

01-18-017-18W4M
1ST STG DISCHARGE BOTTLE
A0174994 3615-3-7
REPORT # A#0174994_GRADY INSPECTION LTD VE UT INSP_30MAR2022

DATE 3/30/2022
CLIENT CNRL

Phone:403-793-7697

8 Sarah King Crt E Brooks, Alberta, T1R 0J8
grady.rustebakke@gmail.com




RESULTS OF INSPECTION:


VE Inspection:
Fit For Service. Vessel is in good visual condition.
UT Inspection:
No corrosion was found with the ultrasonic inspection.


PRESSURE EQUIPMENT										AB-506 INTERVAL																		
DISTRICT	AB - OIL & NATURAL GAS					SHELL	TUBE			Compressor Bottles in vibrating																		
FACILITY	Armada Gas Plant					MAWT	300			F	<table><tr><td rowspan="3">GRADE</td><td colspan="3">YEARS</td><td rowspan="3">REG</td></tr><tr><td>Equip</td><td>PSV</td><td>UT</td></tr><tr><td>3</td><td>6</td><td>6</td><td>6</td></tr></table>						GRADE	YEARS			REG	Equip	PSV	UT	3	6	6	6
GRADE	YEARS			REG																								
	Equip	PSV	UT																									
	3	6	6		6																							
A#	A0174994		YR	1981	MAWP	655				psi																		
SERIAL #					PSV		655		psi																			
CRN	D-9135.2				PSV CRN		01832.568																					
EQUIP#					SERVICED		9/9/2020																					
STATUS	IN SERVICE				UNIT	K301				<table><tr><td>VE</td><td>VI</td><td>MT</td><td>PT</td><td>ET</td><td>UT</td></tr><tr><td>X</td><td></td><td></td><td></td><td></td><td>X</td></tr></table>						VE	VI	MT	PT	ET	UT	X					X	
VE	VI	MT	PT	ET	UT																							
X					X																							
MANUFACTURER										BARBER INDUSTRIES INC																		
DH LSD										L		5		Ft		OD	1.35		Ft									
REPAD										UNIQUE ID																		
										NCR-OPERATIONS																		
										NCR-REGULATORY/ADMIN																		
										ACTION ITEM RAISED																		
										REPAIR REQUIRED																		
										SUITABLE FOR SERVICE						X												
										RECOMMENDATIONS:																		
										VE Inspection:																		
										No Recommendations from the External																		
										Inspection.																		

SIGN OFF		API 510	EXP.	IPV	EXP.	INSPECTOR - PRIMARY	INSPECTOR - REVIEW	CLIENT SIGN OFF
INSPECTED BY	ToddM Mckenzie	97445	12/31/2022	00133	7/13/2026			
REVIEWED BY	Ashley Rustebakke	60285	7/31/2024	966	6/16/2026			

Ultrasonic Report		Date	3/25/2022	Phone: 403-793-7697 8 Sarah King Crt E Brooks, Alberta, T1R 0J8 grady.rustebakke@gmail.com	
LSD	01-18-017-18W4M	Facility	Armada Gas Plant		
DH-LSD		Field	Red Deer District		
Jurisdiction # A0174994					
Serial #					
Ultrasonic Report #: A#0174994_GRADY INSPECTION LTD VE UT INSP_30MAR2022					

ULTRASONIC SET			COMPONENT DETAILS				CODE					
EQUIPMENT	CALIBRATION DUE	SERIAL NUMBER	MATERIAL GRADE	SURFACE PREP	TEMP	THICKNESS	CALIBRATION	EVALUATION				
EPOCH 600	2/25/2023	120388107	Carbon Steel	Painted	0C		ASME V	ASME VIII Div 1				
CALIBRATION BLOCK		PROBE						COUPLING		METHOD		
TYPE	SERIAL#	REF dB	SCAN dB	FREQ.	SIZE.	ANGLE	SERIAL #	TYPE	COUPLANT	CABLE	TECHNIQUE	PROCEDURE
10 Step Metric	14-2065	60	66	5 Mhz	0.25 "	0	15B00DU3	Dual	UT-X	6' BNC to Micro	LW Dual	UT01T1R4
SCOPE		As requested by Dustin Rumohr an ultrasonic inspection was completed on the DISCHARGE BOTTLE										
LIMITATIONS		Previous ultrasonic inspection data not obtained by Grady Inspection Ltd.										
RESULTS		No corrosion was found with the ultrasonic inspection.										

