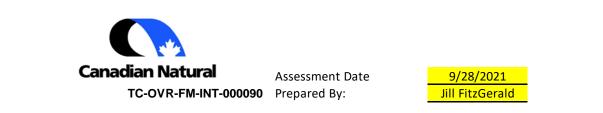


PRESSSURE EQUIPMENT INSPECTION INTERVAL APPROVAL

		Part 1 – Fa	acility and Equipment Informatio	n
Facility / Field Name:			Location:	
GRAND F	ORKS EAST 1	Charles the state of the state		04-01-013-13W4 BATTERY
			Part 2 - Assessment Type	
	Inter	val assessment has	been performed as per TC-OVR-	PRO-INT-000036
Individual Equipment:				
Provide the aguisment number				
Provide the equipment number Multiple Equipment:				
	Ľ			
Provide the equipment number	rs or refer to Se	ection 4 for the file le	ocation:	
Like Service Comparison:				
Eine dervice demparison.	V			
Provide the equipment number	s or refer to Se	ection 4 for the file le	ocation:	
			ary of Findings / Issues / Action	M
The vessels and PSVs that requ	uire a complete			d Forks East 04-01 battery were assessed for interval
revision.				
The test treater (A0227925) TMI	L 25 3" Sch ST	D elbow RL is 8.6 yr	s using structural Tmin, the vess	el itself was in good condition. The HP flare KO
KO in 2023 to verify STCR.	ow (bridle) RL	is 8.0 yrs using stru	ctural Tmin, the vessel itself was	in good condition. VE/UT the test treater and HP flare
A0161444: middle anodes were	40% consume	ed in 2019, confirm i	f replaced.	
Increase the internal inspection	n interval to 60	months, due in 2024	4, for all vessels assessed.	
2022. All other PSVs assessed	SV (S/N 93107) were in good c	0) was a new install	in 2019 and is currently assigned ave their service interval increase	d the max interval as per AB-506 grade 1. Service PSV in
	were in good o		art 4 – Inspection Interval	to to months, service in 2024.
Assessment Completed Date:	Γ		· · · · · · · · · · · · · · · · · · ·	2004
Assessment Completed Date:			September 28th	
Previous Interval:	New Interval:		Assessment Spreadsheet File of	r Form Location:
36		60		
30		00		ENERAL\15 Rep Inspections & Interval
			East 04-01- Integrity Assessment	al Revision\Grand Forks East 15-15\Grand Forks
Note: If the assigned inspection	n intonval is no	t the came for all an		erval may be identified on the assessment Form or
Spreadsheet.	i interval is no	tine same for all eq	uipment being assessed, the inte	erval may be identified on the assessment Form or
		Par	t 5 – Approvals / Rejection	
Final Approval: Asset Integrity		l	t o Approvais / Nejection	
Final Approval: Asset Integrity				∠ ACCEPT
Name: Kelly Matsalla				REJECT
		1945 1947 1947	144, confirm if middle anodes	
Cert. #: ABSA IPV-PV# 1001, TS 81691	ASK Class 2#	were replaced in 20 Periodic VE/UT ins	pections A0227925 TML 25,	Kally J. Martacilla
100		posterior contrata de la contrata del contrata de la contrata del contrata de la contrata del la contrata de la contrata del la contrata de l	noted in Part 3, must be	, ,
		completed for valid	l extension.	
