox"/>		
<b>4</b>	<input type="checkbox"/>						
<b>PWHT :</b>	YES <input type="checkbox"/> NO <input checked="" type="checkbox"/>						
<b>Diameter</b>	20 in OD	<b>Length</b>	(T/T) 480in (estimated)	<b>OAL</b>	Mm/in		
<b>Shell</b>	Mat'l	SA-106B	<b>Thickness</b>	0.375 in	<b>Corr Allowance</b>	0.0625 in	
<b>Head</b>	Mat'l	SA-516-70N	<b>Thickness</b>	0.270 in	<b>Corr Allowance</b>	0.0625 in	
<b>Nozzle</b>	Mat'l	N/A	<b>Thickness</b>	Mm/in	<b>Corr Allowance</b>	Mm/in	
<b>Internal Coating :</b>	YES <input type="checkbox"/> NO <input checked="" type="checkbox"/>		<b>Internal Clad :</b>	YES <input type="checkbox"/> NO <input checked="" type="checkbox"/>		<b>Capacity</b>	m <sup>3</sup>
<b>Manway :</b>	YES <input type="checkbox"/> NO <input type="checkbox"/>		<b>Inspection Port :</b>	YES <input checked="" type="checkbox"/> NO <input type="checkbox"/>		<b>Skirt</b>	<input checked="" type="checkbox"/>
<b>Nozzle Rating</b>	150	<b>lb ANSI</b>	<b>Painted :</b>	YES <input type="checkbox"/> NO <input checked="" type="checkbox"/>		<b>Insulated :</b>	YES <input checked="" type="checkbox"/> NO <input type="checkbox"/>

**PROCESS DATA**

<b>Product Description</b>	Glycol/Gas	<b>Sweet</b>	<input checked="" type="checkbox"/>	<b>Sour</b>	<input type="checkbox"/>	<b>PPM:</b>	
<b>Operating Pressure</b>	KPag	<b>Operating Temperature</b>	100	<b>°C</b>			

**PSV STATIC DATA**

Tag / Serial No.	Location	Size Inlet	Size Outlet	Set Pressure	Capacity SCFM	Manufacturer	Model / Type	Service Date
Tag# PSV-350	Shell	1.5 in	3 in	1586 kPa	3675scfm air	Farris Eng.	26HA10-	11/01
S#487853-1-A11							120	

**INSPECTION HISTORY**

<b>RBI Category</b>	A <input type="checkbox"/> B <input type="checkbox"/> C <input type="checkbox"/> D <input type="checkbox"/>	<b>Last Inspection Date</b>		<b>W.O. #</b>	6045735										
<b>Inspection Task List #</b>		<b>Inspection Type</b>	VE / UT	<b>Inspection Reason</b>	Planned Inspection										
<b>Inspection Techniques Required</b>		<b>Next Inspection Type</b>	VE / UT	<b>Due Date</b>	2010										
<b>VE</b>	<input type="checkbox"/>	<b>VI</b>	<input type="checkbox"/>	<b>RT</b>	<input type="checkbox"/>	<b>UT</b>	<input type="checkbox"/>	<b>MT</b>	<input type="checkbox"/>	<b>PT</b>	<input type="checkbox"/>	<b>TT</b>	<input type="checkbox"/>	<b>Outstanding Repairs</b>	

**INSPECTION SUMMARY**

- Complete Visual External Inspection as per API 510
- UT Corrosion Survey as per Husky Energy Asset Integrity Program, Section IBP-007

No notable defects were observed; the vessel is recommended fit for service.

**RECOMMENDATIONS**

- Check the Ground Cable Connection and install one if deemed necessary.

**REPAIRS COMPLETED**

Object Name	Cause	Damage	Repair Activity
<ul style="list-style-type: none"> <li>• There are no repairs required at this time</li> </ul>			

**VESSEL STATUS**

<b>Integrity Status</b>	<input checked="" type="checkbox"/> Suitable for Continued Service	<input type="checkbox"/> Immediate Repairs Required	<input type="checkbox"/> Replace
		<input type="checkbox"/> Future Repairs Required	
<b>Inventory Status</b>	<input checked="" type="checkbox"/> In service Fully Utilized	<input type="checkbox"/> Idle	<input type="checkbox"/> Surplus
		<input type="checkbox"/> Scrap	
<b>This IR completes a thorough inspection. Reschedule as indicated</b>		<input checked="" type="checkbox"/>	<b>Partial IR only. Do not reschedule</b>
		<input type="checkbox"/>	