Technician Name	Certification Body	Certification #	Expiry	Technician Signature			
3 ToddM	CGSB	9234					
				Client Name			
				Client Signature			

External Inspection - (Vessel)		Date	3/25/2022	Phone:403-793-7697 8 Sarah King Crt E Brooks, Alberta, T1R 0J8 grady.rustebakke@gmail.com	
LSD	01-18-017-18W4M	Facility	Armada Gas Plant		
DH-LSD		Field	Red Deer District		
Juristiction #		A0174994			

Fit For Service:	Fit For Service.
Inspection Summary:	Vessel is in good visual condition.
Recommendations:	No Recommendations from the External Inspection.

External Inspection Items	G/F/P	Comments
General Condition:	Good	No notable mechanical damage, areas of wear/fretting, distortion, misalignment, or visible weld defects.
External Coating:	Good	Vessel is in good visual condition. Vessel is painted with approximately 20% flaking do to heat disbonding, no notable corrosion Vessel is indoors.
Insulation / Cladding:	N/A	Non insulated vessel
Nozzles, Piping and Connections:	Good	Number of nozzles repaded: Number of nozzles without repad: Nozzles and piping in good visual condition
Buried Vessels:	N/A	Above Ground
Ladders, Platforms and Walkways:	N/A	No attached ladder or platform
Foundations and Supports:	Good	Anchor bolts fully engaged Building is secure Concrete is intact with no visible deficiencies
Shell:.	Good	No notable mechanical damage, areas of wear/fretting, distortion, misalignment or visible weld defects.
Saddles / Skirts:	Good	Saddle is in good visual condition
Grounding:	Good	Ground Wire is secure Grounded through piping system
Gauges and Instrumentation:	Good	<div>Shell Gauge (- @)Temp Gauge (- @)</div> <div>Gauge is clear, colorless and correct for the MAWT. Compressor is digitally monitored for pressure and temperature.</div>
Pressure Protection:	Good	The PSV Set Pressure (655 psi) is suitable for the MAWP (655 psi)
NDE Summary:	Good	No corrosion was found with the ultrasonic inspection.
Manway Davits/Quick Closure:	N/A	No Manway
Nameplate:	Good	Nameplate is legible and readily accessible and securely affixed
Code Variance:		

