

Item Name: CONTACTOR
Location: HILLMOND
Equip #: S12-01-00V-SN94210AA
Service: SWEET GAS

Test Date: 97.2.19
Prov #: S94210AA
CRN #: M5722.23
Tag #: S/N 94210-AA

Type of Inspection: VI UG PT HT
 VIN Yes VE Yes LT RT
 MT Other:

Scope: EXTERNAL
Cleaning: NONE
Access: NONE

Observations

Summary:

- Glycol contactor is in good condition and suitable for service.

Details:

EXTERNAL INSPECTION

Insulation/Cladding - N/A
Piping Alignment - Acceptable
Grounding - Acceptable
Base/Supports - Acceptable
Paint/Coating - Acceptable
Ladder/Stairs - N/A

- Visual inspection of Contactors external surfaces did not reveal any areas of concern.
- UT thickness tests were performed on random locations of the Contactors shell and bottom head with all areas examined exceeding the values shown on the nameplate. See attached UT report and sketch for thicknesses and locations.
- The Pressure Relief Device protecting the contactor was inspected and tagged with Husky I.D. #1328. Inspection revealed the PRD's nameplate to have been removed - nameplate was found laying on a beam beneath the PRD.

INTERNAL INSPECTION

- Unit was in service at time of inspection - internal inspection was not performed.

Recommendations

Summary:

- Nameplate for Pressure Relief Device to be reattached to the PRD body.
- PRD should be serviced in 1999.
- UT thickness survey should be continued on a two year cycle.

Details:

cc: Greg Nelson

Suitable For Service: Yes
Follow Up Required: No
Inspector: Ray Trachuk

Remedial Action Priority:

Date: 97.2.19

NEW

Page 1

Grid: CNTCTR SN94210AA
File: 94210AA.GRD
Remark: HIL 11-3-50-26W3

Grid Coordinates

Upper Left : A1
Lower Right: A6

Statistics

Grid Readings: 6
Empty Readings: 0
Maximum: 0.748
Minimum: 0.726
Mean: 0.738
Std Dev: 0.008
Breakpoint: 0.625
Above or = Bkpt 6
Below Breakpoint 0

Grid: CNTCTR SN94210AA
File: 94210AA.GRD

A

1	0.741
2	0.748
3	0.739
4	0.732
5	0.740
6	0.726

FORM U-1A MANUF. URER'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

3102871

Manufactured and certified by PROPAK SYSTEMS LTD., 505 EAST LAKE BLVD., AIRDRIE, ALBERTA, T4B 2C3, CANADA
(Name and address of manufacturer)

Manufactured for PROPAK SYSTEMS LTD., 505 EAST LAKE BLVD., AIRDRIE, ALBERTA, T4B 2C3, CANADA
(Name and address of purchaser)

Location of installation STOCK UNIT
(Name and address)

Type VERTICAL 94210-AA M-5722.23 D-CTR-94023-101 REV.1 N/A 1995
(Horiz. or vert., tank) (Mfr's serial No.) (ICRN) (Drawing No.) (Nat'l. Bd. No.) (Year built)

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
Year

to 1993 N/A N/A
Addenda (Date) Code Case Nos. Special Service per UG-120(d)

Shell: SA-106-B .687" .062" 0'-11.3" 26'-6"
Matl. (Spec. No., Grade) Nom. Thk. (in.) Corr. Allow. (in.) Diam. I.D. (ft. & in.) Length (overall) (ft. & in.)

Seams: SNLS N/A 100% N/A N/A SNGL. BUTT WELD **SPOT 5
Long. (Welded, Dbl., Sngl., Lap, Butt) R.T. (Spot or Full) EH. (%) H.T. Temp. (°F) Time (hr) Girth (Welded, Dbl., Sngl., Lap, Butt) R.T. (Spot, Partial, or Full) No. of Courses

Heads: (a) Matl. SA-516-70 (Spec. No., Grade) (b) Matl. SA-516-70 (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)
TOP	.575"	.063"			2:1				CONCAVE
BOTTOM	.575"	.063"			2:1				CONCAVE

If removable, bolts used (describe other fastenings) N/A
(Matl., Spec. No., Gr., Size, No.)

MAWP 1310 psi at max. temp. 151 °F
Min. design metal temp. -20 °F at 1310 psi. Hydro., pneu., or comb. test pressure * 1965 psi.