**PRESSURE VESSEL INSPECTION REPORT**

PAGE : 2 of 2

<b>FACILITY</b>	<b>Gallaway Gas Plant</b>	<b>DATE</b>	<b>May 12, 2005</b>	<b>REPORT #</b>	<b>IR050512MCSI</b>
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**INSPECTION OBSERVATIONS****NONCOMPLIANCES OR INSPECTION DEFICIENCIES ISSUED**

- None

**EXTERNAL VISUAL INSPECTION**

- The Name Plate is present and readable.
- The skirt support is painted; the paint appears to be in good condition. The skirt support appears to be in good condition, no distortions were noted, the fillet welds appeared to be of good quality.
- No Ground Cable Connection was present on the Tower or on the skid.
- The Tower is bolted on the skid; all the anchor bolts are present and appear to be in good condition.
- The Tower, the Gas outlet and the Glycol inlet piping are insulated. The insulation (Aluminum Clad) appears to be in good condition throughout. Good seal is present between the building and Vessel and piping.
- No Visual External Inspection of the top head and shell was possible. The Bottom head appears to be in good condition.
- The Welded piping (2" gas inlet piping, 1-1/2" drain elbow) appears to be in good condition, the welds appear to be of good quality.
- Minor leaks were noted at almost all the threaded connections on the glycol piping circuits. The Operations were informed.
- The Temperature Indicator was present on the shell and appeared to be in good working order.
- No Pressure Indicator was present.
- The PSV appears to be in good condition, the name plate was present and readable, the last inspection date was posted and the seal was intact. The PSV discharge piping was connected to a common header.

**EXTERNAL NDE EXAMINATION****UT Inspection was performed by SUMMIT Inspection Services Ltd.**

- UT corrosion survey performed on the bottom of the second section of the shell, bottom shell and bottom head found no signs of internal corrosion.
- UT corrosion was performed on the piping. Minor corrosion was noted on the 2" gas outlet elbow.

**INTERNAL VISUAL INSPECTION**

- No Internal Visual Inspection was performed at this time.

**INTERNAL NDE EXAMINATION**

- No Internal NDE was performed at this time.

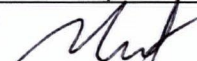
**PRESSURE TEST**

Test Completed	<input type="checkbox"/> Yes <input type="checkbox"/> No	Test Acceptable	<input type="checkbox"/> Yes <input type="checkbox"/> No	Test Report #
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**INSPECTOR CERTIFICATION**

*I, the undersigned certify that the above equipment has been inspected in accordance with the assigned task list and that statements within this report are correct and represent inspection findings*

Inspectors Name	Maria C. Savulescu, API 510, CGSB Lev. II UT
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Inspector's Signature	
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Inspection Company	SUMMIT Inspection Services Ltd.
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Date	May 10, 2005
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**LEAD INSPECTOR'S ACCEPTANCE & SCHEDULE CONFIRMATION**

Lead Inspector	
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Signature	
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Date	July 20/05
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Vessel Inspection Interval	5yrs.
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Leave "as-is"	<input type="checkbox"/>
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Change to	
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PSV Inspection Interval	
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Leave "as-is"	<input type="checkbox"/>
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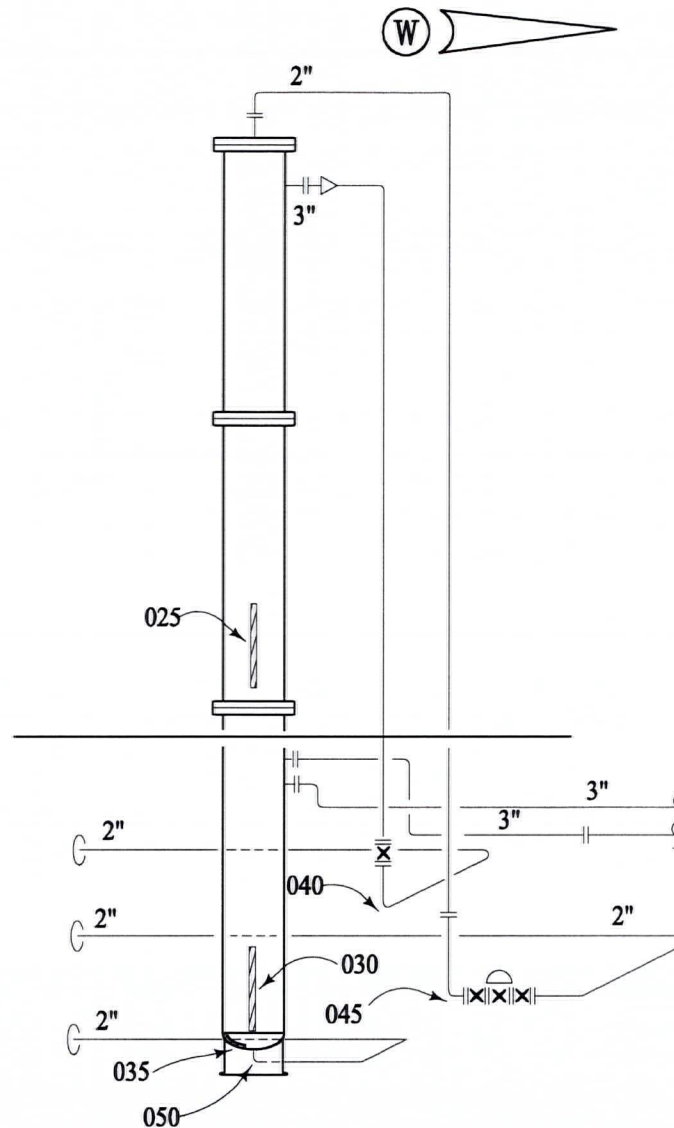
Change to	
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Office Use Only	Report Entered to SEQA Database by	Date
	Static Data Verified by	Date



