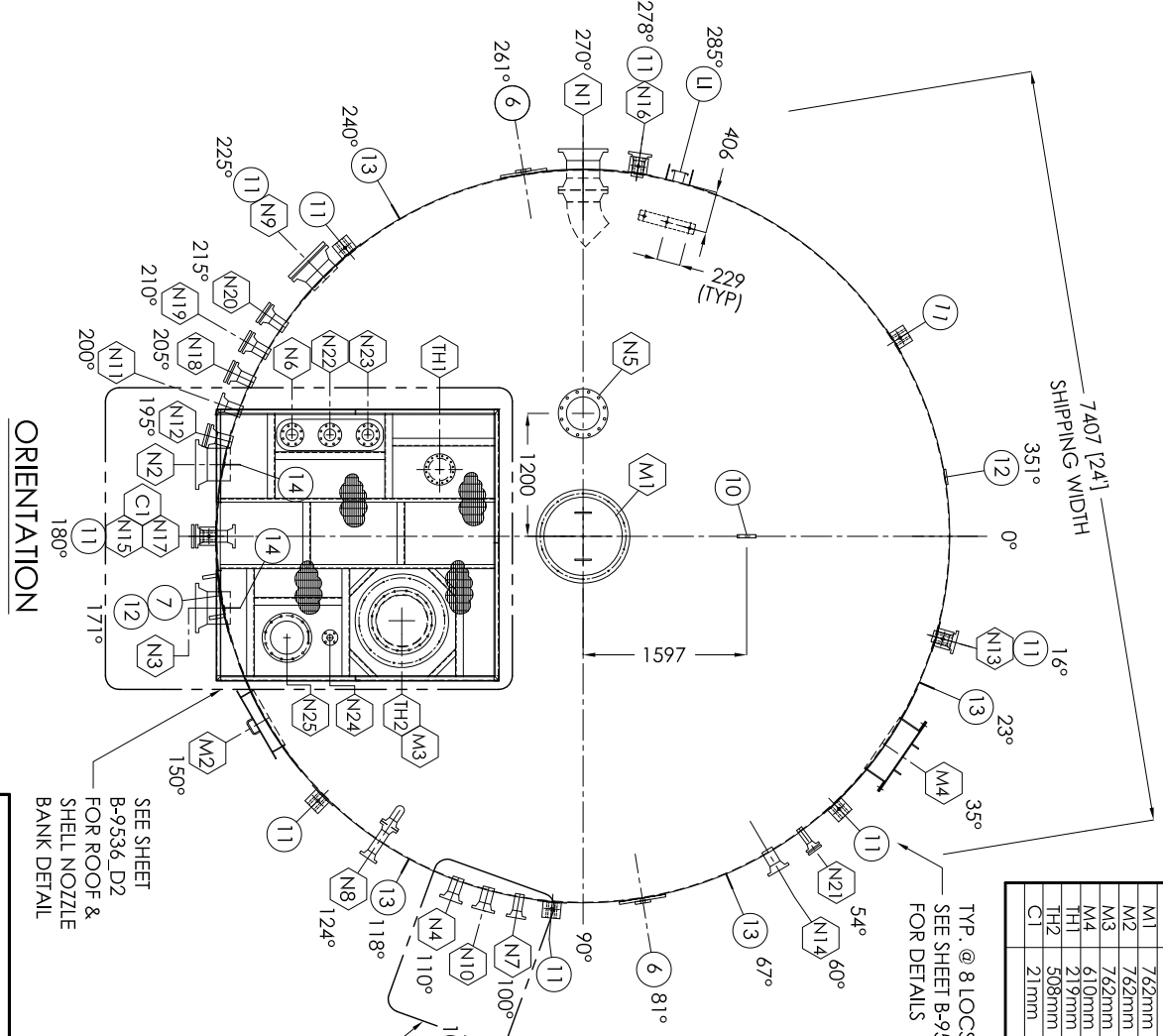
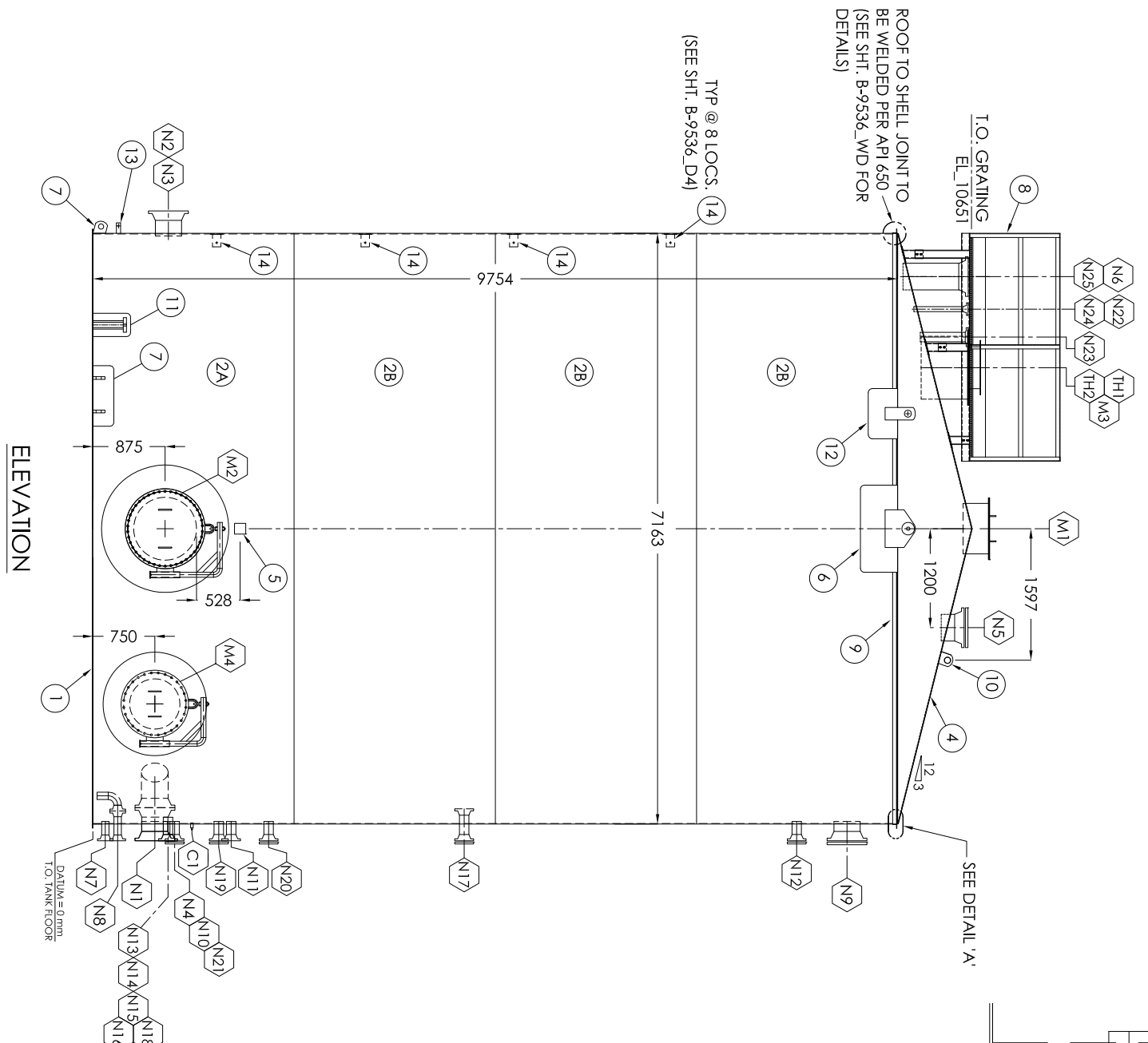
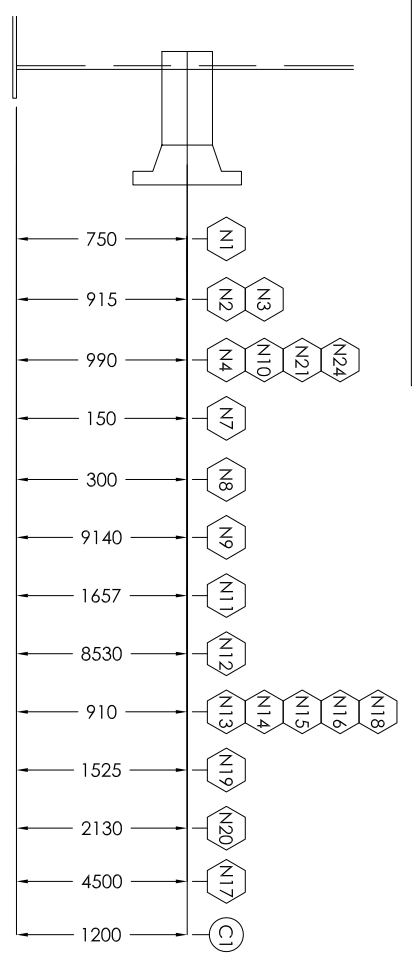


23'-6" O.D. x 32'-0" HIGH



SHIPPED LOOSE ITEMS
 - (1) ROOF PLATFORM C/W SAFETY GATE & BOLTPUS

REVISIONS

NO.	DESCRIPTION	DATE	BY
7	AS BUILT	12.08.14	MG
6	REVISED ROOF PLATFORM, ADD DAVIT ARM ON M2 & M4	02.04.14	GR
5	ISSUED FOR FABRICATION	08.07.13	MG
4	ISSUED FOR REVIEW / APPROVAL	06.28.13	MG
3	ISSUED FOR REVIEW / APPROVAL	06.14.13	MG
2	ISSUED FOR REVIEW / APPROVAL	05.03.13	MG
1	ISSUED FOR REVIEW / MARKUP	02.22.13	MG
0	ISSUED FOR REVIEW / MARKUP	09.18.12	MG

SHIPPING INFORMATION - TANK LAID DOWN-
 1. ESTIMATED SHIPPING WEIGHT = 32000 LBS. (14,515 KG) - EMPTY-
 2. WIDTH: APPROX. 7163MM (24'-0")
 3. LENGTH: APPROX. 10845mm (35'-6")
 4. HEIGHT: APPROX. 7487mm (24'-6")

CUSTOMER: DEVON CANADA CORPORATION
 PO# 4100000658

TITLE: 400 CU. M. (2500 BBL)
 7163 DIA. (23' - 6" Ø) x 9754 HIGH (32'-0")
 STORAGE TANK

APPROVED BY: 09.18.12 TAG #:
 CHECKED BY: PROJECT MANGR. RR
 DRAWING #: B-9536 OR
 SERIAL #: 9536

DATE: 09.18.12 TAG #:
 SCALE: NTS

ARGO SALES LTD

COUPLING & NOZZLE - BILL OF MATERIALS

MARK	QUANTITY	MATERIAL	DESCRIPTION	SERVICE
N1	2	A350 LF2 A333 GR.6 38W	324 DIA. (12") 150# RFWN FLANGE 324 DIA. (12") SCH. STD SWLS PIPE X 173 LG. 6.4 THK x 327 ID x 685 OD REPAD (SEE SHEET B-9536, D2 FOR DETAIL)	INLET
N2	1	A350 LF2 A333 GR.6 38W	324 DIA. (12") 150# RFWN FLANGE 324 DIA. (12") SCH. STD SWLS PIPE X 224 LG. 6.4 THK x 327 ID x 685 OD REPAD	OUTLET
N3	1	A350 LF2 A333 GR.6 38W	324 DIA. (12") 150# RFWN FLANGE 324 DIA. (12") SCH. STD SWLS PIPE X 224 LG. 6.4 THK x 327 ID x 685 OD REPAD	OUTLET
N4	1	A350 LF2 A333 GR.6 38W	114 DIA. (4") 150# RFWN FLANGE 114 DIA. (4") SCH. XH SWLS PIPE X 158 LG. 6.4 THK COMMON REPAD (SEE SHEET B-9536, D2 FOR DETAIL)	LEVEL TRANSMITTER
N5	1	A350 LF2 A333 GR.6 38W	324 DIA. (12") 150# RFWN FLANGE 324 DIA. (12") SCH. STD SWLS PIPE X 162 LG. 324 DIA. (12") 150# RFWN FLANGE	VENT
N6	1	A350 LF2 A333 GR.6 38W	114 DIA. (4") 150# RFWN FLANGE 114 DIA. (4") SCH. XH SWLS PIPE X 674 LG. 6.4 THK COMMON REPAD (SEE SHEET B-9536, D2 FOR DETAIL)	BLANKET GAS
N7	1	A350 LF2 A333 GR.6 38W	89 DIA. (3") 150# RFWN FLANGE 89 DIA. (3") SCH. XH SWLS PIPE X 165 LG. 6.4 THK x 92 ID x 265 OD REPAD	TRUCK OUT
N8	2	A350 LF2 A333 GR.6 38W	89 DIA. (3") 150# RFWN FLANGE 89 DIA. (3") SCH. XH SWLS PIPE X 222 LG. 6.4 THK x 92 ID x 265 OD REPAD (SEE SHEET B-9536, D2 FOR DETAIL)	TRUCK OUT
N9	1	A350 LF2 A333 GR.6 38W	324 DIA. (12") 150# RFWN FLANGE 324 DIA. (12") SCH. STD SWLS PIPE X 120 LG. 324 DIA. (12") 150# RFWN FLANGE	OVERFLOW/BLIND
N10	1	A350 LF2 A333 GR.6 38W	114 DIA. (4") 150# RFWN FLANGE 114 DIA. (4") SCH. XH SWLS PIPE X 158 LG. 6.4 THK COMMON REPAD (SEE SHEET B-9536, D2 FOR DETAIL)	LEVEL TRANSMITTER
N11	1	A350 LF2 A333 GR.6 38W	114 DIA. (4") 150# RFWN FLANGE 114 DIA. (4") SCH. XH SWLS PIPE X 158 LG. 6.4 THK x 117 ID x 305 OD REPAD	TEMP. INDICATOR
N12	1	A350 LF2 A333 GR.6 38W	114 DIA. (4") 150# RFWN FLANGE 114 DIA. (4") SCH. XH SWLS PIPE X 158 LG. 6.4 THK x 117 ID x 305 OD REPAD	SPARE
N13	1	A350 LF2 A333 GR.6 38W	114 DIA. (4") 150# RFWN FLANGE 114 DIA. (4") SCH. XH SWLS PIPE X 158 LG. 6.4 THK x 117 ID x 305 OD REPAD	ANODE (FUTURE)
N14	1	A350 LF2 A333 GR.6 38W	114 DIA. (4") 150# RFWN FLANGE 114 DIA. (4") SCH. XH SWLS PIPE X 158 LG. 6.4 THK x 117 ID x 305 OD REPAD	ANODE (FUTURE)
N15	1	A350 LF2 A333 GR.6 38W	114 DIA. (4") 150# RFWN FLANGE 114 DIA. (4") SCH. XH SWLS PIPE X 209 LG. 6.4 THK x 117 ID x 305 OD REPAD	ANODE (FUTURE)
N16	1	A350 LF2 A333 GR.6 38W	114 DIA. (4") 150# RFWN FLANGE 114 DIA. (4") SCH. XH SWLS PIPE X 209 LG. 6.4 THK x 117 ID x 305 OD REPAD	ANODE (FUTURE)
N17	2	A350 LF2 A333 GR.6 38W	114 DIA. (4") 150# RFWN FLANGE 114 DIA. (4") SCH. XH SWLS PIPE X 235 LG. 6.4 THK x 117 ID x 305 OD REPAD	SKIM / SPARE
N18	1	A350 LF2 A333 GR.6 38W	114 DIA. (4") 150# RFWN FLANGE 114 DIA. (4") SCH. XH SWLS PIPE X 158 LG. 6.4 THK x 117 ID x 305 OD REPAD	SPARE
N19	1	A350 LF2 A333 GR.6 38W	114 DIA. (4") 150# RFWN FLANGE 114 DIA. (4") SCH. XH SWLS PIPE X 158 LG. 6.4 THK x 117 ID x 305 OD REPAD	SPARE
N20	1	A350 LF2 A333 GR.6 38W	114 DIA. (4") 150# RFWN FLANGE 114 DIA. (4") SCH. XH SWLS PIPE X 158 LG. 6.4 THK x 117 ID x 305 OD REPAD	SPARE
N21	1	A350 LF2 A333 GR.6 38W	114 DIA. (4") 150# RFWN FLANGE 114 DIA. (4") SCH. XH SWLS PIPE X 170 LG. 6.4 THK x 117 ID x 305 OD REPAD	SPARE
N22	1	A350 LF2 A333 GR.6 38W	114 DIA. (4") 150# RFWN FLANGE 114 DIA. (4") SCH. XH SWLS PIPE X 588 LG. 6.4 THK COMMON REPAD (SEE SHEET B-9536, D2 FOR DETAIL)	LEVEL SWITCH HIGH
N23	1	A350 LF2 A333 GR.6 38W	114 DIA. (4") 150# RFWN FLANGE 114 DIA. (4") SCH. XH SWLS PIPE X 503 LG. 6.4 THK COMMON REPAD (SEE SHEET B-9536, D2 FOR DETAIL)	LEVEL SWITCH HIGH
N24	1	A350 LF2 A333 GR.6 38W	60 DIA. (2") 150# RFWN FLANGE 60 DIA. (2") SCH. XH SWLS PIPE X 595 LG. 6.4 THK COMMON REPAD (SEE SHEET B-9536, D2 FOR DETAIL)	SPARE
N25	1	A350 LF2 A333 GR.6 38W	324 DIA. (12") 150# RFWN FLANGE 324 DIA. (12") SCH. STD SWLS PIPE X 676 LG. 6.4 THK COMMON REPAD (SEE SHEET B-9536, D2 FOR DETAIL)	PVRY

