

APPLUS-RTD
 EDMONTON, ALBERTA,
 CANADA T6P 1N5
 TEL: (780) 440-6600 FAX: (780) 440-2538

GENERAL NDE REPORT

A-3129683_06_21
 2013_MT-Report-a

Date June 20, 2013 Page 1 of 4
 RTD Job #: 10-113249
 RTD Dep. #: G/P

Client: C.N.R.L
 Address: ClearHills Gas Plant (AB)
 W.O.#: _____
 Client Rep.: Craig Liba

LSD: L.S.D. 16-11-88-13 W6M
 Location: ClearHills Gas Plant
 Procedure: RTD-MT- 003
 Code: Asme VIII Div 1

Description: MPI Inspection on all internal tee intersections, nozzles, boot to shell weld, inlet diffuser and manway weld to shell in the (Stabilizer Feed Drum) (A-3129683).

Surface Condition: Weldment Machined Painted
 Ground Sandblasted Other Surface Temp (C°): < 5 > 5 x < 60 > 60

MAGNETIC PARTICLE INSPECTION

Equipment Type: Yoke Bench Asset No.: 2227 Calibration Due Date: 07-21-13
 Blacklight: Intensity Check: 2080 $\mu\text{W}/\text{cm}^2$ Asset No.: 12754 Calibration Due Date: 08-21-13
 Method: A/C D/C Type: Continuous Residual Power Supply: 120 V Battery Natural
 Type: Dry Powder: Colour; _____ Wet: Black and White Fluorescent
 Product Manufacturer: Magna Flux Product Identification Code: 14 AM

LIQUID PENETRANT INSPECTION

Type: I-Fluorescent II-Visible Dye Method: A (Water Wash) B (P.E. Lipophilic) C (Solvent Removable) D (P.E. Hydrophilic)
 Blacklight: Asset No.; _____ Calibration Due Date; _____ Blacklight Intensity; _____ $\mu\text{W}/\text{cm}^2$
 Dwell Times: Penetrant; _____ Minutes Developer; _____ Minutes Product Manufacturer: _____

ULTRASONIC THICKNESS MEASUREMENT

Method: P/E Dual T/T Other Type: Longitudinal Shear Wave
 Instrumentation: Manufacturer; _____ RTD Asset No.; _____ Calibration Date; _____
 Cal. Block(s): Type; _____ RTD Asset No.; _____ Serial No.; _____
 Couplant: Manufacturer; _____ Type; _____

Probe Type	Angle	Frequency	Size	Reference Level (dB)	Scanning Level (dB)	Range	Skip Value	Beam Travel	Transfer Value (dB)

INSPECTION DETAILS

Scope: **Carry out Magnetic Particle Inspection on all internal tee intersections, nozzles, boot to shell weld, inlet diffuser to shell and manway weld to shell in the (Stabilizer Feed Drum- A-3129683).**

Results: **(1) No cracks found at time of inspection**
(2) 50% inspection on top inlet nozzle due to access.

See Attached photos for areas inspected and location.

Technician: Jerry Hrynkiw CGSB /ASNT/SNT Level: II Start Time: _____ Stop Time: _____ ST _____ OT _____
 Signature: _____ Method: MT #5709 Unit: _____ Km: _____ Travel Time: _____
 Assistant: _____ CGSB /ASNT/SNT Level: _____ Subsistence required OT Meal
 Client Signature: _____ Consumables: _____

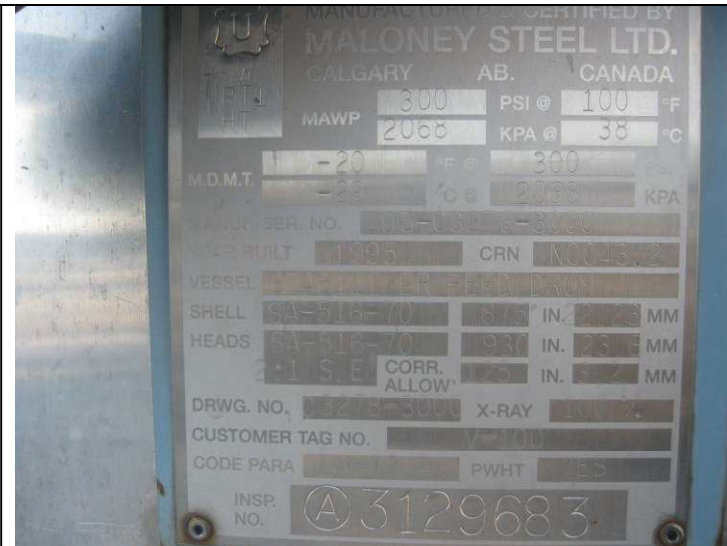
*Results are an interpretation of the inspection method, not a guarantee. Client signature indicates acceptance of report, results and applicable charges.

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A-3129683_21-06-2013 MT-Report-a

Date June 21, 2013 Page 2 of 4
 RTD Job #: 10-113249
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Vessel Dataplate Overview (A3129683)

Nozzle East End



East Head Nozzle

East End bottom nozzles

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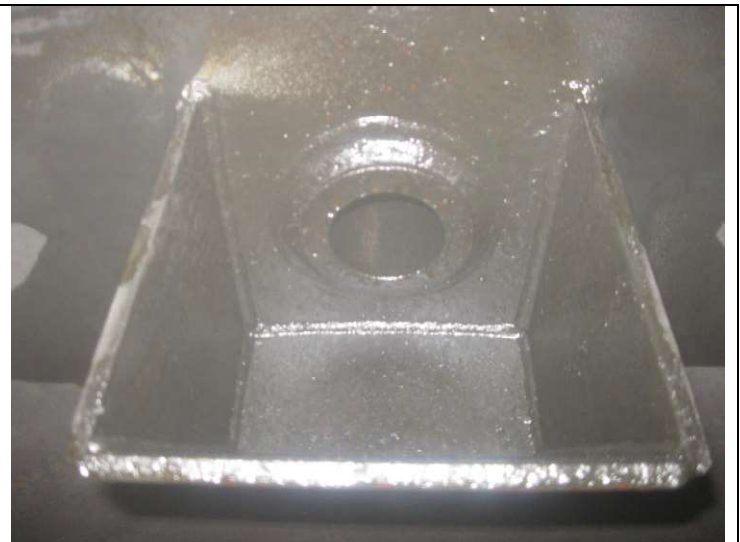
A-3129683_21-06-
2013 MT-Report-a

Date June 21, 2013 Page 3 of 4
RTD Job #: 10-113249
RTD Dep. #: G/P



Bottom Boot to shell weld

Tee intersections



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Inlet Diffuser box to shell

Inlet nozzle (Limited access)

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**A-3129683_21-06-
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Date June 21 , 2013 Page 4 of 4
RTD Job #: 10-113249
RTD Dep. #: G /P



Outlet nozzle

Manway weld to shell