

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

A2916624

1. Manufactured and certified by R.J.V. Gas Field Services Ltd., 4901-47St. Vegreville, AB T9C 1C3
(Name and address of manufacturer)

Manufactured for Husky Oil Operations Ltd., 19th Fl. Western Canada Place, 707-8th Ave. S.W. Calgary, AB T2P 1H5
(Name and address of purchaser)

3. Location of installation 11-5-48-24-W3 Marshall Field
(Name and address)

4. Type Vertical 2532 K2422.23 V90-306 N/A 1994
(Horiz. or vert. tank) (Mfg'r's serial No.) (CRN) (Drawing No.) (Net L. 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 1992 Edition
Year

to 1992 Addenda N/A N/A
Addenda (Date) Code Case Nos. Special Service per UG-120(d)

6. Shell: SA-516-70 .625" (15.87) .125" (3.17) 22.75" (578 mm) 60" (1525 mm)
Mat'l. (Spec. No., Grade) Nom. Thk. (in.) Corr. Allow. (in.) Diam. I.D. (ft. & in.) Length (overall) (ft. & in.)

7. Seams: Long'l S.W.B. Full 100% N/A N/A Circ. S.W.B. Spot UW 11(a)5(b) 2
Long. (Welded, Dbl. Sng'l. Lap, Buttl) R.T. (Spot or Full) Eff. (%) H.T. Temp. (°F) Time (hr) Girth (Welded, Dbl. Sng'l. Lap, Buttl) R.T. (Spot, Partial, or Full) No. of Courses

8. Heads: (a) Mat'l. SA-516-70 (b) Mat'l. SA-516-70
(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 Pressure (Convex or Concave)
(a)	Top	.625" (15.87)	.125" (3.17)			2:1				Concave
(b)	Bottom	.625" (15.87)	.125" (3.17)			2:1				Concave

If removable, bolts used (describe other fastenings) _____
(Mat'l., Spec. No., Gr., Size, No.)

9. MAWP (4965 Kpa) 720 psi at max. temp. (38°) 100 °F
Min. design metal temp (-29°C) -20 °F at (4965 Kpa) 720 psi. Hydro., pneu., or comb. test pressure (7448 Kpa) 1080 psi

10. Nozzles, inspection and safety valve openings:

Purpose (Inlet, Outlet, Drain)	No	Diam or Size	Type	Mat'l	Nom Thk	Reinforcement Mat'l	How Attached	Location
Inlet	N1	2" (60.3)	RFWN	SA-106-B/SA-105	Sch. XXS	-----	Weld	Shell
Outlet	N2	2" (60.3)	RFWN	SA-106-B/SA-105	Sch. XXS	-----	Weld	Top Head
L.L.C.	N3	3" (88.9)	RFWN	SA-106-B/SA-105	Sch. XXS	-----	Weld	Shell
Water-Dump	N4	2" (60.3)	RFWN	SA-106-B/SA-105	Sch. XXS	-----	Weld	Shell

11. Supports: Skirt Yes Lugs --- Legs --- Other --- Attached Weld to Head
(Yes or 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, Mfg'r's name and identifying stamp)

Volume - 18.15 Cu. Ft. (.514 m³) Vertical 2 Phase Separator
Exempt from impact test requirements as per Paragraph UG 20(f)
Hydrostatically tested in the Vertical Position.

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. 19 562 expires July 12, 1996.
Date MAR 16 1994 Co. name R.J.V. Gas Field Services Ltd. Signed _____
(Manufacturer) (Representative)

CERTIFICATE OF SHOP INSPECTION

Vessel constructed by R.J.V. Gas Field Services Ltd. at 4901-47 Street, Vegreville, AB T9C 1C3
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 Department of Labour
have inspected the component described in this Manufacturer's Data Report on MAR 16 1994, 19_____, 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 16 1994 Signed _____ Commissions Alberta # 31
(Authorized Inspector) (Nat'l Board (incl. endorsement), State, Prov. and No.)