BILL OF MATERIALS (FOR 1 TANK)

MARK	QTY	MATL	DESCRIPTION	SERVICE
1	1	38W	7.9 PL. x 7264 DIA. FLAT BOTTOM	
2A	1	38W	7.9 PL. x 2438.5 x 22503 LG. SHELLS	
2B	3	38W	6.4 PL. x 2438.5 x 22503 LG. SHELLS	
4	1	38W	9.5 PL. x 2382 DIA. CONED ROOF (3:12 SLOPE)	
5	1		NAMEPLATE AND BRACKET	
6	2	A516 GR70	HEAVY LIFT LUGS (SEE DETAIL SHT B-9536, D1)	
7	2	A516 GR70	HEAVY TAIL LUG C/W REPAD (SEE DETAIL SHT B-9536, D1)	
8	1	A36	ROOF PLATFORM (SEE SHT B-9536, RP FOR DETAILS)	
9	1	A36	50 x 50 x 4.8 THK. RUNAROUND ANGLE ROLLED TO 2143.1 LD. (LEG OUT) (SEE SHT B-9536, OR FOR DETAILS)	
10	1	38W	LANYARD TIE OFF (ARGO STD. TAIL LUG) NO REPAD	
11	8	A516 GR70	ANCHOR CHAIRS C/W REPAD (SEE SHT. B-9536, AN)	
12	2	A516 GR70	LARGE LIFT LUGS (SEE SHT. B-9536, D1 FOR DETAILS)	
13	4	A36	GROUNDING LUG (SEE SHT. B-9536, D1 FOR DETAILS)	
14	8	A36	INTERNAL BRACKETS (SEE SHT. B-9536, D4 FOR DETAILS)	
M1	1	38W	30" API ROOF MANWAY C/W COVER (SEE SHT. B-9536, D3 FOR MANWAY DETAIL)	ROOF MANWAY
M2	1	38W	30" API SHELL MANWAY C/W COVER & REPAD (SEE SHT. B-9536, D5 FOR MANWAY DETAIL)	SHELL MANWAY
M3	1	38W	30" API SHELL MANWAY C/W COVER (SEE SHT. B-9536, D3 FOR MANWAY DETAIL)	ROOF MANWAY
M4	1	38W	24" API SHELL MANWAY C/W COVER & REPAD (SEE SHT. B-9536, D5 FOR MANWAY DETAIL)	SHELL MANWAY
TH1	1		219 DIA. (8") ENARDO 660 PT SOUR SERVICE THIEF HATCH SET @ 8 oz. PRESS./0.4 oz. VAC 219 DIA. (8") ARGO FABRICATED FLANGE 219 DIA. (8") SCH. STD. X 389 LG. PIPE	THIEF HATCH
TH2	1		508 DIA. (20") API MANWAY C/W TEMPORARY COVER FOR SHIPPING (SEE SHEET B-9536, D3 FOR DETAILS) (PRV SUPPLIED BY OTHERS)	EPRV
U	1	316SS	33 DIA. (1") 3000# FS CRIG	
	2	316SS	42 DIA. (1-1/4") 3000# FS CRIG	
	1		AMGAS SOUR SERVICE LEVEL GAUGE SYSTEM C/W PVC	
	10	A36	FLOAT AND (4) EXTERNAL CABLE BRACKETS	
	2	316SS	GAUGE BOARD BRACKETS	
C1	1	316SS	1/2" NPT 3000# FULL CPLG. (SEE SHT. B-9536, D4 FOR DETAILS)	LUBE CONNECTION

- TESTING
- TANK TO BE AIR/COAP LEAK TESTED TO 12 OZ.
 - SHELL TO FLOOR JOINT: MPI AS PER API 650
 - FLOOR SEAM WELDS TO BE VACUUM BOX TESTED WITH A PARTIAL VACUUM OF 3-5 PSIG APPLIED.
 - RADIOPARTY INSPECTION
 - RADIOGRAPHY AS PER API 650

THIRD PARTY INSPECTION

MIL INSPECTION
PH: (780) 819 - 7009
ATTN: DWAYNE HARPER

INTERNAL & EXTERNAL FINISH

- INTERNAL FINISH:
NO INTERNAL FINISH (CLEAN FOR FUTURE COATING)
- EXTERNAL FINISH:
BLAST: SSPC-SP6 COMMERCIAL BLAST
PRIMER: 4.0 - 8.0 MILS DFT DEVOE BAR-RUST 235 EPOXY
PAINT: 2.0 - 3.0 MILS DEVOE DEVIHANE 389 EPOXY URETHANE (COLOR: LIGHT GREY (FS 14376))
- EXTERNAL FINISH:
BARE STEEL

DESIGN NOTES

- TANK TO BE BUILT AND TESTED TO API-12F SPECS. MODIFIED (NON LABELLED)
- TANK DESIGN PRESSURE = 8 OZ / DESIGN VACUUM = 0.5 OZ
- MDMT = -35 °C
- MAX. DESIGN TEMP = 93 °C
- ROOF/SHELL JOINTS NOT TO BE BACKWELDED.
- REFER TO ORIENTATION DRAWING FOR PROPER LOCATION OF ALL NOZZLES, COUPLINGS, ETC.
- ALL DIMENSIONS ARE IN mm.
- STUDS/NUTS/GASKETS - ANSI F15G (EXTERNAL & INTERNAL): B7M / 2HM / 316SS FLEX
- FASTENERS/GASKETS - MANWAY: GRADE 5 / NEOPRENE
- MATERIAL MTRS TO BE RECORDED.
- ALL SHELL NOZZLES 3" AND LARGER TO HAVE REPADS.
- SEE SHT. B-9536, WD FOR WELD NOTES & DETAILS
- ALL ELEVATIONS ARE TAKEN FROM TOP OF TANK FLOOR.
- CORROSION ALLOWANCE - 0.0625 INCHES

REVISIONS

REV.	DESCRIPTION	BY	DATE
6	AS BUILT	MG	12/08/14
5	ISSUED FOR FABRICATION	MG	08/07/13
4	ISSUED FOR REVIEW / APPROVAL	MG	06/28/13
3	ISSUED FOR REVIEW / APPROVAL	MG	06/14/13
2	ISSUED FOR REVIEW / APPROVAL	MG	05/03/13
1	ISSUED FOR REVIEW / MARKUP	MG	02/22/13
6	UPDATED EXTERNAL FINISH ONLY	CGC	05-12-14

CUSTOMER:

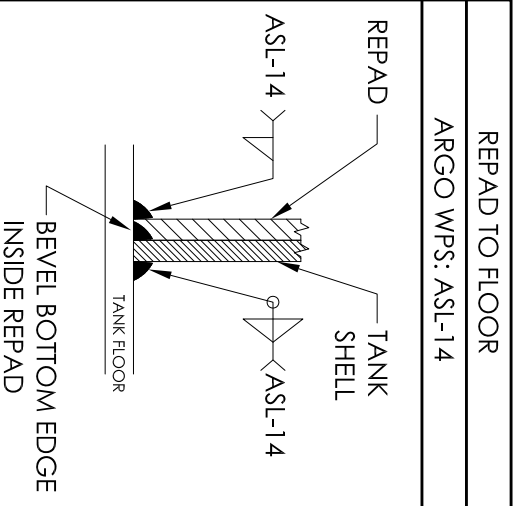
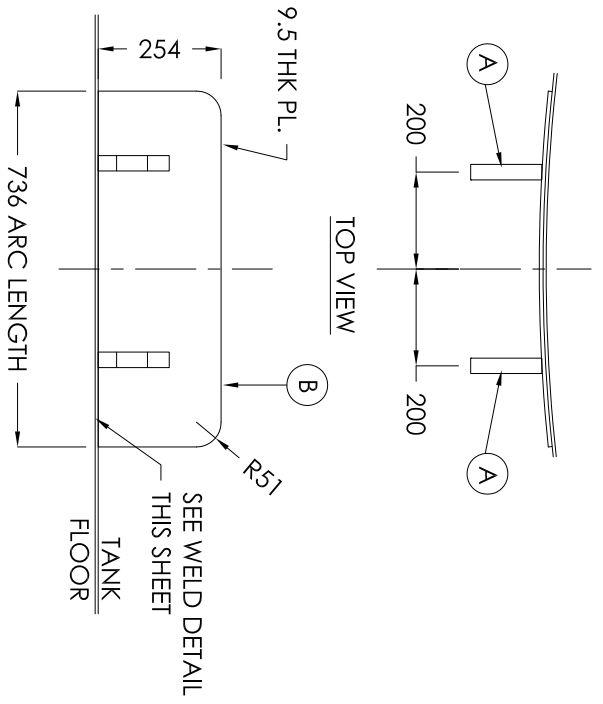
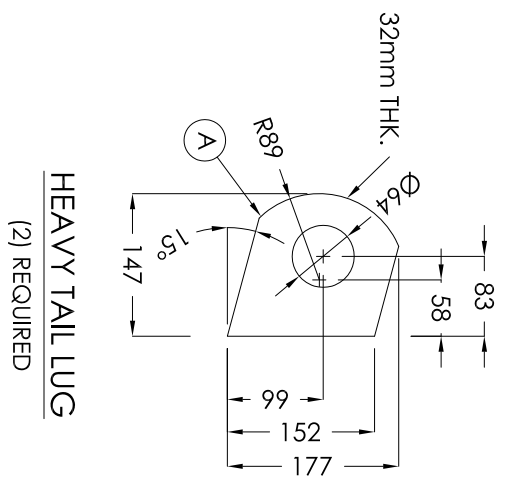
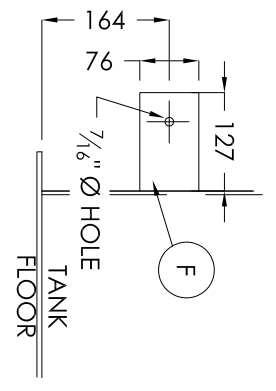
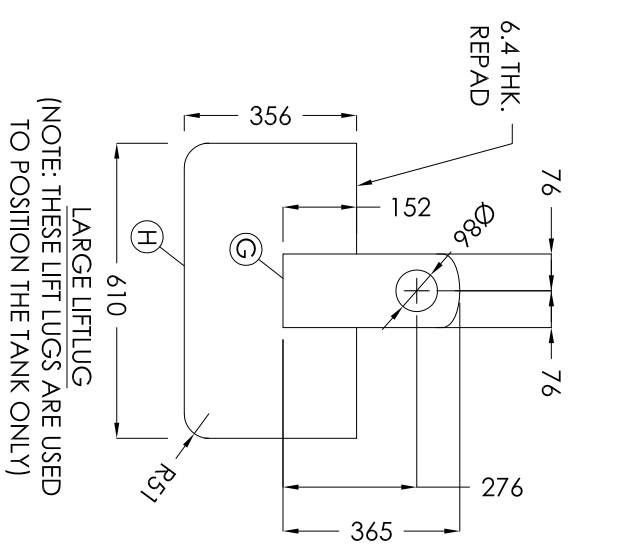
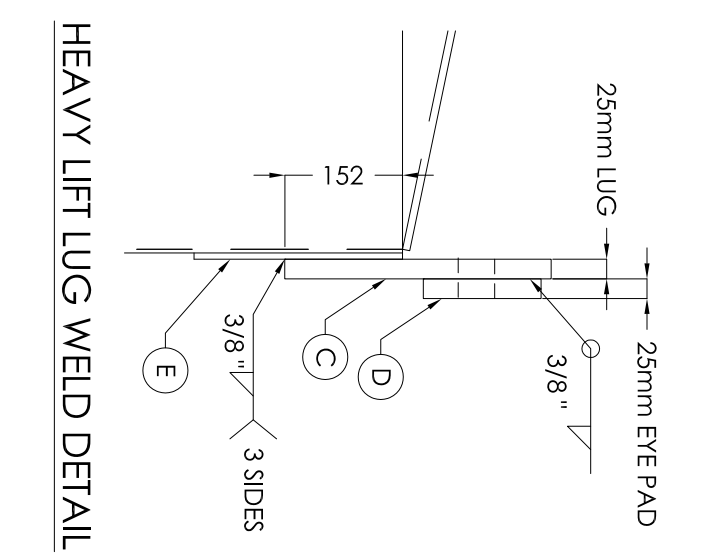
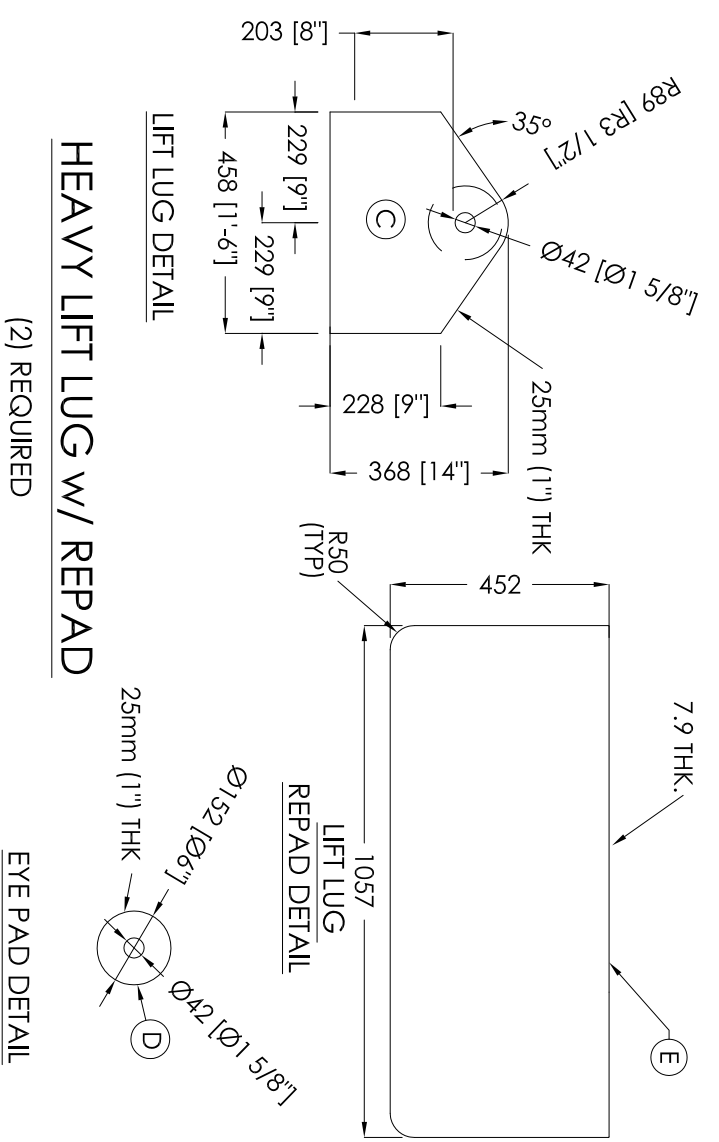
DEVON CANADA CORPORATION
PO # 4100000658

TITLE:

400 CU. M. (2500 BBL)
7163 DIA. (23' - 6" Ø) x 9754 HIGH (32'-0")
STORAGE TANK

APPROVED BY:	CHECKED BY:	PROJECT MANGR.	RR	REV.
DATE:	09.18.12	TAG #:		DRAWING #: B-9536 BOM
SHEET:	2 OF 14	SCALE:	NTS	SERIAL #: 9536





DESIGN NOTES

1. ALL DIMENSIONS ARE IN mm.
2. ALL ELEVATIONS TAKEN FROM TOP OF TANK FLOOR
3. REFER TO ORIENTATION DRAWING FOR PROPER LOCATION OF ALL NOZZLES, COUPLINGS, ETC.

