



Canadian Natural

## Addition/Repair of Non-Pressure Containing Parts Static Data Form

Date:	Nov 30, 2014	Vessel Description:	TREATER
A #:	A0403457	CRN #:	L-0015.2
Serial #:	97015-2-30	MAWP:	75 PSI
Facility:	12-09 Brintnell Battery	Shell Thickness:	0.500"
Vessel LSD:	12-09-081-22w4m	Firetube Thickness:	N/A
Owners Inspector:	Ed Tymensen	Repair Organization:	Cameron
Scope of Work:	Alteration <del>Addition</del> of treater – removal of existing inlet deflector box and addition of inlet horseshoe downcomer shroud.		

## Travel Sheet - Addition/Repair of Non-Pressure Containing Parts

A #:	A0403457	Date:	Nov 30, 2014
Vessel LSD:	12-09-081-22w4m	Facility:	12-09 Brintnell Battery

Step #	Description of Step	<del>CNRL</del> <sup>Contractor</sup> Asset Integrity		<del>CNRL</del> <sup>CNRL</sup> Asset Integrity		CNRL Inspector	
		Action	Initial & Date	Action	Initial & Date	Action	Initial & Date
<b>Scope Sign-Off</b>							
		H	J.B. 11/30				
<b>Vendor Qualification</b>							
Step 1	Ensure Vendor is Qualified	H	J.B. 11/30				
Step 2	Notify Jurisdiction	H	J.B. 11/30				
<b>Weld Preparation</b>							
Step 2	Area Cleaned to White Metal		J.B. 11/30				ET 11/30
Step 3	UT & MPI Weld Are for Discontinuities		J.P. 11/30				ET 11/30
<b>Hydrogen Bake Out</b>							
Step 4	Perform Bake-Out (If Required)		n/a		n/a		n/a
Step 5	Heating Method Used for Bake-Out		n/a		n/a		n/a
Step 6	Substitution of Induction Coils		n/a		n/a		n/a
<b>Welding</b>							
Step 7	Pre-Heat Temperature		J.P. 11/30				ET 11/30
Step 8	New Electrodes		J.B. 11/30				ET 11/30
Step 9	Approved WPS	H	J.B. 11/30				
Step 10	Stringer Beads – no down hand welding		J.B. 11/30				ET 11/30
Step 11	Dry Powder MT on First Layer		n/a		n/a		n/a
Step 12	Interpass Temperatures		J.P. 11/30				ET 11/30
Step 13	Wrap & Cooling Rates		J.B. 11/30				ET 11/30
Step 14	Grind and Smooth Contour		J.P. 11/30				ET 11/30
Step 15	MT of final weld		J.P. 11/30				ET 11/30
Step 16	PWHT if Required as Per U1A		n/a		n/a		n/a
<b>Non-Destructive Examination (NDE) after Post-Weld Heat Treatment</b>							
Step 17	12 Hour MPI		J.P. 11/30				ET 11/30
Step 18	No Hydrotest		J.B. 11/30				ET 11/30
<b>Documentation</b>							
Step 19	Completion of Contractor Documentation		J.P. 11/30			H	
Step 20	CNRL Inspector Signs Jurisdictional Docs		J.P. 11/30			H	
Step 21	File final QC Package and update Maxitrak	H	J.B. 11/30				

Action Required: H = Hold Point, W = Witness Point, R = Review Point, NA = Not Applicable

<b>Final Sign-Off</b>	
Contractor:	CNRL Inspector: