

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 Boiler and Pressure Vessel Code Rules, Section VIII, Division 1 Page 1 of 2

1. Manufactured and certified by Tri-Point Oil & Gas Production Systems, LLC, 701 South Eastern, Elk City, Oklahoma, 73644

(Name and address of Manufacturer)

2. Manufactured for FourPoint Energy, 8450 E Crescent Pkwy, Suite 400, Greenwood Village, Colorado, 80111

(Name and address of Purchaser)

3. Location of Installation Unknown

(Name and address)

4. Type Vertical 014847-10 N/A 014847-DSS-VES 9918 2020
(Horizontal or vertical, tank) (Manufacturer's serial number) (CRN) (Drawing number) (National Board number) (Year built)5. ASME Code, Section VIII, Division 1 2017/ N/A N/A N/A
(Edition and Addenda, if applicable (date)) (Code Case numbers) (Special service per UG-120(d))6. Shell: SA-516-70N 3.50 in 0.0625 in 0' 28.0" (ID) 8' 0.0"
(Material spec. number, grade) (Nominal thickness) (Corr. allow.) (Inner diameter) (Length (overall))

Body Flanges on Shells												
No.	Type	ID	OD	Flange Thk	Min Hub Thk	Material	How Attached	Location	Bolting			
									Num & Size	Bolting Material	Washer (OD, ID, thk)	Washer Material
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A

7. Seams: Type 1 Full 100% 1100 °F 2hr 30min Type 1 Full 100% 1
[Long. (welded, dbl., sngl., lap, butt)] [R.T. (spot or full)] (Eff. %) (H.T. temp) (Time, hr) [Girth. (welded, dbl., sngl., lap, butt)] [R.T. (spot or full)] (Eff. %) (No. of courses)8. Heads: (a) Material SA-516-70N (b) Material SA-516-70N
(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 Pressure (Convex or Concave)
(a)	END	2.9023"	0.0625"	N/A	N/A	2:1	N/A	N/A	N/A	Concave
(b)	END	2.9023"	0.0625"	N/A	N/A	2:1	N/A	N/A	N/A	Concave

Body Flanges on Heads												
	Location	Type	ID	OD	Flange Thk	Min Hub Thk	Material	How Attached	Bolting			
									Num & Size	Bolting Material	Washer (OD, ID, thk)	Washer Material
(a)	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A		N/A	N/A	N/A

9. MAWP 5000 psi N/A at max. temp. 200 °F N/A
(Internal) (External) (Internal) (External)Min. design metal temp. -20 °F at 5000 psi . Hydro, pneu., or comb. test pressure HYDRO at 6500 psi .Proof test N/A .

10. Nozzles, inspection and safety valve openings:

Purpose (Inlet, Outlet, Drain, etc.)	No.	Diameter or Size	Type	Material		Nozzle Thickness		Reinforcement Material	Attachment Details		Location (Insp. Open.)
				Nozzle	Flange	Nom.	Corr.		Nozzle	Flange	
Inlet	1	3"	RTJHB	N/A	SA-105	CL2500	0.0625"	Integral	N/A	UW-16.1(I)	Shell
Outlet	1	3"	RTJHB	N/A	SA-105	CL2500	0.0625"	Integral	N/A	UW-16.1(I)	Shell
Drain	2	3"	Pipe/RTJWN	SA-106-C	SA-105	XXH/CL2500	0.0625"	SA-516-70	UW-16.1(a-1)	Fig.2-4(6)	Head

Additional Nozzles - See Attached U-4...

11. Supports: Skirt No Lugs 0 Legs 0 Other N/A Attached N/A
(Yes or no) (Number) (Number) (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:

Uni-Form Components Co.

S/N: 8954

(Name of part, item number, Manufacturer's name and identifying stamp)

Over Pressure Protection Provided per UG-125.**Impact per UG-84 To -20 F.****Tested in Horizontal Position.****(1) Name Plate Bracket; SA-36. Welded to Shell.****(2) Saddle Legs; SA-36. Welded to Shell.****(1) Large Lift Lugs; SA-105. Welded to Shell.****(1) Repad; SA-516-70. Welded to Head.****(2) Support Repad; SA-36. Welded to Head.**

Additional Remarks - See Attached U-4...

Manufactured by Tri-Point Oil & Gas Production Systems, LLC, 701 South Eastern, Elk City, Oklahoma, 73644Manufacturer's Serial No. 014847-10CRN N/ANational Board No. 9918

CERTIFICATE OF SHOP/FIELD 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 BOILER AND PRESSURE VESSEL CODE, Section VIII, Division 1. "U" Certificate of Authorization Number 29800 expires April 6, 2021.

Date 03/05/2020

Co. name

Tri-Point Oil & Gas Production Systems, LLC

Signed


(Representative)

(Manufacturer)

CERTIFICATE OF SHOP/FIELD INSPECTION

Vessel constructed by Tri-Point Oil & Gas Production Systems, LLC at 701 South Eastern, Elk City, Oklahoma, 73644

I, the undersigned, holding a valid commission issued by The National Board of Boiler and Pressure Vessel Inspectors and employed by

OneCIS Insurance Company, of Lynn, MAhave inspected the component described in this Manufacturer's Data Report on March 2, 2020,

and state that, to the best of my knowledge and belief, the Manufacturer has constructed this pressure vessel in accordance with ASME BOILER AND PRESSURE VESSEL CODE, Section VIII, Division 1. By signing this certificate neither the Inspector nor his/her employer makes any warranty, expressed or implied, concerning the pressure vessel described in this Manufacturer's Data Report. Furthermore, neither the Inspector nor his/her 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 03/05/2020

Signed


(Authorized Inspector)

Commissions

16179

(National Board Authorized Inspector Commission number)

FORM U-4 MANUFACTURER'S DATA REPORT SUPPLEMENTARY SHEET

As Required by the Provisions of the ASME Boiler and Pressure Vessel Code Rules, Section VIII, Division 1

1. Manufactured and certified by	<u>Tri-Point Oil & Gas Production Systems, LLC, 701 South Eastern, Elk City, Oklahoma, 73644</u>		
	(Name and address of Manufacturer)		
2. Manufactured for	<u>FourPoint Energy, 8450 E Crescent Pkwy, Suite 400, Greenwood Village, Colorado, 80111</u>		
	(Name and address of Purchaser)		
3. Location of installation	<u>Unknown</u>		
	(Name and address)		
4. Type	<u>Vertical</u>	<u>N/A</u>	<u>014847-10</u>
	(Horizontal, vertical, or sphere)	(Tank, separator, heat exch., etc.)	(Manufacturer's serial number)
	<u>N/A</u>	<u>014847-DSS-VES</u>	<u>9918</u>
	(CRN)	(Drawing number)	(National Board number)
	<u>2020</u>		
	(Year built)		
Data Report			
Item Number		Remarks	

Additional Remarks:

(2) Support Lugs; SA-36. Welded to Shell.

Additional nozzles, inspection and safety valve openings:

Purpose (Inlet, Outlet, Drain, etc.)	No.	Diameter or Size	Type	Material		Nozzle Thickness		Reinforcement Material	Attachment Details		Location (Insp. Open.)
				Nozzle	Flange	Nom.	Corr.		Nozzle	Flange	
PSV	1	2"	TOL	SA-105	N/A	9000#	0.0625"	Integral	UW-16.1(a)	N/A	Head
Cleanout	1	2"	TOL	SA-105	N/A	9000#	0.0625"	Integral	UW-16.1(a)	N/A	Shell
PI	1	3/4"	TOL	SA-105	N/A	9000#	0.0625"	Integral	UW-16.1(a)	N/A	Shell

Certificate of Authorization: Type	<u>"U"</u>	No.	<u>29800</u>	Expires	<u>April 6, 2021</u>
Date	<u>03/05/2020</u>	Name	<u>Tri-Point Oil & Gas Production Systems, LLC</u>	Signed	<u></u>
			(Manufacturer)		(Representative)
Date	<u>03/05/2020</u>	Signed	<u></u>	Commissions	<u>16179</u>
			(Authorized Inspector)		(National Board Authorized Inspector Commission number)

50:28233

Examination & Inspection Sheet				Job. No.: E101865				NBN: 9918		PJ#: 20729		Page 1 of 3			
				Serial No.: 014847-10				Dwg. No.:		014847-DSS-VES					
				Customer: STOCK				Location:		Elk City, OK					
				New Construction		Repair		Alteration		Routine Repair					
Vessel Data		Applicable Code(s):		ASME Code Sec. VIII-1, Yr/Ed:				2017		NBIC Yr/Ed					
Description: 28"OD x 8'-0" x 5000# V. Sand Separator															
Completed Vessel Operations								Quality Control		Authorized Inspector					
								Initial		Date		Initial		Date	
1.0 Calculations								AW		3/25/19		DW*		3/25/19	
2.0 Drawings								AW		3/25/19		DW*		3/25/19	
3.0 Welding Procedures								AW		3/25/19					
4.0 Welder Performance Qualifications								AW		3/25/19					
5.0 Material Test Reports								AW		10/30/19					
6.0 Customer Specifications								AW		10/30/19					
7.0 Vessel Layout Prior to Burning								NB		1/2					
8.0 Head and Shell Forming Seam Alignment								NB *		1/2					
								NB *		1/2					
9.0 Internal Vessel Inspection								NB		1/2		JTS *		1/20/20	
10.0 Hold Dimensions															
MAWP		5000		PSI @		200		°F		WT/lbs.		9,921			
MAEWP		N/A		PSI @		N/A		°F		HD./in.		2.9023"			
MDMT		-20		°F @		5000		PSI		SH./in.		3.50"			
11.0 Impact Testing Required								Yes		No					
12.0 Heat Treat / Chart Review								Yes		No					
13.0 NDE (Ref. NDE Inspection Reports)								RT - 1							
14.0 Witness And Record Hydrostatic Test															
15.0 Hydrostatic Test		PSIG		Chart Time				NB		3/2		JTS *		3/12/20	
Data		6500		N/A											
16.0 Review Documentation															
17.0 Conformity Corrections								Yes		No					
18.0 Nameplate Stamping Verification															
U		R						AW		10/30/19					
19.0 Welder's Identification								(y)							
20.0 Final Inspection								NB		1/20		JTS *		3/12/20	
19.0 Sign Data Report								JTS		3/5/2020		JTS *		3/15/20	
20.0 Quality Checklist Review: Above Documents Scanned for 3 year min. Record Retention															
21.0 Remarks:															
Corrosion Allowance: 0.0625"															
Rev: 1															

Material Heat Numbers

Job No.: E101865

Serial No.: 014847-10

Drawing No.: 014847-DSS-VES

Page 2 of 3

Drawing No.: 014847-DSS-VES

A diagram of a cell with a rectangular body and rounded ends. The cell is divided into three regions by two vertical lines. The leftmost rounded region is labeled 'C', the central rectangular region is labeled 'B', and the rightmost rounded region is labeled 'A'.