1. Manufactured and certified by R.J.V. Gas Field Services Ltd., 4901-47 Street, Vegreville, AB T9C 1C3
(Name and address of manufacturer)

2. Manufactured for Husky Oil Operations Ltd., 19th Fl., Western Canada Place, 707-8th Ave. S.W., Calgary, AB T2P 1H5
(Name and address of purchaser)

3. Location of installation 11-5-48-24-W3 Marshall Field
(Name and address)

4. Type Vertical 2532 K2422.23 V90-306 N/A 1994
(Horiz. vert., tank, etc.) (Mfg'r serial No.) (CRN) (Dwg) (Nat'l Bd No.) (Year built)

[illegible]

Co. name R.J.V. Gas Field Services Ltd.

Signe

(Representative

Signed _____

(Authorized Inspector)

Commissions

Alberta ^{II} 31
[Nat. Board (incl. endorsements), State Prov., and No.]

U
W
RT-2

CERTIFIED BY
R. J. V.
GASFIELD SERVICE LTD.
BOX 295, VEGREVILLE, ALBERTA
PHONE 632-7774

A2916624

UNIT NAME

Vert. 2 Phase Separator

C.R. NO.

K2422.23

SERIAL NO.

2532

M. A. W. P.

720 psi
4965 kpa

MASS TEST

1080 psi
7448 kpa

DESIGN TEMP.

100 °F
38 °C

CORR. ALLOW.

3.17 mm

HEAT TREATMENT

Nil

SIZE

610 x 1525 mm

SHELL MAT'L

SA-516-70

HEAD MAT'L

SA-516-70

WEIGHT

592 Kg

SHELL THICK.

15.87 mm

HEAD THICK.

15.87 mm

DATE MFG.

94-03

M.D.M.T.

-20 °F
-29 °C



Saskatchewan
Municipal
Government

Municipal Services Division

Saskatchewan

Protection Services Branch
Boiler & Pressure Vessel Safety
1870 Albert Street
Regina, Saskatchewan
S4P 3V7

(306)787-4490
FAX: (306)787-9273

**PLEASE DO NOT SEND REMITTANCE
WITHOUT A COPY OF THIS INVOICE
WHICH IS DUE WITHIN 30 DAYS**

February 7, 1995

**R.J.V. GAS FIELD SERVICES LTD.
4901 - 47 STREET
VEGREVILLE, ALBERTA
T9C 1C3**

**#327 Reg. of Design
File #04457/0456F**

Dear Sirs:

With reference to your letter respecting registration of **Drip Bottle, Drawing KMF1-88, Rev 0** for legal use in the Province of Saskatchewan, please note we have surveyed, approved, registered and allotted same registration C.R.N. **0H0102.23.**

We are returning herewith, one copy of the **drawings** stamped with the above registration number and should point out that every vessel must be constructed strictly in accordance with the registration design drawing.

Sincerely,

John Gosselink
Design and Registration

/ok
encl.

FORM U-1A MANUFACTURER'S DATA REPORT FOR PRESSURE VESSELS

(Alternative Form for Single Chamber, Completely Shop-Fabricated Vessels Only)

As Required by the Provisions of the ASME Code Rules, Section VIII, Division 1

A 2916624

1. Manufactured and certified by R.J.V. Gas Field Services Ltd., 4901-47 St. Vegreville, AB T9C 1C3
(Name and address of Manufacturer)
2. Manufactured for Husky Oil Operations Ltd., 19th Fl. Western Canada Place, 707-8th Ave. S.W. Calgary, AB T2P 1H5
(Name and address of purchaser)
3. Location of installation 11-5-48-24-W3 Marshall Field
(Name and address)
4. Type Vertical 2532 K2422.23 V90-306 N/A 1994
(Mark, or work, Load) (Design serial No.) (ICRNI) (Drawing No.) (INr), Ed. 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 1992 Edition
Year
- to 1992 Addenda N/A N/A
(Addenda (Date)) (Code Case Nos.) (Special Exemptions per UG-120(d))
6. Shell: SA-516-70 .625" (15.87) .125" (3.17) 22.75" (578 mm) 60" (1525 mm)
(Matl., Spec. No., Grade) (Nom. Thk. (in.)) (Corr. Allow. (in.)) (Diam. I.D. (in.)) (Length (General) (ft. & in.))
7. Seams: Long'l S.W.B. Full 100% N/A N/A Circ. S.W.B. Spot UW 11(a)5(b) 2
(Long. (Welded, Dbl., Spt., Lap, Butt)) (R.T. (Spot or Full)) (R.T. (%) (R.T. Temp. (°F)) (Time (hr)) (Circ. (Welded, Dbl., Spt., Lap, Butt)) (R.T. (Spot, Partial, or Full)) (No. of Coupons)
8. Heads: (a) Matl. SA-516-70 (b) Matl. SA-516-70
(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 Pressure (Convex or Concave)
(a)	Top	.625" (15.87)	.125" (3.17)			2:1				Concave
(b)	Bottom	.625" (15.87)	.125" (3.17)			2:1				Concave

