

6-10420 123 St  
 Grande Prairie, Alberta  
 T8V 8B8  
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**Magnetic Particle  
 Inspection Report**

MT\_87-3568-0\_jun2013

Client: Devon Canada Corporation		Equipment Owner: Devon		Date: June 11, 2013	
Item Inspected: Both Fire Tubes from Treater			Acceptance Code: ASME VIII, Div 1		
Location: Valhalla Oil Battery 10-14-76-10 w6m					
Procedure: MT-01	Surface Preparation: Sand Blasted	Method: Wet Continuous	Light Source: 3 x C cell Halogen		
Equipment: AC Yoke	Manufacturer: Magnaflux	Serial # HY-10	Cal. Due: Oct 1, 2013	Cal Std: ASME 10 lbs S/N: A392	
Contrast Paint: Magnaflux WCP-2	Batch# 02269	Black Light: None	Cal. Due: N/A	Serial # n/a	
Wet Particles: Magnaflux 7HF	Batch# 00116	Particles: N/A	Batch # N/A	Temp: 10-20'C	

**Job Scope:**

- To perform contrast magnetic particle on 100% of the welds on both fire tubes from treater serial #87-3568-0.
- To perform an external visual inspection on both fire tubes.

**Overview**



**Results:** There was three small cracks detected in tube #1, All three cracks were found in one location and were removed by lightly sanding the weld. There was one crack found on tube #2 which was also removed by lightly sanding. No other cracking or linear indications detected on any of the welds on both fire tubes.

These welds remain acceptable to reference code.

These fire tubes were left in the rain overnight after sandblasting and were covered with a wet thick rust. The surface of these tubes were cleaned as much as possible with rags and a wire brush but the visual inspection was still limited. There is areas of corrosion and pitting on all sides of both fire tubes. The average depth of the pitting on tube 1 is 0.53mm . The deepest pit found on tube 1 was 1.05mm. The average depth of the pitting on tube 2 is 0.22mm . The deepest pit found on tube 2 was 0.47mm.

*See pg 2 for more inspection photos.*

Technician(s): Steve Utz (CGSB Level 2 U.T / M.T #12119)

Client Representative: Jason McGovern

Assistants: Patrick Rabara



**Cracks**

Three small cracks were found on the back of the flange to tube weld. Cracks were removed.



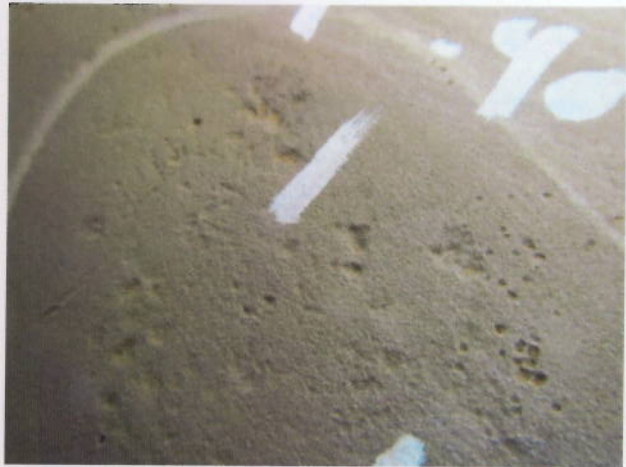
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Crack found on the front of the flange to tube weld. Crack was removed.