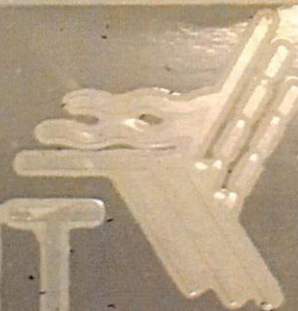
[illegible]



9918

CERTIFIED BY

TRIPOINT



U

PLANT

ELK CITY, OK

W

MAWP

5000

PSI AT 200

°F

RT1

MAWP

N/A

PSI AT N/A

°F

HT

MDMT

-20

°F AT 5000

PSI

S/N

014847-10

DATE BUILT

2020

WT

9921

LBS

DWG 014847-DSS-VES

HD

3.50"

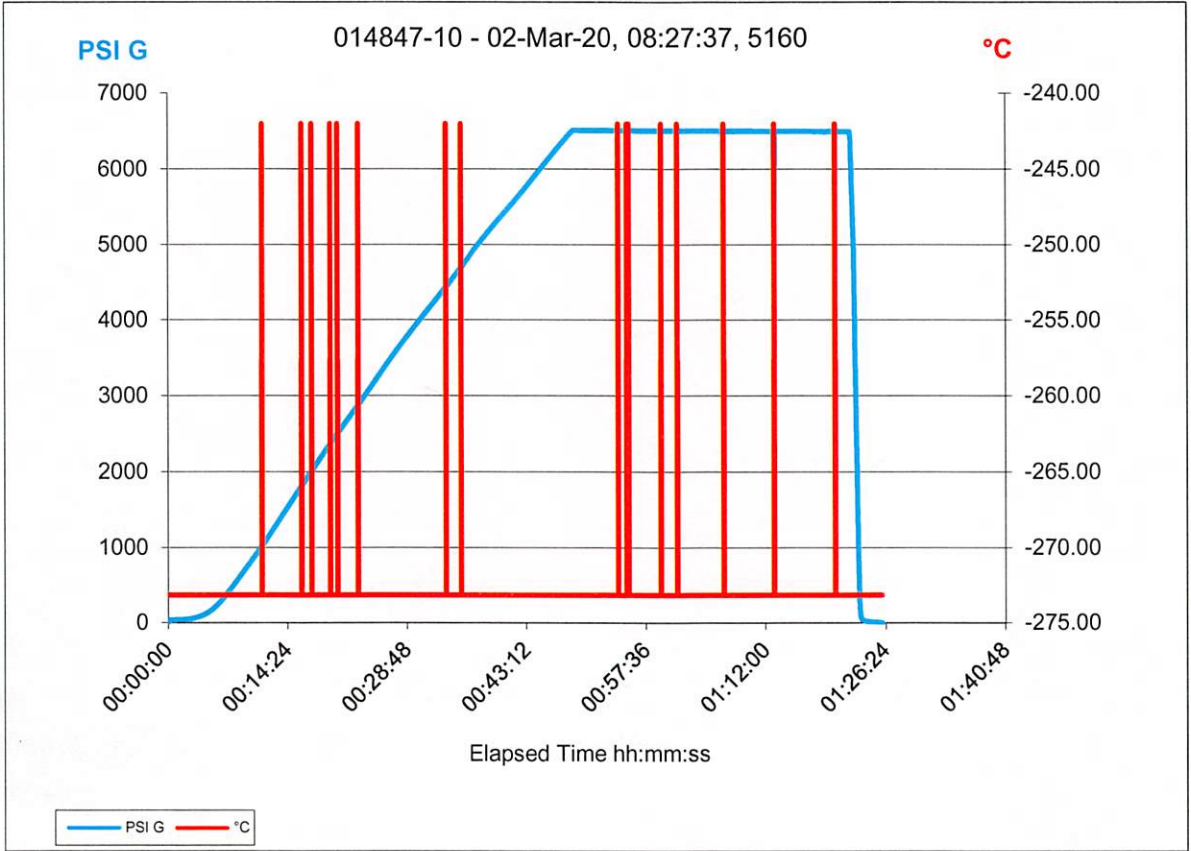
SH

3.50"

Data Collection Report

	Chassis	Left Scale	Right Scale
Serial Number	464939	465986	468628
Datatype		Lower	Upper
Units		PSI G	°C

LowerUpper



FORM U-2A MANUFACTURER'S PARTIAL DATA REPORT (ALTERNATIVE FORM)
A Part of a Pressure Vessel Fabricated by One Manufacturer for Another Manufacturer
As Required by the Provisions of the ASME Boiler and Pressure Vessel Code Rules, Section VIII, Division 1

1. Manufactured and certified by: UNI-FORM COMPONENTS CO. 10703 SHELDON ROAD HOUSTON, TX 77044
(Name and address of Manufacturer)
2. Manufactured for: SUPERIOR FABRICATION 701 SOUTH EASTERN ELK CITY, OK 73644
(Name and address of Purchaser)
3. Location of installation: NOT KNOWN
(Name and address)
4. Type: CYLINDER
(Description of vessel part (shell, two piece head, tube bundle))
NO DRAWING BY UCC
(National Board number) (Drawing number)
(Manufacturer's serial number) (CRN) (Drawing prepared by) (Year built)
8954
2017
5. ASME Code Section VIII Div 1 2015
(Edison and Addenda, if applicable (date)) (Code Case number) (Special Service per UG-120(d))
6. Shell (a) Number of course (s): 1 (b) Overall Length: 96"

Course(s)			Material	Thickness		Long. Joint (Cat. A)			Circum. Joint (Cat. A, B & C)			Heat Treatment	
No.	Diameter	Length	Spec./Grade or Type	Nom.	Corr.	Type	Full, Spot, None	Eff.	Type	Full, Spot, None	Eff.	Temp.	Time
1	28" OD	96"	SA 516-70N	3.500	-	1	FULL	-	-	-	-	1650	1.5

Body Flanges on Shell													
No.	Type	ID	OD	Flange Thk	Min Hub Thk	Material	How Attached	Location	Bolting				Washer Material
									Num & Size	Bolting Material	Washer (OD, ID, thk)	Washer Material	
-	-	-	-	-	-	-	-	-	-	-	-	-	-

7. Heads: (a) - (b) Material -
(Material spec, number, grade or type) (H.T. - time and temp) (Material spec, number, grade or type) (H.T. - time and temp)

	Location (Top, Bottom, Ends)	Thickness		Radius		Elliptical Ratio	Conical Apex Angle	Hemispheric at Radius	Flat Diameter	Side to Pressure		Category A		
		Min.	Corr.	Crown	Knickdo					Convex	Concave	Type	Full, Spot, None	Eff.
(a)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
(b)	-	-	-	-	-	-	-	-	-	-	-	-	-	-

Body Flanges on Heads:													
	Location	Type	ID	OD	Flange Thk	Min Hub Thk	Material	How Attached	Bolting				Washer Material
									Num & Size	Bolting Material	Washer (OD, ID, thk)	Washer Material	
(a)	-	-	-	-	-	-	-	-	-	-	-	-	-
(b)	-	-	-	-	-	-	-	-	-	-	-	-	-

8. MAWP - - PSI at max temp. - °F - °F Min. design metal temp. - °F at - PSI
(Internal) (External) (Internal) (External)

9. Impact Test YES, BASE, HAZ, AND WELDMENT at test temperature of -20 DEG.F
Indicate yes or no and the component(s) impact tested

10. Hydro., pneum., or comb. test press. - PSI Proof Test -

11. Nozzles, inspection, and safety valve openings:

Purpose (Inlet, Outlet, Drain, etc.)	No.	Diameter or Size	Type	Material		Nozzle Thickness		Reinforcement Material	Attachment Details		Location (Insp. open.)
				Nozzle	Flange	Nom.	Corr.		Nozzle	Flange	
-	-	-	-	-	-	-	-	-	-	-	-

12. Identification of part (s)

Name of Part	Quantity	Line No	Mfr's Identification No.	Mfr's Drawing No.	CRN	National Board No	Year Built

13. Support: Skirt - Lugs - Legs - Other - Attached -
Yes or no (Number) (Number) Describe (Where and how)

14. Remarks (1) WELDED CYLINDERS 28" O.D. X 3.500" NOM X 96" LONG SA 516-70N UCC J/N 129970
 DESIGN AND DRAWINGS OTHERS, NO HYDRO TESTING. WPS QUALIFIED WITH AND WITHOUT PWHT.

Mfg. Representative

JK
(Initial)6/20/17
(Date)

Authorized Inspector

CJ
(Initial)6-20-17
(Date)

Serial Number 8954

FORM U-2A (BACK)

CERTIFICATE OF SHOP/FIELD COMPLIANCE

We certify that the statements made in this report are correct and that all details of material, construction and workmanship of this pressure vessel part conform to the ASME Boiler and pressure Vessel Code, Section VIII, Division 1

"U" Certificate of Authorization Number

18.206

Expires

11/3/19

Date

6/20/17

Name

UNI-FORM COMPONENTS CO.

Signed

JK

(Manufacturer)

(Representative)

CERTIFICATE OF SHOP/FIELD INSPECTION

I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and employed by

OneCIS Insurance Company

of

Lynn, MA

have inspected the pressure vessel part described in this Manufacturer's Data Report on

6/20/17

and state that,

to the best of my knowledge and belief, the Manufacturer has constructed this pressure vessel part in accordance with ASME BOILER AND PRESSURE VESSEL CODE, Section VIII, Division 1. By signing this certificate neither the Inspector nor his/her employer makes any warranty, expressed or implied, concerning the pressure vessel part described in this Manufacturer's Data Report. Furthermore, neither the Inspector nor his/her 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 6-20-17 SignedJK

Commissions

NB 14610 J.E.B.

