

A2583006

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

1. Manufactured and certified by ALCO GAS & OIL PRODUCTION EQUIPMENT LTD. 5203 - 75 St., EDMONTON, AB.  
(Name and address of manufacturer)  
2. Manufactured for AMOCO CANADA 240 - 4th Ave., S.W., CALGARY, AB.  
(Name and address of purchaser)  
3. Location of installation 2-11-80-8-W5M  
(Name and address)  
4. Type VERT. 89C-4224-10 H-9272-2 A-13323R3 1990  
(Horn or vert. tank) (Mfr's serial No.) (CRN) (Drawing No.) (Nat'l. Bd. No.) (Year built)  
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 1989  
Year

6. Shell: SA-516-70 N 1.375" .0625 30" ID 10'-0" s/s  
(Matl. (Spec. No., Grade)) (Nom. Thk. (in.)) (Corr. Allow. (in.)) (Diam. I.D. (ft. & in.)) (Length overall (ft. & in.))  
7. Seams: WELDED DBL FULL 100% --- --- WELDED DBL FULL(uw-11a) 1  
(Long. (Welded, Dbl., Singl., Lap, Butt)) (R.T. (Spot or Full)) (Eff. (%)) (H.T. Temp. (°F)) (Time (hr)) (Girth (Welded, Dbl., Singl., Lap, Butt)) (R.T. (Spot, Partial, or Full)) (No. of Courses)  
8. Heads: (a) Matl. SA-516-70 N (b) Matl. SA-516-70 N  
(Spec. No., Grade) (Spec. No., Grade)

Location (Top, Bottom, Ends)	Minimum Thickness	Corrosion Allowance	Crown Radius	Knuckle Radius	Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure (Convex or Concave)
(a) TOP	1.317	.0625"			2-1				CONCAVE
(b) BOTTOM	1.317	.0625"			2-1				CONCAVE

If removable, bolts used (describe other fastenings) \_\_\_\_\_  
(Matl., Spec. No., Gr., Size, No.)  
9. MAWP 1380 psi at max. temp. 650 °F  
design metal temp. 0 °F at 1380 psi. Hydro., pneu., or comb. test pressure 2070 psi.

10. Nozzles, inspection and safety valve openings:

Purpose (Inlet, Outlet, Drain)	No.	Diam. or Size	Type	Matl.	Nom. Thk.	Reinforcement Matl.	How Attached	Location
INLET	1	3"RFWN	900#	SA-105 - 106B	SCH 80	SA-516-70N 1 1/8"	WELDED	SHELL
OUTLET	1	4x3"RFWN	900#	SA-105 - 333-6	SCH 80	SA-516-70N 1"	WELDED	HEAD
REG. IN	1	2"RFWN	900#	SA-105 - 106B	SCH 80		WELDED	NOZZLE NECK
DRAIN	1	2"RFWN	900#	SA-105 - 106B	SCH 80		WELDED	NOZZLE NECK

1. Supports: Skirt yes Lugs --- Legs --- Other --- Attached WELDED BOTTOM HEAD  
(Yes or no) (No.) (No.) (Describe) (Where and how)

2. Remarks: Manufacturer's Partial Data Reports properly identified and signed by Commissioned Inspectors have been furnished for the following items of the report: \_\_\_\_\_  
(Name of part, item number, Mfr's name and identifying stamp)  
NGL MOLE SIEVE COLUMN CAPACITY 1.5 cu m  
IMPACT TEST EXEMPT UG-20 (f) UCS-66 (c)

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, "U" Certificate of Authorization No. 14259 expires Oct. 24, 1992.  
Date JAN 19/90 Co. name ALCO GAS & OIL PROD EQUIP LTD Signed \_\_\_\_\_  
(Manufacturer) (Representative)

CERTIFICATE OF SHOP INSPECTION

Vessel constructed by ALCO GAS & OIL PROD EQUIP LTD at EDMONTON  
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 PROVINCE OF ALBERTA  
have inspected the component described in this Manufacturer's Data Report on Jan 19, 1990, 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 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 a loss of any kind arising from or connected with this inspection.  
Date 90-01-19 Signed D. W. Hudson Commissions Prov. of Alberta  
(Authorized Inspector) (Nat'l Board or State, Prov. and No.)

