



Canadian Natural

Addition/Repair of Non-Pressure Containing Parts Static Data Form

Date:	Nov 6-10/14	Vessel Description:	Treater
A #:	A0403458	CRN #:	L-0015.2
Serial #:	97015-330	MAWP:	75 PSI
Facility:	12-09 Brintnell Battery	Shell Thickness:	0.500"
Vessel LSD:	12-09-081-2204	Firetube Thickness:	N/A
Owners Inspector:	Ed Tymensen Streamline Insp.	Repair Organization:	Cameron
Scope of Work:	Alteration of treater - removal of existing inlet deflector box ; addition of inlet horseshoe down comer.		

Travel Sheet - Addition/Repair of Non-Pressure Containing Parts

A #:	A0403458	Date:	
Vessel LSD:	12-09-081-2254	Facility:	12-09 Brimnell Battery

Step #	Description of Step	CNRL Asset Integrity		Contractor		CNRL Inspector	
		Action	Initial & Date	Action	Initial & Date	Action	Initial & Date
Scope Sign-Off		H					
Vendor Qualification							
Step 1	Ensure Vendor is Qualified	H		RB	Nov 5/14		
Step 2	Notify Jurisdiction	H		RB	Nov 5/14		
Weld Preparation							
Step 2	Area Cleaned to White Metal			RB	Nov 7/14	ET	Nov 7/14
Step 3	UT & MPI Weld Are for Discontinuities			RB	Nov 7/14	ET	Nov 07/14
Hydrogen Bake Out							
Step 4	Perform Bake-Out (If Required)		N/A		N/A		N/A
Step 5	Heating Method Used for Bake-Out		N/A		N/A		N/A
Step 6	Substitution of Induction Coils		N/A		N/A		N/A
Welding							
Step 7	Pre-Heat Temperature			RB	Nov 7/14	ET	Nov 07/14
Step 8	New Electrodes			RB	Nov 5/14	ET	Nov 07/14
Step 9	Approved WPS	H		RB	Nov 5/14		
Step 10	Stringer Beads - no down hand welding			RB	Nov 5/14	ET	Nov 07/14
Step 11	Dry Powder MT on First Layer		N/A		N/A		N/A
Step 12	Interpass Temperatures						
Step 13	Wrap & Cooling Rates						
Step 14	Grind and Smooth Contour						
Step 15	MT of final weld					ET	Nov 9/14
Step 16	PWHT if Required as Per U1A		N/A		N/A		N/A
Non-Destructive Examination (NDE) after Post-Weld Heat Treatment							
Step 17	12 Hour MPI			RB	Nov 10/14	ET	Nov 10/14
Step 18	No Hydrotest			N/A	RB Nov 8/14	NA	ET Nov 8/14
Documentation							
Step 19	Completion of Contractor Documentation					H	
Step 20	CNRL Inspector Signs Jurisdictional Docs					H	
Step 21	File final QC Package and update Maxitrac	H					

Action Required: H = Hold Point, W = Witness Point, R = Review Point, NA = Not Applicable

Final Sign-Off	
Contractor: Cameron	CNRL Inspector: Ed Tymensen

RB IPV #000711
APJ 510 #27479