

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

2733863
July 5/91

1. Manufactured and certified by I.P. CONSTRUCTORS LTD., 5430-30 Street S.E., Calgary, AB T2C 1G2
(Name and address of manufacturer)
2. Manufactured for Saskatchewan Oil & Gas Corporation, 1777 Victoria Ave., Regina, Sask.
(Name and address of purchaser)
3. Location of installation LSD 1-30-44-26-W3M Marsden Unit #1, Sask.
(Name and address)
4. Type Horizontal 91-1275 A-1952.3 D-1275-09-01 n/a 1991
(Hob. or vert., tank) (Mfr'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 1989
Year
to 1989 n/a n/a
Addenda (Date) Code Case Nos. Special Section per UG-120(d)
6. Shell: SA516-70 0.375 1.59 119.25 in 40'-0" S/S
Mat'l. (Spec. No., Grade) Nom. Thk. (in.) Cor. Allow. (in.) Diam. I.D. (ft. & in.) Length (overall) (ft. & in.)
7. Seams: Singl. B. Weld FULL .85 N/A N/A Sng. B. Weld * Spot 4
Long. (Welded, Obl., Singl., Lap, Butt) R.T. (Spot or Full) E.H. (%) H.T. Temp. (°F) Time (hr) Girth (Welded, Obl., Singl., Lap, Butt) R.T. (Spot, Partial, or Full) No. of Courses
8. Heads: (a) Mat'l. SA516-70 (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)	L. F/T	.632	1.59	N/A	N/A	2:1 SE	N/A	N/A	N/A	concave
(b)	Right	.417	1.59	N/A	N/A	2:1 SE	N/A	N/A	N/A	concave

If removable, bolts used (describe other fastenings)

9. MAWP 75 121 112.5 psi at max. temp. 121 °F
* Min. design metal temp. -20 °F at 75 psi Hydro., pneu., or comb. test pressure 112.5 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

11. Supports: Skirt No Lugs 0 Legs 0 Other 2-saddles Attached welded to shell
(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: N/A
(Name of part, item number, Mfr's name and identifying stamp)

UG20F Charpy impact not required * UW11(A)5B

TAG: V-101 Free Water Knockout

VOLUME: 97 cu. meter WEIGHT: 39700 lbs

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. U15544 expires 12 Nov, 1991.
Date 5/7/91 Co. name I.P. CONSTRUCTORS LTD. Signed [Signature]
(Manufacturer) (Representative)

CERTIFICATE OF SHOP INSPECTION

Vessel constructed by I.P. CONSTRUCTORS LTD. at Calgary, 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 The Alberta Government

have inspected the component described in this Manufacturer's Data Report on July 5, 1991, 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 July 5/91 Signed [Signature] Commissions ALTA.
(Authorized Inspector) (Print Board (incl. endorsement), State, Prov. and No.)