(Authorized Inspector)

(National Board (incl. endorsements))



TRINITY HEADS, INC
11765 Highway 6 South Navasota, TX 77868

July 27, 2017

SFI OIL & GAS PRODUCTION SYSTEMS
PO BOX 429
ELK CITY, OK 73648

Customer PO: 77337 TAG: SFI PART# 03-3043-J
Trinity SO #: 127066

Gentlemen

Attached are copies of mill test reports for the following material provided on referenced purchase order.
We certify the following:

4-SA516-70 ELLIP- 2:1 HEAD 28.00 OD 3.5000 NOM 2.8750 MIN WITH 2" SF.

CODE	QTY	THICKNESS	PRODUCER	MELT	SLAB	GRADE
SURS	4	3.5000	ARCELOR	D0444	6	SA516-70

TRINITY HEADS, INC certifies that heads manufactured from material represented by this report were normalized during forming at 1750F (+/-25F) for 105 minutes and air cooled.

The items listed above were formed in strict accordance with all applicable requirements of the ASME Boiler and Pressure Vessel Code Section VIII, Div. 1. All heads comply with UCS-79, UG-79 and UG-81.

Attached mill test reports are in compliance to ASME Code Section II latest edition.

If you have further questions, please contact your customer service representative in Navasota, TX at 1-800-392-3594.

Very Truly Yours

Mel Chapman
Quality Assurance and Technical Services Manager

S F I
CHEMICALS & PHYSICALS
BY EC DATE 8/7/17
CODE NO. NHQ

TEST CERTIFICATE

SHIP TO:
ARCELORMITTAL PLATE LLC
TRINITY INDUSTRIES INC
HEAD DIV
PLANT 56
THEIR SIDING
NAVASOTA TX 77868

PAGE NO: 01 OF 02
FILE NO: 7978-12-77
MILL ORDER NO: 72553-001
MELT NO: D0444
SLAB NO: 6
DATE: 04/17/17

SOLD TO:
TRINITY INDUSTRIES, INC.
HEAD DIVISION
11765 HWY. 6 SOUTH
NAVASOTA TX 77868

SEND TO:

01-C

STEEL PLATE DIMENSIONS / DESCRIPTION

TOTAL QTY	GAUGE	WIDTH	LENGTH	DESCRIPTION	PIECE WEIGHT
1	3.5"	88"	264"	RECTANGLE	23060#

CUSTOMER INFORMATION

CUSTOMER PO: 403349
PART NO. HP1605

S 30 F 1
CHEMICALS & PHYSICALS
BY EC DATE 8/7/17
CODE NO. NHQ

SPECIFICATION (S)

THIS MATERIAL HAS BEEN MANUFACTURED AND TESTED IN ACCORDANCE WITH PURCHASE ORDER REQUIREMENTS AND SPECIFICATION(S).

ASME SA516 REV ED YR 13 GR 70
THE MANAGEMENT SYSTEMS FOR MANUFACTURE OF THIS PRODUCT ARE CERTIFIED TO ISO 9001:2008 (CERTIFICATE NO. 30130) AND ISO 14001:2004 (CERTIFICATE NO. 49009).

CHEMICAL COMPOSITION (WT%) FOR ALL ELEMENTS EXCEPT H (PPM)

	C	MN	P	S	CU	SI	NI	CR	MO
MELT:D0444	.24	.94	.014	.003	.18	.20	.11	.18	.03
	V	TI	B	AL	CB	SN			
MELT:D0444	.002	.003	.0002	.029	.001	.007			

HEAT TREAT CONDITION

MATL OR TEST	HEAT TREAT DESCRIPTION	NOM TEMP	HOLD MINS	COOL MTHD
TEST ONLY	NORMALIZE	1750F	105	AIR COOL

NOTARY

AFFIRMED AND SUBSCRIBED BEFORE ME
THIS DAY OF 04/17/17

Carol L. Slody
NOTARY PUBLIC

NOTARIAL SEAL
CAROL L. SLODY, NOTARY PUBLIC
COATESVILLE, CHESTER CO., PA
MY COMMISSION EXPIRES MAY 27, 2018

WE HEREBY CERTIFY THE ABOVE
INFORMATION IS CORRECT:

ARCELORMITTAL PLATE LLC
QUALITY ASSURANCE LABORATORY
139 MODENA ROAD
COATESVILLE, PA 19320

Loc Tran
SUPERVISOR - TEST REPORTING
LOC TRAN

5785

TEST CERTIFICATE

PAGE NO: 02 OF 02
 FILE NO: 7978-12-77
 MILL ORDER NO: 72553-001
 MELT NO: D0444
 SLAB NO: 6
 DATE: 04/17/17

TENSILE PROPERTIES

SET ONE

SLAB NO.	LOC	DIR	YIELD STRENGTH PSI X 1000	TENSILE STRENGTH PSI X 1000	ELONGATION AFTER FRACTURE GAGE LGTH %
6	BOT.	TRANS.	50	77	2.00" 21.0

HEAT TREAT CONDITION

SET TWO

MATL OR TEST	HEAT TREAT DESCRIPTION	NOM TEMP	HOLD MINS	COOL MTHD
TEST ONLY	NORMALIZE	1650F	105	AIR COOL

TENSILE PROPERTIES

SET TWO

SLAB NO.	LOC	DIR	YIELD STRENGTH PSI X 1000	TENSILE STRENGTH PSI X 1000	ELONGATION AFTER FRACTURE GAGE LGTH %
6	BOT.	TRANS.	50	79	2.00" 27.0

GENERAL INFORMATION

ALL STEEL HAS BEEN MELTED AND MANUFACTURED IN THE U.S.A.
 NO WELD REPAIR PERFORMED BY ARCELORMITTAL PLATE LLC.
 ACID SOLUBLE ALUMINUM
 FOR MORE INFORMATION AND PROCESSING GUIDELINES, REFER TO
 WWW.USA.ARCELORMITTAL.COM/PLATE

B/L #13004 BVRV 63016

S F
CHEMICALS & PHYSICALS
 BY EC DATE 8/7/17
 CODE NO. NHQ

HT.#	<u>70444</u>
MTR APPROVED	
DATE	<u>4/29/17</u>
ISP	
QUALITY CONTROL DEPT.	

NOTARY

AFFIRMED AND SUBSCRIBED BEFORE ME
 THIS DAY OF 04/17/17

Carol L. Slody
 NOTARY PUBLIC

WE HEREBY CERTIFY THE ABOVE
 INFORMATION IS CORRECT:

ARCELORMITTAL PLATE LLC
 QUALITY ASSURANCE LABORATORY
 139 MODENA ROAD
 COATESVILLE, PA 19320

NOTARIAL SEAL
 CAROL L. SLODY, NOTARY PUBLIC
 COATESVILLE, CHESTER CO., PA
 MY COMMISSION EXPIRES MAY 27, 2018

Lo J Tran
 SUPERVISOR - TEST REPORTING
 LOC TRAN

Packing List

Customer Number 935609 Date 7/28/17 Ship To Number 1 Load#
 Bill of Lading # BN75790

Bill to Customer

Ship To Customer

SFI OIL & GAS PRODUCTION SYSTE
 PO BOX 429

SFI OIL & GAS PRODUCTION SYS.
 701 S EASTERN AVE

ELK CITY

OK 73648

USA

ELK CITY

OK

73644

USA

Contact

SANDI SCHROEDER

Phone

580.246.5507

Order Number 127066 Your Order Number 77337

Warehouse 56

Consolidation

Order Date 6/22/17

Carrier

Route

Request Date 7/13/17

Ship Via

SAIA MOTOR FREIGHT

Ship Date 7/28/17

Customer Registration Number

Shipper

Line	Item Number	Description	Ship Qty	Carton	Weight
1	27-09392	HEAD 28.0000 OD, 3.5000, ELIP	8.000		6903.13

TAG SFI PART # 03-3043-J

Weight 6903.130
 Volume .000
 Pallet .000

S F I
CHEMICALS & PHYSICALS
 BY EC DATE 8/7/17
 CODE NO. NHQ

NON-DESTRUCTIVE TESTING AND INSPECTION

17110 East Pine St, Tulsa, OK 74116

Tele: (918) 234-6300 Fax: (918) 234-6301

CUSTOMER DATA

NAME		TRI POINT	
ADDRESS		ELK CITY, OK.	
PURCHASE ORDER #			
ATTENTION			
DAY	SATURDAY	DATE	1/18/2020

RADIOGRAPHIC INSPECTION REPORT

JOB NUMBER 014847-10 SO# PAGE 1 OF 1

APPLICABLE CODE	ASME SEC VIII UW51	ORIGINAL FILM	14	REPAIR FILM
-----------------	--------------------	---------------	----	-------------

PROCEDURE # RT-1 REVISION # 4 DATE: 7/3/2018

TRAVEL MILES	TRAVEL HRS.	WORK HRS.	STANDBY HRS.	TOTAL HRS.
--------------	-------------	-----------	--------------	------------

RADIOGRAPHER	TROY WEBB	LEVEL II	ASSISTANT	ANDREW SIMMS	LEVEL I
--------------	-----------	----------	-----------	--------------	---------

TESTING VARIABLES

IR 192 ☒ CO 60 ☐ X-RAY ☐ PROCESSING: AUTOMATIC ☐ MANUAL ☒ TIME 5:00 TEMP. 71

CURIES 84 Kv EXPOSURE / VIEWING: SINGLE FILM ☒ COMPOSITE FILM ☐

FOCAL SPOT 0.143 Ma DWE/SWV ☐ DWE/DWV ☐ SWE/SWV ☒

MATERIAL TYPE CARBON ☐ ☐ ☐

FILM:	FILM USAGE:	3 1/2" X 8 1/2"	3 1/2" X 10"	3 1/2" X 17"
-------	-------------	-----------------	--------------	--------------

MFG.	FUJI	4 1/2" X 8 1/2"	4 1/2" X 10"	4 1/2" X 17"

TYPE	100	70mm X 8 1/2"	8 X 10"	7" X 17"	14
------	-----	---------------	---------	----------	----

CLASS	I	70 mm X 6"	70 mm X 17"	14" X 17"
-------	---	------------	-------------	-----------

SENSITIVITY	<u>2-2T</u>		
OTHER _____			

✓			
---	--	--	--

FILM/CASSETTE	1	LOC	THIN	REIN	MA1	FILM INTERPERATOR	TROY WEBB	PT	CT
---------------	---	-----	------	------	-----	-------------------	-----------	----	----

[illegible]**DEFECT CODE**

AB - ARC BURN	HB - HOLLOW BEAD
AI - ALIGNED INDICATION	IF - INADEQUATE FUSION
BT - BURN THROUGH	IP - INCOMPLETE PENETRATION
CON - CONCAVITY	MA - MISALIGNMENT
CRACK - CRACK	POR - POROSITY

