

7161444

FORM U-1A MANUFACTURERS' DATA REPORT FOR PRESSURE VESSELS (Alternate Form Single Chamber, Completely Shop-Fabricated Vessels Only) As Required by the Provisions of the ASME Code Rules, Section VIII, Division 1 (A) 161444

1. Manufactured by C.E. NATCO LIMITED, 1100A - 58 AVE. S.E. CALGARY, ALTA.  
2. Manufactured for OAKWOOD PETROLEUMS LTD. 2700 - 400 - 4 AVE. S.W. CALGARY, ALTA.  
3. Location of Installation 7-23-12-14-W4 M  
4. Type HORIZONTAL LM-1671 C-8805.2 LA-9174 (Year Built) 1980  
5. The chemical and physical properties of all parts meet the requirements of material specifications of the ASME BOILER AND PRESSURE VESSEL CODE. The design, construction, and workmanship conform to ASME Rules, Section VIII, Division 1 1977 and Addenda to WINTER 79 and Code Case Nos. (Year) (Date)  
Special Service per UG-120(d)  
Manufacturers' Partial Data Reports properly identified and signed by Commissioned Inspectors have been furnished for the following items of the report:

6. Shell: Matl. SA-285 C Nom. Thk. 7.93 xx Corr. Allow. NIL xx Diam. 2438 xx Lgth. 6096 xx  
7. Seams: Long. DBL. BUTT R.T. SPOT Efficiency 85 % H.T. Temp. F Time hr  
Girth DBL. BUTT R.T. SPOT & PARTIAL No. of Courses 2  
8. Heads: (a) Material SA-285C (Spec. No., Grade) (b) Material SA-285C (Spec. No., Grade)

Location (Top, Bottom, Ends)	Min. Thk.	Corr. Allow.	Crown Radius	Knuckle Radius	Ellipse Ratio	Conical Apex Angle	Hemisp. Radius	Flat Diam.	Side to Pressure (Convex or Concave)
(a) F.T. END	15.9	NIL	2286	149	F&D	-	-	-	CONCAVE
(b) COAL. END	12.7	NIL	2286	149	F&D	-	-	-	CONCAVE

If removable, bolts used (describe other fastenings) (Material, Spec. No., Size, No.)

9. Constructed for max. allowable working pressure 517 kPa xx at max. temp. 93 C xx Min. temp. (when less than -20 F) F. Hydrostatic, pneumatic, or combination test pressure 777 kPa xx  
10. Safety Valve Outlets: Number 1 Size 3" Location SHELL

11. Nozzles and Inspection Openings:

Purpose (Inlet, Outlet, Drain)	No.	Diam. or Size	Type	Matl.	Nom. Thk.	Reinforcement Matl.	How Attached	Location
SEE NOZZLE SCHEDULE								

12. Supports: Skirt NO Lugs - Legs - Other SADDLES Attached SHELL-WELD (Where and how)  
13. Remarks:

2438 O.D. x 6096 LG - 517 kPa  
FREE WATER KNOCKOUT VOLUME 31 M<sup>3</sup>

CERTIFICATE OF 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.  
Date March 27/80 Signed C.E. NATCO LIMITED by [Signature] (Manufacturer) (Representative)  
"U" Certificate of Authorization No. 11313 expires SEPT. 8th, 1980

CERTIFICATE OF SHOP INSPECTION  
Vessel made by C.E. NATCO LIMITED at CALGARY,  
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 GOVERNMENT have inspected the pressure vessel described in this Manufacturers' Data Report on APRIL 9 19 80, 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 Manufacturers' 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.  
Signed [Signature] (Inspector) Date 8/04/09 Commissions (Nat'l Board, State, Province and No.)