REVISIONS

NO.	DESCRIPTION	BY	DATE
6	AS BUILT	MG	12.08.14
5	ISSUED FOR FABRICATION	MG	08.07.13
4	ISSUED FOR REVIEW/APPROVAL	MG	06.28.13
3	ISSUED FOR REVIEW/APPROVAL	MG	06.14.13
2	ISSUED FOR REVIEW/APPROVAL	MG	05.03.13
1	ISSUED FOR REVIEW/APPROVAL	MG	02.22.13
0	ISSUED FOR REVIEW/APPROVAL	MG	09.18.12

BILL OF MATERIALS

MARK	QTY	MATL	DESCRIPTION	SERVICE
A	2	A516 GR70 32 THK. x 147 x 177 PLATE	TAIL LUG DETAIL	
B	1	38W	9.5 THK. TAIL LUG REPAD [SEE DETAIL THIS SHJ]	
C	2	A516 GR70 25 THK. PL. x 368 x 458 LG.	HEAVY LIFTING LUG DETAIL	
D	2	A516 GR70 25 THK. PL. x 152 DIA. (EYE PAD)		
E	2	38W	7.9 THK. PL. x 452 x 1057 LG. REPAD	
F	4	A36	GROUNDING LUGS COMPONENTS	
G	2	A516 GR70 25 THK. x 152 x 368 PLATE	LARGE LIFT LUG DETAIL	
H	2	38W	6.4 THK. REPAD [SEE DETAIL]	

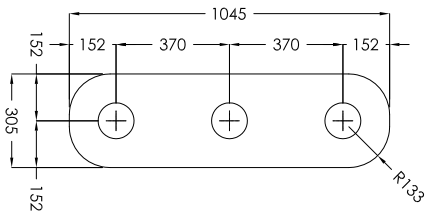
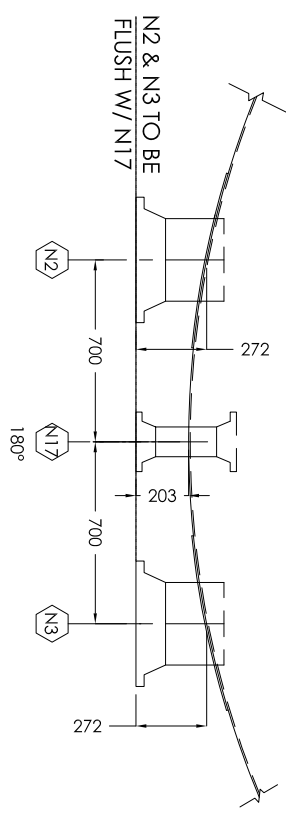
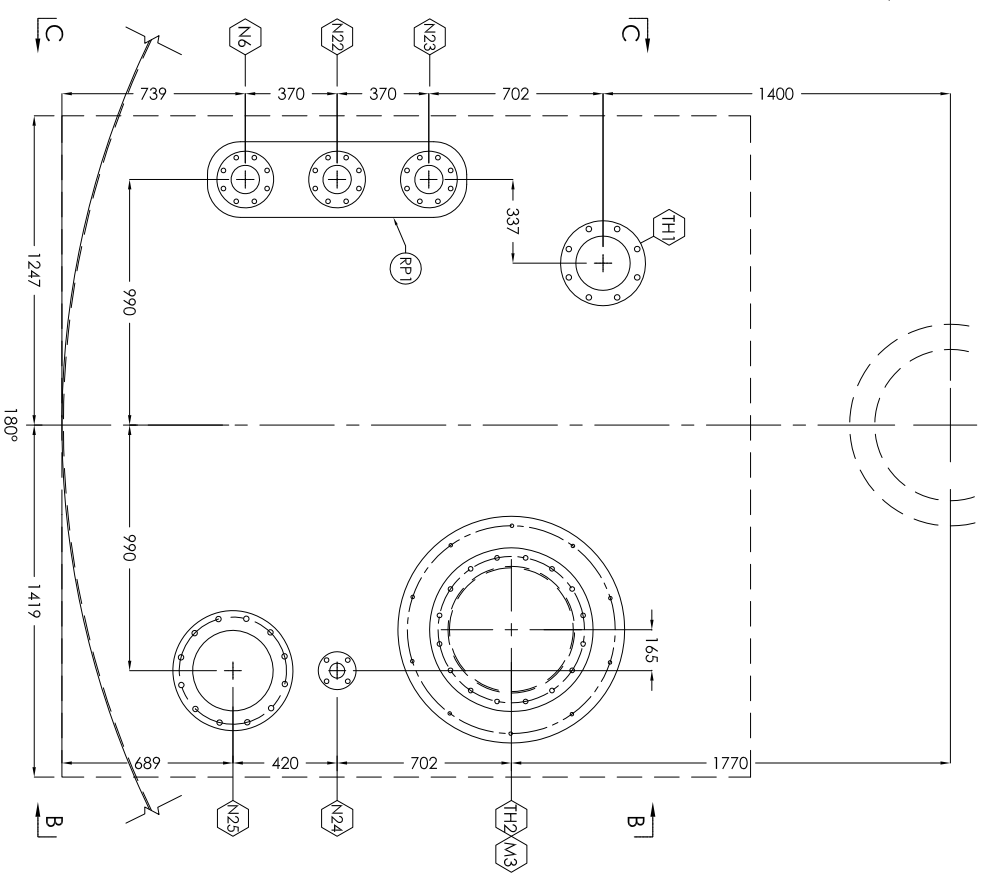
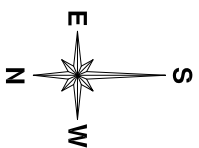
CUSTOMER: DEVON CANADA CORPORATION
PO# 4100000658

TITLE: DETAIL 1

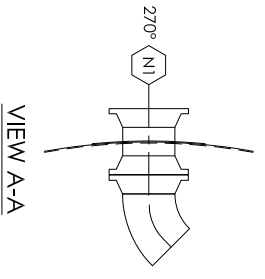
APPROVED BY: _____ CHECKED BY: _____ PROJECT MANGR. RR

DATE: 09.18.12 TAG #: _____ DRAWING #: B-9536.D1 REV.

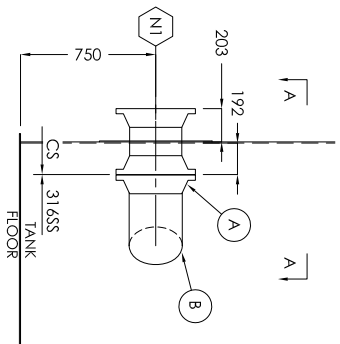
SHEET: 3 OF 14 SCALE: NTS SERIAL #: 9536



RP1 - ROOF REPAD 1 DETAIL
(REPAD FOR N6, N22, & N23)

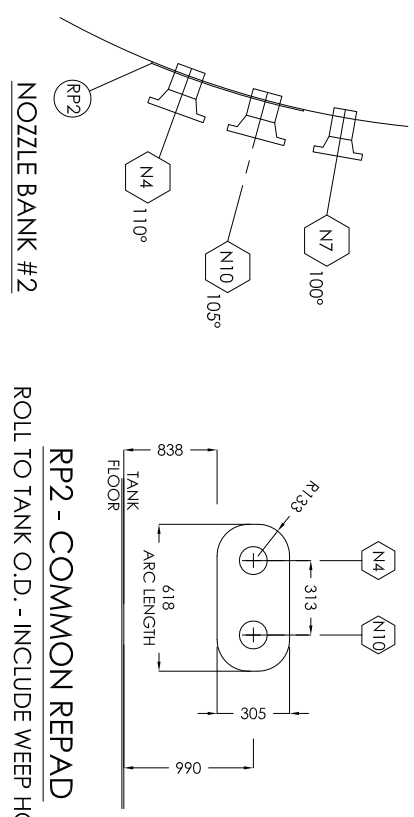


VIEW A-A



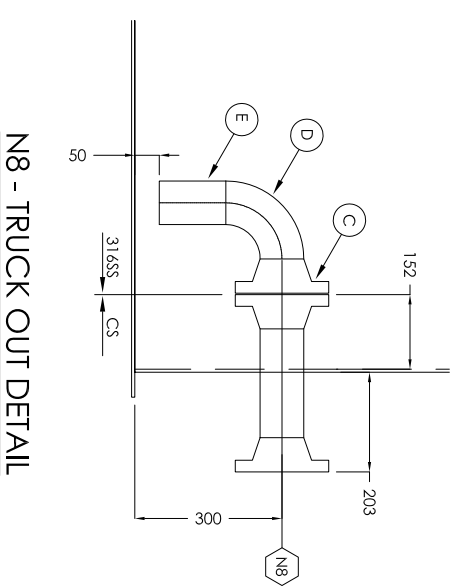
N1 - INLET DETAIL

BILL OF MATERIALS (FOR 1 TANK)			DESCRIPTION	SERVICE
MARK	QTY	MATL		
RP1	1	38W	6.4 PL. X 305 X 1045 LG.	ROOF COMMON REPAD
RP2	1	38W	6.4 PL. X 305 X 418 LG. (SEE DETAIL ON THIS SHEET)	COMMON REPAD
N1-INTERNAL PIPING				
A	1	316SS	324 DIA. (12") 150# RFWN FLG.	
B	1	316SS	324 DIA. (12") SCH. STD. 45° LRWE	
N8-DOWNCOMER COMPONENTS				
C	1	316SS	89 DIA. (3") 150# RFWN FLG.	
D	1	316SS	89 DIA. (3") SCH. 80 90° LRWE	
E	1	316SS	89 DIA. (3") SCH. 80 PIPE X 136 LG.	

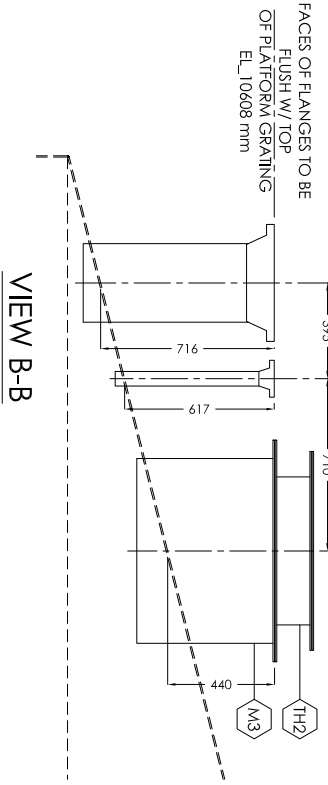


NOZZLE BANK #2

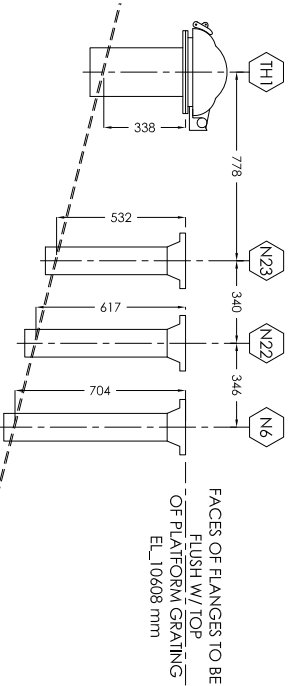
RP2 - COMMON REPAD
ROLL TO TANK O.D. - INCLUDE WEEP HOLES



N8 - TRUCK OUT DETAIL



VIEW B-B



VIEW C-C

REVISIONS		
6	AS BUILT	MG 12.08.14
5	ISSUED FOR FABRICATION	MG 08.07.13
4	ISSUED FOR REVIEW / APPROVAL	MG 06.28.13
3	ISSUED FOR REVIEW / APPROVAL	MG 06.14.13
2	ISSUED FOR REVIEW / APPROVAL	MG 05.03.13
1	ISSUED FOR REVIEW / MARKUP	MG 02.22.13
0	ISSUED FOR REVIEW / MARKUP	MG 09.18.12

CUSTOMER: DEVON CANADA CORPORATION
PO# 4100000658

TITLE: MISC DETAILS

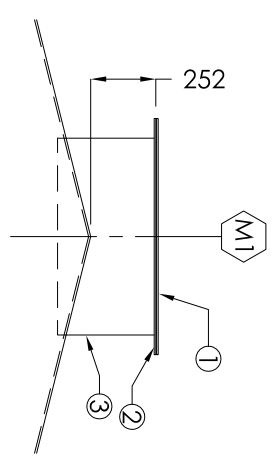
APPROVED BY: _____ CHECKED BY: _____ PROJECT MANGR. RR

DATE: 02.22.13 TAG #: _____ DRAWING #: B-9536.D2

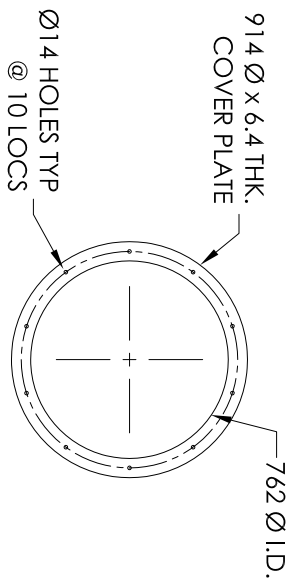
SHEET: 4 OF 14 SCALE: _____ NTS SERIAL #: 9536

BILL OF MATERIALS

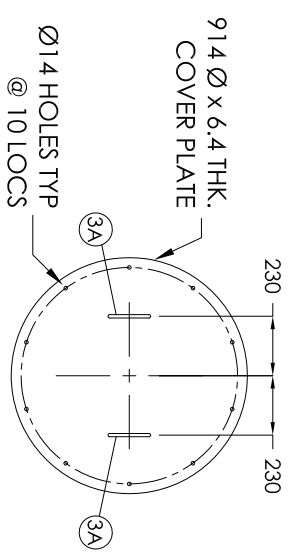
MARK	QTY	MATL	DESCRIPTION	SERVICE
1	1	38W	M1 - ROOF MANWAY	
2	1	38W	6.4 THK. x 914 DIA. MANWAY COVER (LASER CUT PART) (ARGO FABRICATED)	
3	1	38W	6.4 THK. x 914 DIA. O.D. x 765 DIA. I.D. FLANGE (ARGO FABRICATED)	
3A	2	A36	6.4 THK. x 762 DIA. (30") x 563 LG. MANWAY NECK MANWAY HANDLES	
4	1	38W	M2 - ROOF MANWAY	
5	1	38W	6.4 THK. P.L. ROLLED TO 308 O.D. (20") x 140 LG. 6.4 THK. x 660 DIA. (20") MANHOLE APT FLANGE (SEE DETAIL ON THIS SHEET)	
6	1	38W	M3 - ROOF MANWAY	
7	1	38W	6.4 THK. x 914 DIA. O.D. x 765 DIA. I.D. FLANGE (ARGO FABRICATED)	
8	1	38W	6.4 THK. x 762 DIA. (30") x 563 LG. MANWAY NECK	



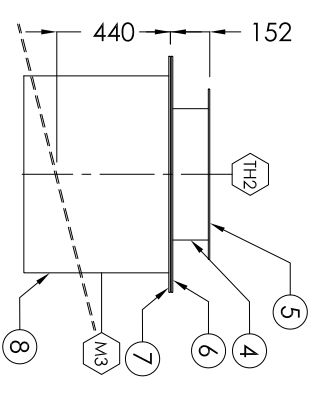
M1 - 30" DIA. ROOF MANWAY DETAIL
(SEE THIS SHEET B-9536_D2 FOR ROUND MANWAY EXACT LOCATION)



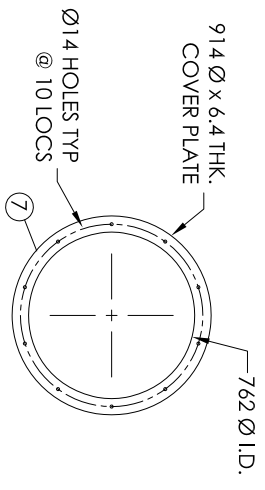
M1-30" ROOF MANWAY FLANGE DETAIL



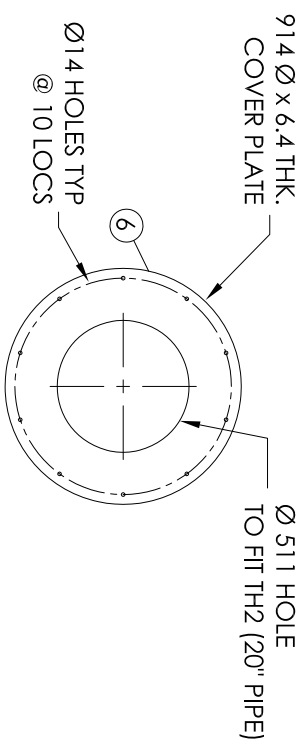
M1-30" ROOF MANWAY COVER DETAIL



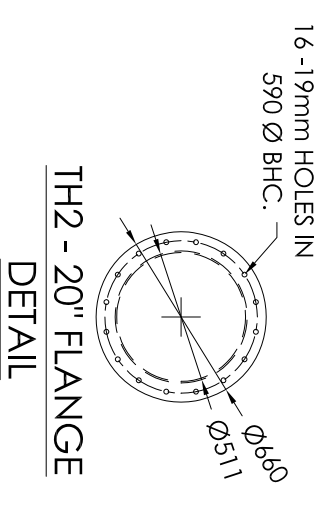
M3 - 30" DIA. ROOF MANWAY DETAIL
(SEE THIS SHEET B-9536_D2 FOR ROUND MANWAY EXACT LOCATION)



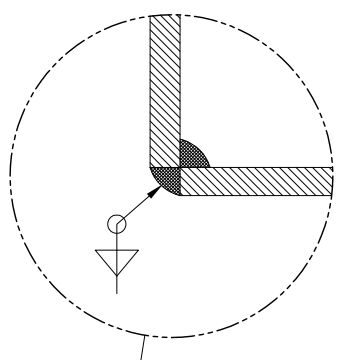
M3 - 30" ROOF MANWAY FLANGE DETAIL



M3 - 30" ROOF MANWAY COVER DETAIL



TH2 - 20" FLANGE DETAIL



MANWAY COVER TO NOZZLE DETAIL

FABRICATED FLG TO NECK
ARGO WPS: ASL114

DESIGN NOTES

1. ALL DIMENSIONS ARE IN mm.
2. ALL ELEVATIONS TAKEN FROM TOP OF TANK FLOOR

REVISIONS

NO.	DESCRIPTION	BY	DATE
6	AS BUILT	MG	12.08.14
5	ISSUED FOR REVIEW / APPROVAL	MG	08.07.13
4	ISSUED FOR REVIEW / APPROVAL	MG	06.28.13
3	ISSUED FOR REVIEW / APPROVAL	MG	06.14.13
2	ISSUED FOR REVIEW / APPROVAL	MG	05.03.13
1	ISSUED FOR REVIEW / APPROVAL	MG	02.22.13
0	ISSUED FOR REVIEW / APPROVAL	MG	09.18.12

