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Q218190
Jan 10/85
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FORM U-1A MANUFACTURER'S DATA REPORT FOR PRESSURE VESSELS
(Alternative Form for Single Chamber, Completely Shop-Fabricated Vessels Only)
As Required by the Provisions of the ASME Code Rules, Section VIII, Division 1

JOB # 21-426

1. Manufactured and certified by Western Rock Bit Co. Ltd. 510-77th Ave. S.E. Calgary, Alta. T2H1X3

2. Manufactured for STOCK

3. Location of installation _____

4. Type Horiz. 26904A C4936.2314 1984

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, 1983

Summer, Sept. 30, 1984

6. Shell: SA516-70 19.76 NIL 2743

7. Seams: Welded, Dbl. Butt Full 100 Welded, Dbl. Butt Partial

8. Heads: (a) SA516-70 (b) None

Location (Top, Bottom, Ends)	Minimum Thickness	Corrosion Allowance	Crown Radius	Embossed Radius	Elastic Ratio	Conical Apex Angle	Approximate Radius	Flare Diameter	Self-Stress (Comps or Curves)
(a) Ends	19.62	Nil			2:1SE				CONCAVE
(b) _____									

If removable, bolts used (describe other fastenings) _____

9. MAWP 1724 876 at max. temp. 46 °C
Min. temp. (when less than _____) °C. Hydro, pres., or comb. test pressure 2586 kPa

10. Nozzles, inspection and safety valve openings:

Purpose (Inlet, Outlet, Drain)	No.	diam. or Size	Type	Material	Reinforcement	Notes	Location
Liquid Out	1	88.9	F.CPIG	SA105	CL6000	Welded	shell
Liquid In	1	60.3	HF.CPIG	SA105	CL3000	Welded	shell
Vapour	1	60.3	F.CPIG	SA105	CL3000	Welded	shell
Continued on U4 FORM							

11. Supports: Skirt NO Legs NO Other Attached

12. Remarks: Manufacturer's Partial Data Reports properly identified and signed by Commissioned Inspector have been furnished for the following items of the report: _____

68 600 litre Storage LPG/NH3 Surface Area 113.8 sq. meter 68.6m3
Stress Relieved Heads 621 deg. C
Registration DWG. # 8311-04D

CERTIFICATE OF SHOP 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. My Certificate of Authority is No. 551 expires July 19 1986
Date 25.01.10 Co. name Western Rock Bit Co. Ltd. Signed [Signature]

Vessel constructed by Western Rock Bit at 1026 Western Drive, Crossfield, Alberta
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 _____
has inspected the component described in this Manufacturer's Data Report on Sept 10, 1984, and am so 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 this Manufacturer's Data Report. Furthermore, neither the Inspector nor his employer shall be liable in any manner for any personal injury or property damage or loss of any kind arising from or connected with this inspection.
Date Sept 10/85 Signed [Signature] Commission _____

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FORM U-4 MANUFACTURER'S DATA REPORT SUPPLEMENTARY SHEET
As Required by the Provisions of the ASME Code Rules, Section VIII, Division 1

JOB # 21-426

1. Manufactured and certified by Western Rock Bit Co. Ltd. 510-77th Ave. S.E. Calgary, Alta. T2H1X3

2. Manufactured for STOCK

3. Location of installation _____
4. TYPE Horiz. (Type, size, and use) _____
26904A (Code) C4936.2314 (Part No.) 1984 (Year built)

Data Report Item Number _____ Remarks _____

10. Nozzles, Inspection and Safety Valve Openings.

PURPOSE	NO.	DTA. OR SIZE	TYPE	NAT'L	NOM.	REIN.	HOV	LOCATION
				THK.			ATTACHED	
Purge	1	60.3	HF cp1g	SA105	CL3000		welded	shell
Relief	2	60.3	HF cp1g	SA105	CL3000		welded	shell
Float Gauge	1	73.0	F cp1g	SA105	CL6000		welded	head
Outage	1	26.7	F cp1g	SA105	CL6000		welded	head
Manway	1	406.4	Dwg.#	8305.10B	SAS16-70	CL250	welded	head
Thermowell	1	21.3	NPT Dwg.#	722-19A			welded	Head
Roto Gauge	1	33.4	NPT Drill and Tapped	on Cntr. of blind flang				manway cover

Date 85.01.10 Co. name Western Rock Bit Co. Ltd signed [Signature]
Date Jan 10/85 signed [Signature] Commission _____