

	RAE Engineering and Inspection Ltd. www.raeengineering.ca Phone: (780) 469-2401 Fax: (780)-469-2401		Inspection Date:		March 03, 2025		UT Report																		
			Report Number:		TAS000163																				
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Client:		Rare Oilfield Services		Job Number:		PR0004081																			
Facility:		Shop		Location/LSD:		Vegreville / RJV Gas Field Services																			
Equipment Number:		RAE58155		Client Representative:		Ron Gryba																			
Equipment Description:		Fuel Gas Scrubber		Client Contact:		403-999-1175																			
Equipment Type:		Vessel		Measurment Unit:		Inch																			
JOB DESCRIPTION																									
Procedure:		NDE Technical Manual Rev 2 (NDE - 701B)																							
Acceptance Code:		ASME Sec. VIII Div. 1		Surface Condition:		Painted																			
Material:		Carbon Steel		Surface Temp:		0 - 120 °C																			
EQUIPMENT, TECHNIQUE & CALIBRATION																									
Instrument Mfr:		Waygate Tech		Model:		DMS Go+		S/N:		GOPLS22030098		Cal. Due:		2025-07-07											
Probe Model		Freq MHz		Angle		Dia. (In)		Probe Type		Manufacturer		Serial #		Cable Length		Vel. (m/sec)		Ref dB		Scan dB		Range (in)			
1		DA512		7.5		0		0.250		Dual		GE		21E0108P		4'		5850		60		As Needed		0.500"	
Cal Block S/N				1 or 2 Point Cal				Calibration Range				Couplant				Block Material									
1				21-3393				2				0.100" - 0.500"				UTX				Carbon Steel					

Scope:

Conduct 0° straight beam ultrasonic testing on the equipment looking for any signs of wall thinning due to corrosion, erosion, laminations or inclusions.

Result:

The measurements obtained from the inspection locations showed the thicknesses of all the components inspected to be at or around nominal. There were no signs of wall thinning, internal corrosion, erosion, laminations or inclusions at the time of inspection.

Please see the following pages for the pictures of nameplate, the overall view, the isometric drawings, and the thickness measurements.

Conclusion:

No concerns noted at the time of inspection.