CUSTOMER: DEVON CANADA CORPORATION
PO # 410000658

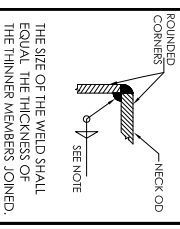
TITLE: ROOF MANWAY DETAILS

APPROVED BY: [Signature] CHECKED BY: [Signature] PROJECT MANGR: RR

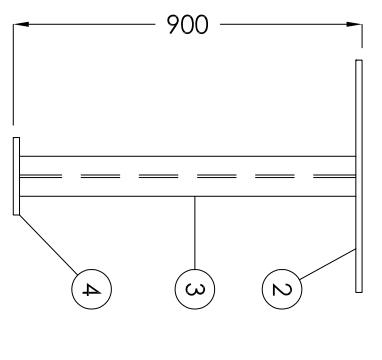
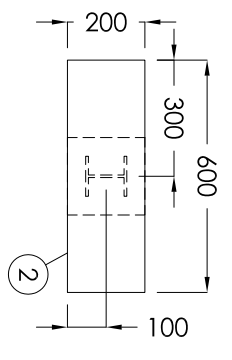
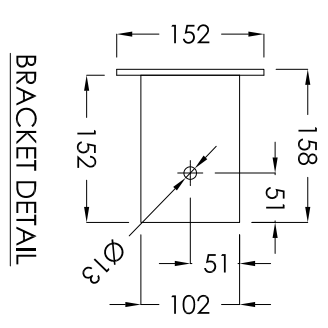
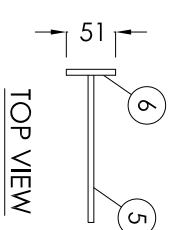
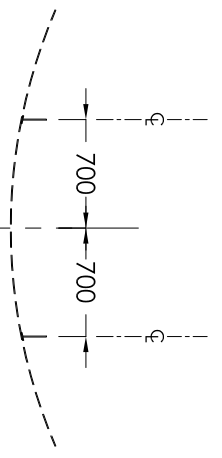
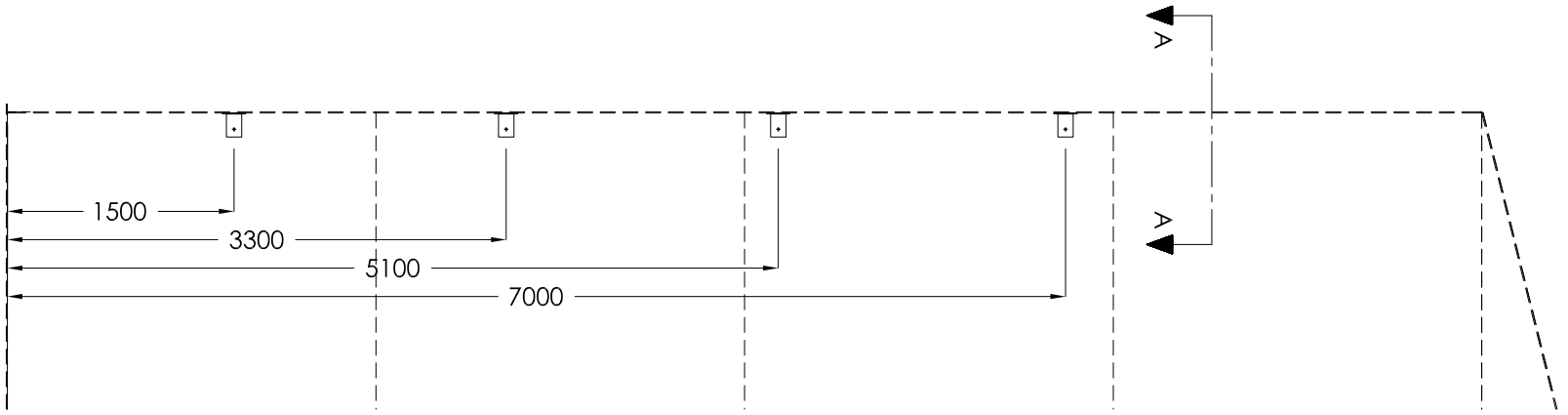
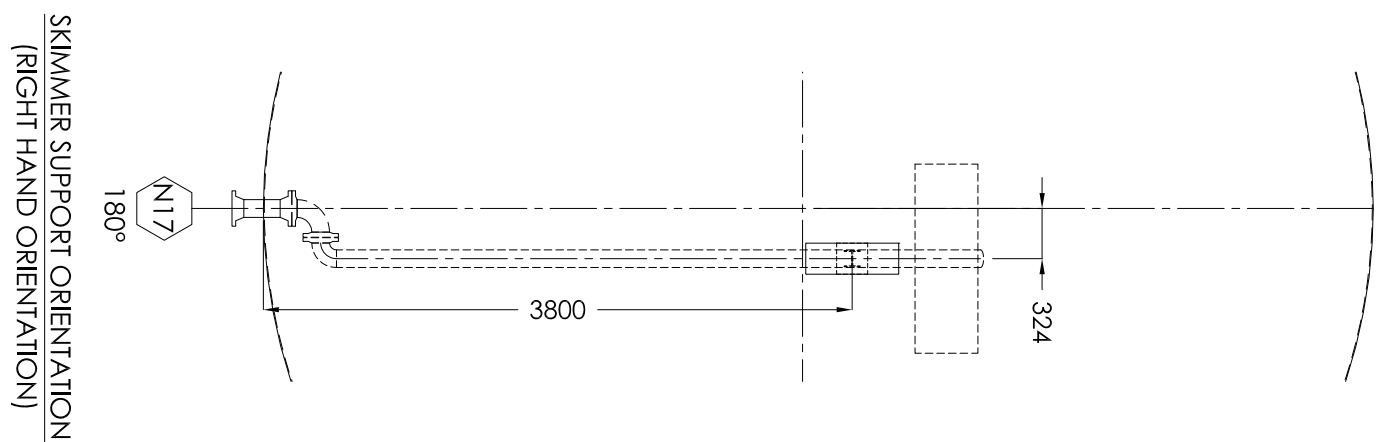
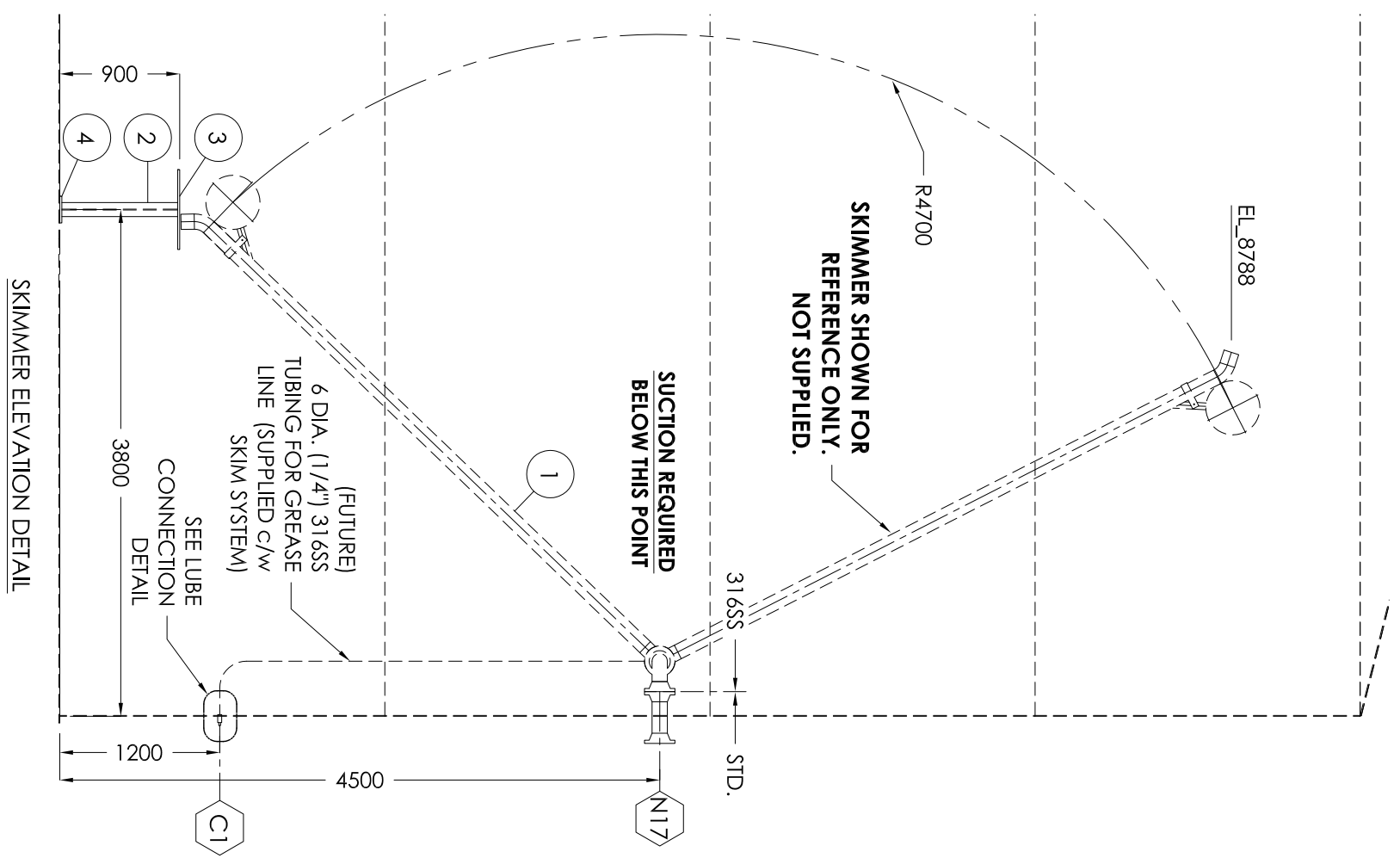
DATE: 09.18.12 TAG #: [] DRAWING #: B-9536_D3 REV. []

SHEET: 5 OF 14 SCALE: NTS SERIAL #: 9536

ARGO SALES LTD



THE SIZE OF THE WELD SHALL EQUAL THE THICKNESS OF THE THINNER MEMBERS JOINED.



DESIGN NOTES

1. ALL DIMENSIONS ARE IN mm.
2. ALL ELEVATIONS TAKEN FROM TOP OF TANK FLOOR
3. SKIMMER NOT SUPPLIED. DETAIL SHOWN IS FOR FUTURE REFERENCE ONLY.

REVISIONS

NO.	DESCRIPTION	BY	DATE
6	AS BUILT	M/G	12.08.14
5	ISSUED FOR FABRICATION	M/G	08.07.13
4	ISSUED FOR REVIEW / APPROVAL	M/G	06.28.13
3	ISSUED FOR REVIEW / APPROVAL	M/G	06.14.13
2	ISSUED FOR REVIEW / APPROVAL	M/G	05.03.13
1	ISSUED FOR REVIEW / APPROVAL	M/G	02.22.13
0	ISSUED FOR REVIEW / APPROVAL	M/G	09.18.12

BILL OF MATERIALS

MARK	QTY	MATL	DESCRIPTION	SERVICE
2	1	A36	SKIMMER SUPPORT COMPONENTS	
3	1	A36	15.8 THK. PL x 200 x 600 LG.	
4	1	A36	W100 x 19 I-BEAM	
1	1	A36	15.8 THK. PL x 200 x 200 LG.	
5	8	A36	CLIP BRACKETS	
6	8	A36	6.4 THK. PL x 102 x 158 LG.	
8	1	A36	6.4 THK. PL x 51 x 152 LG.	
7	1	316SS	C1-EXTERNAL LUBE LINE CONNECTION	
8	1	316SS	21 DIA. (1/2") 3000# NPT FULL COUPLING	
			1/2" TO 1/4" REDUCING BUSHING 3000# NPT w/ 1/4" PLUG	

CUSTOMER:

DEVON CANADA CORPORATION
PO# 410000658

TITLE:

MISC. DETAILS

APPROVED BY: _____ CHECKED BY: _____ PROJECT MNGR: RR

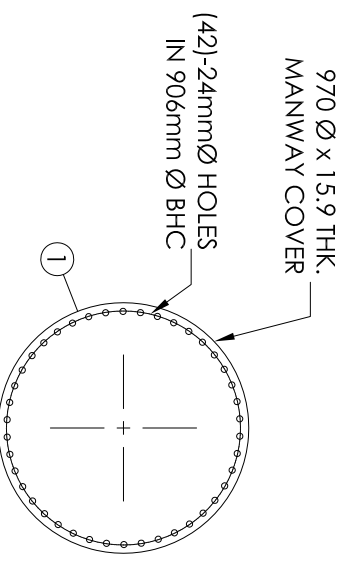
DATE: 06.03.13 TAG #: _____ DRAWING #: B-9536 D4

SHEET: 6 OF 14 SCALE: NTS SERIAL #: 9536

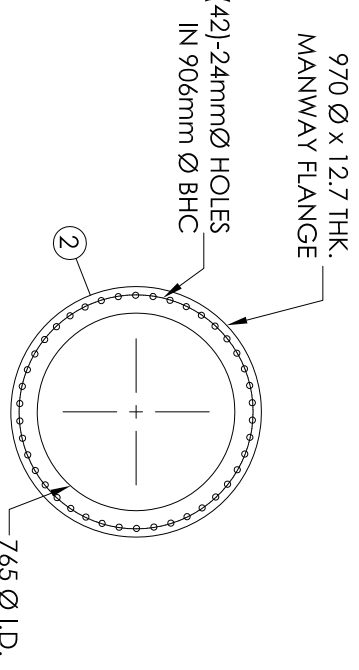
ARGO SALES LTD

BILL OF MATERIALS

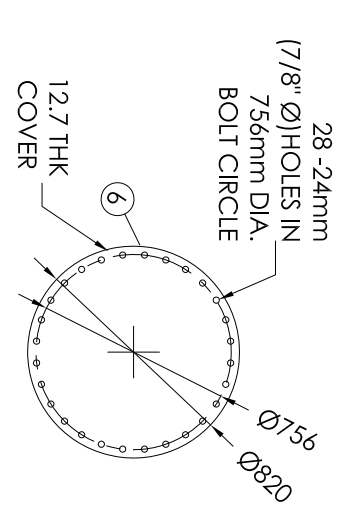
MARK	QTY	MATL	DESCRIPTION	SERVICE
			M2 - 30" MANWAY COMPONENTS	
1	1	A516GR 70N1	15.9 THK. x 970 DIA. (38 5/8") MANWAY COVER (LASER CUT PART)	
2	1	A516GR 70N1	12.7 THK. x 970 DIA. O.D. x 765 DIA. I.D. FLANGE	
3	1	38W	7.9 THK. x 762 DIA. (30") x 254 LG. MANWAY NECK	
4	2	A36	ARGO STD. MANWAY HANDLE	
5	1	38W	6.4 THK. x 1545 DIA. O.D. x DIA. 765 I.D. MANWAY REPAD	
5A	1		ARGO STD DAVIT ARM	
			M4 - 24" MANWAY COMPONENTS	
6	1	A516GR 70N1	12.7 THK. x 820 DIA. (38 5/8") MANWAY COVER (LASER CUT PART)	
7	1	38W	7.9 THK. x 820 DIA. O.D. x 612 DIA. I.D. FLANGE	
8	1	38W	6.4 THK. x 610 DIA. (24") x 234 LG. MANWAY NECK	
9	2	A36	ARGO STD. MANWAY HANDLE	
10	1	38W	6.4 THK. x 1255 DIA. O.D. x DIA. 613 I.D. MANWAY REPAD	
10A	1		ARGO STD DAVIT ARM	