If removable, bolts used (describe other fastenings)

(Matl., Spec. No., Gr., Size, No.)

9. M-WP (4965 Kpa) 720 psi at max. temp. (38°) 100 °F
design metal temp. (-29°C) -20 °F at (4965 Kpa) 720 psi. Hydro., pneu., or comb. test pressure (7448 Kpa) 1080 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
Inlet	N1	2" (60.3)	RFWN	SA-106-B/SA-105	Sch. XXS	-----	Weld	Shell
Outlet	N2	2" (60.3)	RFWN	SA-106-B/SA-105	Sch. XXS	-----	Weld	Top Head
L.C.	N3	3" (88.9)	RFWN	SA-106-B/SA-105	Sch. XXS	-----	Weld	Shell
Water Dump	N4	2" (60.3)	RFWN	SA-106-B/SA-105	Sch. XXS	-----	Weld	Shell

Supports: Skirt Yes Lugs --- Legs --- Other --- Attached Weld to Head
(Yes or no) (No.) (No.) (Describe) (Where and how)

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, form number, title's name and identifying number)

Volume - 18.15 Cu. Ft. (.514 m³) Vertical 2 Phase SeparatorExempt from impact test requirements as per Paragraph UG 20(f)Hydrostatically tested in the Vertical Position.

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. 19 562 expires July 12, 1996.
Date MAR 16 1994 Co. name R.J.V. Gas Field Services Ltd. Signed [Signature] (Representative)

CERTIFICATE OF SHOP INSPECTION

Vessel constructed by R.J.V. Gas Field Services Ltd. at 4901-47 Street, Vegreville, AB T9C 1C3

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 Department of Labour have inspected the component described in this Manufacturer's Data Report on MAR 16 1994, 19____, 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 16 1994Signed [Signature]

(Inspector)

Commissioned

Alberta # 31

(Not Board listed, under contract, State, Prov., and his.)

62019555.

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(Name and address of manufacturer)
2. Manufactured for Husky Oil Operations Ltd., 19th Fl. Western Canada Place, 707-8th Ave. S.W. Calgary, AB T2P 1H5
(Name and address of purchaser)
3. Location of installation 11-5-48-24-W3 Marshall Field
(Name and address)
4. Type Vertical 2532 K2422.23 V90-306 N/A 1994
(HORIZ. OR VERT. TANK) (Mfg.'s serial No.) (CRN) (Drawing No.) (Mat'l. 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 1992 Edition
Year
- to 1992 Addenda N/A N/A
Addenda (Date) Code Case Nos. Special Service per UG-120(d)
6. Shell: SA-516-70 .625" (15.87) .125" (3.17) 22.75" (578 mm) 60" (1525 mm)
Mat'l. (Spec. No., Grade) Nom. Thk. (in.) Corr. Allow. (in.) Diam. I.D. (ft. & in.) Length (overall) (ft. & in.)
7. Seams: Long'l S.W.B. Full 100% N/A N/A Circ. S.W.B. Spot UW 11(a)5(b) 2
Long. (Welded, Dbl., Singl., Lap, Butt) R.T. (Spot, Partial, or Full) Eff. (%) H.T. Temp. (°F) Time (hr) Girth (Welded, Dbl., Singl., Lap, Butt) R.T. (Spot, Partial, or Full) No. of Courses
8. Heads: (a) Mat'l. SA-516-70 (b) Mat'l. SA-516-70
(Spec. No., Grade) (Spec. No., Grade)

	Location (Top, Bottom, End)	Minimum Thickness	Corrosion Allowance	Crown Radius	Knuckle Radius	Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure (Convex or Concave)
(a)	Top	.625" (15.87)	.125" (3.17)			2:1				Concave
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(Mat'l., Spec. No., Gr., Size, No.)

