



Ultrasonic Inspection Report

Job #:
Report #:
Inspection Date:

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--UT-BV-1

October 10, 2012

Client:	CNRL	Location:	Ralston Battery
Procedure:	UT-0001	Item Inspected:	Vessel Group Treater A2710237
Code:	ASME Section VIII Div 1		

Surface Condition:	Painted <input checked="" type="checkbox"/>	Sandblasted <input type="checkbox"/>	Machined <input type="checkbox"/>	As Cast <input type="checkbox"/>	As Forged <input type="checkbox"/>
	Weldment <input type="checkbox"/>	Other <input type="checkbox"/>	Material: C.S.		

Scanning Surface:	OD <input checked="" type="checkbox"/>	ID <input type="checkbox"/>	Other: <input type="checkbox"/>	Surface Temp (°C):	> 5° / < 60°
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Method:	Contact <input checked="" type="checkbox"/>	Immersion <input type="checkbox"/>	Other <input type="checkbox"/>		
Type:	P/E <input type="checkbox"/>	T/T <input type="checkbox"/>	Dual <input checked="" type="checkbox"/>	Automated <input type="checkbox"/>	TOFD <input type="checkbox"/>
Application:	Laminar <input checked="" type="checkbox"/>	Shear Wave <input type="checkbox"/>	Volumetric <input type="checkbox"/>	Thickness <input checked="" type="checkbox"/>	

Instrumentation:	Mfg: G.E.	Type: Krautkramer	Equip #: DMS2	Serial #: 020XP6
Calibration:	Date: 01/12/2012		Reference Flaw Size: Backwall	
Calibration Block (s):	Type:	Block#:	Type:	Block#:
	Type: .5" Stepwedge	Block#: 10-2192	Type:	Block#:

Couplant:	Brand: Sono Tech	Type: Echogel	Cable:	Type: Coaxial	Length: 36"
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PROBE						Settings - dB			Range - <input type="checkbox"/> IN. <input type="checkbox"/> MM		
Manufacturer	Type	Serial #	Angle	Frequency	Size	Ref Level	Scan Level	Transfer Value	Screen Size	Skip Value	Beam Travel
G.E.	Dual	0200LL	0	7.5Mhz	0	6db					

Scope and Inspection Results

Carry out UT examination of Group Treater at LSD: 05-14-018-10W4M.
 Check for corrosion of the heads, shell and elbows to verify integrity for service and identify any areas of concern.

Results:

UT examination was carried out; all readings taken were 10" band scans with three readings per TML location/band. Minimum, Maximum and Average readings were taken and recorded in each location. All readings were found to be at or above nominal on the heads, shell and elbows. See attached Pictures, drawing and UTM Readings for locations and thicknesses recorded.

Recommendation:

Continue to carry out UT corrosion survey and Visual inspections at the required inspection frequency.

Final Comment:

Group Treater is fit for continued service.