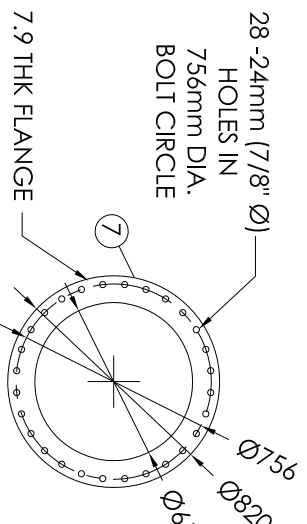
M2 - 30" SHELL MANWAY COVER DETAIL



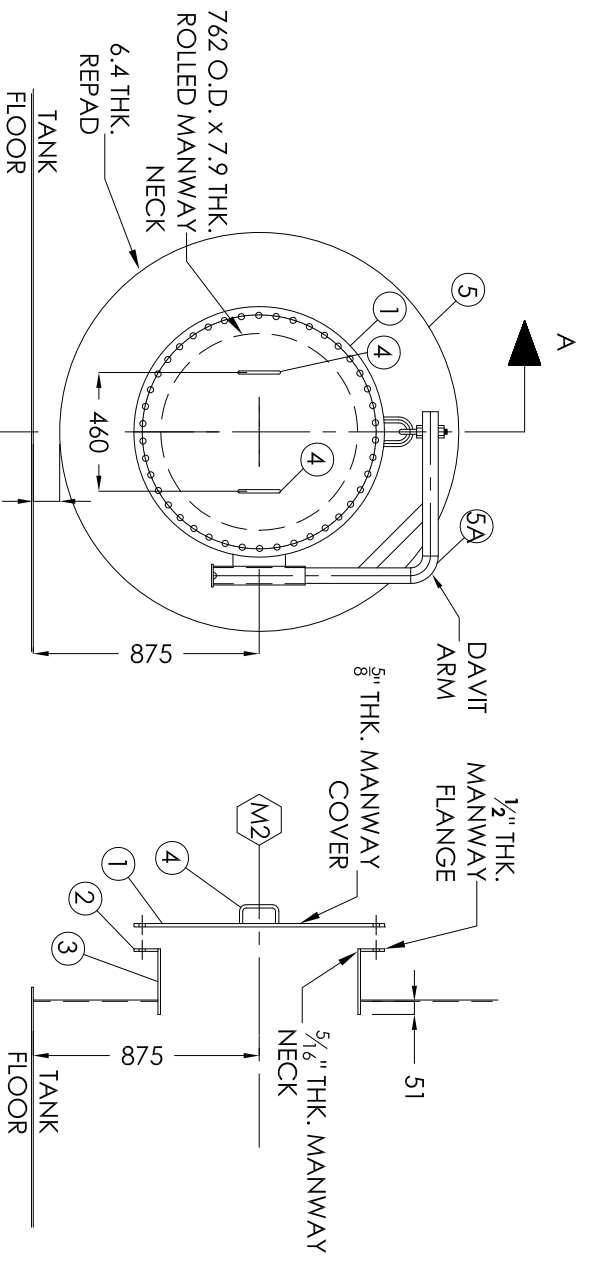
M2 - 30" SHELL MANWAY FLANGE DETAIL



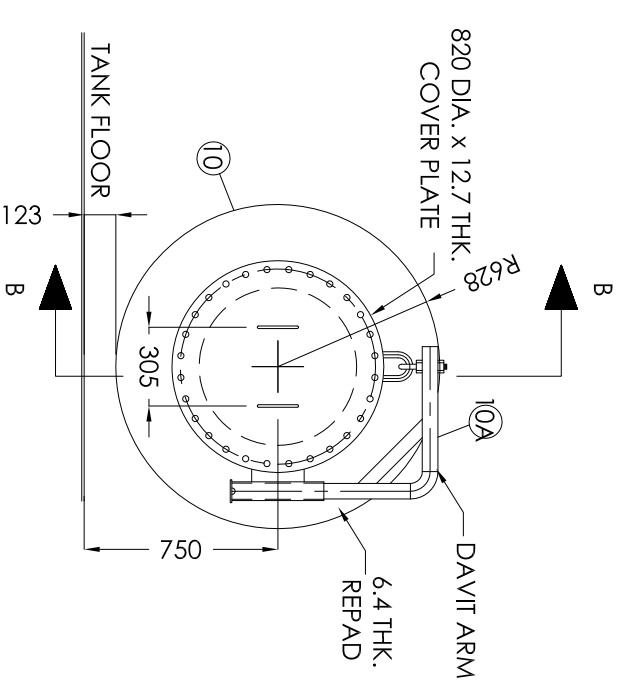
M4 - 24" SHELL MANWAY COVER DETAIL



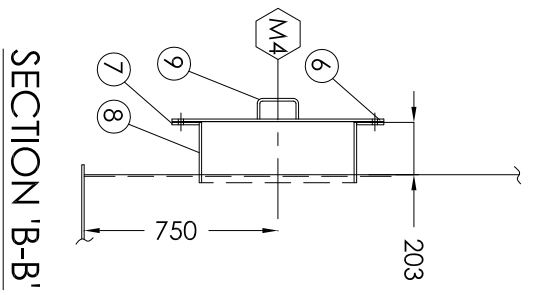
M4 - 24" FLANGE DETAIL



SECTION A-A DETAIL



M4 - 24" SHELL MANWAY DETAIL

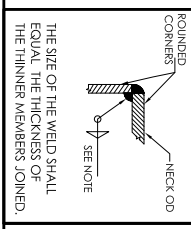


SECTION 'B-B'

M2 - 30" ROUND SHELL MANWAY DETAIL

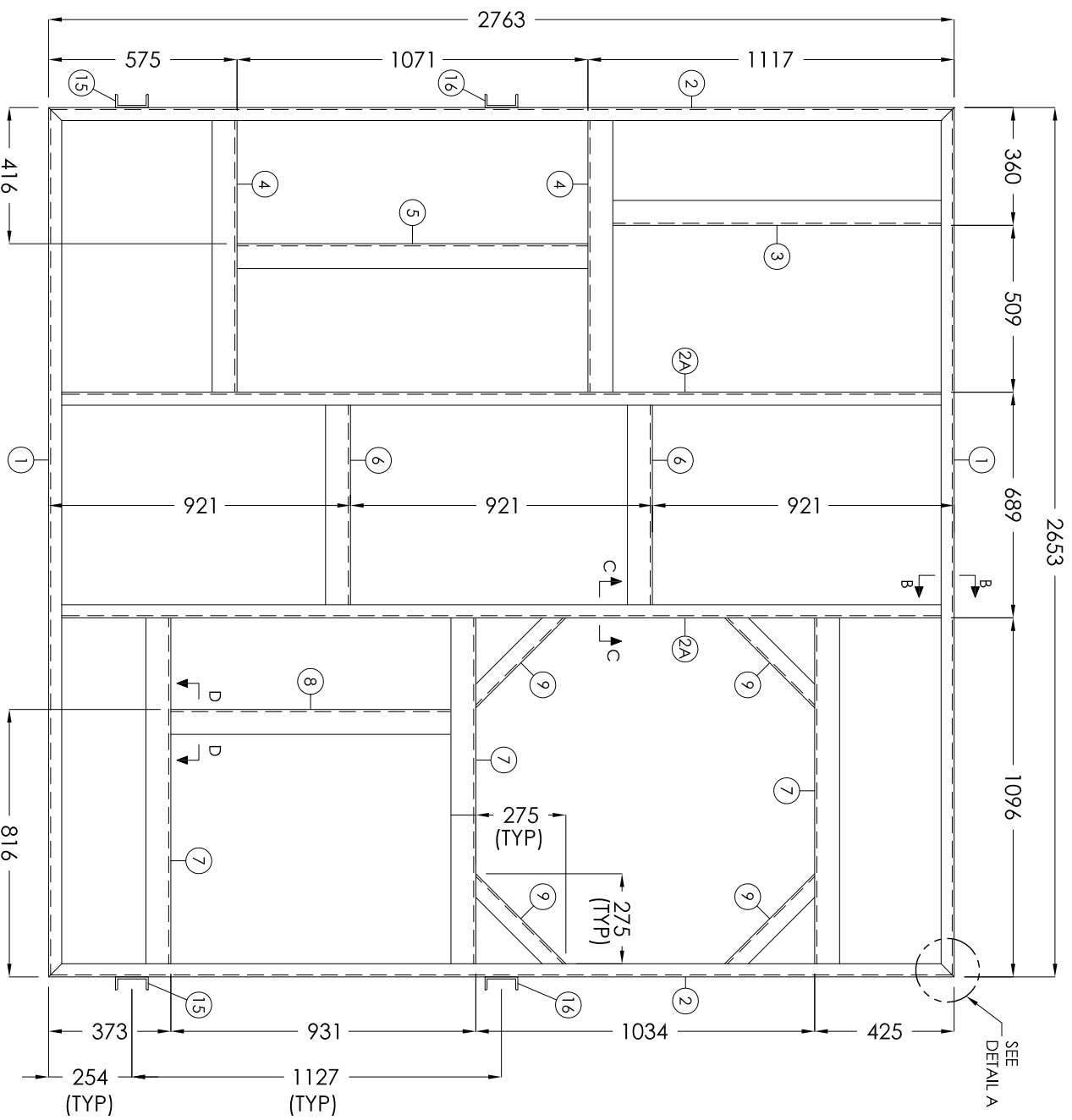
ROLL TO TANK O.D. - INCLUDE WEEP HOLES

FABRICATED FLG TO NECK	DESIGN NOTES
ARGO WPS: AS1.14	1. ALL DIMENSIONS ARE IN mm. 2. ALL ELEVATIONS TAKEN FROM TOP OF TANK FLOOR



NO.	DESCRIPTION	BY	DATE
7	AS BUILT	MG	12.08.14
6	ADD DAVIT ARM M2 & M4	CFP	02.04.14
5	ISSUED FOR FABRICATION	MG	08.07.13
4	ISSUED FOR REVIEW / APPROVAL	MG	06.28.13
3	ISSUED FOR REVIEW / APPROVAL	MG	06.14.13
2	ISSUED FOR REVIEW / APPROVAL	MG	05.03.13
1	ISSUED FOR REVIEW / APPROVAL	MG	02.22.13
0	ISSUED FOR REVIEW / APPROVAL	MG	09.18.12

CUSTOMER:	DEVON CANADA CORPORATION
PO #	4100000658
TITLE:	SHELL MANWAY DETAILS
APPROVED BY:	CHECKED BY:
DATE:	TAG #:
SHEET:	7 OF 14
SCALE:	NTS
PROJECT MANGR.	RR
DRAWING #:	B-9536.D5
SERIAL #:	9536



ROOF PLATFORM LAYOUT

DESIGN NOTES

1. ALL DIMENSIONS ARE IN mm.
2. ALL ELEVATIONS TAKEN FROM TOP OF TANK FLOOR.
3. ALL WELDING TO BE DONE TO LATEST REVISION OF CWB WPDS.
4. CWB SHOP SUPERVISORS SPECIFY WELDING PROCESS.
5. GRATING TO BE REMOVABLE & SECURED WITH MECHANICAL FASTENERS.
6. GRATING SHOULD BE BANDED AS NEEDED.

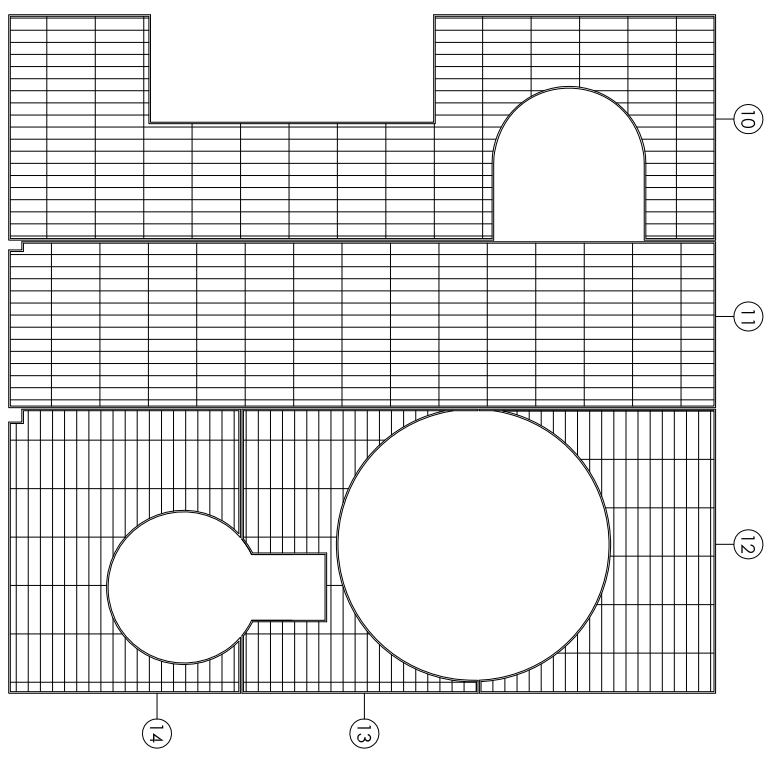
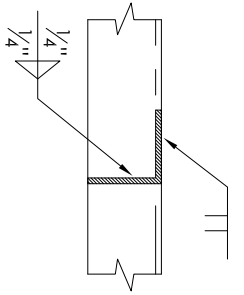
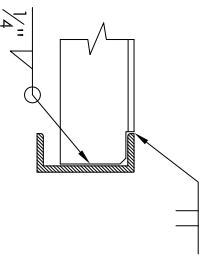
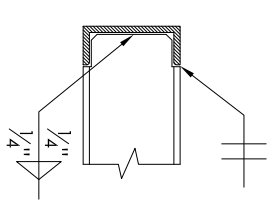
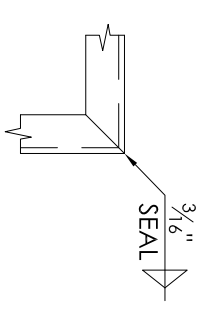
EXTERNAL FINISH

PLATFORM FINISH

BLAST: SSPC-SP6 COMMERCIAL BLAST
PRIMER: 4.0 - 8.0 MILS DFT DEVOE BAR-RUST 235 EPOXY
PAINT: 2.0 - 3.0 MILS DEVOE DEVIHANE 389 EPOXY URETHANE (COLOR: SAFETY YELLOW)

REVISIONS

NO.	DESCRIPTION	BY	DATE
7	AS BUILT	MG	12.08.14
6	REVISED ROOF PLATFORM	CFP	02.04.14
5	ISSUED FOR FABRICATION	MG	08.07.13
4	ISSUED FOR REVIEW / APPROVAL	MG	06.28.13
3	ISSUED FOR REVIEW / APPROVAL	MG	06.14.13
2	ISSUED FOR REVIEW / APPROVAL	MG	05.03.13
1	ISSUED FOR REVIEW / APPROVAL	MG	02.22.13
7	UPDATED EXTERNAL FINISH ONLY	CGC	05.12.14



BILL OF MATERIALS

MARK	QTY	MATL	DESCRIPTION	SERVICE
1	2	A36/44W	C100 x 8 CHANNEL x 2653 LG.	PLATFORM
2	2	A36/44W	C100 x 8 CHANNEL x 2763 LG.	PLATFORM
2A	2	A36/44W	C100 x 8 CHANNEL x 2751 LG.	PLATFORM
3	3	A36/44W	76 x 76 x 6.4 ANGLE 1105 LG.	
4	2	A36/44W	76 x 76 x 6.4 ANGLE 863 LG.	
5	1	A36/44W	76 x 76 x 6.4 ANGLE 1071 LG.	
6	2	A36/44W	76 x 76 x 6.4 ANGLE 876 LG.	
7	3	A36/44W	76 x 76 x 6.4 ANGLE 1090 LG.	
8	1	A36/44W	76 x 76 x 6.4 ANGLE 925 LG.	
9	4	A36/44W	76 x 76 x 6.4 ANGLE 437 LG.	
10	1	A36/44W	4.8 THK. x 25 SERRATED GRATING (SEE DWG. B-9536 RP2)	SERRATED GRATING
11	1	A36/44W	4.8 THK. x 25 SERRATED GRATING (SEE DWG. B-9536 RP2)	SERRATED GRATING
12	1	A36/44W	4.8 THK. x 25 SERRATED GRATING (SEE DWG. B-9536 RP2)	SERRATED GRATING
13	1	A36/44W	4.8 THK. x 25 SERRATED GRATING (SEE DWG. B-9536 RP2)	SERRATED GRATING
14	1	A36/44W	4.8 THK. x 25 SERRATED GRATING (SEE DWG. B-9536 RP2)	SERRATED GRATING
15	2	A36/44W	C100 x 8 CHANNEL x 664 LG.	PLATFORM LEG SUPPORT
16	2	A36/44W	C100 x 8 CHANNEL x 382 LG.	PLATFORM LEG SUPPORT

CUSTOMER: **DEVON CANADA CORPORATION**
PO# 4100006558

ROOF PLATFORM DETAILS

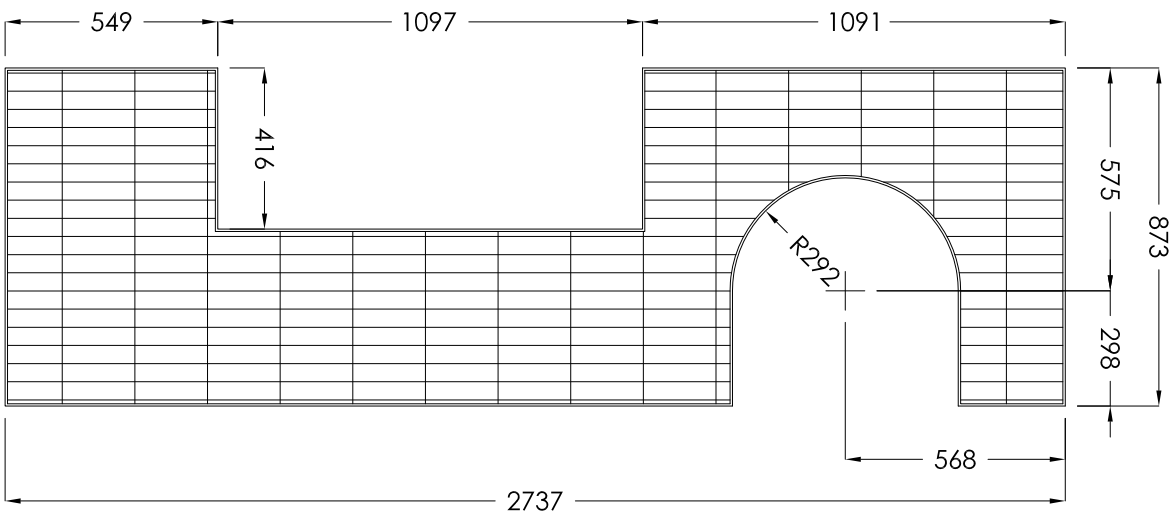
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APPROVED BY: _____ CHECKED BY: _____ PROJECT MNGR: RR

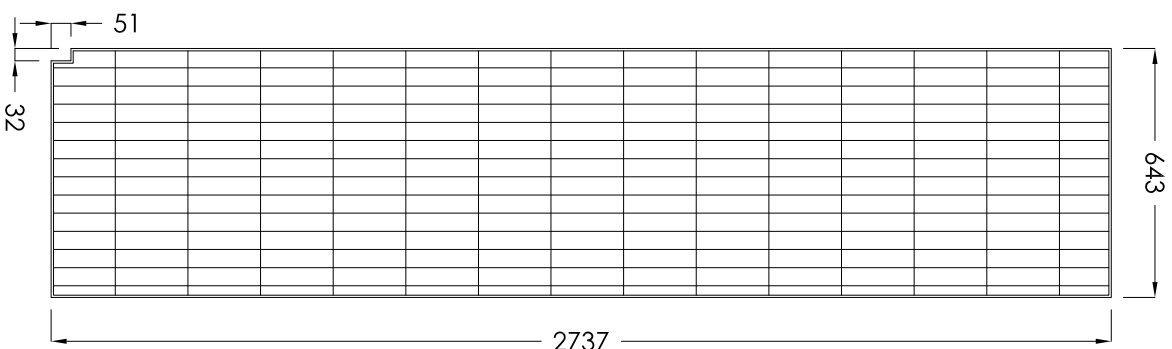
DATE: 03.04.13 TAG #: _____ DRAWING#: B-9536 RP1

SHEET: 8 OF 14 SCALE: _____ NTS SERIAL#: 9536

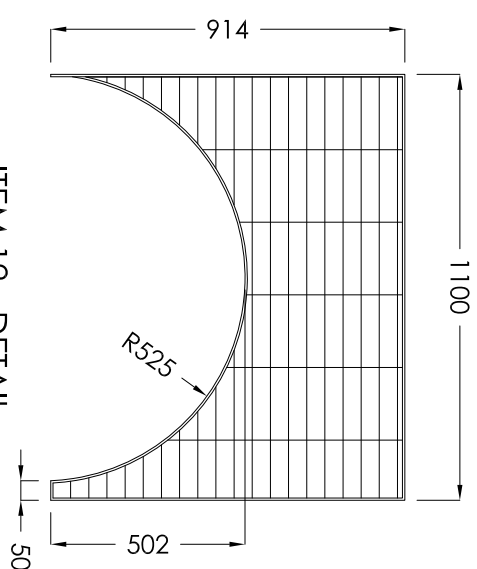
ARGO SALES LTD.