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UT Report

Photo Graphics



Nameplate

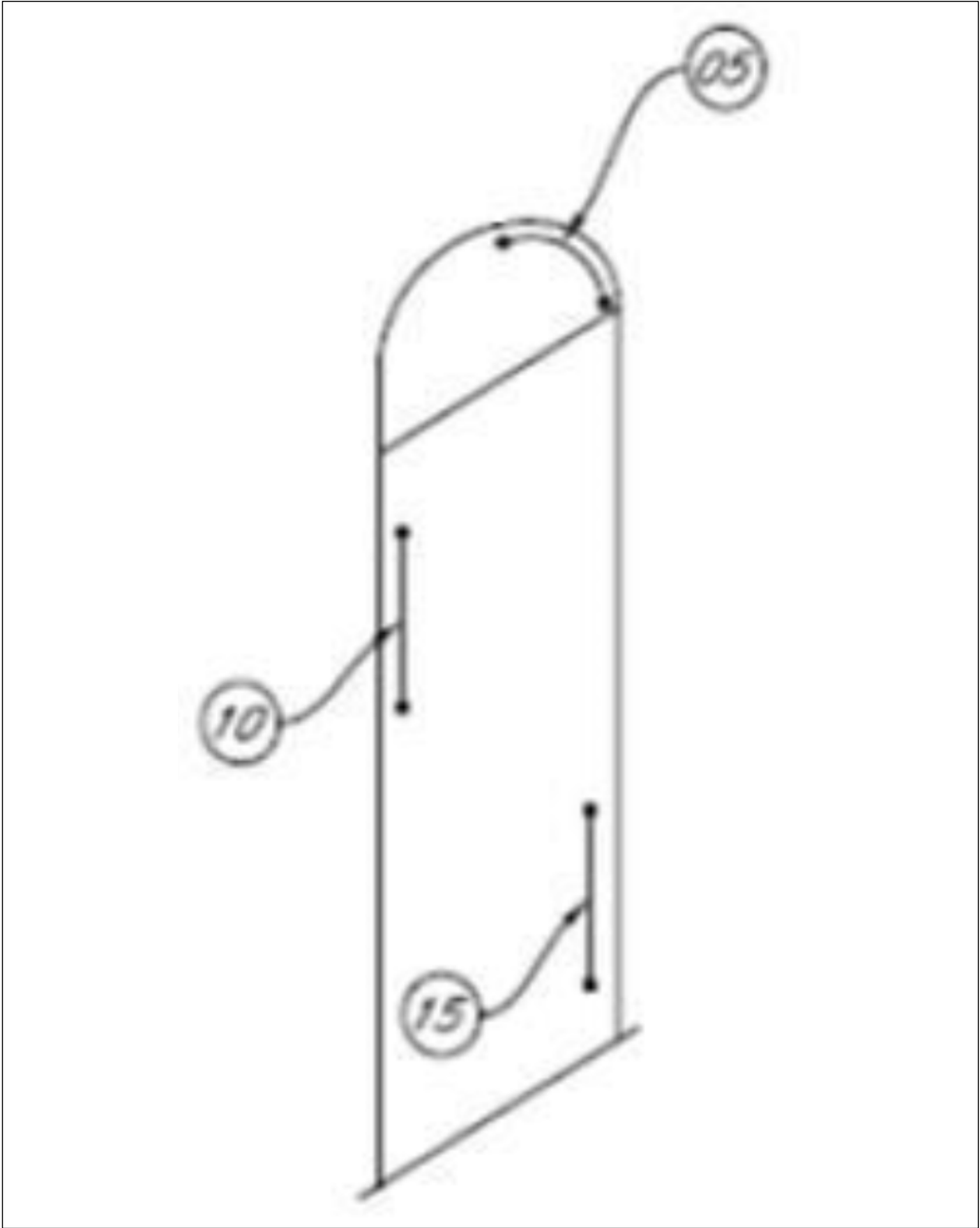


Overall View



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ISO Drawing



ISO Drawing

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UT Data														
#	01	02	03	04	05	06	07	08	09	10	11	12	Min & Avg	
5	Top Head						Nom	0.282	Mil	0.035	CA	0.125	Min:	0.309
	0.318	0.318	0.316	0.309	0.309	0.311	0.320	0.322	0.326	0.327	0.347	0.347	Avg:	0.323
10	Top Shell						Nom	0.318	Mil	0.040	CA	0.125	Min:	0.316
	0.316	0.319	0.320	0.321	0.326	0.326	0.327	0.331	0.329	0.327	0.325	0.324	Avg:	0.324
15	Bottom Shell						Nom	0.318	Mil	0.040	CA	0.125	Min:	0.321
	0.329	0.330	0.325	0.323	0.323	0.321	0.323	0.330	0.333	0.328	0.328	0.328	Avg:	0.327

Tyson Shewchuk

Technician: Tyson Shewchuk
CGSB#:28881 UT Level:1



**NDE-709D Thickness Gage Horizontal Linearity Certificate of Calibration**

Instrument Make: GE Transducer Make: Stresstel
Instrument Model: USM/DMS GO+ Transducer Model: FH2E
Instrument S/N: GOPLS22030098 Transducer S/N: 23A015YZ
Temperature: 21°C Couplant: UTX

Table 1: Thickness Gage Horizontal Linearity Data

CALIBRATION BLOCK S/N	CALIBRATION BLOCK THICKNESS (IN)	BACKWALL NUMBER	MEASURED LENGTH (IN)	DEVIATION (IN)	TOLERANCE (IN)	ACCEPTABLE
60764	0.050	1st	0.050	0	0.006	Yes
21-3393	0.100	1st	0.098	0.002	0.006	Yes
21-3393	0.200	1st	0.200	0	0.006	Yes
21-3393	0.300	1st	0.300	0	0.006	Yes
21-3393	0.400	1st	0.399	0.001	0.006	Yes
21-3393	0.500	1st	0.500	0	0.006	Yes
21-3393	1.00	2nd	1.000	0	0.006	Yes
21-3393	2.000	4th	2.002	0.002	0.006	Yes
21-3393	3.000	6th	3.000	0	0.006	Yes
21-3393	4.000	8th	4.000	0	0.006	Yes

Technician Name: Tyson ShewchukSignature: Tyson ShewchukDate: July 07/2024Calibration Due: July 07/2025