

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

① 546397

1. Manufactured and certified by OpSCO Energy Industries Ltd., 285175 Kleysen Way, RR5, Calgary AB T2P 2G6
 (Name and address of manufacturer)
 2. Manufactured for ORBAN INDUSTRIES LTD.
 (Name and address of purchaser)
 3. Location of installation STOCK
 (Name and address)
 4. Type Horiz., Blowcase 22-4488-1 T5423.21 05-328-C.R.1 N/A 2006
 (Horiz or vert. tank) (Mfg'r 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 specification of the ASME BOILER AND PRESSURE VESSEL CODE. The design, construction, and workmanship conform to ASME Rules, Section VIII, Division 1 2004 ED.
 Year

to 05 ADD N/A N/A
 Addenda (date) Code Case Nos. Special service per UG-1 20(d)

6. Shell: SA-516-70 N 1.125" 0.0625" 2'-9.75" ID 16'-0"
 Mat'l (Spec. No., Grade) Nominal Thk. (in.) Corr. Allow. (in.) Diam. I.D. (ft. & in.) Length (overall) (ft. & in.)

7. Seams: Type 1 Full N/A N/A Type 1 *Spot 70%
 Long (Welded Dbl. Sngl., Lap, Butt) R.T. (Spot or Full) Eff. (%) H.T. Temp. (F) Time (hr) Girth (Welded Dbl., Sngl., Lap, Butt) R.T. (Spot, Eff. (%) or Full) No. of Courses

8. Heads: (a) Mat'l SA-516-70 N (b) Mat'l 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 Pres (Con c/Co nv)
(a)	<u>Both Ends</u>	<u>1.09"</u>	<u>0.0625"</u>			<u>2:1</u>				<u>Concave</u>
(b)										

if removable, bolts used (describe other fasteners)

9. MAWP 1200 N/A psi at max. temp 150 N/A °F
 (Internal) (External) (Internal) (External)
 Min. Design Metal Temp. **20 °F at 1200 Psi Hydro., pneu, or comb. test 1560 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
<u>Inlet/Outlet</u>	<u>2</u>	<u>3"</u>	<u>CI 600 RFWN</u>	<u>SA-106B/SA-105N</u>	<u>.600"</u>	<u>Integral</u>	<u>Fig. UW-16.1(c)</u>	<u>Shell</u>
<u>LCH/LCL</u>	<u>2</u>	<u>3"</u>	<u>CI 600 RFHB</u>	<u>SA-105N</u>	<u>1.24</u>	<u>Integral</u>	<u>Fig. UW-16.1(c)</u>	<u>Shell</u>
<u>Drain</u>	<u>1</u>	<u>2"</u>	<u>CI 6000 RFWN</u>	<u>SA-106B/SA-234WPB/SA-105N</u>	<u>.436"</u>	<u>Integral</u>	<u>Fig. UW-16.1(c)</u>	<u>Shell</u>
<u>CLEAN OUT</u>	<u>1</u>	<u>8"</u>	<u>CI 600 RFHB</u>	<u>SA-105N</u>	<u>2.16"</u>	<u>Integral</u>	<u>Fig. UW-16.1(c)</u>	<u>Shell</u>
<u>Insp/SPARE</u>	<u>2</u>	<u>2"</u>	<u>CPLG</u>	<u>SA-105 N</u>	<u>6000#</u>	<u>Integral</u>	<u>Fig. UW-16.1(c)</u>	<u>Shell</u>
<u>EQUALIZER/LG</u>	<u>3</u>	<u>1.5"</u>	<u>CPLG</u>	<u>SA-105 N</u>	<u>6000#</u>	<u>Integral</u>	<u>Fig. UW-16.1(c)</u>	<u>Shell</u>
<u>PSV</u>	<u>1</u>	<u>1"</u>	<u>CPLG</u>	<u>SA-105 N</u>	<u>6000#</u>	<u>Integral</u>	<u>Fig. UW-16.1(c)</u>	<u>Shell</u>
<u>Temp. Ind.</u>	<u>1</u>	<u>0.75"</u>	<u>CPLG</u>	<u>SA-105 N</u>	<u>6000#</u>	<u>Integral</u>	<u>Fig. UW-16.1(c)</u>	<u>Shell</u>
<u>Pressure Ind.</u>	<u>1</u>	<u>0.5"</u>	<u>CPLG</u>	<u>SA-105 N</u>	<u>6000#</u>	<u>Integral</u>	<u>Fig. UW-16.1(c)</u>	<u>Shell</u>

11. Supports: Skirt NO Lugs 2 Legs 2 Other Attached
 (Yes or no) (No.) (No.) (Describe) (Where and how)

12. 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, Mfg'r's name and identifying stamp)
 Impact Testing: **Exempt as per UCS-66(a), (b), (c), & (g) TO-20 Radiography per: *As per UW-11(a)5(b) and UW-52
 Tag No.: V-110 Volume: 97.90 Cu. ft. (2.77Cu. m)
 A No: CYCLIC DESIGN : 20YEARS @1 CYCLE/HUR CONSTRUCTION DRAWING #: Y-05-4488-2954 R2

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. 21,356 expires July 21, 2007
 Date: February 08, 2006 Co. Name OpSCO Energy Industries Ltd. Signed HASSA
 (mm/dd/yy) (Manufacturer) (Representative)

CERTIFICATE OF SHOP INSPECTION

Vessel constructed by OpSCO Energy Industries Ltd. at Calgary, Alberta, Canada
 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 ABSA,
 have inspected the component described in the Manufacturer's Data Report on FEB - 8 2006, 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 the 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 FEB - 8 2006 Signed [Signature] Commissions AB #11
 (mm/dd/yy) (Authorized Inspector) (Nat'l Bnd (incl. endorsements), State, Prov and No.)