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design metal temp. (-29°C) -20 °F at (4965 Kpa) 720 psi. Hydro., pneu., or comb. test pressure (7448 Kpa) 1080 psi.
10. zzles, inspection and safety valve openings:

Purpose (Inlet, Outlet, Drain)	No.	Diam. or Size	Type	Mat'l.	Nom. Thk.	Reinforcement Mat'l.	How Attached	Location
Inlet	N1	2" (60.3)	RFWN	SA-106-B/SA-105	Sch. XXS	-----	Weld	Shell
Outlet	N2	2" (60.3)	RFWN	SA-106-B/SA-105	Sch. XXS	-----	Weld	Top Head
L.L.C.	N3	3" (88.9)	RFWN	SA-106-B/SA-105	Sch. XXS	-----	Weld	Shell
Water-Dump	N4	2" (60.3)	RFWN	SA-106-B/SA-105	Sch. XXS	-----	Weld	Shell

1. Supports: Skirt Yes Lugs --- Legs --- Other --- Attached Weld to Head
(Yes or no) (No.) (No.) (Describe) (Where and how)

2. 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, Mfg.'s name and identifying stamp)

Volume - 18.15 Cu. Ft. (.514 m³) Vertical 2 Phase Separator

Exempt from impact test requirements as per Paragraph UG 20(f)

Hydrostatically tested in the Vertical Position.

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. 19 562 expires July 12, 1996.
Date MAR 15 1994 Co. name R.J.V. Gas Field Services Ltd. Signed [Signature] (Representative)

CERTIFICATE OF SHOP INSPECTION

Vessel constructed by R.J.V. Gas Field Services Ltd. at 4901-47 Street, Vegreville, AB T9C 1C3
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 Department of Labour

have inspected the component described in this Manufacturer's Data Report on MAR 15 1994, 19____, 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 15 1994 Signed [Signature] Commissions Alberta # 31
(Authorized Inspector) (Nat'l. Board (incl. endorsements), State, Prov. and No.)

U
W
RT-2

CERTIFIED BY
R. J. V.
GASFIELD SERVICE LTD.
BOX 295, VEGREVILLE, ALBERTA
PHONE 632-7774

A2916624

UNIT NAME

Vert. 2 Phase Separator

C.R. NO.

K2422.23

SERIAL NO.

2532

B. A. W. P.

720 psi
4965 kpa

MAZED TEST

1080 psi
7448 kpa

DESIGN TEMP.

100 °F
38 °C

CORR. ALLOW.

3.17 mm

HEAT TREATMENT

Nil

SIZE

610 x 1525 mm

SHELL MATL.

SA-516-70

HEAD MATL.

SA-516-70

WEIGHT

592 Kg

SHELL THICK.

15.87 mm

W.O.M.T.

-20 °F
-29 °C

HEAD THICK.

15.87 mm

DATE MFG.

94-03



EDMONTON
EXCHANGER

5545-89 Street, EDMONTON, Alberta T6E 5W9
Phone: (403) 468-6722 Fax: (403) 466-5155

QCC-001
REV. 0
DATE: AUG. 19/93
APPROVED BY: *S.2.*

CERTIFICATE OF COMPLIANCE - HEADS # 2532

CUSTOMER	ROY GASFIELD LTD	PACKING SLIP	H 33137
PURCHASE ORDER	788	PAGE	1 OF 2
TYPE	SE2.1	MATERIAL	SA 516-70MT
INSIDE CROWN RADIUS		INSIDE KNUCKLE RAD	