PSV Data

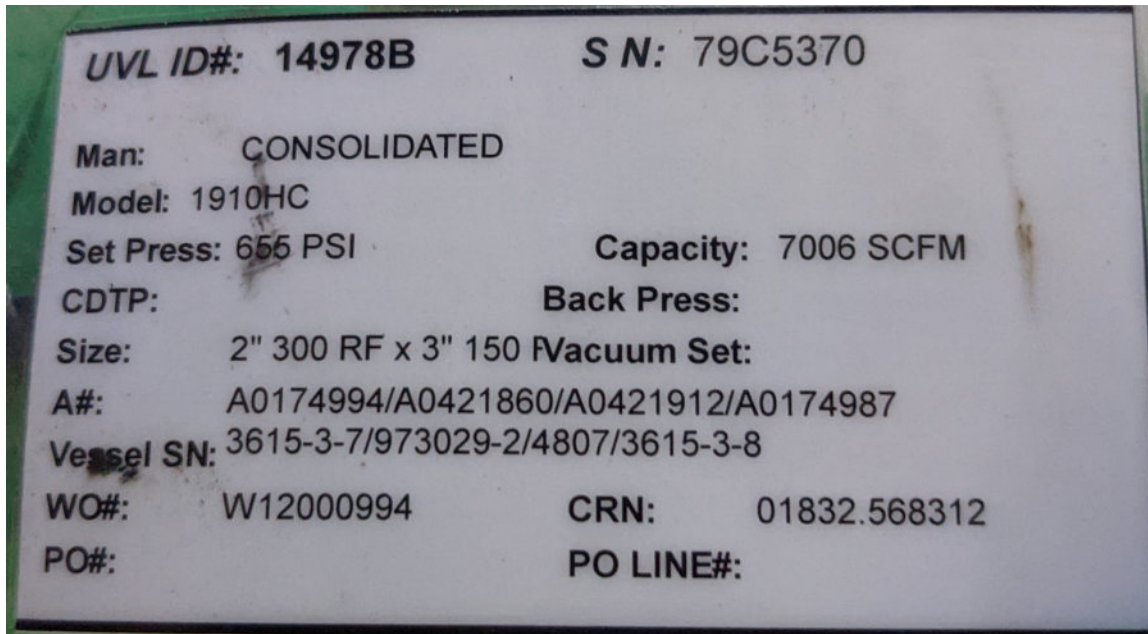
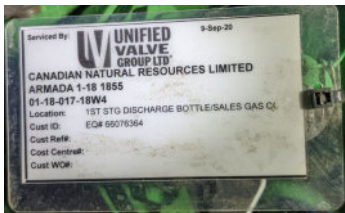
LSD

01-18-017-18W4M

FACILITY Armada Gas Plant

FIELD Red Deer District

Phone:403-793-7697

8 Sarah King Crt E Brooks, Alberta, T1R 0J8
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INSPECTION LTD

ASSOCIATED PRESSURE EQUIPMENT DATA

PV JUR/SER A0174994

SHELL

TUBE

MAWP

655

psi

PSV FIT FOR SERVICE STATEMENT

Fit For Service.