Date: Sept. 29, 2021				
				Signature
Final Approval: Operations				Signature
(Foreman level or above)				✓ACCEPT
Name: Jim Yaroslawsky				□REJECT
Danisiana Field Ferrance		Comments:		
Position: Field Foreman				
Date: Sept. 29, 2021				
				0
				Signature

Assessment Date: 9/28/2021
Prepared By: Jill FitzGerald

	LOCAT	TION	IDENT	FICATION			VESSEL DESCR	CRIPTION			SERVICE DATA	l l	ISPECTION DATES				INSPECTION REVIEW				PIPING	BEYOND VESSEL BOU	NDARY									PO	ST REVIEW
	LOCAT		IDEIAII				MANWAY	VEAD			SHELL TUBE	1.407.07	LACT DOW	INT	D LACTINGS OFFICE			COPROSION DATE	DEMAINING LIE	WORST CORRSION	WORST CASE PIPING	PIPING REMAINING LIFE	WORST CORROSION		EQUIPED ACTIONS FOR	DICK DANKING	NDL BEVIEW COMPLETE	DEVIEWED DV			DON DITE TO DO OFFICE AND	NEW INSP.	PENGE
JR#	FACILITY	LSD	JUR# SERIAL#	CRN UNIT #	EQUIPMENT DESCRIPTION	EQUIPMENT TYPE	(INTERNAL ACCESS)	BUILT	MANUFACTURER	STATUS	MAWP MAWP SWEE (PSI) (PSI)	EET/SOUR LAST REG INSP	SERVICE (MON	ITHS) METHODS	S PROVIDER	MAINTENANCE NOTES / COMMENTS	LAST INSP. COMMENTS	(in/yr)	(Years)	(HEAD, SHELL, NOZZLE CML)	CORROSION RATE (in/yr)	(YEARS)	LOCATION F (CML)	EEG 2 (VEG/NIC) I	EQUIRED ACTIONS FOR INTERVAL EXTENSION	(HIGH, MEDIUM, LOW)	(YES/NO)	REVIEWED BY (Name & Cert #)	COMMENTS	NCR-OPERATIONAL OPI	PSV DUE FOR SERVICING (YES/NO)	INTERVAL (Months)	REVISED I REGULATOR
RAN	AND FORKS EAST 15-15 (150	04-01-013-13W4 BATTERY	A0161444 LM-1671	C-8805.2 LAYDOWN AREA	FREE WATER KNOCK OUT #2	FREE WATER KNOCKOUT	Y	1980	CE NATCO LTD.	IN SERVICE	75	SOUR 5/9/2019	3/5/2020 3	6 ASSESSMEN	NT VITUS TECH		VE/UT 02/19/2019: NO SAFE ACCESS TO OBTAIN PSV DATA/PICTURES. TML 60 & 65 LOW RDG IS > 10% BELOW NOM-CA BUT > Tmin VI 05/09/2019: VESSEL IS FIT FOR SERVICE. Previous coating repairs intact, no concerns. 4 anodes, middle 2 anodes are approx. 40% consumed. CS internal piping is in good condition. Deflector plates on west side in good condition, no concerns. East and west heads in good condition. 2 shell sections coated, no concerns. Welds in good condition. Nameplate painted over and barely legible.	0.0014	61.1	SHELL 20	0.0069	21.9	60	YES	None	LOW		K. Matsalla ABSA IPV-PV# 1001, TSASK Class 2# 81691; Sept. 29, 2021	Overall vessel in good condition. All vessel TMLs greater than nominal. Piping TMLs 60 & 65 3" So 80 elbows were flagged for low readings. TML 6 ow reading is 0.03" less than avg reading, may be indicative of pitting. Treq calc'd using structura Tmin, RL is 21.9 yrs, no concerns. Extend regulatory inspection interval to 60 months. Mee all considerations of TC-OVR-PRO-INT-000036 Sections 3 & 7.1 High Risk Equipment remainin life guidelines. Middle two anodes were 40% consumed but no mention if they were replaced 2019, confirm status.	Sch 60 be al ets 66 ng	No	60	2024
925 iRAN	AND FORKS EAST 15-15 (150	04-01-013-13W4 BATTERY	A0227925 L-6-348	D-781.2134	CRUDE OIL TEST TREATER	TREATER	Y	1987	CE NATCO	IN SERVICE	50	SOUR 5/9/2019	5/8/2019 3	6 ASSESSMEN	NT VITUS TECH		VE/UT 02/18/2019: NO SAFE ACCESS TO OBTAIN PSV DATA/PICTURES. TML 40 LOW RDG IS > 10% BELOW NOM-CA BUT > Tmin VI/FT MT 05/09/2019: VESSEL IS FIT FOR SERVICE. Previous coating repairs intact, no concerns. CS internal piping, good condition. 3 trays minor corrosion observed. Several coating patches on bottom head from previous repairs, no concerns. Top head coated, no concerns. Welds good condition, no concerns. MPI all welds on test separator firetube - there were no visible relevant rejectable linear indications found on the areas tested.	