

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

① 567984

1 Manufactured and certified by Dynacorp Fabricators Inc. 9815 48 ST. S.E Calgary, AB

(Name and address of manufacturer)

2 Manufactured for Ultrafab Industries Ltd. 820 59 th. Ave S.E.

(Name and address of purchaser)

3 Location of Installation

Portable

(Name and address)

4 Type 24" vertical separator 2J70889-12 U0725.21 5100-43 Rev.1 N/A 2007
(If horizontal or vert. Tank) (Mfr's serial No.) (CRN) (Drawing No.) (Nat'l Bd No) (Year built)

5 The chemical and physical properties of all parts meet the requirements of material specification of the ASME BOILER AND PRESSURE VESSELS CODE. The design, construction, and workmanship conform to ASME Rules, Section VIII, Division 1 2004
(Year)

To 2006

Addenda (date)

Code Case Nos

Special service per UG-120(d)

6 Shell: SA516 70N 1.0" 0.125" 24" OD 12'-0"S/S
(Mat'l (Spec. No., Grade)) (Nominal Thk.) (Corr. Allow.) (DIAMETER I.D. (FL & in)) (Length (overall) (ft & in))

7 Seams: Type 1 Full 100% 1150° 60 minutes Type 1 Full 100% 2
(Long (Welded, Dbl, Singl, Lap, Butt)) (R.T. (Spot or Full)) (Effy. (%)) (H.T. Temp (°F)) (Time (hr)) (Clth (Welded Dbl, Singl, Lap, Butt)) (RT (Spot or Full)) (Eff. (%)) (No. of Courses)

8 Heads: (a) Mat'l SA516 70N (b) Mat'l SA516 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 (Convex or Concave)
(a)	Top	0.959"	0.125"	N/A	N/A	2:1	N/A	N/A	N/A	Concave
(b)	Bottom	0.959"	0.125"	N/A	N/A	2:1	N/A	N/A	N/A	Concave

If removable, bolts used (describe other fastenings)

(Material Specification No. Gr. Size, No.)

9 MAWP: 1480 PSI 1480 100° 2220 psi
Min. Des. Met. Temp -20° Psi at max. temp 100° F
Psi Hydro., pneu. or comb. Test pressure 2220

10 Nozzles, inspection and safety valve openings:

Purpose (Inlet, Outlet, Drain)	No.	Diam Or Size	Type	Mat'l	Nom Thk	Reinforcement Material	How Attached	Location
Inlet	1	NPS 3	Cl. 600 RFWN	SA105 N/SA106B	N/A	N/A	UW16.1(c)	Shell
Outlet	1	NPS 3	Cl. 600 RFWN	SA105N/SA106B	N/A	N/A	UW16.1(c)	Shell
Insp.	2	NPS 8	Cl. 600 RFWN	SA105N/SA106B	N/A	SA516-70N	UW16.1(c)	Shell
Drain	1	NPS 2	Cl. 600 RFWN	SA105N/SA106B	N/A	N/A	UW16.1(c)	Head
PSV	1	NPS 2	Cl. 600 RFWN	SA105N/SA106B	N/A	N/A	UW16.1(c)	Shell
Vent	1	NPS .5	6000# TOL	SA182-F316L	N/A	N/A	UW16.1(a)	Shell

11 Supports: Skirt Yes 2 Legs Other Attached Welded to bottom head/Shell
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 items of The report:

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

Volume: 40.23 cu. ft. Weight: 4342 lbs. Vessel is exempt from impact testing as per UCS-66(c)
PSV to be installed as per UG-125 Fabrication Drawing: 5100-43 Rev.6

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. 34, 971 Expires February 18, 2008

Date JUNE 21/07 Co. Name Dynacorp Fabricators Inc. Signed [Signature]
(Manufacturer) (Representative)

CERTIFICATE OF SHOP INSPECTION

Vessel constructed by Dynacorp Fabricators Inc. At 9815 48ST. S.E Calgary, AB
I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and for the State or Province of ALBERTA And employed by ABSA

have inspected the component described in the Manufacturer's Data Report on JUN 21 2007 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 JUN 21 2007 Signed [Signature] Commissions ABSA #11
(Authorized Inspector) (Nat'l Board (incl. endorsements), State Prov. and No.)



567984

CERTIFIED BY

W

HT



DYNACORP
EXHAUSTORS, LLC

RT-1

MAWP 1480

PSI (kPa) AT 100 °F (°C)

MDMT -20

°F (°C) AT 1480 PSI (kPa)

SERIAL NO. 2J70889-12 YEAR 2007

CRN U0725.21

SA516-70N

SHELL MATERIAL

1.0

| in. (mm)

SHELL THICKNESS

SA516-70N

HEAD MATERIAL

1.125

| in. (mm)

HEAD THICKNESS

CORROSION ALLOWANCE

0.125

| in. (mm)