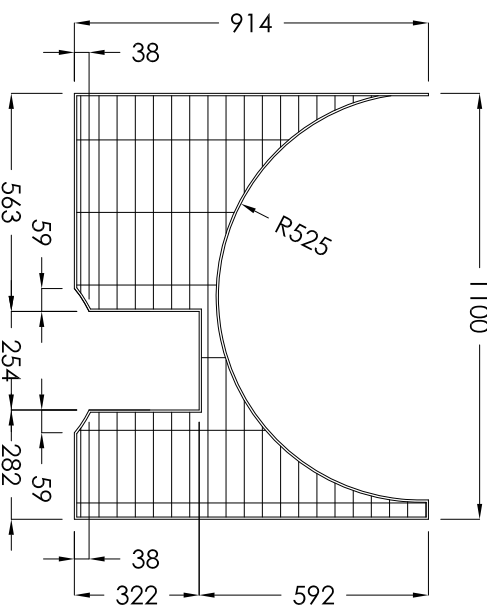
ITEM 10 - DETAIL



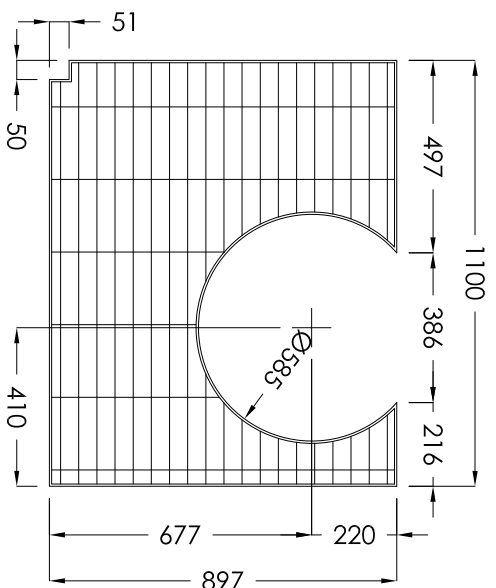
ITEM 11 - DETAIL



ITEM 12 - DETAIL



ITEM 13 - DETAIL



ITEM 14 - DETAIL

DESIGN NOTES

1. ALL DIMENSIONS ARE IN mm.
2. ALL ELEVATIONS TAKEN FROM TOP OF TANK FLOOR.
3. ALL WELDING TO BE DONE TO LATEST REVISION OF CWB WPDS.
4. CWB SHOP SUPERVISORS SPECIFY WELDING PROCESS.
5. GRATING TO BE REMOVABLE & SECURED WITH MECHANICAL FASTENERS.
6. GRATING SHOULD BE BANDED AS NEEDED.

EXTERNAL FINISH

PLATFORM FINISH

BLAST: SSPC-SP6 COMMERCIAL BLAST
 PRIMER: 4.0 - 8.0 MILS DFT DEVOLVE BAR-RUST 235 EPOXY
 PAINT: 2.0 - 3.0 MILS DEVOLVE DEVTHANE 389 EPOXY URETHANE
 (COLOR: SAFETY YELLOW)

REVISIONS

NO.	DESCRIPTION	BY	DATE
7	AS BUILT	MG	12.08.14
6	REVISED ROOF PLATFORM DESIGN	MG	02.04.14
5	ISSUED FOR FABRICATION	MG	08.07.13
4	ISSUED FOR REVIEW / APPROVAL	MG	06.28.13
3	ISSUED FOR REVIEW / APPROVAL	MG	06.14.13
2	ISSUED FOR REVIEW / APPROVAL	MG	05.03.13
1	ISSUED FOR REVIEW / APPROVAL	MG	02.22.13
7	UPDATED EXTERNAL FINISH ONLY	CGC	05.12.14

CUSTOMER: DEVON CANADA CORPORATION
 PO# 4100000658

TITLE: PLATFORM GRATING DETAILS

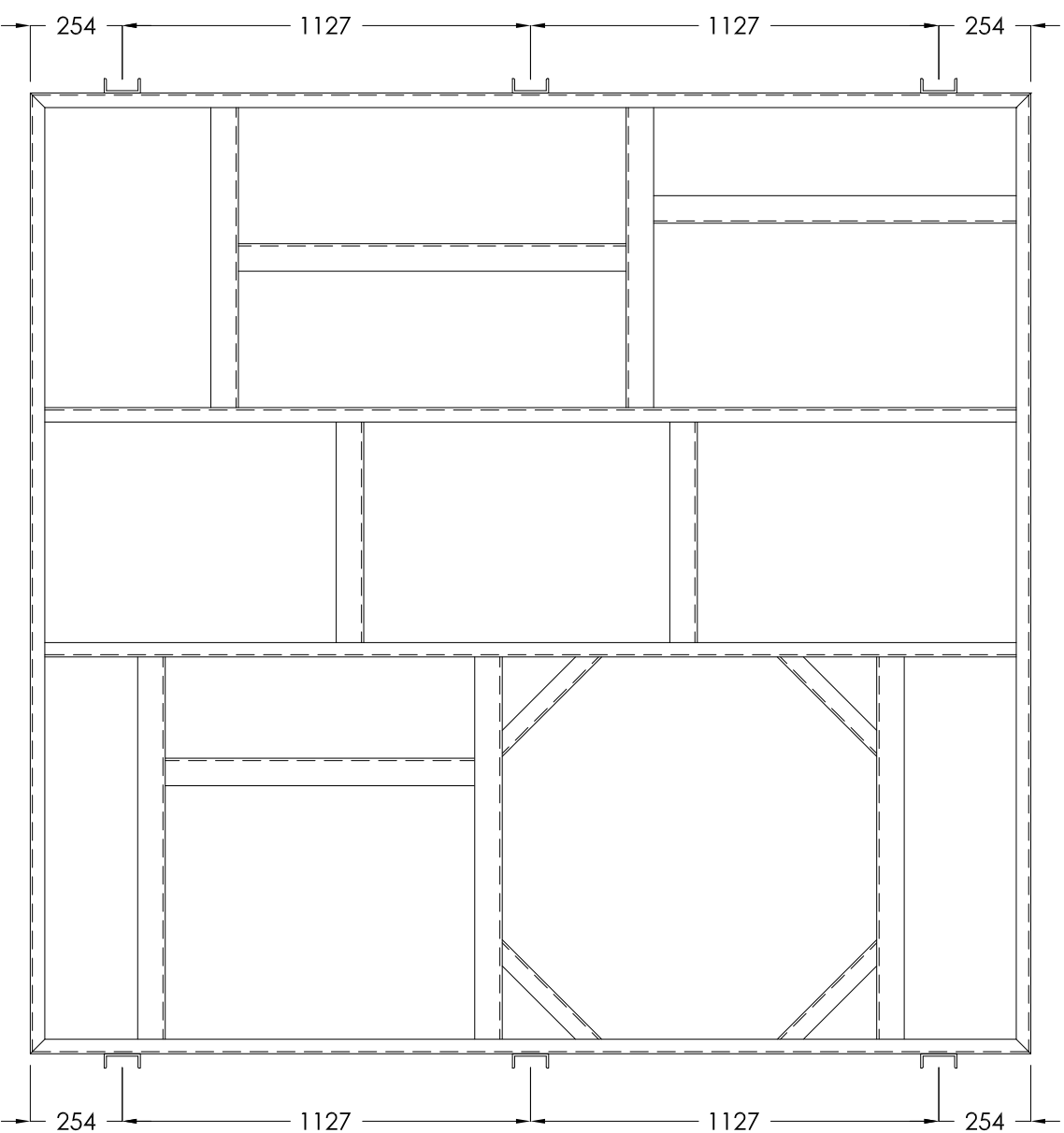
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 DATE: 03.04.13

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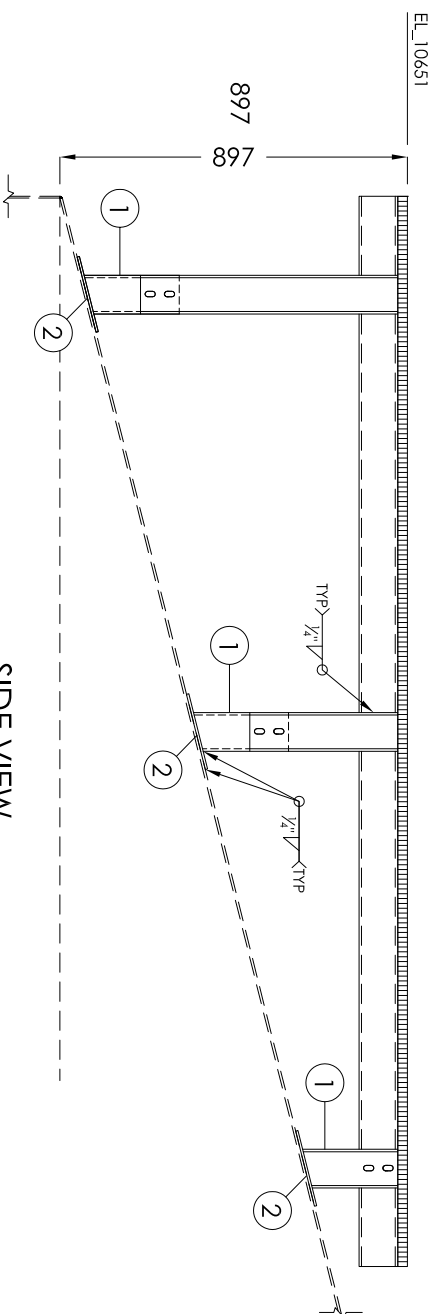
SHEET: 9 OF 14

SCALE: NTS

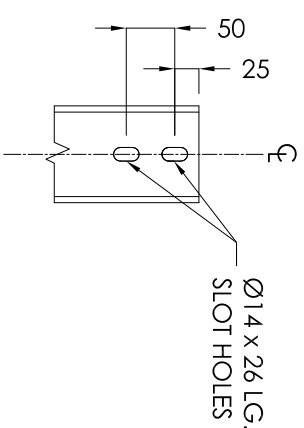
PROJECT MANGR: RR
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 SERIAL#: 9536



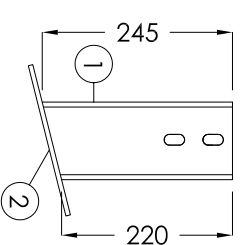
PLAN VIEW



SIDE VIEW



SLOT HOLE DETAIL (TYP)



ITEM 1 DETAIL

DESIGN NOTES

1. ALL DIMENSIONS ARE IN mm.
2. ALL ELEVATIONS TAKEN FROM TOP OF TANK FLOOR.
3. ALL WELDING TO BE DONE TO LATEST REVISION OF CWB WPDs.
4. CWB SHOP SUPERVISORS SPECIFY WELDING PROCESS.
5. GRATING TO BE REMOVABLE & SECURED WITH MECHANICAL FASTENERS.
6. GRATING SHOULD BE BANDED AS NEEDED.

EXTERNAL FINISH

PLATFORM FINISH

BLAST: SSPC-SP8 COMMERCIAL BLAST
 PRIMER: 4.0 - 8.0 MILS DEVE BAR-RUST 235 EPOXY
 PAINT: 2.0 - 3.0 MILS DEVE DEVTHANE 389 EPOXY URETHANE
 (COLOR: SAFETY YELLOW)

REVISIONS

NO.	DESCRIPTION	BY	DATE
7	AS BUILT	MG	12.08.14
6	REVISED ROOF PLATFORM DESIGN	MG	02.04.14
5	ISSUED FOR FABRICATION	MG	08.07.13
4	ISSUED FOR REVIEW / APPROVAL	MG	06.28.13
3	ISSUED FOR REVIEW / APPROVAL	MG	06.14.13
2	ISSUED FOR REVIEW / APPROVAL	MG	05.03.13
1	ISSUED FOR REVIEW / APPROVAL	MG	02.22.13
7	UPDATED EXTERNAL FINISH ONLY	CGC	05.12.14

BILL OF MATERIALS

MARK	QTY	MATL	DESCRIPTION	SERVICE
1	6	A36/44W	PLATFORM SUPPORT	
2	6	A36	C100 X 8 CHANNEL X 245 LG. 6.4 THK. 200 X 200 REPAD	

CUSTOMER: DEVON CANADA CORPORATION
 PO# 4100000658

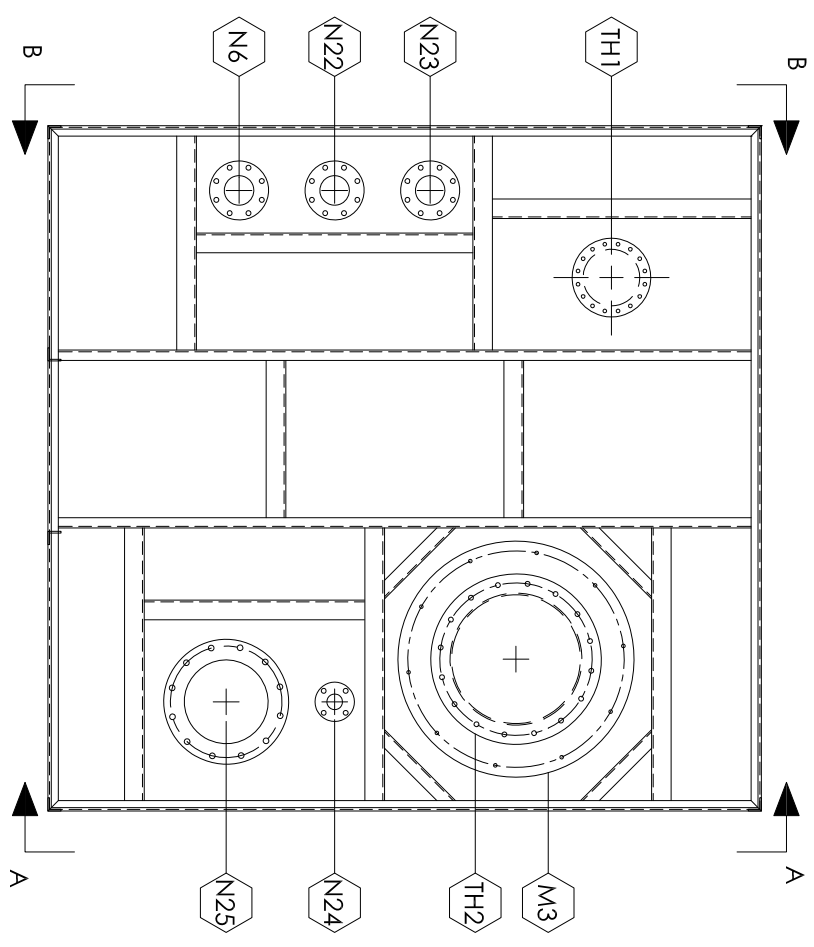
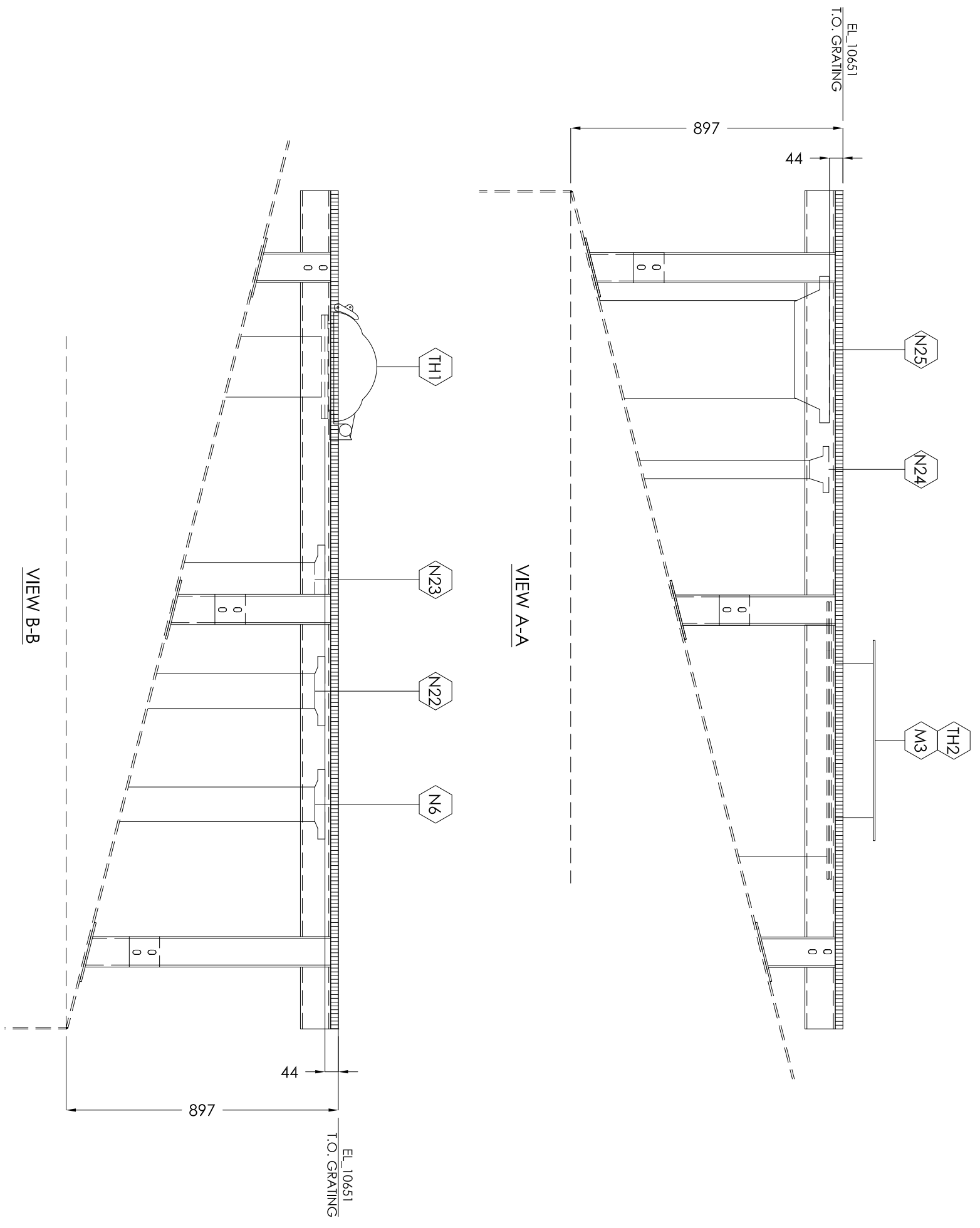
TITLE: ROOF PLATFORM ASSEMBLY DETAIL

