Alpine NDT Services Inc.

Report #: 1096-1
Item Examined: Pressure Vessel
Client: Enlyn Process Systems
Branch: Blackfalds, AB
Location: Enlyn Shop
Client Rep: Tony

Serial #: A#401844
Inspection Date: 10/31/2014
PO #:
WO #:
Reference #: Job# E-358

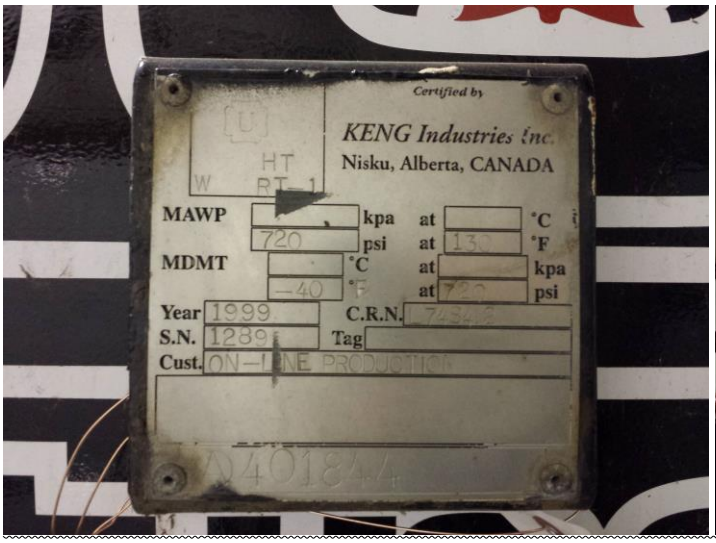
Testing Equipment

UT Machine
Make: GE Inspection Technologies **Model:** USM Go **Serial #:** 13016019 **Calibration Date:** 3/1/2013
Transducer
Make: Stresstel **Serial #:** 13A0213R **Frequency:** 5 MHz **Size**: .250" **Angle:** 0° **Mode:** Longitudinal
Calibration Block
Type: 4 Step Block **Serial #:** 12-4685 **Reflector:** BWE **Thickness:** .250" – 1.000"

Code: ASME V Article 23 SE797 **Acceptance Criteria:** Client Specification **Temperature:** Ambient
Material: Carbon Steel **Surface Prep:** Bare Metal **Procedure:** UT-1 Thickness Testing

Examination Results:

Examination was conducted on the vessel & nozzles for thickness as requested.
Thickness measurements include the paint thickness of approximately .005" thick.
See the following pages for results.



Technician: Mitch O'Meara **Signature:** _____ **Qualifications: CGSB - MT2**
Assistant: **SNT - UT1**

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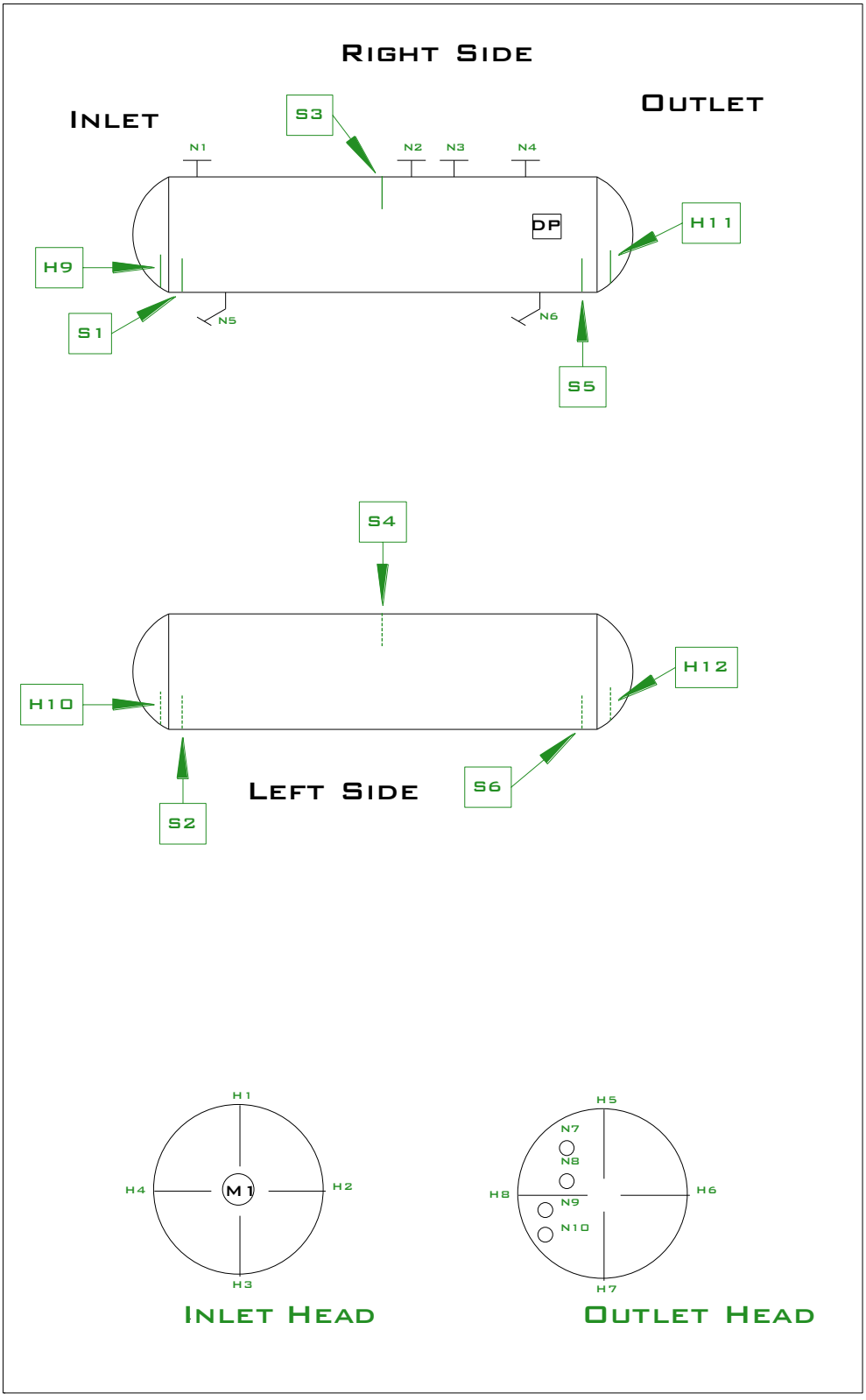