Nozzles, inspection and safety valve openings:

Purpose (Inlet, Outlet, Drain)	No.	Diam. or Size	Type	Matl.	Nom. Thk.	Reinforcement Matl.	How Attached	Location
GAS IN	1	2"	RPWN	SA-106-B	.343"	N/A	WELDED	SHELL
GAS OUT	1	2"	RPWN	SA-106-B	.343"	N/A	WELDED	TOP HEAD
L.C. (OIL)	1	2"	CPLG	SA-105	3000#	N/A	WELDED	SHELL
L.C. (WATER)	1	2"	CPLG	SA-105	3000#	N/A	WELDED	SHELL

Supports: Skirt YES Lugs 2 Legs NIL Other N/A Attached HEAD-WELDED
(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: N/A
(Name of part, item number, Mfr's. name and identifying stamp)

VOLUME : 21.47 CU.FT. -EXEMPT FROM IMPACT TESTS PER UG20(f) AND UG22 * HYDROSTATIC TEST
TAG NUMBER : T-710 **SPOT-UW11(a) 5(b) ITEM #10 CONT'D ON U-4
VESSEL TYPE : GLYCOL CONTACTOR -BUILT TO DRWG #D-CTR-94210-101 REV.1 FILE NUMBER: 210AAU1A

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. 21387 expires JULY 12, 19 96
Date Aug. 1, 95 Co. name PROPAK SYSTEMS LTD. Signed Leon S. Bault
(Manufacturer) (Representative)

CERTIFICATE OF SHOP INSPECTION

Vessel constructed by PROPAK SYSTEMS LTD. at AIRDRIE, ALBERTA
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 ALBERTA BOILERS SAFETY ASSOCIATION
have inspected the component described in this Manufacturer's Data Report on Aug. 2, 19 95, 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 95/8/2 Signed [Signature] Commissions Alberta 40 (R)
(Authorized Inspector) (Nat'l. Board (incl. endorsements), State, Prov. and No.)

3102871

FORM U-4 MANUFACTURER'S DATA REPORT SUPPLEMENTARY SHEET
As Required by the Provisions of the ASME Code Rules, Section VIII, Division 1

1. Manufactured and certified by PROPAK SYSTEMS LTD., 505 EAST LAKE BLVD., POSTAL BAG #2, AIRDRIE, ALBERTA, T4B 2C3, CANADA
(Name and address of Manufacturer)

2. Manufactured for PROPAK SYSTEMS LTD., 505 EAST LAKE BLVD., POSTAL BAG #2, AIRDRIE, ALBERTA, T4B 2C3, CANADA
(Name and address of Purchaser)

3. Location of installation STOCK UNIT
(Name and address)

4. Type: VERTICAL GLYCOL CONTACTOR 94210-AA
(Tank, separator, heat exch., etc.) (Mfg's. serial No.)
M-5722.23 D-CTR-94023-101 REV.1 N/A 1995
(CRN) (Drawing No.) (Nat'l. Bd. No.) (Year built)

Data Report Item Number	Remarks							
PURPOSE	NO	SIZE	TYPE	MATERIAL	THICKNESS	REINFORCEMENT	ATTACHED	LOCATION
GLYCOL IN	1	.75"	CPLG	SA-105	3000#	N/A	WELDED	SHELL
GLYCOL OUT	1	.75"	CPLG	SA-105	3000#	N/A	WELDED	SHELL
GLYCOL COIL	2	.75"	CPLG	SA-105	3000#	N/A	WELDED	SHELL
OIL OUT	2	1"	CPLG	SA-105	3000#	N/A	WELDED	SHELL
TRAY DRAIN/INSPECTION	9	.75"	CPLG	SA-105	3000#	N/A	WELDED	SHELL
DRAIN	1	1"	SOL	SA-105	3000#	N/A	WELDED	BTM. HEAD
LG (OIL)	2	.75"	CPLG	SA-105	3000#	N/A	WELDED	SHELL
LG (WATER)	2	.75"	CPLG	SA-105	3000#	N/A	WELDED	SHELL
PSV	1	.75"	CPLG	SA-105	3000#	N/A	WELDED	SHELL
TI	1	.75"	CPLG	SA-105	3000#	N/A	WELDED	SHELL
PI	1	.50"	CPLG	SA-105	3000#	N/A	WELDED	SHELL
INSPECTION	2	.75"	CPLG	SA-105	3000#	N/A	WELDED	SHELL
EQUALIZATION	1	1"	CPLG	SA-105	3000#	N/A	WELDED	SHELL
FILE NO: 210AAU4								

Certificate of Authorization: Type U No. 21387 Expires JULY 12, 19 96

Date Aug 1, 95 Name PROPAK SYSTEMS LTD. Signed Leon R. Houllet
(Manufacturer) (Representative)

Date 9/5/92 Name [Signature] Commission Alberta 40 (R)
(Authorized Inspector) (Nat'l. Board incl. endorsement, State, Province and No.)