ABBREVIATED TERMS

ABBREVIATED TERMS

SOD = SOURCE TO OBJECT DISTANCE		
OFD = SOURCE SIDE OF OBJECT TO FILM DISTANCE		
OD = OUTER DIAMETER	REP = REPAIR	RET = RETAKE
WT = WELD THICKNESS	RES = RESHOOT	
WR = WELD REINFORCEMENT	BM = BASE MATERIAL	

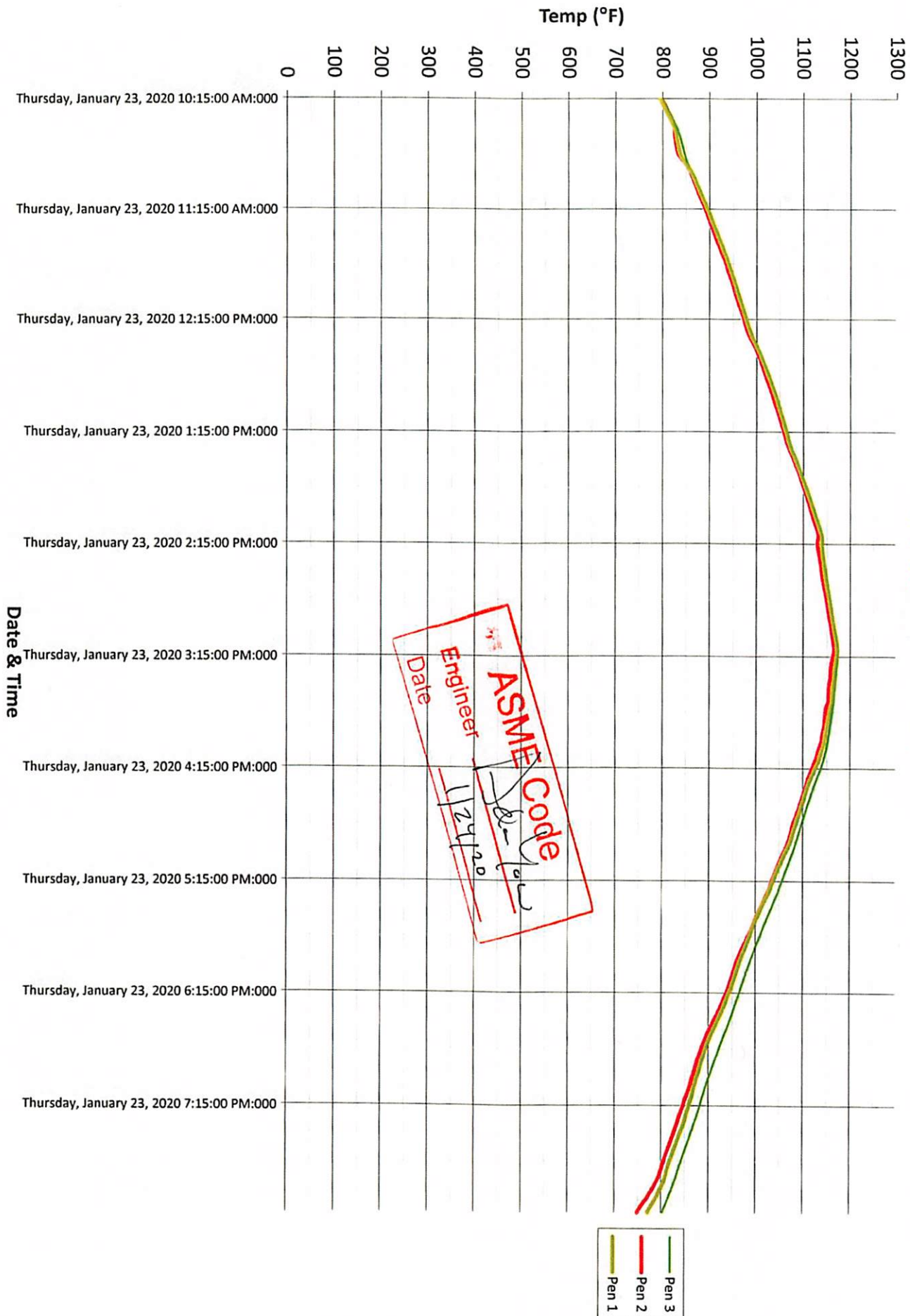
RADIOGRAPHERS SIGNATURE: _____

COMPANY REPRESENTATIVE:

Multi Trend Serial Number:
0751Y776530600001
Date of Calibration: 6/4/2019



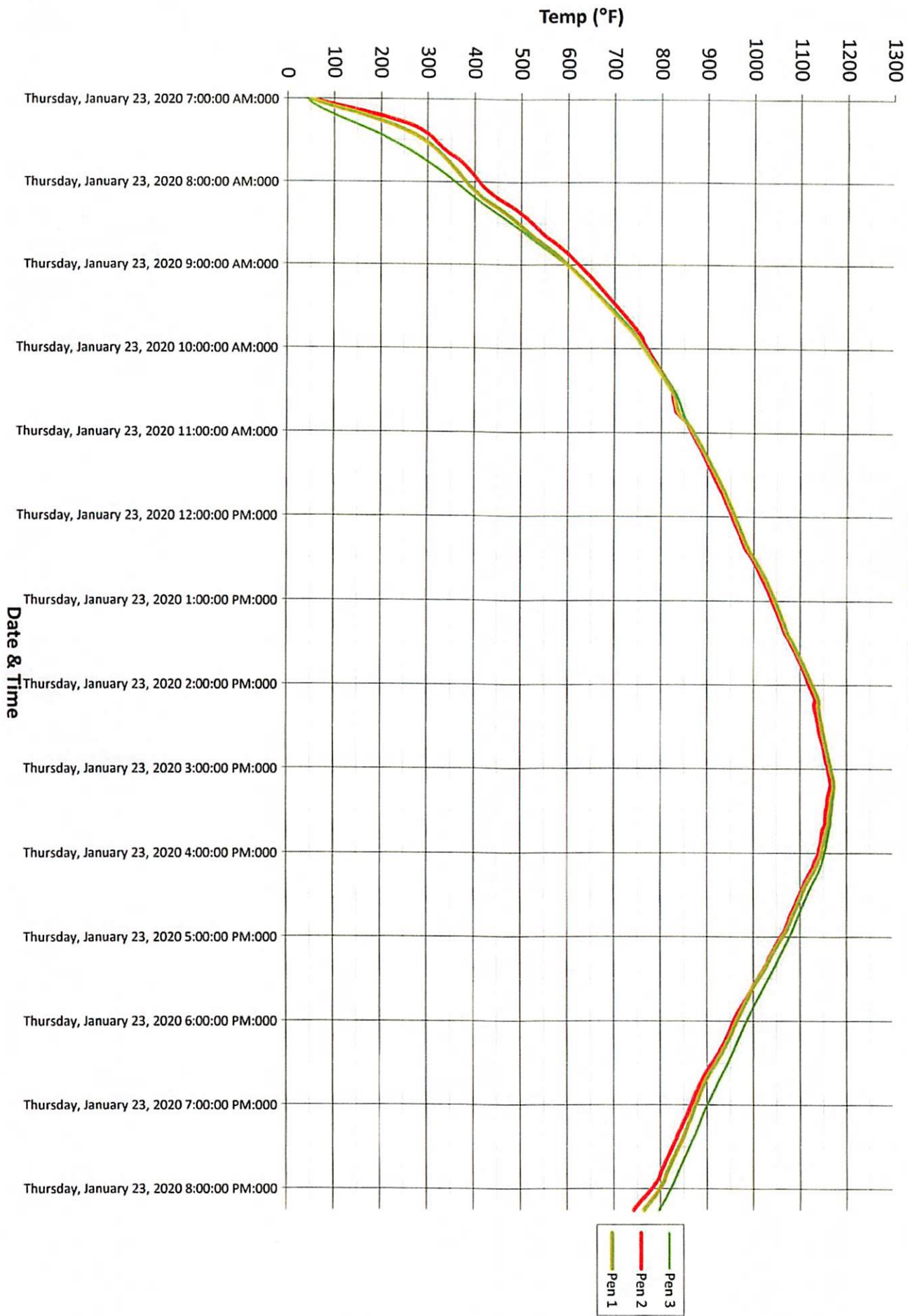
PWHT
Job Number: 014847-10



Muti Trend Serial Number:
0751Y776530600001
Date of Calibration: 6/4/2019



PW/HT
Job Number: 014847-10



Organization:	Tri-Point	Lab Number:	20010362 Rev. 0
Base Material:	1 SA-516-70 to 2 SA-516-70	Heat Number:	S28374
Coupon Dimension:	3" Thick Plate Pos.	Welder Name/ID:	Circle Y ID.
Filler Metal:	GMAW (ER70S-6) FCAW (E71T-1M) SAW (F7 A2 EM12K)	Process(es):	GMAW Root (0.125" Thick) FCAW (0.500" Thick) SAW Fill & Cap (2.375" Thick)
WPS/PQR #:	TP-23	PWHT:	1100°F +/- 25°F for 2 Hours 15 Minutes
Serial Number:	014936 Blanket Test	Project Number:	UP TO 400'

Charpy V-Notch Impact Test per ASTM A370-19, Transverse Across the Weld

Notch Location	Specimen Size, (mm)	Test Temperature, (°F)	Impact Value Individual, (Ft-Lbs)			Impact Value Average, (Ft-Lbs)	Lateral Expansion, (mils)			Shear, (%)		
Weld Metal at 3/4T (SAW Process)	10 x 10	-20	22	25	37	28.0	19	22	26	25	25	30

Comments: Impact values above 80% of the 240 ft-lb scale range of the impact tester are approximate. Impact values below 5 ft-lbs or above 192 ft-lbs are outside of the verified range.

These results MEET the requirements of ASME Sec.VIII (2019), Div.1, Figure UG-84.1

Charpy V-Notch Impact Test per ASTM A370-19, Transverse Across the Weld

Notch Location	Specimen Size, (mm)	Test Temperature, (°F)	Impact Value Individual, (Ft-Lbs)			Impact Value Average, (Ft-Lbs)	Lateral Expansion, (mils)			Shear, (%)		
HAZ 1/4t to 1/2t from Cap Surface (SAW Process)	10 x 10	-20	61	40	41	47.3	43	29	29	35	30	30

Comments: Impact values above 80% of the 240 ft-lb scale range of the impact tester are approximate. Impact values below 5 ft-lbs or above 192 ft-lbs are outside of the verified range.