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### Conditioner Stabilizer Tower

Reg. No. : A 0465811  
 S/N : 2001-6729-01  
 CRN : P-7688.2  
 Built : 2001  
 MAWP : 1586kPa @ 146C  
 Dia. : 20"  
 J.E. : RT2  
 C.A. : 0.0625"  
 Shell : SA 106B, 0.375"  
 Head : SA 516-70N, 0.270"  
 Built By : ALCO Gas & Oil Production Equipment

Husky Energy  
 Gallaway Gas Plant  
 12-05-54-20 W5M

SUMMIT Inspection Services Ltd.

By: MCS Date: 06/2005 Dwg: 2

Items: 025-050

#66068139

# Husky Energy

## PRESSURE VESSEL INSPECTION REPORT

PAGE : 1 of 2

FACILITY GALLOWAY Plant		DATE Feb 15/16, 2002		REPORT #	
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VESSEL STATIC DATA					
Prov. Insp. # A465811		CRN P7688.2		Equip Tag # V-350	
Equipment Location (LSD) 12-05-54-20W5M				Serial # 2001-6729-01	
Equipment Description Condensate Stabilizer Tower				Vessel Class	
Manufacturer Alco Oil & Gas				Year Built 2001	
MAWP 1585		KPag @ 145 °C		MDMT -29 °C	
CODE : UM <input type="checkbox"/> U X U2 <input type="checkbox"/>		RT : 1 <input type="checkbox"/> 2 <input type="checkbox"/> 3 <input type="checkbox"/> 4 <input type="checkbox"/>		PWHT : YES <input type="checkbox"/> NO X	
Shell	Mat'l SA 106B	Thickness	8.52 Mm	Corr Allowance	1.6 Mm
Top Head	Mat'l SA 105	Thickness	? Mm	Corr Allowance	Mm
Bottom Head	Mat'l SA 516-70N	Thickness	6.86 Mm	Corr Allowance	Mm
Internal Coating : YES <input type="checkbox"/> NO X		Internal Clad : YES <input type="checkbox"/> NO X		Capacity m <sup>3</sup>	
Manway : YES <input type="checkbox"/> NO X		Inspection Port : YES X NO <input type="checkbox"/>		Skirt X Legs <input type="checkbox"/> Saddle <input type="checkbox"/>	
Nozzle Rating lb ANSI		Painted : YES X NO <input type="checkbox"/>		Insulated : YES X NO <input type="checkbox"/>	

PROCESS DATA			
Product Description Natural gas liquids			Sweet X
Operating Pressure 360 KPag		Operating Temperature 90 °C	

PSV STATIC DATA								
PSV ID #	Location	Size		Set Pressure	Capacity SCFM / Lbs/Hr / GPM	Manufacturer	Model	Last Service
		Inlet	Outlet					
350	Vessel	1.5 in	3 in	1586 kpa	3675 SCFM	Farris	26HA-10-120	01/02

INSPECTION HISTORY									
RBI Category A <input type="checkbox"/> B <input type="checkbox"/> C <input type="checkbox"/> D <input type="checkbox"/>				Last Inspection Date			W.O. #		
Inspection Task List #				Inspection Type VE			Inspection Reason 1002		
Inspection Techniques Required				Next Inspection Type VE, UT			Due Date 2005		
VE <input checked="" type="checkbox"/>	VI <input type="checkbox"/>	RT <input type="checkbox"/>	UT <input type="checkbox"/>	MT <input type="checkbox"/>	PT <input type="checkbox"/>	PT <input type="checkbox"/>	TT <input type="checkbox"/>	Outstanding Repairs	

INSPECTION SUMMARY	
Vessel Size: 508 mm X 14800 mm New – excellent condition, no deficiencies noted	

RECOMMENDATIONS	
Set-up UT survey. Survey slots in insulation required.	