(12/91) This form (E00118) may be obtained from the ASME Order Dept., 22 Law Drive, Box 2300, Fairfield, NJ 07007-2300 REPRINT 9/92

[Signature]

Construction Data Report for Piping Systems

Field Construction ☐

Shop Construction ☒

Constructed by: Propak Systems Ltd.

Alberta Quality Program No: AQP(S) 1050

Address: 505 East Lake Blvd., Airdrie, Alberta, T4B 2C3, Canada

Expiry Date: June 17, 1999

Alberta WPS Registration No: WP-590.2 Alberta Piping Design Registration No: _____

Constructed for: Husky Oil Operations Ltd. Contract No: 94210-151

Address of Owner: Highway 16 East, Lloydminster, Saskatchewan, S9V 0Z8, Canada

Location of Installation (LSD): L.S.D.#11-03-50-26 W3M, Saskatchewan

WPS No's. used: P.S.L. Nos. GTSMP1

Construction Code: ANSI/ASME B31.1 ☐ B31.3 ☒ B31.5 ☐

Drawing No. & Line No.	Process	Design Press. kpa	Design Temp. °C	Test Press. kpa	Test Medium	Material Specification & Grade	Pipe Diameter & Sched.	Flange Primary Rating	Preheat or PWHT Temp.	NDE	Other NDE
B-PIP-94210-151-1	Natural Gas	9032	66	13548	water	SA-106-B	60-3.91	600	10°C/no	10%	Visual
B-PIP-94210-151-2	Natural Gas	9032	66	13548	water	SA-234-WPB	60-Std.	600	10°C/no	10%	Visual
B-PIP-94210-151-3	Natural Gas	9032	66	13548	water	SA-106-B	60-3.91	600	10°C/no	10%	Visual
B-PIP-94210-151-4	Natural Gas	Atm.	N/A	Leak-proof	water	SA-106-B	60-5.54	150	10°C/no	None	Visual

Shop Construction Data Reports have been attached for the following items which form part of the above piping system(s):


Drawing No: _____ Line No: _____ Constructor: _____

Page No: 1 File No: 94210151.PIP Spool No's: 1-4

Certificate of Compliance

I certify that the information in this Construction Data Report is correct and that the piping described herein was constructed in compliance with the applicable ANSI/ASME Piping Code(s), and where applicable, the Alberta Boilers and Pressure Vessels Act and Regulations.

Date: Nov 21/99 Propak Systems Ltd.
Constructor


Authorized Representative

Certificate of Inspection

I, the undersigned, have inspected the piping described in this Construction Data Report and state that, to the best of my knowledge and belief, _____ has constructed this piping in accordance with the applicable sections of the ANSI/ASME Piping Code(s) and, where applicable, the Alberta Boilers and Pressure Vessels Act and Regulations.

Date: _____

Date: _____

Owner's/Customer's Inspector

Inspector (Province of Alberta)