APPROVED BY: _____ DATE: 01.09.13 TAG #: _____

CHECKED BY: _____ PROJECT MANGR: RR

DRAWING#: B-9536.RP3

SHEET: 10 OF 14 SCALE: NTS SERIAL#: 9536



PLAN VIEW

DESIGN NOTES

1. ALL DIMENSIONS ARE IN mm.
2. ALL ELEVATIONS TAKEN FROM TOP OF TANK FLOOR.
3. ALL WELDING TO BE DONE TO LATEST REVISION OF CWB WPDS.
4. CWB SHOP SUPERVISORS SPECIFY WELDING PROCESS.
5. GRATING TO BE REMOVABLE & SECURED WITH MECHANICAL FASTENERS.
6. GRATING SHOULD BE BANDED AS NEEDED.

EXTERNAL FINISH

PLATFORM FINISH

BLAST: SSPC-SP6 COMMERCIAL BLAST
 PRIMER: 4.0 - 8.0 MILS DFT DEVCOE BAR-RUST 235 EPOXY
 PAINT: 2.0 - 3.0 MILS DEVCOE DEVIHANE 389 EPOXY URETHANE
 (COLOR: SAFETY YELLOW)

REVISIONS

NO.	DESCRIPTION	BY	DATE
7	AS BUILT	MG	12.08.14
6	REVISED ROOF PLATFORM DESIGN	MG	02.04.14
5	ISSUED FOR FABRICATION	MG	08.07.13
4	ISSUED FOR REVIEW / APPROVAL	MG	06.28.13
3	ISSUED FOR REVIEW / APPROVAL	MG	06.14.13
2	ISSUED FOR REVIEW / APPROVAL	MG	05.03.13
1	ISSUED FOR REVIEW / APPROVAL	MG	02.22.13
7	UPDATED EXTERNAL FINISH ONLY	CGC	05.12.14

CUSTOMER: DEVON CANADA CORPORATION
 PO# 410000658

TITLE: ROOF PLATFORM ASSEMBLY DETAIL

APPROVED BY: [Signature] **CHECKED BY:** [Signature]

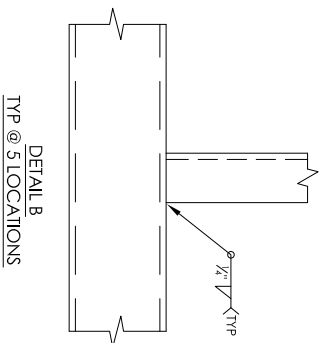
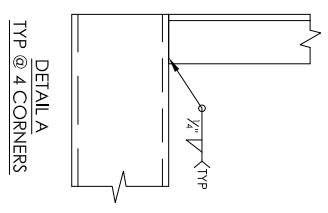
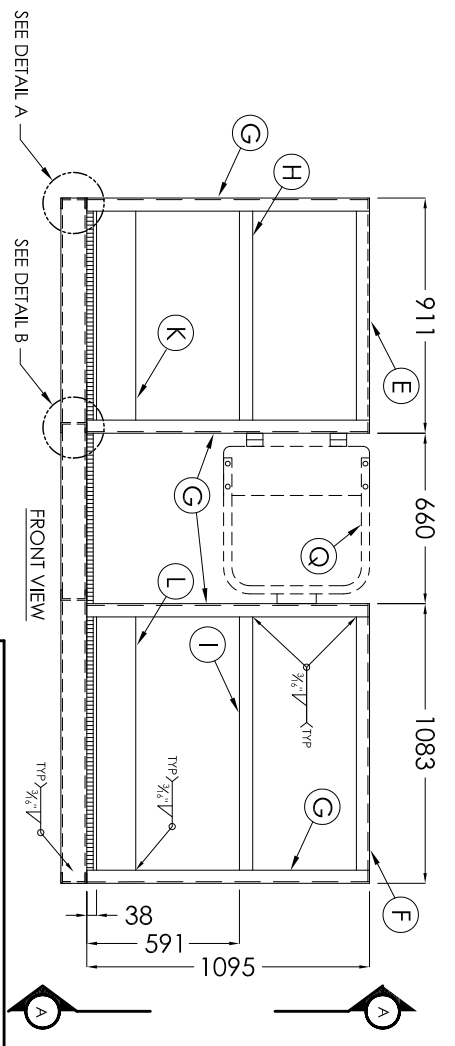
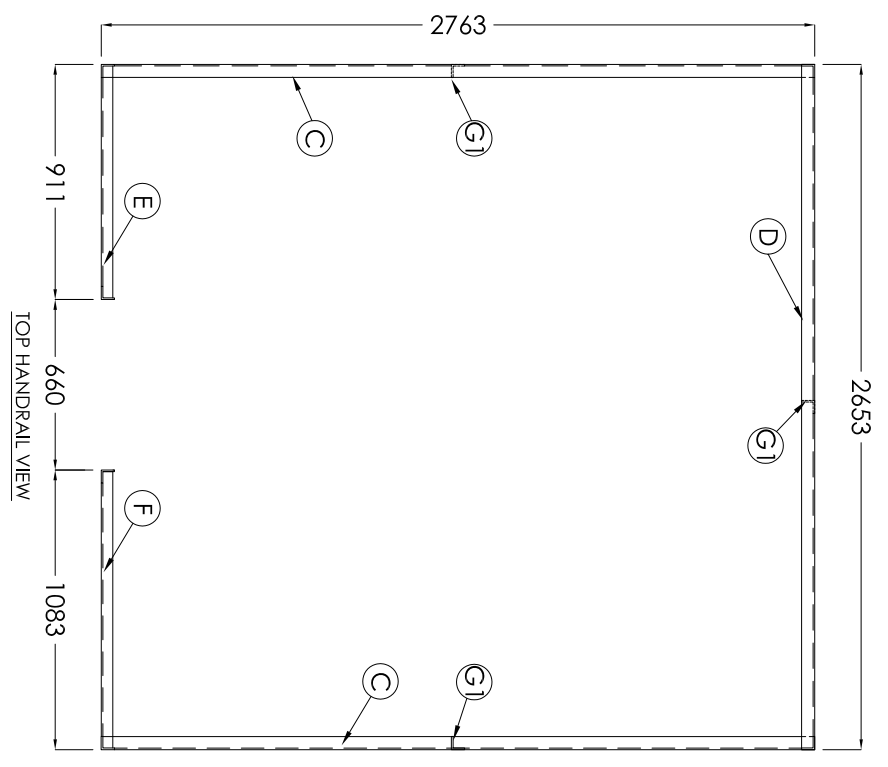
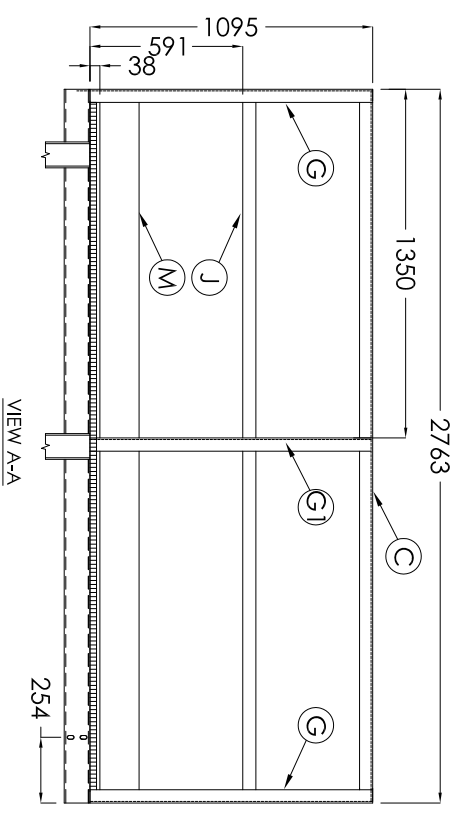
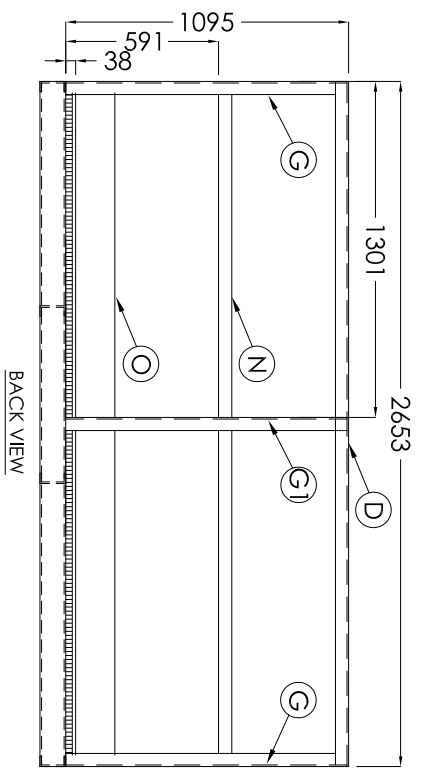
DATE: 01.09.13 **TAG #:** [Blank]

SHEET: 11 OF 14 **SCALE:** NTS

PROJECT MANGR: RR **DRAWING#:** B-9536, RP4

REV.: [Blank]

SERIAL#: 9536



- DESIGN NOTES**
1. ALL DIMENSIONS ARE IN mm.
 2. ALL ELEVATIONS TAKEN FROM TOP OF TANK FLOOR.
 3. ALL WELDING TO BE DONE TO LATEST REVISION OF CWB WPDS.
 4. CWB SHOP SUPERVISORS SPECIFY WELDING PROCESS.
 5. GRATING TO BE REMOVABLE & SECURED WITH MECHANICAL FASTENERS.
 6. GRATING SHOULD BE BANDED AS NEEDED.

EXTERNAL FINISH

PLATFORM FINISH

BLAST: SSPC-SP4 COMMERCIAL BLAST
PRIMER: 4.0 - 8.0 MILS DFT DEVCO BAR-RUST 235 EPOXY
PAINT: 2.0 - 3.0 MILS DEVCO DEVTHANE 399 EPOXY URETHANE
(COLOR: SAFETY YELLOW)

REVISIONS

NO.	DESCRIPTION	BY	DATE
7	AS BUILT	MG	12.08.14
6	REVISED DETAIL	CFP	02.04.14
5	ISSUED FOR FABRICATION	MG	08.07.13
4	ISSUED FOR REVIEW / APPROVAL	MG	06.28.13
3	ISSUED FOR REVIEW / APPROVAL	MG	06.14.13
2	ISSUED FOR REVIEW / APPROVAL	MG	05.03.13
1	ISSUED FOR REVIEW / APPROVAL	MG	02.22.13
7	UPDATED EXTERNAL FINISH ONLY	CGC	05.12.14

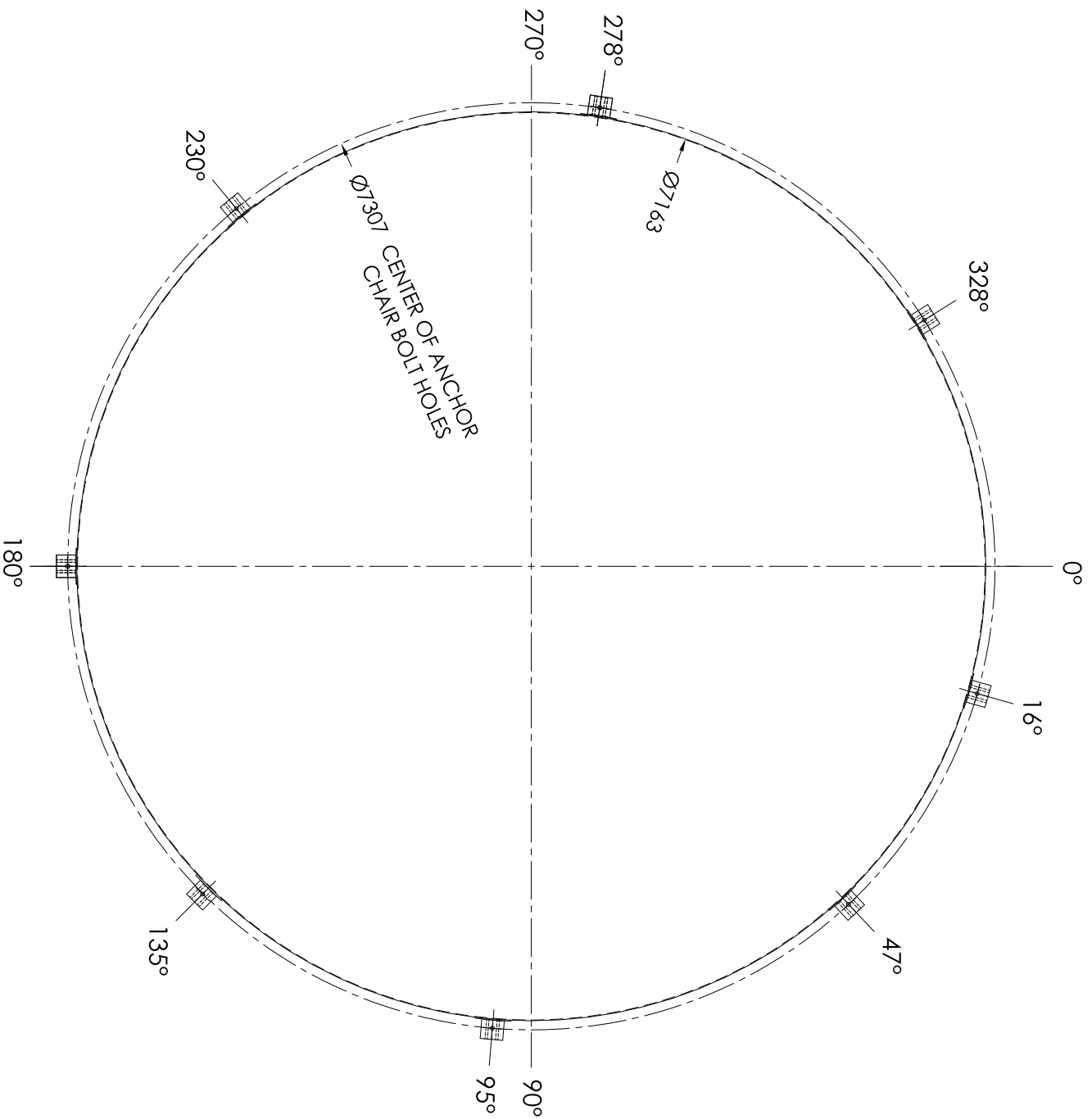
BILL OF MATERIALS

MARK	QTY	MAT'L	DESCRIPTION	SERVICE
C	2	A36/44W	6.4 THK. X 51 X 51 X 2750 LG. ANGLE	TOP SIDE HANDRAIL
D	1	A36/44W	6.4 THK. X 51 X 51 X 2640 LG. ANGLE	TOP BACK HANDRAIL
E	1	A36/44W	6.4 THK. X 51 X 51 X 898 LG. ANGLE	TOP FRONT HANDRAIL
F	1	A36/44W	6.4 THK. X 51 X 51 X 1070 LG. ANGLE	TOP FRONT HANDRAIL
G	6	A36/44W	6.4 THK. X 51 X 51 X 1089 LG. ANGLE	VERT. POST
G1	3	A36/44W	6.4 THK. X 51 X 1089 LG. ANGLE	MID VERT. POST
H	1	A36/44W	6.4 THK. X 51 X 898 LG. FLAT BAR	MID FRONT HANDRAIL
I	1	A36/44W	6.4 THK. X 51 X 1070 LG. FLAT BAR	MID FRONT HANDRAIL
J	1	A36/44W	6.4 THK. X 51 X 2750 LG. FLAT BAR	MID SIDE HANDRAIL
K	1	A36/44W	6.4 THK. X 51 X 898 LG. KICK PLATE	MID SIDE HANDRAIL
L	1	A36/44W	6.4 THK. X 152 X 1070 LG. KICK PLATE	FRONT KICK PLATE
M	2	A36/44W	6.4 THK. X 152 X 2750 LG. KICK PLATE	FRONT KICK PLATE
N	1	A36/44W	6.4 THK. X 51 X 2640 LG. FLAT BAR	SIDE KICK PLATE
O	1	A36/44W	6.4 THK. X 152 X 2640 LG. KICK PLATE	MID BACK HANDRAIL
Q	1		SAFETY GATE	SIDE BACK PLATE