REPAIRS COMPLETED			
Object Name	Cause	Damage	Repair Activity

VESSEL STATUS			
Integrity Status	X- Suitable for Continued Service	<input type="checkbox"/> Immediate Repairs Required	<input type="checkbox"/> Replace
Inventory Status	X- Inservice Fully Utilized	<input type="checkbox"/> Future Repairs Required	<input type="checkbox"/> Scrap
		<input type="checkbox"/> Idle	<input type="checkbox"/> Surplus



**Husky Energy**  
**PRESSURE VESSEL INSPECTION REPORT**

PAGE : 2 of 2

FACILITY	GALLOWAY Plant	DATE	Feb 15/16, 2002	REPORT #	

**INSPECTION OBSERVATIONS**

**NONCOMPLIANCES OR INSPECTION DEFICIENCIES ISSUED**

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**EXTERNAL VISUAL INSPECTION**

No deficiencies noted in foundations/supports, nozzles, grounding connections, external metal surfaces, or pressure relief devices.

**EXTERNAL NDE EXAMINATION**

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**INTERNAL VISUAL INSPECTION**

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**INTERNAL NDE EXAMINATION**

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**PRESSURE TEST**

Test Completed	<input type="checkbox"/> Yes <input checked="" type="checkbox"/> No	Test Acceptable	<input type="checkbox"/> Yes <input type="checkbox"/> No	Test Report #	
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**INSPECTOR CERTIFICATION**

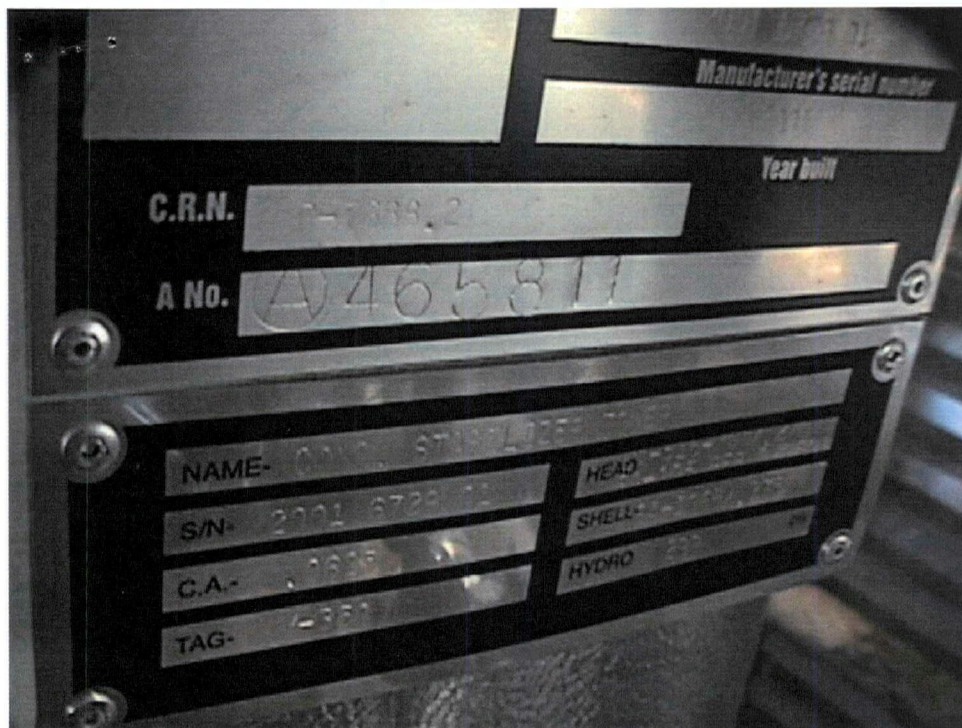
*I, the undersigned certify that the above equipment has been inspected in accordance with the assigned task list and that statements within this report are correct and represent inspection findings*

Inspectors Name	Glenn Bielech	Inspector's Signature	
Inspection Company		Date	Feb 15, 2002

**LEAD INSPECTOR'S ACCEPTANCE & SCHEDULE CONFIRMATION**

Lead Inspector	GREG MURRAY	Signature	<i>[Signature]</i>	Date	June 18, 2002
Vessel Inspection Interval	5	Leave "as-is"	<input checked="" type="checkbox"/>	Change to	
PSV Inspection Interval	3	Leave "as-is"	<input checked="" type="checkbox"/>	Change to	

Office Use Only	Report Entered to SEQA Database by	Date
	Static Data Verified by	Date



NAME PLATE :  
CONDENSATE STABILIZER  
TOWER