These results MEET the requirements of ASME Sec.VIII (2019), Div.1, Figure UG-84.1

Comments

Weld metal and HAZ impacts for GMAW process are not required to be tested per ASME Sec.VIII (2019), Div.1, UG-84(h)(5)(c).

All testing performed in accordance with the methods specified in ASME Sec.VIII (2019), Div.1, UG-84

Approved by: Aaron Brewer Date: 1/30/2020 Signature:

Title: Technical Director





American Piping Inspection, Metallurgical Lab
18501 E. Admiral Pl. Catoosa, Oklahoma 74015
Office: (918) 266-4130

Form: MR-3
Established: 10/2/16
Revision: 1
Date: 1/13/17

Mechanical/Lab Test Report

Page 1 of 2

Organization: Tri-Point Lab Number: 20010362 Rev. 0
Base Material: 1 SA-516-70 to 2 SA-516-70 Heat Number: S28374
Coupon Dimension: 3" Thick Plate Pos. Welder Name/ID: Circle Y ID.
Filler Metal: GMAW (ER70S-6) Process(es): GMAW Root (0.125" Thick)
FCAW (E71T-1M) FCAW (0.500" Thick)
SAW (F7 A2 EM12K) SAW Fill & Cap (2.375" Thick)
WPS/PQR #: TP-23 PWHT: 1100°F +/- 25°F for 2 Hours 15 Minutes
Serial Number: 014936 Blanket Test Project Number: UP TO 400'

Charpy V-Notch Impact Test per ASTM A370-19, Transverse Across the Weld

Notch Location	Specimen Size, (mm)	Test Temperature, (°F)	Impact Value Individual, (Ft-Lbs)			Impact Value Average, (Ft-Lbs)	Lateral Expansion, (mils)			Shear, (%)		
Weld Metal 1/16" from Cap Surface (FCAW Process)	10 x 10	-20	40	68	66	58.0	33	49	52	20	30	30

Comments: Impact values above 80% of the 240 ft-lb scale range of the impact tester are approximate. Impact values below 5 ft-lbs or above 192 ft-lbs are outside of the verified range.

These results MEET the requirements of ASME Sec. VIII (2019), Div.1, Figure UG-84.1

Charpy V-Notch Impact Test per ASTM A370-19, Transverse Across the Weld

Notch Location	Specimen Size, (mm)	Test Temperature, (°F)	Impact Value Individual, (Ft-Lbs)			Impact Value Average, (Ft-Lbs)	Lateral Expansion, (mils)			Shear, (%)		
HAZ 1/4t to 1/2t from Cap Surface (FCAW Process)	10 x 10	-20	38	35	35	36.0	31	28	31	20	20	20

Comments: Impact values above 80% of the 240 ft-lb scale range of the impact tester are approximate. Impact values below 5 ft-lbs or above 192 ft-lbs are outside of the verified range.

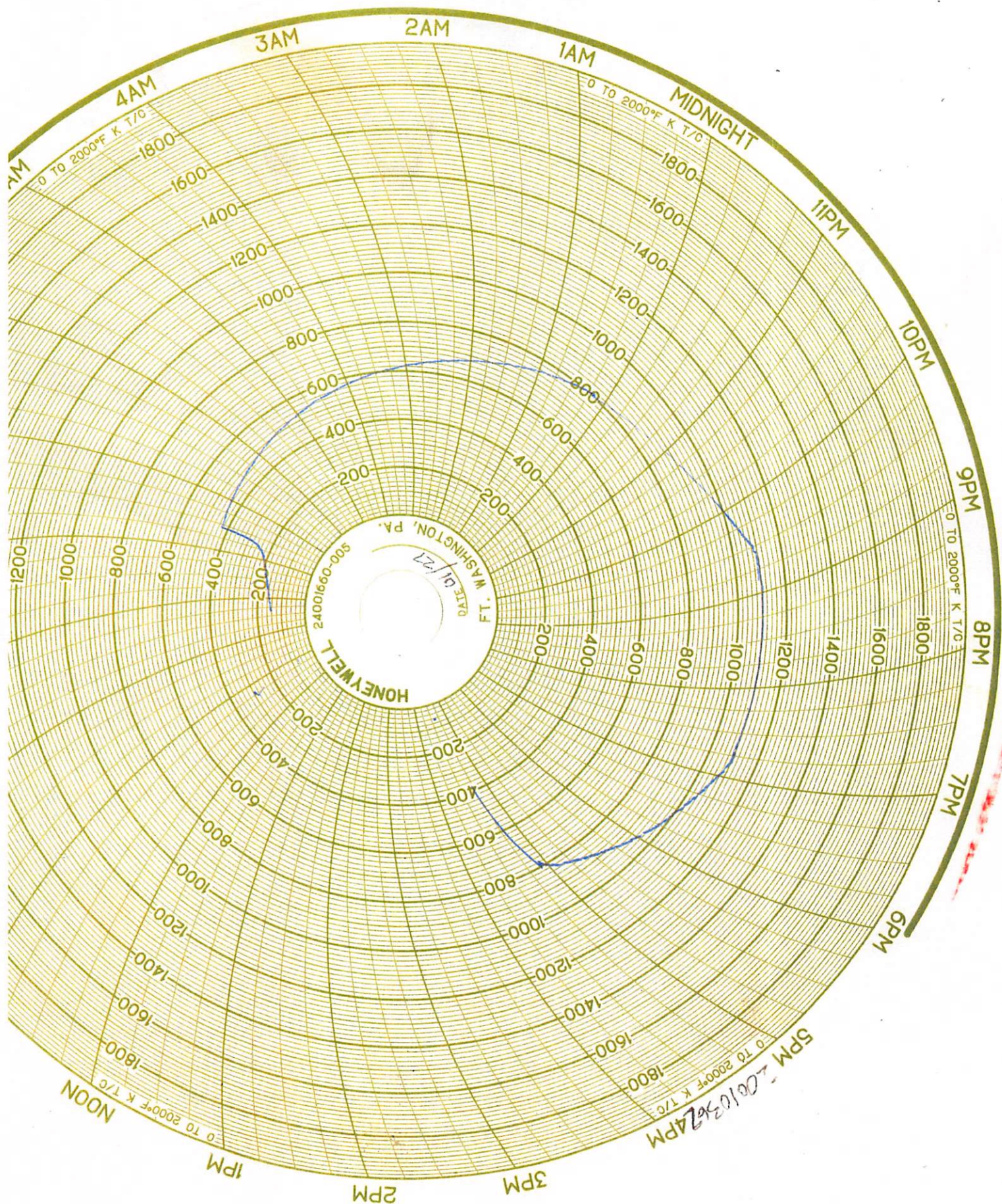
These results MEET the requirements of ASME Sec. VIII (2019), Div.1, Figure UG-84.1

Charpy V-Notch Impact Test per ASTM A370-19, Transverse Across the Weld

Notch Location	Specimen Size, (mm)	Test Temperature, (°F)	Impact Value Individual, (Ft-Lbs)			Impact Value Average, (Ft-Lbs)	Lateral Expansion, (mils)			Shear, (%)		
Weld Metal 1/16" from Cap Surface (SAW Process)	10 x 10	-20	48	77	57	60.7	32	60	42	20	30	20

Comments: Impact values above 80% of the 240 ft-lb scale range of the impact tester are approximate. Impact values below 5 ft-lbs or above 192 ft-lbs are outside of the verified range.

These results MEET the requirements of ASME Sec. VIII (2019), Div.1, Figure UG-84.1



4				3		2		1
MATERIAL LIST				IFS BOM REV. #	1			
MARK	PART NO.	QTY.	DESCRIPTION	COMMENTS	WT.			
1	01-0617-B	1	PIPE 10 3/4in S/40 (0.365) SA-106-B	1'-6" (25° OUTSIDE BEVEL ONE END)	60.7			
2	01-0811-B	1	PIPE 3in S/80 (0.300) SA-106-B	4 1/2" LG. (BBE)	3.9			
3	01-0811-B	1	PIPE 3in S/80 (0.300) SA-106-B	5'-3 1/2" LG. (BOE AND CUT PER DWG.)	53.2			
4	01-1611-C	1	PIPE 3in XXH (0.600) SA-106-C	1 15/16" LG. (BOE)	3.0			
5	01-1611-C	2	PIPE 3in XXH (0.600) SA-106-C	5 5/8" LG. (BBE)	6.6			
6	02-0911-H	1	FLAT BAR 1/8in x 2in SA-36	2" LG. STAMP USING 1/4" LETTERS OUTLET	0.1			
7	02-0911-H	1	FLAT BAR 1/8in x 2in SA-36	2" LG. STAMP USING 1/4" LETTERS INLET	0.1			
8	02-5028-H	2	PLATE 3/8in SA-36	2'-1" x 1'-7" (CUT PER DWG.) (475/355)	75.3			
9	02-5028-H	4	PLATE 3/8in SA-36	1'-7" x 8 5/8" (CUT PER DWG.) (164/126)	53.4			
10	02-5028-H	2	PLATE 3/8in SA-36	5 9/16" x 5 1/2" (CUT PER DWG. AND FORM TO HEAD) (31/24)	5.1			
11	02-5028-H	3	PLATE 3/8in SA-36	8 3/4" x 4" (35/35)	11.1			
12	02-5028-H	2	PLATE 3/8in SA-36	4" x 3" (CUT PER DWG. LUG-005D) (12/11)	0.0			
13	02-5028-H	3	PLATE 3/8in SA-36	3 1/4" x 2" (7/7)	2.1			
14	02-5029-H	1	PLATE 1/2in SA-36	6" x 7" (CUT PER DWG. LUG-002A) (42/31)	4.4			
15	02-5030-I	1	PLATE 5/8in SA-516-70	9 9/16" x 9 9/16" (CUT PER DWG. AND FORM TO HEAD) (91/72)	10.9			
16	02-5033-I	1	PLATE 1in SA-516-70	1'-3 11/16" x 8" (ROLL TO 10 1/2" O.R.) (126/126)	35.2			
17	02-5033-I	1	PLATE 1in SA-516-70	1'-2 1/8" x 8" (ROLL TO 9 1/2" O.R.) (113/113)	31.7			
18	03-0205-I	1	E2:1-10 3/4in-OD x 3/8in SA-516-70 SF 2in	SINGLE 25° OUTSIDE BEVEL	19.5			
19	03-3043-J	2	E2:1-28in OD x 3 1/2in SA-516-70N SF 2in SF	MIN.: 2.9023" (SINGLE 25° OUTSIDE BEVEL) (IMPACT TEST TO -20°F PER UG-84) (ORDER ONE EXTRA PIECE 1'-0" x 2'-0" FOR IMPACT TESTING) (MTR'S AND PDR'S REQUIRED)	1676.2			
20	05-1211-T	1	WELD ELBOW 3in S/80 L.R. 90D SA-234-WPB		6.0			
21	05-5611-T	1	WELD TEE 3in x 3in x 3in XXH SA-234-WPB		12.6			
22	05-9409-N	2	THREADOLET 2in NPT x 9000psi x SA105		9.4			
23	05-9405-H	1	THREADOLET 3/4in NPT x 9000psi x SA-105		1.2			
24	27-5511-H	2	FLANGE 3in CL2500 RTJ WN XXH-B SA-105		187.4			
25	27-6611-H	1	FLANGE 3in CL2500 RTJ x HB-12in SA-105		153.6			
26	27-6811-H	1	FLANGE 3in CL2500 RTJ x HB-16in SA-105		109.7			
27	28-5043-J	1	CYLINDER 28in OD x 3 1/2in THK SA-51670 NORMALIZED	LS#1 = 8'-0" LG. (SINGLE 25° OUTSIDE BEVEL BOTH ENDS) (IMPACT TEST TO -20°F PER UG-84) (ORDER ONE EXTRA PIECE 1'-0" x 2'-0" FOR IMPACT TESTING) (X-RAY 100% ALL LONG SEAMS) (MTR'S AND PDR'S REQUIRED)	7327.4			
28	MSC-051	1	NAME PLATE BRACKET (7 1/2in x 6in) w/HOLES, 10ga. SA-36		3.0			
29	NPL-012-SS	1	TRI-POINT VESSEL NAME PLATE 5" x 6-1/2" x 316 SS		0.9			
TOTAL WEIGHT (LBS):					9942.8			

