

0114

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

3121678

1. Manufactured and certified by Opco32 Industries Ltd. 2601 Centre Avenue East, Calgary, Alberta, T2P 2L1  
(Name and address of manufacturer)  
2. Manufactured for RIGEL OIL & GAS LTD., 255-6th AVE., S.W., CALGARY, AB.  
(Name and address of purchaser)  
3. Location of installation L50-10-8-33-9-W6M  
(Name and address)  
4. Type VERT. SEPARATOR V-2285 MS991.2 V-95-2285-1247 R3 1995  
(Formal or set name) (Vessel's serial No.) (Code) (Drawing No.) (Part No.) (Year)  
5. The chemical and physical properties of all parts meet the requirements of material specification of the ASME BOILER AND PRESSURE VESSEL CODE. The design, construction, and workmanship conform to ASME Rules, Section VIII, Division 1 1992  
(Year)

6. Shell: SA-516-70N 875" 0825" 2'-10.250" 8'-0"  
(Advance plate) (Code Case No.) (Special service per UG-100a)  
7. Seams: SWB FULL 100% SWB \*SPOT 1  
(Weld Spec. No., Grade) (Nominal Thk. in.) (Cor. Allow. in.) (Diameter (D) in.) (Length (overall) in.)  
(Long. Weld Det. Sing. Lap Butt) (R.T. (Spot or Full)) (Et. No.) (H.T. Temp. F) (Time (hr)) (Grp. (Welder Det. Sing. Lap Butt)) (R.T. (Spot, Partial or Full)) (No. of Covers)

8. Heads: (a) Mat'l SA-516-70N (b) Mat'l SA-516-70N  
(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 Flare (Cont. Conv)
TOP	8125"	0825"			2:1				CONC
BTM	8125"	0825"			2:1				CONC

9. MAWP: 735 PSI psi at max. temp 100 F °F  
Min. Des. Met. Temp. -20 F °F at 735 PSI psi hydro. test pressure 1103 PSI psi  
(Where Specified No. CU, SA, etc.)  
(Where Specified No. CU, SA, etc.)  
10. Nozzles, inspection and safety valve openings:

Process (Mat. Code, Det.)	No.	Dim. or Size	Type	Mat.	Thk.	Reinforcement	How	Location
IN/OUT	2	6"	RFW	SA-203G	20#	INTEGRAL	WELDED	
HLS/MS/MS/MS/MS/MS	6	2"	TOL	SA-105	3000#	INTEGRAL	WELDED	SH/D
VALV/SP								
DRWN	1	1"	NPT	SA-203G	34#	INTEGRAL	WELDED	
WLG/T/MS/CLG	3	.75"	TOL	SA-105	3000#	INTEGRAL	WELDED	
PI	1	.5"	TOL	SA-105	3000#	INTEGRAL	WELDED	

11. Supports: Skirt YES Logs Other Attache BTM HD & WELDED  
(Yes/No) (Yes/No) (Where and how)

12. Remarks: Manufacturer's Partial Data Reports properly identified and signed by Commissioned Inspectors have been furnished for the following the report:  
(Name of part, item number, MFR's name and identifying stamp)  
Impact Testing: EXEMPT AS PER UG-20f Radiography per: \* SPOT RT AS PER UG-11a 5b  
Tag No.: V-101 Volume: 68.42 CU FT (1.833 CU M)

**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. 21366 expires July 21, 1998  
Date Oct 13/95 Co. Name Opco32 Industries Ltd. Signed \_\_\_\_\_  
(Manufacturer)

**CERTIFICATE OF SHOP INSPECTION**  
Vessel constructed by Opco32 Industries Ltd. at CALGARY, ALBERTA, CANADA  
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 ABSA, Alberta Boilers Safety Association  
have inspected the component described in the Manufacturer's Data Report on OCT. 13 1995 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 the 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 95-10-13 Signed \_\_\_\_\_ Commissions \_\_\_\_\_ ALBERTA 55 (R)  
(Inspector) (Where and how)