

A 429 910

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

1. Manufactured and certified by Opsco '92 Industries Ltd. 2601 Centre Avenue East, Calgary, Alberta, T2P 2L1

2. Manufactured for NORCEN ENERGY 715 5TH AVE. S.W. CALGARY, AB.

3. Location of installation TABER NORTH 09-17-11-16 W4M BATTERY

4. Type VERTICAL SEPARATOR V-27268 (Drawing No.) N7672.2 V-97-2726-1583 P/Q N/A (Part Bd) 1997 (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 1995 (Year)

6. Shell: Address (date) 1995 N/A Code Case Nos. SA-516-70N .500" .125" Special service per UG-120(g) 35" Length (overall) (ft. & in.) 10'

7. Seams: TYPE 1 FULL 1150 F 1 HR TYPE 1 FULL TYPE 1 Diameter (D) (ft. & in.) FULL Length (overall) (ft. & in.) 10'

8. Heads: (a) Mat'l SA-516-70N (b) Mat'l SA-516-70N (Spec. No. Grade)

Location (Top Bottom, Ends)	Minimum Thickness	Corrosion Allowance	Crown		Knuckle Radius	Elliptical Ratio	Conical		Hemispherical Radius	Flat Diameter	Side to Press (Conc'd/Conv)
			Radius	Radius			Apex Angle	Radius			
(a) TOP	.470"	.125"				2:1					CONC
(b) BTM	.470"	.125"				2:1					CONC

if removable, bolts used (describe other fasteners)

9. MAWP: 280 °F at 280 psi at max. temp 100 °F 420 psi
Min. Des. Met. Temp. -20 °F at 280 psi Hydro. pres. of comp. test

10. Nozzles, Inspection and safety valve openings:

Purpose (Inlet, Outlet, Drain)	No.	Diam. or Size	Type	Mat'l.	Thk.	Reinforcement Material	How Attached	Location
IN/O OUT	2	3"	150# RFWN	SA-333-6	.600"	INTEGRAL	WELDED	
G OUT/CL/CS/NS/PL/SHH	6	4"	150# RFWN	SA-333-6	.674"	INTEGRAL	WELDED	SH
LG/SL/CP/PSV/SHH	10	2"	150# RFWN	SA-333-6	.426	INTEGRAL	WELDED	
S COND OUT/CDRAIN								

11. Supports: Skirt Legs Other Attache

12. Remarks: Manufacturer's Partial Data Reports properly identified and signed by Commissioned Inspectors have been furnished for the following the report:

Impact EXEMPT AS PER UG-20(f) Volume: 76 CU. FT. 2.15 CU. M. CONST. DN: V-97-2726-1583 R3
Tag No.: V-102

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. 21256 expires July 21, 1998
Date Aug 28 1997 Co. Name Opsco '92 Industries Ltd. Signed [Signature] (Representative)

CERTIFICATE OF SHOP COMPLIANCE
Vessel constructed by Opsco '92 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 09-17-11-16 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 25 Aug 1997 Signed [Signature] Commissions ALBERTA (Authorized Inspector)