ISSUED FOR CONSTRUCTION
DATE _____
WORK ORDER #S _____

0A	2019-02-13	AICV	TMR	WEEP HOLE NOTE ADDED
0	2019-03-08	SDM	TMR	ISSUED FOR CONSTRUCTION
NO.	DATE	BY	ENG	DESCRIPTION
01	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
02	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
03	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
04	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
05	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
06	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
07	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
08	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
09	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
10	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
11	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
12	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
13	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
14	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
15	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
16	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
17	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
18	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
19	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
20	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
21	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
22	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
23	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
24	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
25	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
26	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
27	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
28	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
29	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
30	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
31	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
32	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
33	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
34	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
35	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
36	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
37	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
38	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
39	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
40	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
41	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
42	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
43	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
44	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
45	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
46	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
47	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
48	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
49	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
50	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
51	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
52	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
53	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
54	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
55	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
56	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
57	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
58	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
59	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
60	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
61	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
62	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
63	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
64	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
65	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
66	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
67	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
68	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
69	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
70	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
71	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
72	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
73	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
74	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
75	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
76	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
77	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
78	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
79	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
80	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
81	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
82	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
83	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
84	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
85	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
86	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
87	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
88	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
89	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
90	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
91	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
92	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
93	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
94	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
95	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
96	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
97	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
98	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
99	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION
100	2019-03-08	SDM	ENG	ISSUED FOR CONSTRUCTION

DETAIL-INLET DIVERTER PLATES

LEFT ORIENTATION

TOP ORIENTATION

FRONT ORIENTATION

DETAIL-SADDLE

DETAIL-HEAD
SUPPORT REPAD

DETAIL-DRAIN REPAD

RIGHT ORIENTATION

45°	
90°	1"
180°	3"
360°	7'-3 15/16"
26" O.D.	STRAP

WELDING NOTES	W1	W2	W3	W4	W5	W6	W7
1. CHARACTER 'Y' IN MATRIX $\bar{K}$ AND NOTED OTHERWISE. 2. FILLING: OUTER EDGE OF BEARING. 3. ONLY OUTER BEARING BEARING: WELD AND $\bar{K}$ THE. 4. WELD WELD PER BEARING: BEARING. 5. IF BEARING WELD AND OUTER EDGE OF BEARING: BEARING WELD OF BEARING OR BEARING: 1.5 mm.							

PIP	NAME PLATE	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100
7	CLEANOUT	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100
8	PSV	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100
9	DRAIN	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100
10	OUTLET	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100
11	INLET	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100
KEY	SERVICE	QTY.	SIZE	RATING	TYPE	EXP.	HP	PROJECTION										FABRICATION LENGTH										REINFORCEMENT																																																																									

[illegible][illegible]

ISSUED FOR CONSTRUCTION

DATE _____

WORK ORDER #/S _____

NOTES:

- 1.) VESSEL CONSTRUCTED PER ASME CODE
- 2.) SECTION VIII, DIVISION 1, LATEST EDITION
- 3.) DESIGN ALLOWANCE: 0.79125
- 4.) JOINT EFFICIENCIES: (LONG SEAMS) 100%
(GIRTH SEAMS) 90%
(HEAD TO SHELL SEAMS) 100%
- 5.) RADIOGRAPHY: FULL ON ALL LONG AND ROUND SEAMS PER UW-11(f)
- 6.) HEAT TREAT: 2 HOURS @ 500 F MINUTES @ 1100 F
- 7.) IMPACT TEST: YES, PER UW-RA = 20 F
- 8.) HYDROSTATIC TEST: 6500 PSI
- 9.) ALL BASE AND CLANGE HOLES STRADDLE NORMAL CENTERLINES UNLESS OTHERWISE NOTED
- 10.) DIMENSIONS ARE NOT LISTED FOR SPOT WELDS
- 11.) CRACKING: SEE SHOP ORDER

08	2019-10-10-14:00	MAN CORRECTED: WEIG CALCULD	
09	2019-03-03-17:00	WEEP HOLE NOTE ADDED	
10	2019-11-04-08:50	TRIP HESSED FOR CONSTRUCTION	
01	DATE	END	END OF SECTION
02	DATE	END	END OF SECTION
03	DATE	END	END OF SECTION
04	DATE	END	END OF SECTION
05	DATE	END	END OF SECTION
06	DATE	END	END OF SECTION
07	DATE	END	END OF SECTION
08	DATE	END	END OF SECTION
09	DATE	END	END OF SECTION
10	DATE	END	END OF SECTION
11	DATE	END	END OF SECTION
12	DATE	END	END OF SECTION
13	DATE	END	END OF SECTION
14	DATE	END	END OF SECTION
15	DATE	END	END OF SECTION
16	DATE	END	END OF SECTION
17	DATE	END	END OF SECTION
18	DATE	END	END OF SECTION
19	DATE	END	END OF SECTION
20	DATE	END	END OF SECTION
21	DATE	END	END OF SECTION
22	DATE	END	END OF SECTION
23	DATE	END	END OF SECTION
24	DATE	END	END OF SECTION
25	DATE	END	END OF SECTION
26	DATE	END	END OF SECTION
27	DATE	END	END OF SECTION
28	DATE	END	END OF SECTION
29	DATE	END	END OF SECTION
30	DATE	END	END OF SECTION
31	DATE	END	END OF SECTION
32	DATE	END	END OF SECTION
33	DATE	END	END OF SECTION
34	DATE	END	END OF SECTION
35	DATE	END	END OF SECTION
36	DATE	END	END OF SECTION
37	DATE	END	END OF SECTION
38	DATE	END	END OF SECTION
39	DATE	END	END OF SECTION
40	DATE	END	END OF SECTION
41	DATE	END	END OF SECTION
42	DATE	END	END OF SECTION
43	DATE	END	END OF SECTION
44	DATE	END	END OF SECTION
45	DATE	END	END OF SECTION
46	DATE	END	END OF SECTION
47	DATE	END	END OF SECTION
48	DATE	END	END OF SECTION
49	DATE	END	END OF SECTION
50	DATE	END	END OF SECTION
51	DATE	END	END OF SECTION
52	DATE	END	END OF SECTION
53	DATE	END	END OF SECTION
54	DATE	END	END OF SECTION
55	DATE	END	END OF SECTION
56	DATE	END	END OF SECTION
57	DATE	END	END OF SECTION
58	DATE	END	END OF SECTION
59	DATE	END	END OF SECTION
60	DATE	END	END OF SECTION
61	DATE	END	END OF SECTION
62	DATE	END	END OF SECTION
63	DATE	END	END OF SECTION
64	DATE	END	END OF SECTION
65	DATE	END	END OF SECTION
66	DATE	END	END OF SECTION
67	DATE	END	END OF SECTION
68	DATE	END	END OF SECTION
69	DATE	END	END OF SECTION
70	DATE	END	END OF SECTION
71	DATE	END	END OF SECTION
72	DATE	END	END OF SECTION
73	DATE	END	END OF SECTION
74	DATE	END	END OF SECTION
75	DATE	END	END OF SECTION
76	DATE	END	END OF SECTION
77	DATE	END	END OF SECTION
78	DATE	END	END OF SECTION
79	DATE	END	END OF SECTION
80	DATE	END	END OF SECTION
81	DATE	END	END OF SECTION
82	DATE	END	END OF SECTION
83	DATE	END	END OF SECTION
84	DATE	END	END OF SECTION
85	DATE	END	END OF SECTION
86	DATE	END	END OF SECTION
87	DATE	END	END OF SECTION
88	DATE	END	END OF SECTION
89	DATE	END	END OF SECTION
90	DATE	END	END OF SECTION
91	DATE	END	END OF SECTION
92	DATE	END	END OF SECTION
93	DATE	END	END OF SECTION
94	DATE	END	END OF SECTION
95	DATE	END	END OF SECTION
96	DATE	END	END OF SECTION
97	DATE	END	END OF SECTION
98	DATE	END	END OF SECTION
99	DATE	END	END OF SECTION
100	DATE	END	END OF SECTION

QW-484 MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR QUALIFICATION TESTS (WPQ)

(See QW-301, Section IX, ASME Boiler and Pressure Vessel Code)

saw2

Company name	TRIPOINT		Welder's Name	Modesto Ortega	
	701 S. Eastern		Welder's Stamp	Circle Y	
	Elk City, Oklahoma 73644		Date of Test	05/02/2018	
Welding Process	(1) SAW	(2)	(3)		
Process Type	(1) Machine	(2)	(3)		
WPS used	(1) SFI-2	(2)	(3)		
Base material used	SA-516-70	to	SA-516-70	Thickness	1"