PSV STATIC DATA

MODEL 1910HC

SERIAL 79C5370

MANUFACTURER CONSOLIDATED

TAG 14978B

CRN 01832.568312

SEAL Y

SET PRES

655

psi

CAPACITY 7006

SCFM

SERVICE DATE

9/9/2020

SERVICE COMPANY

Unified Valve Group

T/F

UV

NB

F

UV

NB

SIZE

B VALVE

CARSEAL

INLET

2

N

OUTLET

3

N

PSV COMMENTS

Overview Photo

LSD 01-18-017-18W4M
Jur # A0174994
Serial # 3615-3-7

Date

3/30/2022

FACILITY

Armada Gas Plant

FIELD

Red Deer District

Phone:403-793-7697

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GRADY
INSPECTION LTD



Nameplate



Overview



Temperature Gauge

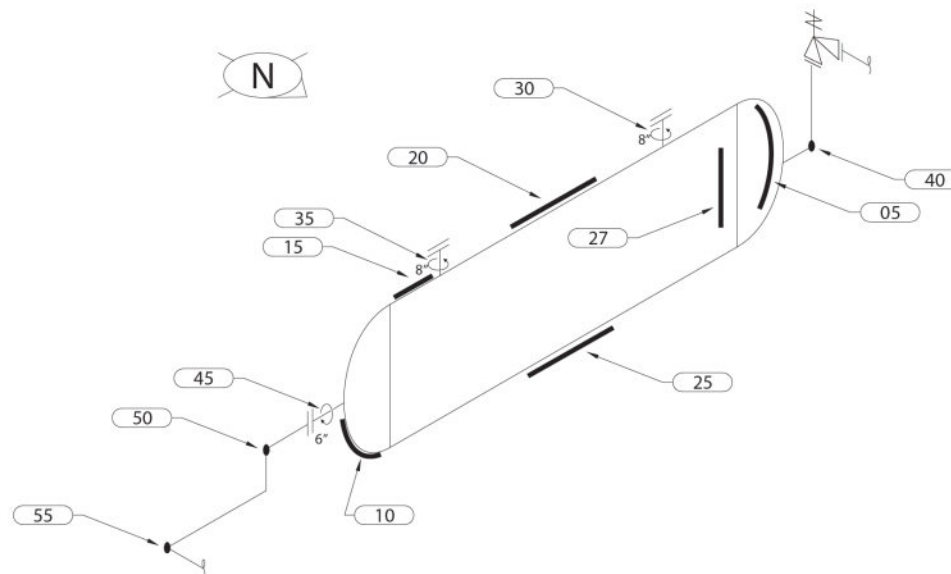
Phone:403-793-7697

GRADY
INSPECTION LTD

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Ser #

Ser #		Inspection Dates and Thickness Values (mm)														% Norm Wall Loss		Corrosion Rates			Rem Life		Rem Life		Next		Insp	
CML#	Norm	CA/Tol	SFlag	STmin	PTmin	> Tmin	Comp	Type	Pipe Size	Code	MOP	Baseline	3rd Last	2nd Last	Last	# of Insp	ST	LTn	LTi	Date	(yrs)	Insp Date	(yrs)	Inspection	Comments			



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LSD 01-18-017-18W4M FACILITY Armada Gas Plant
DH-LSD FIELD Red Deer District
Jur # A0174994 DWG 1 Location:
Ser #

Phone:403-793-7697

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Ser #	Inspection Dates and Thickness Values (mm)																													
	CML#	Nom	CA/Tol	SFlag	STmin	PTmin	> Tmin	Comp	Type	Pipe Size	Code	MOP	Baseline		3rd Last		2nd Last		Last		# of Insp	% Nom Wall Loss	Corrosion Rates			Rem Life	Rem Life (yrs)	Next Insp	Insp Int (yrs)	Inspection Comments
													Date	Min Ave	Date	Min Ave	Date	Min Ave	Date	Min Ave			ST	LTn	LTi	Date				
05	11.0	11.0		8.6		8.6	8.6	Head			UG32HeadEll	655	8/22/07	12.2			11/28/17	13.5	3/30/22	12.3	13.0	4	-12%					3/28/2028	6.0	
10	11.0	11.0		8.6		8.6	8.6	Head			UG32HeadEll	655	9/23/15	12.8	12.9		11/28/17	13.1	3/30/22	12.8	13.5	3	-16%					3/28/2028	6.0	
15	12.7	12.7		20.5		10.3	10.3	Shell			UG27ShellInt	655	9/23/15	13.7	13.8				3/30/22	13.8	14.0	2	-9%					3/28/2028	6.0	
25	12.7	12.7		20.5		10.3	10.3	Shell			UG27ShellInt	655	9/23/15	14.1	14.2				3/30/22	13.3	13.5	2	-5%	0.12				3/28/2028	6.0	
27	12.7	12.7		20.5		10.3	10.3	Shell			UG27ShellInt	655	8/22/07	14.1					3/30/22	14.5	14.8	2	-14%					3/28/2028	6.0	
30	22.2				7.2		7.2	Nozzle	8" XXS ----(22.2mm)		UG45Nozzle	655	9/23/15	23.0	24.3				3/30/22	23.3	24.0	2	-5%					3/28/2028	6.0	Excludes transitions
40	11.1				3.4		3.4	Nozzle	2" XXS ----(11.1mm)		UG45Nozzle	655	9/23/15	11.8	12.2				3/30/22	11.2	11.7	2	-1%	0.09				3/28/2028	6.0	
45	11.0				6.2		6.2	Nozzle	6" XS 80--(11mm)		UG45Nozzle	655	9/23/15	10.9	11.4				3/30/22	10.8	11.5	2	2%	0.02		9/8/2320		3/28/2028	6.0	
50	7.1	6.2		3.3	2.8	2.8	2.8	Elbow	6" STD 40--(7.1mm)		API570	655	9/23/15	7.5	8.2				3/30/22	7.8	8.3	2	-10%					3/28/2028	6.0	