0.0038	46.9	HEAD 005 (CR) SHELL 010 (RL)	0.0121	8.6	25	YES	UT in 2023	LOW		K. Matsalla ABSA IPV-PV# 1001, TSASK Class 2# 81691; Sept. 29, 2021	Overall vessel in good condition. Shell TMLs greater than nominal. Head TML RL 73.9 yrs. Piping TML 40 3" Sch STD elbow was flagged for reading. RL using structural Tmin is 13 yrs, reconcern. TML 25 3" Sch STD elbow RL is 8.6 yr using structural Tmin. VE/UT in 2023 to verify STCR. Extend regulatory inspection interval to 6 nonths. Meets all considerations of TC-OVR-PRINT-000036 Sections 3 & 7.1 High Risk Equipment remaining life guidelines.	Ty 60 RO-	No	60	2024
978 RAN	AND FORKS EAST 15-15 (150	04-01-013-13W4 BATTERY	A0227978 LM-2262	B1175.2	GAS BOOT	SURGE DRUM	Y	1987	CE NATCO	IN SERVICE	50	SOUR 5/9/2019	5/8/2019 3	6 ASSESSMEN	NT VITUS TECH		VE/UT 02/18/2019: NO ACCESS TO PSV AT TIME OF INSPECTION, MANLIFT REQUIRED. TML 125 LOW RDG IS < NOM-CA BY MORE THAN 20% VI 05/09/2019: VESSEL IS FIT FOR SERVICE. Coating in good condition. CS internal piping, no concerns. 1 tray in good condition. Bottom head coated and in good condition. No access to top head. 2 shell sections, no concerns. Welds in good condition, no concerns. No nameplate access (up against wall).	0.0014	92.3	SHELL 010	0.0035	18.6	125	YES	None	LOW		K. Matsalla ABSA IPV-PV# 1001, TSASK Class 2# 81691; Sept. 29, 2021	Overall vessel in good condition. All vessel TMLs reater than Nom-CA. Piping TML 125 3" Sch STelbow was flagged for low reading. RL using structural Tmin is 18.6 yrs, no concern. Extend regulatory inspection interval to 60 months. Mee all considerations of TC-OVR-PRO-INT-000036 Sections 3 & 7.1 High Risk Equipment remainin life guidelines.	od ots 0	No	60	2024
2007 RAN	AND FORKS EAST 15-15 (150	04-01-013-13W4 BATTERY	A0242007 L-6-370	F-7404.2	CRUDE OIL GROUP TREATER	TREATER	Y	1987	CE NATCO	IN SERVICE	75	SOUR 5/9/2019	5/8/2019 3	6 ASSESSMEN	NT VITUS TECH		VE/UT 02/18/2019: TML 090 LOW RDG IS > 10% BELOW NOM-CA BUT > Tmin VI/FT MT 05/09/2019: VESSEL IS FIT FOR SERVICE. Few minor blisters in shell coating. Cleaned and patched blistered areas. Two anodes approx. 5% consumed. CS internal piping is in good condition. Deflector plate is secure and in good condition. East and west head coated and in good condition. 2 shell sections, minor blistering on shell section coating, blisters have been repaired. Welds good condition, no concerns. MPI all welds on group separator firetube May 8, 2019. There were no visible relevant rejectable linear indications found on areas tested.	0.0076	36.7	FT HEAD 040	0.0069	12.5	90	YES	None	LOW	Yes	K. Matsalla ABSA IPV-PV# 1001, TSASK Class 2# 81691; Sept. 29, 2021	Overall vessel in good condition. Coating blisters the north side shell appears to be the same are noted in the 2016 inspection, assumed this area was not repaired in 2016. Insignificant shell was between 2016 & 2019. All vessel TMLs great than Nom-CA. Piping TML 090 3" Sch STD elbo was flagged for low reading. RL using structura Tmin is 12.5 yrs, no concern. Extend regulatory inspection interval to 60 months. Meets all considerations of TC-OVR-PRO-INT-000036 Sections 3 & 7.1 High Risk Equipment remainin life guidelines.	ea ea ea all ater ow eal ory	N/A	60	2024