Manual or Semiautomatic Variables for Each Process (QW-350)

Backing (QW-402)	Actual Values	Range Qualified
ASME P-No. (QW-403)	Weld Metal	With Backing
☒ Plate ☐ Pipe	P1 to P1	P1 thru 11 to P1 thru 11
Filler metal Specification (QW-404)	Flat	2 7/8" OD & up
	SFA Spec. 5.17	
	Classification F7A2-EM12K	
	F-No. F6	
Consumable insert for GTAW or PAW	NA	
Deposited weld metal thickness for each process	(1) .875" (8 layers)	Max to be welded
	(2)	
	(3)	

Welding position (QW-405)	Flat	Flat
Weld progression (uphill or downhill)	NA	
Backing Gas	NA	
GMAW transfer mode (QW-409)	NA	
GTAW welding current type/polarity	NA	

Machine Welding Variables for the Process Used (QW-360)	Actual Values	Range Qualified
Direct/remote visual control	Direct	Direct
Automatic voltage control (GTAW)	NA	NA
Automatic joint tracking	Manual	Manual or Automatic
Welding position (1G, 5G, etc.)	1G	1G
Consumable insert	NA	NA
Backing (metal, weld metal, welded both sides, flux, etc.)	Weld Metal	With Backing
Single pass or Multiple pass per side	Multiple	Multiple or Single

Guided Bend Test Results

Guided Bend Tests Type	☐ QW-462.2 (Side)	☐ QW-462.3(a) (Tran. R & F)	☐ QW-462.3(b) (Long. R & F)

Radiographic Test Results (QW-304 & QW-305) No defects per American Piping Inspection

Fillet Weld Fracture Test Length & percent of defects

Macro test fusion Fillet leg size in. x Concavity/Convexity in.

Welding Tests conducted by SUPERIOR FABRICATION, INC.

Mechanical Tests conducted by Lab. test No. Circle Y 5

Visual Examination, By Tri-Point LLC Results Visually acceptable

We certify that the statements in this record are correct and that the test coupons were prepared, welded, and tested in accordance with the requirements of Section IX of the ASME code.

Date 05/02/2018 By SUPERIOR FABRICATION, INC. Elk City, Oklahoma Title Q.C. Manager

QW-484 MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR QUALIFICATION TESTS (WPQ)

(See QW-301, Section IX, ASME Boiler and Pressure Vessel Code)

short6-2xxh

Company name	SUPERIOR FABRICATION, INC.		Welder's Name	Modesto Ortega
	701 S. Eastern		Welder's Stamp	Circle Y
	Elk City, Oklahoma 73644		Date of Test	3/16/2015
Welding Process	(1) GMAW Short-Arc	(2)	(3)	
Process Type	(1) Semi-Auto.	(2)	(3)	
WPS used	(1) SFI-3	(2)	(3)	
Base material used	SA-106-B	to SA-106-B	Thickness	.436"

Manual or Semiautomatic Variables for Each Process (QW-350)

	Actual Values	Range Qualified
Backing (QW-402)	None	With or Without
ASME P-No. (QW-403)	P1 to P1	P1 to P11 to P1 to P11
☐ Plate ☐ Pipe	Pipe diameter 2.375"	1" OD & above
Filler metal Specification (QW-404)	SFA Spec. 5.18	
	Classification ER70S6	
	F-No. F6	F6
Consumable insert for GTAW or PAW	NA	NA
Deposited weld metal thickness for each process	(1) .436"	.48"
	(2)	
	(3)	

Welding position (QW-405)	6G	6G
Weld progression (uphill or downhill)	Uphill and Downhill	Either
Backing Gas or Fuel Gas (QW-408)	None	May be used
GMAW transfer mode (QW-409)	Short Arc	Short Arc
GTAW welding current type/polarity	NA	NA

Machine Welding Variables for the Process Used (QW-360)

	Actual Values	Range Qualified
Direct/remote visual control	NA	NA
Automatic voltage control (GTAW)	NA	NA
Automatic joint tracking	NA	NA
Welding position (1G, 5G, etc.)	NA	NA
Consumable insert	NA	NA
Backing (metal, weld metal, welded both sides, flux, etc.)	NA	NA

Guided Bend Test Results

Guided Bend Tests Type	☒ QW-462.2 (Side)	☐ QW-462.3(a) (Tran. R & F)	☐ QW-462.3(b) (Long. R & F)
Side Bend #1	Bent Satisfactorily		
Side Bend #2	Bent Satisfactorily		
Side Bend #3	Bent Satisfactorily		
Side Bend #4	Bent Satisfactorily		

Visual Examination (QW-302.4), By SUPERIOR FABRICATION, INC. Results Visually acceptable

Radiographic Test Results (QW-304 & QW-305)

Fillet Weld Fracture Test Length & percent of defects

Macro test fusion Fillet leg size in. x Concavity/Convexity in.

Welding Tests conducted by SUPERIOR FABRICATION, INC.

Mechanical Tests conducted by Superior Fabrication, Inc. Lab. test No. Circle Y 3

We certify that the statements in this record are correct and that the test coupons were prepared, welded, and tested in accordance with the requirements of Section IX of the ASME code.

Date 3/16/2015 By *Tom Stiles* Title Q.C. Manager

SUPERIOR FABRICATION, INC. Elk City, Oklahoma

QW-484 MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR QUALIFICATION TESTS (WPQ)

(See QW-301, Section IX, ASME Boiler and Pressure Vessel Code)

fcaw-6G-XXH

Company name SUPERIOR FABRICATION, INC. Welder's Name Modesto Ortega
701 S. Eastern Welder's Stamp Circle Y
Elk City, Oklahoma 73644 Date of Test 3/16/2015

Welding Process (1) FCAW (2) _____ (3) _____
Process Type (1) Semi-Auto. (2) _____ (3) _____
WPS used (1) SFI-3 (2) _____ (3) _____
Base material used SA-106-B to SA-106-B Thickness .436"

Manual or Semiautomatic Variables for Each Process (QW-350)

Backing (QW-402) None Range Qualified With or Without
ASME P-No. (QW-403) P1 to P1 P1 to P11 to P1 to P11
☐ Plate ☐ Pipe Pipe diameter 2.375" 1" OD & above
Filler metal Specification (QW-404) SFA Spec. 5.20
Classification E71T-1
F-No. F6
Consumable insert for GTAW or PAW NA
Deposited weld metal thickness for each process (1) .436" .872"
(2) _____
(3) _____

Welding position (QW-405) 6G 6G
Weld progression (uphill or downhill) Uphill and Downhill Either
Backing Gas or Fuel Gas (QW-408) None May be used
GMAW transfer mode (QW-409) NA NA
GTAW welding current type/polarity NA NA

Machine Welding Variables for the Process Used (QW-360)

Direct/remote visual control NA NA
Automatic voltage control (GTAW) NA NA
Automatic joint tracking NA NA
Welding position (1G, 5G, etc.) NA NA
Consumable insert NA NA
Backing (metal, weld metal, welded both sides, flux, etc.) NA NA

Guided Bend Test Results

Guided Bend Tests Type ☐ QW-462.2 (Side) ☐ QW-462.3(a) (Tran. R & F) ☐ QW-462.3(b) (Long. R & F)

Side Bend #1	Bent Satisfactorily		
Side Bend #2	Bent Satisfactorily		
Side Bend #3	Bent Satisfactorily		
Side Bend #4	Bent Satisfactorily		

Visual Examination (QW-302.4), By SUPERIOR FABRICATION, INC. Results Visually acceptable

Radiographic Test Results (QW-304 & QW-305) _____

Fillet Weld Fracture Test _____ Length & percent of defects _____

Macro test fusion _____ Fillet leg size _____ in. x _____ Concavity/Convexity _____ in.

Welding Tests conducted by SUPERIOR FABRICATION, INC.

Mechanical Tests conducted by Superior Fabrication, Inc. Lab. test No. Circle Y 7

We certify that the statements in this record are correct and that the test coupons were prepared, welded, and tested in accordance with the requirements

of Section IX of the ASME code.

SUPERIOR FABRICATION, INC. Elk City, Oklahoma

Date 3/16/2015

By Tom [Signature]