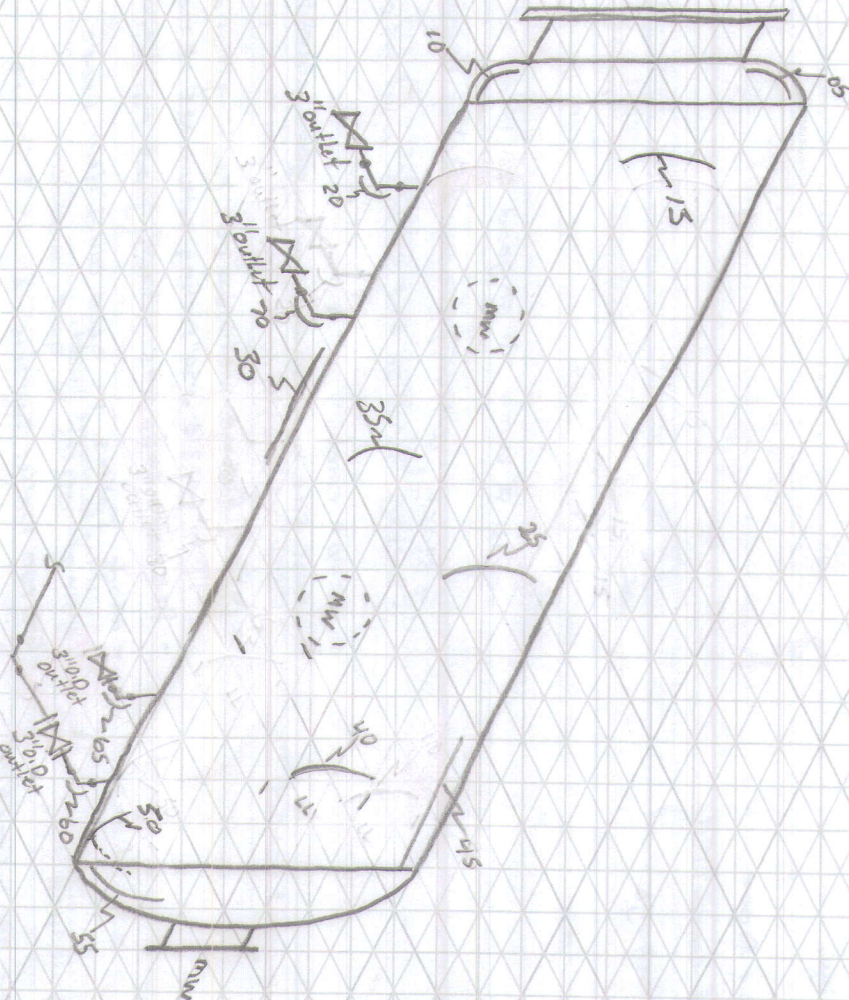
Inspection Limitation(s): None

Time and Billing Information:

Vehicle #:	001	Kms:		Hrs		Tech. (Name):	Blair Verge	SNT-TC-1A:	1
Time In:	00:00	Time Out:	00:00			Tech. (Sign):		CGSB Level:	I
Time In:	00:00	Time Out:	00:00			Client (Name):		CGSB #:	5586
Personnel:	Ayralee Martin Blair Verge				Client (Sign):				

Additional Billing Information: : -

- 05 NETH TB2"
- 10 NEBH TB8"
- 15 VETS TB8"
- 20 VO3DE TB6"
- 25 VMTS TB6"
- 30 HMBS EWER
- 35 NILLS TB5B
- 40 VULLS TB2"
- 45 HWTS EWER
- 50 VWBS NS 5B
- 55 VWBH TB8B
- 60 VO3DE TB8B
- 65 VO3DE TB6"
- 70 VO3DE TB7"



CUSTOMER: CNRL **FACILITY:** Ralston Battery **LSID:** 05-14-018-10W4M
P & ID: _____ **DRAWN BY:** R. Verge **DATE:** Oct 10/12 **DRAWING NO.** _____

VESSEL INFORMATION:
 Equip. No. _____ Pro. Reg. No. (A) 2710237 C.R.N. H-0995.2 Serial No. L-8-325 Yr. Inst. _____
 Code/Div. _____ Size: R1 ID/OD X: _____ Manufacturer: Natco Canada Yr. Blt. 1991
 C. Stamp: yes Service: 80UR PWHT: _____ J.E.: _____ Radiography: RT-4 Insulated: _____

HEAD: Top Mat'l. SA-516-70 Top Nom. .598" / .667" Top C.A. _____ Material: SA-516-70 Nominal: Ø 2.975" C.A. .0625"
 Btm Mat'l. _____ Btm Norm. _____ Btm C.A. _____

BOOT: Head Mat'l. _____ Head Nom. _____ Head C.A. _____ Top Mat'l. _____ Top Nom. _____ Top C.A. _____
 Shell Mat'l. _____ Shell Nom. _____ Shell C.A. _____ Btm Mat'l. _____ Btm Nom. _____ Btm C.A. _____
 MAWP Shell Side: 75PSI @ Temp. 200°F MAWP Tube Side: _____ @ Temp. _____

PIPING INFORMATION: - 5F @ 75 psi
 Circuit No. _____ Line No. (s) **(PLEASE PUT LINE NUMBERS ON APPLICABLE LINES ON THE DRAWING)**
 Piping Class: _____ Service: _____ Yr. Blt. _____
 MAWP: _____ @ Temp. _____ Size & Schedule of Piping **(PLEASE PUT APPROPRIATE SIZES AND SCHEDULES OF PIPING ON DRAWING)**

UT Readings for A2710237 Group Treater

	<u>Minimum</u>	<u>Maximum</u>	<u>Average</u>
LOC 5	0.641	0.669	0.649
LOC 10	0.612	0.666	0.646
LOC 15	0.396	0.402	0.398
LOC 20	0.319	0.329	0.326
LOC 25	0.396	0.397	0.396
LOC 30	0.39	0.396	0.393
LOC 35	0.391	0.393	0.391
LOC 40	0.407	0.41	0.41
LOC 45	0.394	0.401	0.401
LOC 50	0.385	0.386	0.386
LOC 55	0.546	0.582	0.577
LOC 60	0.281	0.291	0.286
LOC 65	0.313	0.323	0.315
LOC 70	0.288	0.293	0.292