U

W
RT2

CERTIFIED BY,

PROPAK SYSTEMS LTD.
AIRBORNE ALBERTA CANADA

MAWP 1310 PSI AT 151 °F

MDMT -20 °F AT 1310 PSI

SERIAL NO. 94210-AA

YEAR BUILT 1995

VESSEL TYPE GLYCOL CONTACTOR

MAWP 9032 KPA AT 66 °C

MDMT -29 °C AT 9032 KPA

SHUT OFF PRESS 17.45 UNL HEAD 562 HLL MM 14.29

TAC T-710

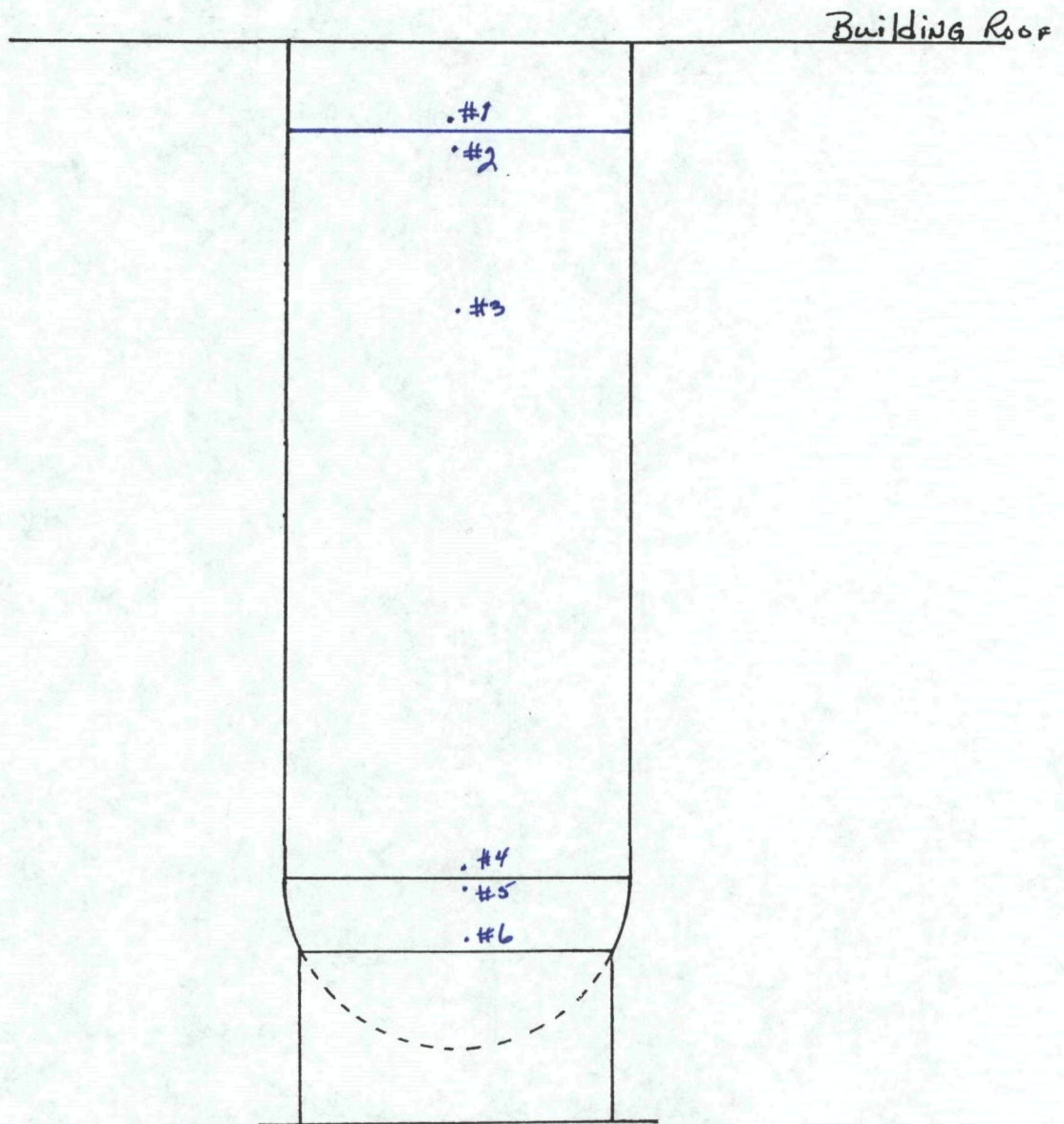
CODE P/N UWL1A5B

GRN M-572.23

C.A. - 1.6 MM

ANNO 3102871

2.0 Remarks (Continued)



Looking South.
 Hillmond 11-3-50-26W3
 S12-01-00V-SN94210AA



CERTIFIED BY

PROPAK SYSTEMS LTD.
AIRDRIE ALBERTA CANADA

M.A.W.P. 1310

P.S.I. 190

M.D.M.T. -20

F. 1310

SERIAL NO. 34210-AA

YEAR BUILT 1995

VESSEL TYPE GLYCOL CONTAINER

M.A.W.P. 9032

N.P.A. 86

M.D.M.T. -29

C 9032

SHELL
THK637
17.45IN.
MMHEAD
THK152
17.21111
14.01

TAG

T-710

CODE 1430

UNL1A3

CRN 14522.23

C.A. 4.6 M

131

A NO.

3402871

'97 2 18

HUSKY OIL QA PHOTOGRAPH

Date: 97-02-18 Inspector: Ray Erickson
Location: Hillmond 11-3-30-26W3
Equipment #: 512-01-00V-SN942101A
Equipment Name: Contactor
Photo facing: N (S) E (W) Report #: _____
Comments: _____



HUSKY OIL QA PHOTOGRAPH

Date: 97-02-18 Inspector: Ray Trachuk
Location: Hildmond 11-3-5026W3
Equipment #: 512-01-00V-SN 94210AA
Equipment Name: Contactor
Photo facing: N S E W Report #: _____
Comments: _____