26	15 1/2 FT	1/16" THICK X 3" WIDE ASBESTOS TAPE JM #132	
27	1	30" DIA. 16-MESH X .015" WIRE CLOTH	S.S.
28	1	30" DIA. 12-MESH X .015" WIRE CLOTH	S.S.
29	1	30" DIA. 1/2" MESH X .135" DEHY WIRE	S.S.
30	1	1" CODE # THREDOLET (2 1/2-2)	SA-105
31	1	18"-900# ANSI 20WN FLANGE 5/100 SORE	SA-105N
32	1	18"-900# ANSI 20J FLIND FLANGE	SA-105N
33	1	GASKET FOR 18"-900# 20J 2-70	ATMCO IRON 90 BHN MAX
34	20	1 7/8" Ø STUD X 13 1/4" LG. 2-HEX NUTS EACH	SA-193-B7 SA-194-ZH
35	1	FILLER 1" B.S. 1" DIA. 1" LG.	SA-516-70
36	1	Ø 27" O.D. X 1 3/8" THK X 18" I.D. (FORM ZEPAD)	SA-516-70
37	1	GASKET FOR 18"-900# PER DWG C-5513	



**DESIGN DATA**

DESIGN PRESS: 1380 PSIG. AT 650° F	HYDROTEST: 2070 PSIG.
PREHEAT TO 200° F AND MAINTAIN DURING WELDING	
RADIOGRAPHY: FULL	LONG'L JOINT EFF.: 100%
P.W.H.T.: NO	CORROSION ALLOWANCE: .0625"
MIN. DESIGN TEMP: 0° F @ 1380 PSIG	
HEADS: SA-516-70N (1.255" MIN. THK)	FLANGES: SA-105 N
SHELL: SA-516-70N (1.315" NOM. THK)	NOZZLES: SA-106-B
WELD FITTINGS: SA-274-WPE	STUDS: SA-193-B7
COUPLINGS (T.O.L.): SA 105	NUTS: SA-194-ZH
INTERNALS: SA-36	MISC. P.: SA-36 / SA-516-70
SURFACE PREP: COMMERCIAL SANDBLAST TO SSPC-SP6	
SHIPPING WT: 10620 LBS. (EMPTY)	CAPACITY: 54.6 CU. FT.
TESTING WT: 1403 LBS. (FULL OF WATER)	
PAINT:	
INSULATION: 3" CAL. INSULATION W/ CORRUGATED ALUM. JACKET	
CRN. 922.2	SERIAL NO.: 892-4224-11

**GENERAL NOTES**

1. ALL BOLTS TO STRADDLE NATURAL VESSEL CENTERLINES.
2. SEE NOTES FOR REPAIR WELD HOLES.
3. PROTECT ALL OPENINGS FOR SHIPMENT.

DRAWN	FB	30" I.D. X 10'-0" H X 1380 PSIG DIP. VERTICAL N3 MOLE SIEVE COLUMN TAG# V10-1012-2 QSD 2-11-80-8 WSM
DATE	89/11-02	
SCALE		
CHK'D		

FIELD SIZE	APP'D	CUSTOMER: ALCO GAS AND OIL PRODUCTION EQUIPMENT LTD	SHOP ORDER: 892-4224-11
<p>The information contained herein is the confidential property of Alco Gas and Oil Production Equipment Ltd. and is not for publication. The information is issued on the understanding that no part thereof shall be copied or communicated to a third party without authorization in writing from Alco Gas and Oil Production Equipment Ltd.</p>			REVISION: 3/1
 			DWG. A-15821

DETAIL  
SHOWING  
ROB IMAGE

W-11 (a)  
289

V.1

MP