88332 iRAN	AND FORKS EAST 15-15 (150	04-01-013-13W4 BATTERY			FLARE KO - HIGH PRESSURE	FLARE KNOCKOUT DRUM	Y	2007	TORNADO TECHNOLOGIES INC.		15	SOUR 5/9/2019	3	6 ASSESSMEN	NT VITUS TECH		VE/UT 02/19/2019: Vessel vents directly to flare stack. TML 60 & 70 (head bridle) LOW RDG < NOM-CA BY MORE THAN 20%. TML 55 & 75 (90L 2" XS) LOW RD IS > 10% BELOW NOM-CA BUT > Tmin VI 05/09/2019: VESSEL IS FIT FOR SERVICE. Coating good condition, no visible corrosion. 2 deflector plates, coated and in good condition. North and south heads, shell sections, and welds in good condition, no concerns.	0.0079	13.5	60 BRIDLE HEAD	0.0121	8.0	55	YES	UT in 2023	MEDIUM		K. Matsalla ABSA IPV-PV# 1001, TSASK Class 2# 81691; Sept. 29, 2021	Shell and heads in good condition. TMLs 60 & 7 flagged for low readings, both are bridle heads (weld caps). Vitus commented "corrosion noted but the low readings are likely due to thinning during forging in the knuckle region. Used pipin structural Tmin to calc RL of 13.5 yrs, no concerns. Piping TMLs 55 & 75 flagged for low readings, both bridle elbows. Vitus commented corrosion noted throughout elbow". TML 55 RL 8.0 yrs using structural Tmin. VE/UT in 2023 to verify STCR. Extend regulatory inspection intervolo 60 months. Meets all considerations of TC-OV PRO-INT-000036 Sections 3 & 7.1 High Risk Equipment remaining life guidelines.	ds d" g ng w 0 d is to	N/A	60	2024
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TC-OVR-FM-INT-000090 Prepared By:	3111112001414																																								
LOCATION		PROT	TECTED EQUIPMENT						PSV STATIC DATA	1										PSV SERVICE DA	ATA REVIEW							CLE	EAN SERVICE REQUIREMEN	ITS						PSV INTEGRITY ASSESSM	MENT RESULTS				SIGN-OFF
PRD FACILITY LSD	JUR#	EQUIP TYPE EQUIP DESCRIPTION	PROTECTING DN EQUIP NAME	STATUS SHI MA	LL VP TUBE MAWP	SERIAL#	TAG # MODEL	EL# MANUFACTU	JRER SET PRESS (PSI)	CAPACITY CAPAC	CITY UNITS SWEET/S	OUR TEST MEDIUM	SERVICE COMPANY	LAST SERVICE CURRI DATE SERVICE (YEAR) (YEA	RRENT Previo CE DATE (Replac EAR) PSVs	ous PSV INLET OF CONDITION CON (Good, Fouled, Plugged) Plugged)	UTLET NDITION d, rouled, ugged) CONDITION R (New, Routine) Major, BE	FAILED TO LIF (YES/NO)	PSV PRE-POP (YES/NO)	PRE-POP PSV RESSURE DEVI (PSI) (6	PRE-POP PRE-POP HI ATION (%) OR LOWER MAX) SET PRESS	GHER THAN URE Continue	ORIFICE DIAMETER REATER THAN 0.7" CLEANL EAKAGE RATE SUBBLES/MIN)	INESS CLEANLINESS RATI	'ING MECHANICA	TAL MECHANICAL RATING COMI	SERVICE IMENTS/ACTION ITEMS (YE	0% OF SOLIDS RCENT THE P = 85% OF CO (N	OF LIQUIDS OR DOES TO	THE FLUIDS INTRATION ED 0.3KPA IN CLEA IN CAP ES/NO)	PASSED PRE-P (PASS/FAIL) PREVIOUS SERVICE	POP PASS PRE-POP (PASS/FAIL) CURRENT SERVICE (PASSED LEAKAGE RATE (PASS/FAIL) APPROVE FOR SER INTERV EXTENS (YES/N	CONDITION CONDIT	# OF SERVICE # Failed REPORTS Pre-Pops	CURRENT PV INSPECTION INTERVAL (Months) MAX INTERVA PER AB-506 (MONTHS)	AL CURRENT PSV SERVICE INTERVAL (MONTHS)	ASSESSED SERVICE INTERVAL (Months) ASSIGNED SERVICE INTERVAL (Months)	REVISED NEXT SERVICE DATE (Year)	NEXT REGULATORY CNR INSPECTION DATE (Year) (Na	Name/Cert#)
52256 GRAND FORKS EAST 15-15 (1 04-01-013-13W4 BATTI	TERY A0161444	FREE WATER KNO FREE WATER K	KNO	N SERVICE 7	;		61444 W9503-125	WELLMARK	75	3528 SCFM	SOUF	R UNKNOWN	TARPON ENERGY SERVICES LTD.	2016 2019	019	GOOD G	GOOD MINOR	NO NO	YES	75	0%		All ins compos absolutes		Good condition slight lapping polishing need	*					NO PASS		PASS YES		2 0	36 72	36	72 60	2024	2022 K. M IPV TSA 816	PSV was in excellent condition at 2 previous services. Meets all conditions of TC-OVR-PRO INT-000036 10.4.1. Increase interval to 60 months to align with next planned turnaround in 2024.