NOZZLE SCHEDULE

MARK	SERVICE	SIZE	RATING	TYPE	BUNE	BECK			HELPAD		PROJ	WELD			REMARKS
						SECT	WALL	LG	MAT'L	D.S.		WELD DETAIL	WELD SIZE		
AI-A3	ANODES	4"	150°	RFWN.	XH	80	337	1-3/4"	SA 53-B	N/R		1/2"	IV	3/8"	ITEMS 50459
NI	FLUID INLET	6"	170°	RFWN.	XH	80	432	2 1/2"	SA 53-B		6"	1/2"	IV	3/8"	ITEMS 5387400
N2	OIL OUTLET	4"	150°	RFWN.	XH	80	337	1 1/2"	SA 53-B		6"	1/2"	IV	3/8"	ITEMS 5387400
N3	F.W. OUTLET	6"	150°	RFWN.	XH	80	432	2 1/2"	SA 53-B		6"	1/2"	IV	3/8"	ITEMS 5387400
N4	DRAIN	3"	150°	RFWN.	XH	80	390	1 1/2"	SA 53-B		6"	1/2"	IV	3/8"	ITEMS 5387400
N5	GAS OUTLET	3"	150°	RFWN.	XH	80	390	1 1/2"	SA 53-B		6"	1/2"	IV	3/8"	ITEMS 5387400
N6	OIL L.C.	4"	150°	RFWN.	XH	80	337	1 1/2"	SA 53-B		6"	1/2"	IV	3/8"	ITEMS 5387400
N7-N8	EQ. CONN'S	3"	150°	RFWN.	XH	80	300	1 1/2"	SA 53-B		6"	1/2"	IV	3/8"	ITEMS 5387400
N9	L.I. L. CONN	4"	150°	RFWN.	XH	80	337	1 1/2"	SA 53-B		6"	1/2"	IV	3/8"	ITEMS 5387400
N10	L.I. S.O. CONN	4"	170°	RFWN.	XH	80	337	1 1/2"	SA 53-B		6"	1/2"	IV	3/8"	ITEMS 5387400
CI-C3	SAMPLE CONN'S	3/2"	6000°	CPLG.				1 1/8"	SA 105			1/4"	V	3/8"	ITEM 70
CI-C7	LEVEL GA. CONN	3/2"	6000°	CPLG.				1 1/8"	SA 105			1/4"	V	3/8"	ITEM 70
CB	PRESS GA. CONN	1/2"	6000°	CPLG.				1 1/8"	SA 105			1/4"	V	3/8"	ITEM 70
C9	TEMP. GA. CONN	1/2"	6000°	CPLG.				1 1/8"	SA 105			1/4"	V	3/8"	ITEM 70
CI-C11	TEMP. GA. CONN	1/2"	6000°	CPLG.				2 3/8"	SA 105			1/4"	V	3/8"	ITEM 63
CI-C13	PG. PREHEAT	1"	6000°	CPLG.				2 3/8"	SA 105			1/4"	V	3/8"	ITEM 69
CI-C14	LV. CONN.	3"	3000°	CPLG.				4 1/2"	SA 105			1/4"	V	3/8"	ITEM 71
CI-C16	VENTS	3/2"	3000°	CPLG.				1 1/8"	SA 105			1/4"	V	3/8"	ITEM 70
N11	METER CONN.	3"	150°	RFWN.	XH							1/2"	IV	3/8"	ITEM 63
II	ACCESS TERMINAL	1/2"	50°	PREHEAT STL			625	4 1/2"	SA 285C			1/2"	II	3/8"	PER DRAWING 48
II	DOME TERMINAL	1/2"	90°	PREHEAT STL			625	4 1/2"	SA 285C	N/R		1/2"	II	3/8"	PER DRAWING 48

17'-9"  
SIDE WALL

A16 1444

A161444

CELLARCOUS

REQ'D. W.O.

VESSEL Free Water Knockout

SIZE 2438 X 6096 MM



DIV. 1  
RT. 2.3  
CRN.

C-8805.2

C.E. NATCO LTD.  
CALGARY, ALBERTA, CANADA

SERIAL NO. LM-1671

MATERIAL SA-285-C T.S. 55000

MAX. PRESS. 517 KPA AT 93 °C.

SHELL TK. 7.93 MM HEAD TK. 12.7 MM  
15.9 MM

C.A. N11 T.P. 777 KPA.

19.: ASME CODE U.W. 12

DATE 3-1980

SHOP ORDER NO. 2700-VKD