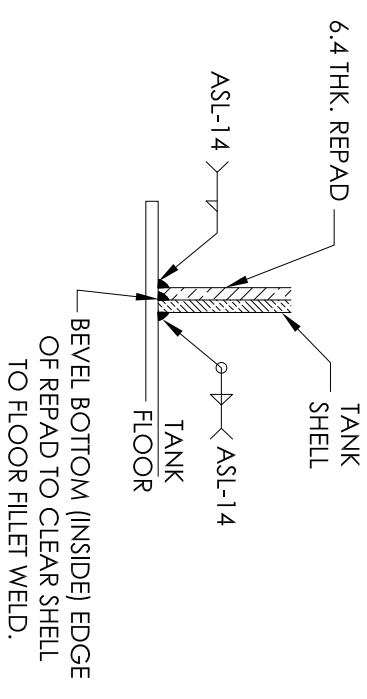
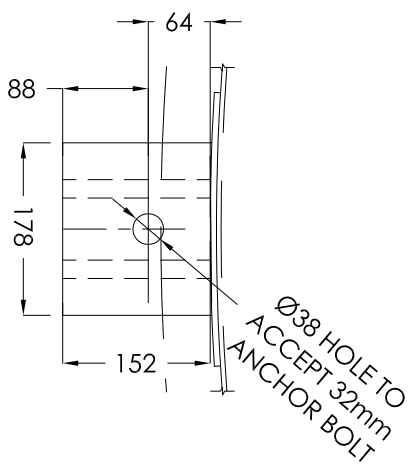
CUSTOMER: DEVON CANADA CORPORATION
PO# 4100000658

TITLE: ROOF PLATFORM HANDRAIL DETAILS

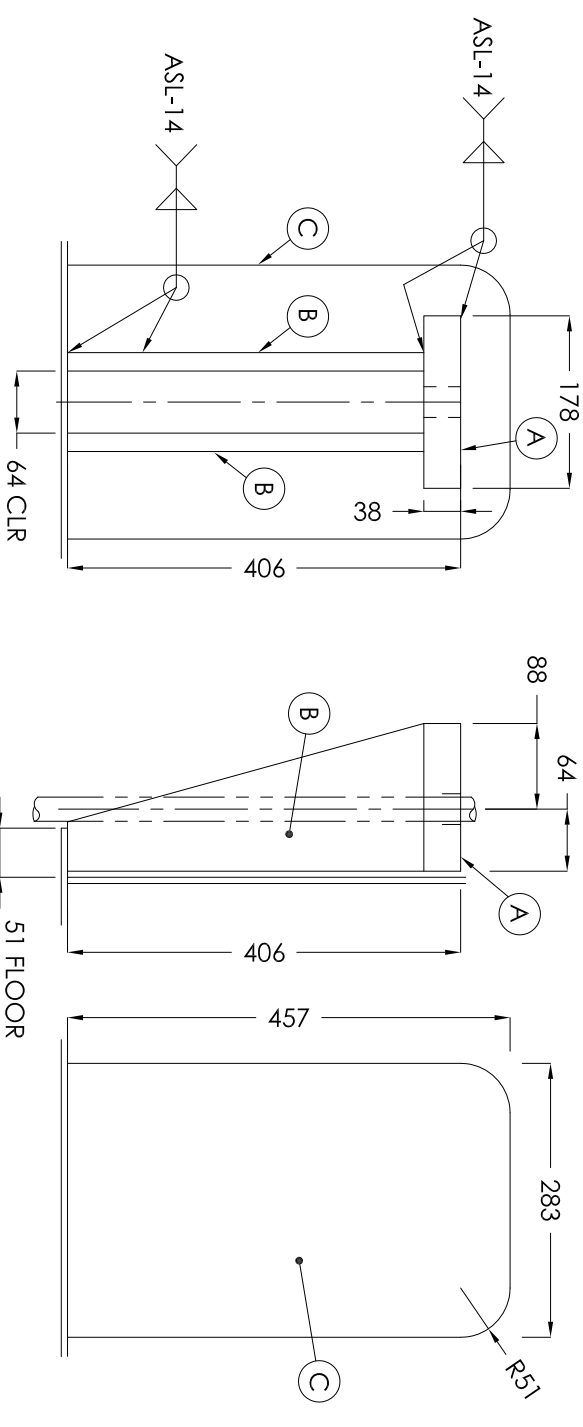
APPROVED BY: 03.04.13
CHECKED BY: TAG #:
DATE: 12 OF 14
SHEET: SCALE: NTS SERIAL#: 9536



ANCHOR CHAIR LAYOUT



REPAD TO FLOOR DETAIL



ANCHOR CHAIR DETAIL

TYPICAL @ 8 LOCATIONS
 ** TRIM FLOOR LIP IF NECESSARY TO ENSURE CLEARANCE OF BOLT HOLE

DESIGN NOTES

1. ALL DIMENSIONS ARE IN mm.
2. ANCHOR BOLTS TO BE SUPPLIED AND INSTALLED IN FOUNDATION BY OTHERS.

EXTERNAL FINISH

1. EXTERNAL FINISH
- BLAST: SSPC-SP6 COMMERCIAL BLAST
 - PRIMER: 4.0 - 8.0 MILS DFT DEVCO BAR-RUST 231 EPOXY
 - PAINT: 2.0 - 3.0 MILS DEVCO DEVTHANE 378 EPOXY URETHANE (COLOR: LIGHT GRAY FS16376)

REVISIONS

NO.	DESCRIPTION	BY	DATE
6	AS BUILT	MG	12.08.14
5	ISSUED FOR FABRICATION	MG	08.07.13
4	ISSUED FOR REVIEW / APPROVAL	MG	06.28.13
3	ISSUED FOR REVIEW / APPROVAL	MG	06.14.13
2	ISSUED FOR REVIEW / APPROVAL	MG	05.03.13
1	ISSUED FOR REVIEW / APPROVAL	MG	02.22.13
0	ISSUED FOR REVIEW / APPROVAL	MG	09.18.12

BILL OF MATERIALS

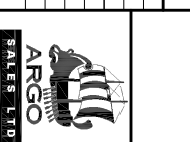
MARK	QTY	MATL	DESCRIPTION	SERVICE
A	8	AS16 GR 70	38 THK PL. x 178 x 152 LG. C/W HOLE (LASER CUT PART)	
B	16	AS16 GR 70	19 THK. PL. (LASER CUT PROFILE)	
C	8	38W	6.4 THK. x 283 x 457 REPAD	

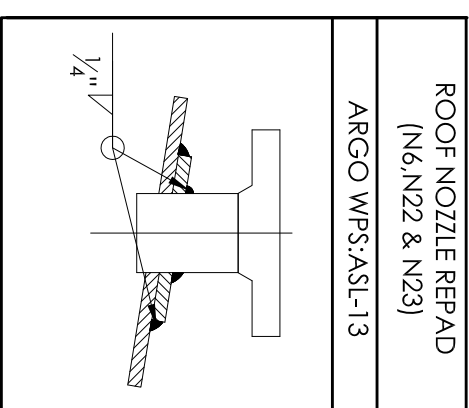
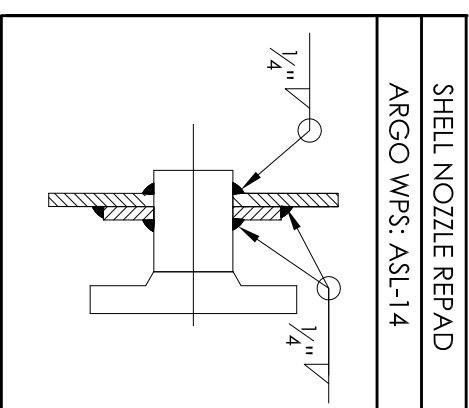
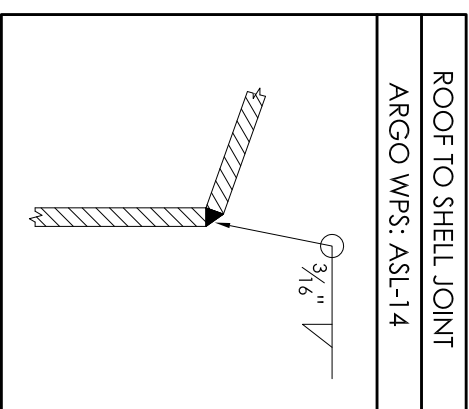
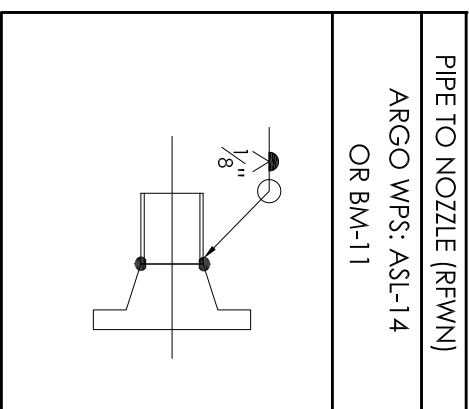
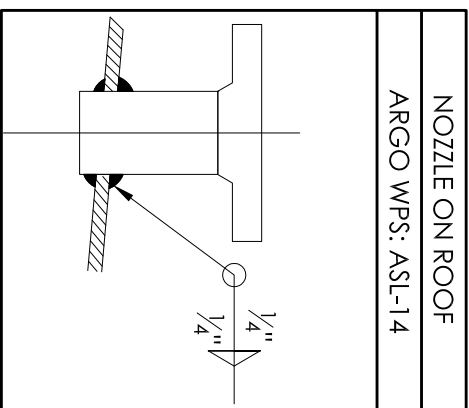
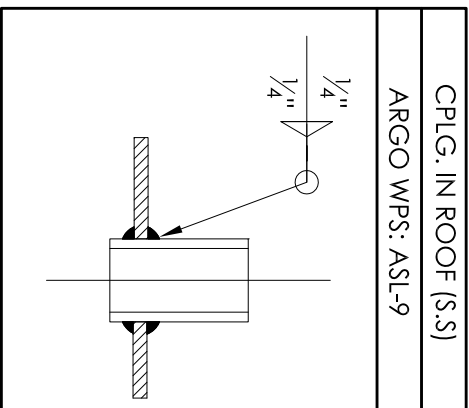
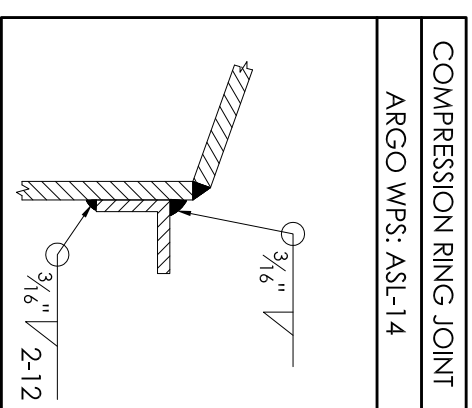
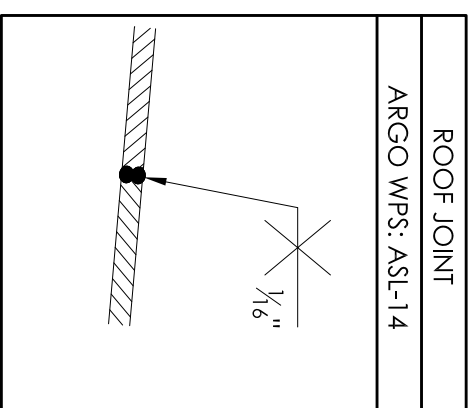
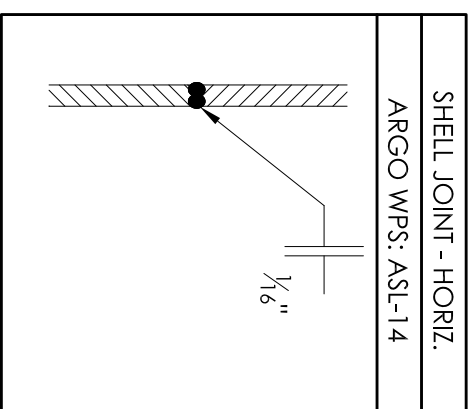
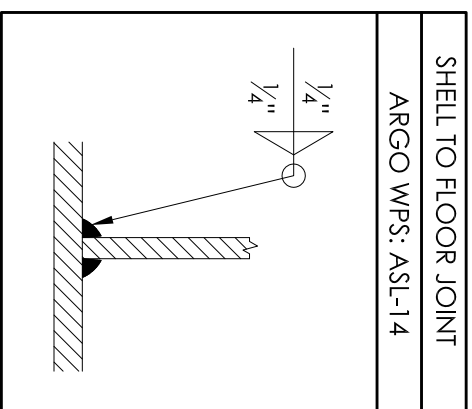
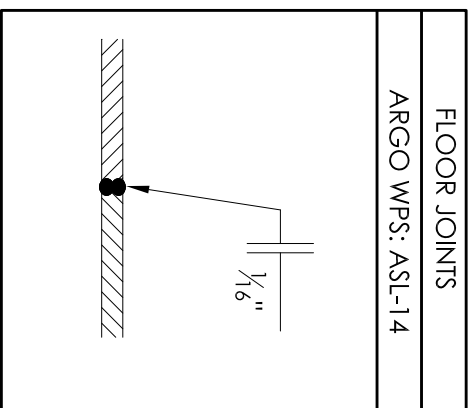
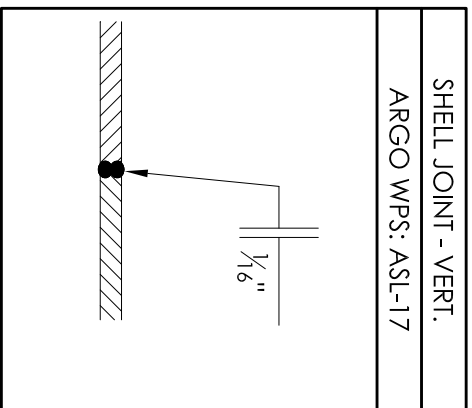
CUSTOMER: DEVON CANADA CORPORATION
 PO# 4100000658

TITLE:

ANCHOR CHAIRS LAYOUT AND DETAILS

APPROVED BY:	CHECKED BY:	PROJECT MANGR.	RR
DATE: 09.18.12	TAG #:	DRAWING#:	B-9536 AN
SHEET: 13 OF 14	SCALE:	NITS	SERIAL#:
9536			





NOTE: ROOF TO SHELL JOINT TO BE CORNER TO CORNER TYPE AS PER API 650 NOT ARGO STANDARD. SEE ROOF TO SHELL JOINT WELD DETAILS.

WELDING NOTES

1. E7024 WELDING ROD HAS BEEN PROHIBITED.
2. FILLET WELD SIZES ARE DETERMINE BY THE SMALLEST THICKNESS OF THE TWO ITEMS WELDED TOGETHER UNLESS OTHERWISE NOTED.
3. ALL EDGES TO BE RADIUS AND PREPARED FOR INTERNAL COATING
4. ALL ATTACHMENT WELDS TO BE 1/4" FILLET UNLESS OTHERWISE NOTED

CUSTOMER:

DEVON CANADA CORPORATION
PO# 4100000658

TITLE:

3rd PARTY INSPECTOR

MEISSA KOBITZ
PH: 780-887-9346

REVISIONS

NO.	DESCRIPTION	BY	DATE
7	AS BUILT	MG	12.08.14
6	ADD WELD DETAIL	CFP	02.04.14
5	ISSUED FOR FABRICATION	MG	08.07.13
4	ISSUED FOR REVIEW / APPROVAL	MG	06.28.13
3	ISSUED FOR REVIEW / APPROVAL	MG	06.14.13
2	ISSUED FOR REVIEW / APPROVAL	MG	05.03.13
1	ISSUED FOR REVIEW / APPROVAL	MG	02.22.13
0	ISSUED FOR REVIEW / APPROVAL	MG	09.18.12

WELDING DETAILS & NOTES

APPROVED BY: _____

DATE: 09.18.12

CHECKED BY: _____

TAG #: _____

PROJECT MANGR. RR

DRAWING#: B-9536_WD

SCALE: NTS

SHEET: 14 OF 14

REV. 7

ARGO SALES LTD