QTY	HEAT #	MFG FILE #	SIZE	THICKNESS		BRINELL HARDNESS	FORMING PROCEDURE
				NOM.	MIN.		
2	9248m-32823	TI44	24"O.D.	.750	.740	—	1
3	26516-62800	TI49	24"O.D.	.750	.737	—	1
1	84916-27033	TI42	24"O.D.	.750	.721	—	1
1	26516-62801	TI39	24"O.D.	.750	.733	—	1
3	84916-27032	TI38	24"O.D.	.750	.740	—	1
1	9248m-32827	TI45	24"O.D.	.750	.733	—	1
1	9248m-33791	TI48	24"O.D.	.750	.740	—	1
1	8692m-27625A	TI50	24"O.D.	.750	.731	—	1
1	3852m-60940	TI43	24"O.D.	.750	.731	—	1

FORMING PROCEDURE:

1. HOT FORMED @ 1650°F AND AIR COOLED
2. HOT FORMED @ 1900°F AND AIR COOLED
3. NORMALIZED @ 1650°F FOR 25 MIN/INCH AND AIR COOLED
4. COLD FORMED
5. RENORMALIZED @ 1650°F AND AIR COOLED AFTER FORMING
6. SOLUTION ANNEALED @ 1900°F AFTER FORMING
7. STRESS RELIEVED @ 1150°F PER UCS-56
- 8.

BRINELL EQUIPMENT: NEWAGE CALIBRATED PIN
BRINELL HARDNESS TESTER

SUPPLEMENTARY REQUIREMENTS:

1

THE HEADS LISTED ABOVE COMPLY WITH THE REQUIREMENTS OF ASME CODE SECTION I, AND ASME CODE SECTION VIII, DIV. I, INCLUDING PARAGRAPHS UG79 AND UG81. COLD FORMED HEADS COMPLY WITH PARAGRAPH UCS 79 (d). MATERIAL BEING SUPPLIED CONFORMS TO LATEST ADDENDA OF THE ASME CODE

EDMONTON EXCHANGER & MANUFACTURING LTD.