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A# 401844	Item: Vessel & Nozzles					Date: Oct. 31, 2014	
Location	Size	Sch.	Nom.	Min.	Component	Min.	Avg.
H1	84"	Plate		1.625"	Head Scan	1.689"	1.750"
H2	84"	Plate		1.625"	Head Scan	1.693"	1.750"
H3	84"	Plate		1.625"	Head Scan	1.684"	1.750"
H4	84"	Plate		1.625"	Head Scan	1.661"	1.750"
H5	84"	Plate		1.625"	Head Scan	1.688"	1.750"
H6	84"	Plate		1.625"	Head Scan	1.693"	1.750"
H7	84"	Plate		1.625"	Head Scan	1.694"	1.750"
H8	84"	Plate		1.625"	Head Scan	1.704"	1.750"
H9	84"	Plate		1.625"	Head Scan	1.779"	1.800"
H10	84"	Plate		1.625"	Head Scan	1.763"	1.800"
H11	84"	Plate		1.625"	Head Scan	1.788"	1.810"
H12	84"	Plate		1.625"	Head Scan	1.791"	1.810"
S1	84"	Plate	1.563"	1.553"	Shell Scan	1.596"	1.610"
S2	84"	Plate	1.563"	1.553"	Shell Scan	1.587"	1.610"
S3	84"	Plate	1.563"	1.553"	Shell Scan	1.599"	1.615"
S4	84"	Plate	1.563"	1.553"	Shell Scan	1.594"	1.610"
S5	84"	Plate	1.563"	1.553"	Shell Scan	1.558"	1.600"
S6	84"	Plate	1.563"	1.553"	Shell Scan	1.582"	1.600"
S7	84"	Plate	1.563"	1.553"	Shell Scan	1.559"	1.600"
M1	24"	160	2.343"	2.050"	Manway	2.853"	2.870"
N1	4"	N/A	N/A	N/A	Nozzle	1.352"	1.395"
N2	2"	160	0.343"	0.300"	Nozzle	0.298"	0.330"
N3	2"	160	0.343"	0.300"	Nozzle	0.296"	0.330"
N4	4"	N/A	N/A	N/A	Nozzle	1.362"	1.380"
N5	3"	XS	0.300"	0.263"	Nozzle (Elbow)	0.246"	0.280"
N6	3"	XS	0.300"	0.263"	Nozzle (Elbow)	0.208"	0.250"
N7	3"	XXS	0.600"	0.525"	Nozzle	0.677"	0.750"
N8	3"	XXS	0.600"	0.525"	Nozzle	0.783"	0.810"
N9	3"	XXS	0.600"	0.525"	Nozzle	0.786"	0.820"
N10	3"	XXS	0.600"	0.525"	Nozzle	0.794"	0.820"