26247-20 GRAND FORKS EAST 15-15 (1 04-01-013-13W4 BATTI	TERY A0227925	TREATER CRUDE OIL TES	EST T II	N SERVICE 5			RV-0254 82G2651311	1 TAYLOR VALVE	E 50	473 SCFM	SOUF	R UNKNOWN	TARPON ENERGY SERVICES LTD.	2016 2019	019	GOOD G	GOOD MINOR	₹ NO	YES	52	4% Higher		Slight oil of a stick light ca	y coat, 2	Good condition slight lapping polishing need	g or 1 Body b	throughout seats. bonnet baked on y throughout.				NO PASS		PASS YES			36 72	36	72 60	2024	K. M IP\ 2022 TSA 816	2019: disc and nozzle seats dirty. Body bonnet had baked on oil throughout. 2016: excellent condition. 2012: Leaked after pre-pop but, relieved at set pressure. Spring, seats, disc holder/stem retainer, and body bonnet were oily and scaly. No mechanical issues at last 3 services. Meets all conditions of TC-OVR-PRO-INT-000036 10.4.1. Increase interval to 60 months to align with next planned turnaround in 2024.
88204 GRAND FORKS EAST 15-15 (1 04-01-013-13W4 BATTI	TERY A0227978	SURGE DRUM GAS BOOT	11	N SERVICE 5		8204 PI	RV-0253 9142H51187	76N MERCER VALVE	/E 50	905 SCFM	SOUF	R UNKNOWN	TARPON ENERGY SERVICES LTD.	2016 2019	019	GOOD G	GOOD ROUTIN	IE NO	YES	50	0%		Slight oil of a stick light ca	y coat, 2	Good condition slight lapping polishing need	g or 1 Body b	throughout seats. bonnet baked on y throughout.				NO PASS	Pass	PASS YES	3	3 0	36 72	36	72 60	2024	X. M IP\ 2022 TSA 816	Disc and nozzle seats dirty, dody bonnet habaked on oil throughout at current servicing PSV in excellent condition at 2016 and 2012 services. No mechanical issues at last 3 services. Meets all conditions of TC-OVR-PRODUCTION (INT-000036 10.4.1. Increase interval to 60 months to align with next planned turnaround in 2024.
931070 GRAND FORKS EAST 15-15 (1 04-01-013-13W4 BATTI	TERY A0242007	TREATER CRUDE OIL GRO	ROUF	N SERVICE 7	;	31070 PI	RV-0252 1905HC	CONSOLIDATED	ED 75	1385 SCFM	SOUF	R UNKNOWN	TARPON ENERGY SERVICES LTD.	2016 201	019 87C2	C2428 GOOD G	GOOD ROUTIN	IE NO	YES				All inscomposed absolutes	nents 1	Good condition slight lapping polishing need	g or 1					NO	Pass	PASS YES			36 36	36	72 36	2022	1P\ 2022 TSA	Matsalla ABSA PV-PV# 1001, SASK Class 2# 1691; Sept. 29, 2021 PSV 931070 replaced 87C2428 in 2019. PSV i assigned max service interval as per AB-506 Grade 1. Service PSV in 2022.
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