Title Q.C. Manager

TASK [Tarea]	HOLD POINT	INITIALS & DATE [Iniciales y fecha]		
		COMPLETED	SUPERVISOR	QC
SHELL [Cilindro]				
VERIFY MATERIALS (Specification & Size, as appropriate) [Verificar materiales] (Especificaciones & dimensiones, apropiadamente)	NO	MO		
PREP AND LAYOUT SHELL (Hole & attachment locations & sizes, scribe hole to be cut on steel, mark bevel size) [Preparacion y trazo del cilindro] (Agujeros y ubicacion de accesorios y tamano, trazar agujeros en el metal, marcar y biselar)	YES	MO	AB/OK/12-2	NB/12/2
CUT HOLES AND BEVEL AS REQUIRED [Cortar agujeros y biselar apropiadamente]	NO	MO		
FIT NOZZLES AND ATTACHMENTS [Presentar boquillas y otros accesorios]	YES	MO	AB/OK	NB/✓
WELD-OUT SHELL NOZZLES AND ATTACHMENTS [Soldar boquillas y otros accesorios]	NO	MO		
VISUAL WELD INSPECTION, SHELL (per QA.001; Weld defects, Material condition, Welder stencil, etc.) [Inspeccion visual, del cilindro] (de acuerdo con QA.001, defectos de soldadura, condicion del material, stencil del soldador, etc)	YES	MO	AB/OK	NB/✓
COMPLETE/VERIFY HEAT/WELD MAP (ENTER/WRITE HEAT NUMBER) [Completar/Verificar Mapa de Soldadura, escribir numero de colada del material]	NO			
INTERNALS/CLOSURE				
HANG & FIT FIRST HEAD [Colgar y Presentar Primera Cabeza]	YES	MO	AB/OK/1-10-20	AW/1/10
WELD-OUT FIRST HEAD ROUND SEAM [Soldar circunferencia de la primera Cabeza]	NO	MO	AB/OK/1-10-20	
LAYOUT AND FIT INTERNAL ATTACHMENTS [Trazado interno y presentar los accesorios internos]	YES	MO	AB/OK/1-10-20	AW/1/10
WELD-OUT INTERNALS [Soldar accesorios internos]	NO	MO		
VISUAL WELD INSPECTION, INTERNALS **THIS IS AN AI HOLD POINT** (per QA.001; Weld defects, Material condition, Round/chamfer corners, etc.) [Inspeccion visual, de accesorios internos] ** SE REQUIERE EL INSPECTOR ASME** (de acuerdo con QA.001, defectos de soldadura, condicion del material, stencil del soldador, etc)	YES	MO	AB/OK/1-10-20	AW/1/10
WATER LEAK TEST BUCKET & WEIR (when so equipped) [Cubo y Prueba de Fugas de Agua] (cuando esta equipado)	YES			
HANG & FIT CLOSING HEAD [Colgar y Presentar Segunda Cabeza]	YES	MO	AB/OK/1-10-20	AW/1/10
WELD-OUT CLOSING ROUND SEAM & PRESSURE BOUNDARY [Soldar circunferencia de la segunda Cabeza y barrera de presion]	NO	MO	AB/OK/1-10-20	
LAYOUT & FIT SADDLES/SKIRT/BASE, AS REQUIRED [Trazar y presentar montaduras/falda/base, apropiadamente]	YES	MO	AB/OK/1-10-20	NB/✓
WELD-OUT SADDLES/SKIRT/BASE [Soldar montaduras/falda/base]	NO	MO		
COMPLETION/TESTING [Final/Prueba]				
FINAL VISUAL WELD INSPECTION (per QA.001; Weld defects, Material condition, Welder stencils, etc.) [Inspeccion visual de soldadura] (de acuerdo con QA.001, defectos de soldadura, condicion del material, stencil del soldador, etc)	YES	MO	AB/OK/1-10-20	NB/✓
WELD PICK-UP (Repairs completed) [Defectos corregidos]	YES			
NONDESTRUCTIVE EXAMINATION (RT, UT, MT, PT on round & long seams, lifting lugs and nozzle penetrations, as required) [Inspeccion no destructiva] (Rayos X, Ultrasonido, Particulas Magneticas, Tinte Penetrante en las soldaduras de Cabeza, Cilindro y accesorios de acuerdo a lo requerido)	YES			
NDE REPAIRS, AS REQUIRED (QC to schedule retesting) [Corregir defectos encontrados en la inspeccion no destructiva] (QC debe programar repetir pruebas no destructivas que fallaron)	NO			
NONDESTRUCTIVE EXAMINATION OF REPAIRS (RT, UT, MT, PT, as required) [Pruba no destructiva en las soldaduras corregidas]	YES			
TRIAL FIT LADDERS/PLATFORMS, ETC, AS REQUIRED (QC document with pictures)	YES			

VESSEL INFORMATION [Informacion del Recipiente de Presion]	
SERIAL NUMBER: [Numero de Serial] 014847-10	CUSTOMER: [Cliente] STOCK
PROJECT NUMBER: [Numero de Proyecto] PJ 20729	VESSEL DESCRIPTION: 28"OD x 8'0" x 5000# 3rd [Descripcion del Recipiente de Presion] SELF
PROJECT MANAGER: [Gerente de Proyecto]	DRAWING: 014847-DSS-VES REV:
REMARKS: [Comentarios]	

PRESSURE VESSEL FABRICATION [Fabrication del Recipiente de Presion]				
TASK [Tarea]	HOLD POINT	INITIALS & DATE [Iniciales y fecha]		
		COMPLETED	SUPERVISOR	QC
FIRST HEAD [Primera Cabeza]				
VERIFY MATERIALS (Specification & Size, as appropriate) [Verificar materiales] (Especificaciones & dimensiones, apropiadamente)	NO			
PREP AND LAYOUT HEAD (Hole & attachment locations & sizes, scribe hole to be cut on steel, mark bevel size) [Preparacion y trazo de la Cabeza] (Agujeros y ubicacion de accesorios y tamano, trazar agujeros en el metal, marcar y biselar)	YES	MO	AB OK 12-3	AW 12/3
CUT HOLES AND BEVEL AS REQUIRED [Cortar agujeros y biselar apropiadamente]	NO	MO		
FIT NOZZLES AND ATTACHMENTS [Presentar boquillas y otros accesorios]	YES	MO	AB OK	AW
WELD-OUT HEAD SUB-ASSEMBLY [Soldar Cabeza y Accesorios]	NO	MO		
VISUAL WELD INSPECTION, FIRST HEAD (per QA.001; Weld defects, Material condition, Welder stencil, etc.) [Inspeccion visual, de la primera Cabeza] (de acuerdo con QA.001, defectos de soldadura, condicion del material, stencil del soldador, etc)	YES	MO	AB OK	AW
COMPLETE/VERIFY HEAT/WELD MAP (ENTER/WRITE HEAT NUMBER) [Completar/Verificar Mapa de Soldadura, escribir numero de colada del material]	NO			
SECOND HEAD [Segunda Cabeza]				
VERIFY MATERIALS (Specification & Size, as appropriate) [Verificar materiales] (Especificaciones & dimensiones, apropiadamente)	NO	MO		
PREP AND LAYOUT HEAD (Hole & attachment locations & sizes, scribe hole to be cut on steel, mark bevel size) [Preparacion y trazo de la Cabeza] (Agujeros y ubicacion de accesorios y tamano, trazar agujeros en el metal, marcar y biselar)	YES	MO	AB OK 1-10-00	AW 1/10
CUT HOLES AND BEVEL AS REQUIRED [Cortar agujeros y biselar apropiadamente]	NO			
FIT NOZZLES AND ATTACHMENTS [Presentar boquillas y otros accesorios]	YES	MO	AB OK	AW
WELD-OUT HEAD SUB-ASSEMBLY [Soldar Cabeza y Accesorios]	NO	MO		
VISUAL WELD INSPECTION, FIRST HEAD (per QA.001; Weld defects, Material condition, Welder stencil, etc.) [Inspeccion visual, de la primera Cabeza] (de acuerdo con QA.001, defectos de soldadura, condicion del material, stencil del soldador, etc)	YES	MO	AB OK 1-20	XIB
COMPLETE/VERIFY HEAT/WELD MAP (ENTER/WRITE HEAT NUMBER) [Completar/Verificar Mapa de Soldadura, escribir numero de colada del material]	NO	MO		

MISC. REMARKS [Otras notas o comentarios]
REMARKS [Notas o comentarios]:

MANUFACTURING FINAL INSPECTION SIGN-OFF
[Firma de Inspeccion Final de Manufactura]

DATE OF FINAL INSPECTION
[Fecha de Inspeccion Final]

QC FINAL INSPECTION SIGN-OFF
[Firma de Inspeccion Final de Control de Calidad]

DATE OF FINAL INSPECTION
[Fecha de Inspeccion Final]

[Presentar preliminarmente la escalera, plataforma y otros] (QC debe documentar esto con fotos)				
PWHT, AS REQUIRED (Chart downloaded, if performed in-house, QC need only sign-off if subcontracted))	YES			
[Tratamiento termico] (carta de registro requerida, si es ejecutado en la planta, si es ejecutado por un contratista QC solo necesita firmar)				
HARDNESS TESTING, AS REQUIRED	YES			
[Prueba de dureza, de acuerdo a lo requerido]				
PRE-HYDRO INSPECTION (Check inside and outside of vessel for any concerns or obstructions)				
[Antes de Hydro Inspeccion] (Chequear interior y exterior del tanque por obstrucciones o algun defecto)				
HYDROSTATIC TESTING **THIS IS AN AI HOLD POINT** (QC to download crystal gauge data)	YES			NB 13/2
[Prueba hidrostática] ** SE REQUIERE EL INSPECTOR ASME** (QC debe obtener data del registrador)				
POST-HYDRO INSPECTION (Assure all water is drained and dry with compressed air)				
[Despues de Hydro Inspeccion] (asegurarse de drenar el agua del tanque y secar con aire comprimido)				
ATTACH VESSEL NAMEPLATE AND APPLY ASME & NB STAMPS	NO			
[Colocar placa del recipiente de presion y las estampas de ASME y NB]				
SURFACE PREPARATION & COATING [Preparacion de Superficies y revestimiento interno]				
INTERNAL SURFACE PREPARATION (Record atmospheric conditions)	NO			
[Preparacion de la superficie interna] (Registrar las condiciones atmosfericas)				
INSPECT SURFACE PREPARATION (Appearance, anchor pattern & welding)	YES			
[Inspeccionar la preparacion de la superficie interna] (Apariencia, anclaje y soldadura)				
INTERNAL FIRST COAT (Record atmospheric conditions and DFTs)	NO			
[Primera capa de revestimiento interno] (Registrar las condiciones atmosfericas y el espesor de la capa seca)				
INTERNAL FINISH COAT (Record atmospheric conditions and DFTs)	YES			
[Capa final de revestimiento interno] (Registrar las condiciones atmosfericas y el espesor de la capa seca)				
INTERNAL HOLIDAY TESTING, AS REQUIRED	YES			
[Prueba para detectar discontinuidades, de acuerdo a lo requerido]				
EXTERNAL SURFACE PREPARATION (Record atmospheric conditions)	NO			
[Preparacion de la superficie externa] (Registrar las condiciones atmosfericas)				
INSPECT SURFACE PREPARATION (Appearance, anchor pattern & welding)	YES			
(Inspeccionar la preparacion de la superficie) (Apariencia, anclaje y soldadura)				
EXTERNAL PRIME COAT (Record atmospheric conditions and DFTs)	NO			
[Primera capa base de revestimiento externo] (Registrar las condiciones atmosfericas y el espesor de la capa seca)				
EXTERNAL INTERMEDIATE COAT (Record atmospheric conditions and DFTs)	NO			
[Capa intermedia de revestimiento externo] (Registrar las condiciones atmosfericas y el espesor de la capa seca)				
EXTERNAL FINISH COAT (Record atmospheric conditions and DFTs)	YES			
[Capa final de revestimiento externo] (Registrar las condiciones atmosfericas y el espesor de la capa seca)				
EXTERNAL HOLIDAY TESTING, AS REQUIRED	YES			
[Prueba para detectar discontinuidades, de acuerdo a lo requerido]				

PROJECT INFORMATION	
PROJECT NUMBER:	20729
PROJECT MANAGER:	Tim Rickle
PROJECT ENGINEER:	
UNIT SERIAL NUMBER:	014847-10
CUSTOMER:	Stock
DESCRIPTION:	Sand Sep #10
DRAWING & REV:	014847-1055-Skp
SHOP ORDER:	38231
REMARKS:	

[illegible]