DO NOT START CONSTRUCTION WITHOUT A.I. REVIEW					TRAVEL SHEET REVISION NO.:				
AI REVIEW: <i>AS</i> **					REVIEW DATE: MAR 15 2007				
DRAWING NO.: 2J70889-12 JOB NO.: 2J70889-12					VESSEL TYPE: 24" Vertical Vessel				
DRAWING NO.: 5100-43 DWG. REVISION NO.: 2					TRAVEL SHEET INITIATION BY: Shelley Reed				
Seq.	Item	Comments	Q.C.I.	Date	A.I. Hold Points	A.I.	Date	Owner	Date
1.	Calculations in File		<i>AS</i>	04/10/07	*	<i>AS</i>	JUN 21 2007		
2.	Release of App'd Dwg.		<i>AS</i>	03/15/07	*	<i>AS</i>	MAR 28 2007		
3.	Heat Numbers Recorded		<i>AS</i>	03/15/07	.	<i>AS</i>	JUN 21 2007		
4.	MTRs Checked		<i>AS</i>	03/15/07	.	<i>AS</i>	"		
5.	WPS(s) Checked		<i>AS</i>	03/15/07	.	<i>AS</i>			
6.	Welder(s) Qualified		<i>AS</i>	03/15/07	.	<i>AS</i>			
7.	Thicknesses Verified & Recorded		<i>AS</i>	03/15/07	.	<i>AS</i>	JUN 21 2007		
8.	Shell(s) & Head(s) Fit-up Inspection		<i>AS</i>	03/29/07	.				
9.	Nozzles & Fittings Fit-up Inspection		<i>AS</i>	04/25/07	.				
10.	Nozzle Orientation		<i>AS</i>	04/02/07	.				
11.	Nozzle & Flange Rating Checked		<i>AS</i>	04/25/07	.				
12.	Impact Tests								
13.	Internals Checked		<i>CR</i>	05/17/07					
14.	Final Internal Inspection	Shell Side Tube Side	<i>CR</i>	05/17/07	<i>CR</i>	<i>CR</i>	MAY 17 2007	N3A - <i>Pragya</i>	MAY 03, 2007
15.	Weld Size Checked		<i>Ref</i>	JUN 18	.				
	Welder I.D. Checked		<i>Ref</i>	JUN 18	.				
17.	Final External Inspection		<i>Ref</i>	JUN 18	.	<i>AS</i>	JUN 21 2007		
18.	Radiography		<i>Ref</i>	JUN 18	.	<i>AS</i>	"		
19.	Other N.D.E.								
20.	Final Ext. Prior to P.W.H.T.		<i>Ref</i>	JUN 18	.				
21.	PWHT Chart Checked		<i>Ref</i>	JUN 18	*	<i>AS</i>	JUN 21 2007		
22.	Hydrostatic Test	Shell Side Gauge # Tube Side Gauge #	<i>Ref</i>	JUNE 21	.	<i>AS</i>	"		
		PI 33 PI 105	<i>Ref</i>	JUNE 21	.	<i>AS</i>	"		
23.	CRN Drawing	CRN# 00725.21	<i>Ref</i>	JUNE 21	.	<i>AS</i>	"		
24.	N.C.R. #								
25.	Nameplate Stamping		<i>Ref</i>	JUNE 21	*	<i>AS</i>	"		
26.	Manuf. Data Report Completed & Verified		<i>Ref</i>	JUNE 21	*	<i>AS</i>	"		
27.	Nameplate Installation								

The Authorized Inspector shall be presented with the Travel Sheet prior to construction so that he can designate additional inspection points and/or Hold Points. Any revisions shall be marked with a delta symbol with revision number and described at the bottom of this page.

* Denotes an A.I. Inspection Point ** Denotes an A.I. Hold Point

** Review for design condition & long beam only *AS* MAR 15 2007

MATERIAL THICKNESS VERIFICATION AND IDENTIFICATION				WELD ID. / WELDER SYMBOLS / FIT-UP					
Description	Thickness	Material Spec. & Grade	Heat & Slab Number or I.D. Number	Weld I.D.	Symbol	Fit-Up	Weld I.D.	Symbol	Fit-Up
Shell #1	1.0"	SA516-70N	G7189 970680713	U/H					
Shell #2	1.0"	SA516-70N	G7190 970680716	U/H					
Head #1	0.959"	SA516-70N	71963 86396	U/H					
Head #2	0.959"	SA516-70N	16527 449110	U/H					

ATTACHMENT AND / OR NOZZLE MATERIAL THICKNESS VERIFICATION AND IDENTIFICATION						WELDER SYMBOLS / FIT-UP			
Mark	Mat. I.D.	Neck	Fitting	Flange	Repad or Attachment	Cat. B	Cat. C	Cat. D	Pad OD
N1	Spec.-Grd.	SA106B		SA105N					
3"	Thk./Rating	XXH SMLS		600# RFWN		A		U	
	Heat# or ID	745187		38510					
N2	Spec.-Grd.	SA106B		SA105N					
3"	Thk./Rating	XXH SMLS		600# RFWN		U		U	
	Heat# or ID	745187		38510					
N3	Spec.-Grd.	SA106B		SA105N	SA516-70N				
A 8"	Thk./Rating	SCII 100 SMLS		600# RFWN	1" PLx222 ID X 381 OD	A		U	U
	Heat# or ID	265186		58095	23847				
N3	Spec.-Grd.	SA106B		SA105N	SA516-70N				
B 8"	Thk./Rating	SCH 100 SMLS		600# RFWN	1" PL x 222 ID x 381 OD	U		U	U
	Heat# or ID	265186		58095	23847				
N4	Spec.-Grd.	SA106B	SA234- WPB	SA105N 600# RFWN		A		R	
2"	Thk./Rating	SCII 160 SMLS	SCH 160 90°						
	Heat# or ID	614219	5K3762	72319					
N5	Spec.-Grd.	SA106B		SA105N 600# RFWN		U			U
2"	Thk./Rating	SCH 160 SMLS							
	Heat# or ID	614219		72319					
C1	Spec.-Grd.		SA182- F316L			U			
1/2"	Thk./Rating		6000# TOL						
	Heat# or ID								
	Spec.-Grd.		DF 731						