SUPPLEMENTARY EXAMINATION

DC

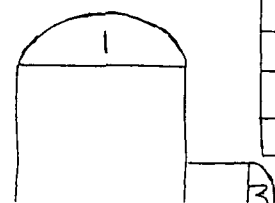
17 1994

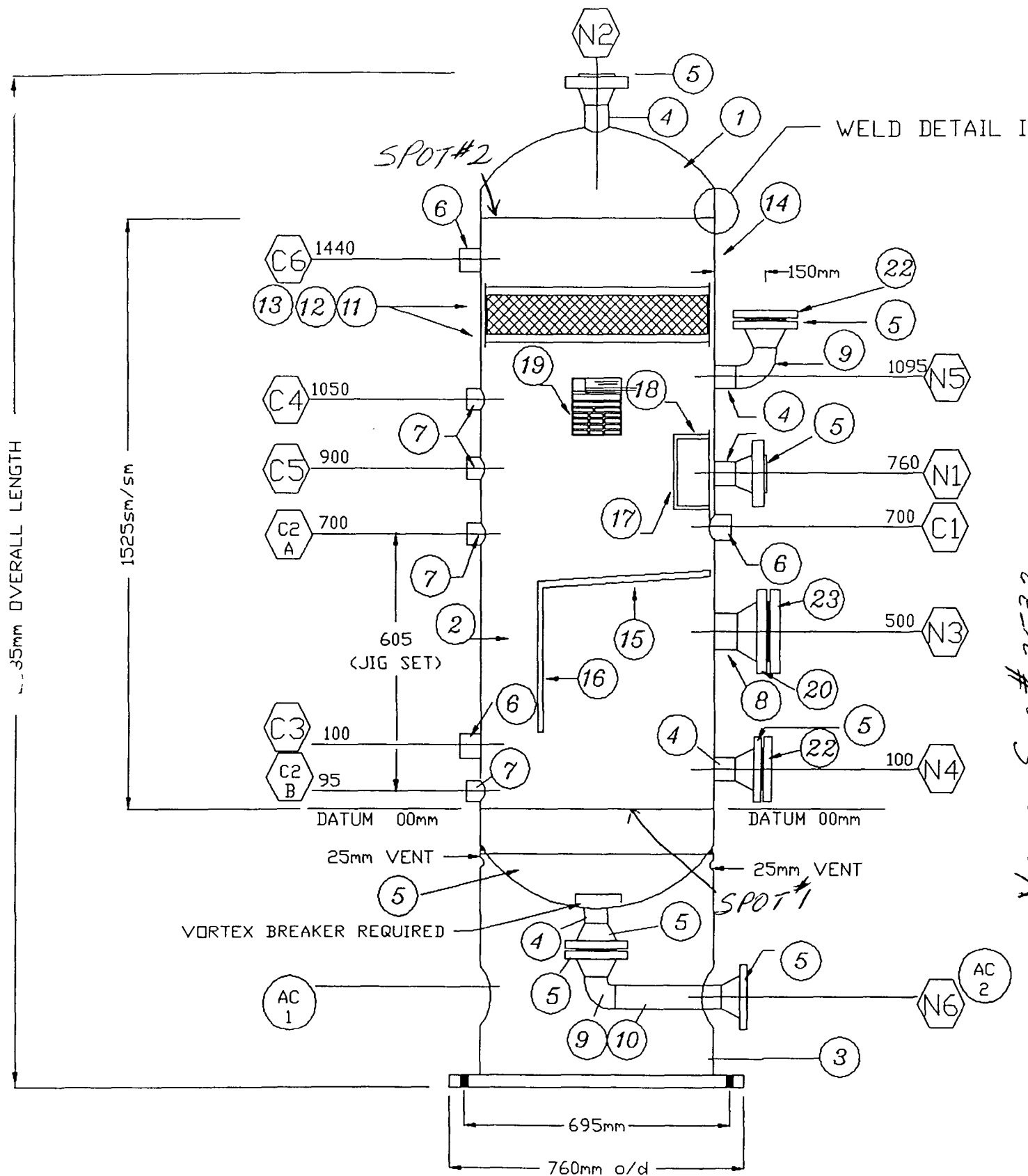
1. Points established - Sign & Date *[Signature]* (Authorized Inspector)

Serial # 2532 DWG# V90-306 (A)# 2916624
 Title 24" Separator CRN# K2422.23

ITEM	COMMENTS	AUTH. INS. HOLD POINTS	DATE FUNCTION COMPLETE & INSPECTOR'S INITIALS	
			QC INSPECTOR	AUTHORIZED INSPECTOR
Approved Drawing			FEB 18 1994 DE	<i>[Signature]</i> 94-03-04
Material checked against drawing, material list			FEB 18 1994 DE	
All tests checked			FEB 18 1994 DE	<i>[Signature]</i> 94-03-04
Process Layout			FEB 23 1994 DE	
Process Orientation & Rating			FEB 23 1994 DE	
Shell & Head			MAR 08 1994 DE	
Nozzles & fittings			MAR 23 1994 DE	
Internals (tray, baffles, ect)			FEB 25 1994 DE	
Internal Inspection			FEB 25 1994 DE	<i>[Signature]</i> 94-03-04
Sizes			MAR 10 1994 DE	
Welders I.D.			MAR 10 1994 DE	
Internal after completion all welding			MAR 10 1994 DE	<i>[Signature]</i> 94-03-25
Diagrams			MAR 15 1994 DE	<i>[Signature]</i> 94-03-16
Per N.D.E.				
Impact tests				
RT chart checked				
Neplate			MAR 10 1994 DE	<i>[Signature]</i> 94-03-16
Hydrostatic test			MAR 16 1994 DE	✓
Final Reports			MAR 16 1994 DE	✓

		Spec.	Heat Number	Thickness
Shell	C1	SA-516-70	1734P-47117	15.87 mm
	C2			
	C3			
Heads	1-	SA-516-70	26516-62800	15.87 mm
	2-	SA-516-70	24403-90660	15.87 mm
	3-			
		Spec.	Size	Schedule
Nozzles		SA-106-B	2"	Sch. XXS
Fittings		SA-105	1 1/2"	# 6000 cplg.
Tubes				





ELEVATION

VESSEL SER # 2532