

W May 27, 2026
D&F 05/27/2026

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

0716980

1. Manufactured and certified by Bilton Welding and Manufacturing LTD., 5815 - 37th Street, Innisfail Alberta, T4G 1S8, Canada.
(Name and address of Manufacturer)

2. Manufactured for Keyera Partnership/Keyera Corp. 144-4th Avenue S.W. Calgary, AB, T2P 3N4, Canada

3. Location of installation L.S.D. 05-22-063-01 W6M
(Name and address)

4. Type: Horizontal Vessel 19463 AA6790.2 BWM-1108-100, 201, 202, 203 N/A 2026
(Horizontal or vertical, tank) (Manufacturer's serial number) (CRN) (Drawing number) (National Board number) (Year built)
Rev 0

5. ASME Code, Section VIII, Div. I 2023 Ed N/A N/A
(Edition and Addenda, if applicable (date)) (Code Case number) [Special Service per UG-120(d)]

6. Shell SA-516-70N 0.625" 0.0625" 96" ID 20'-0" S/S
(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	

7. Seams: Type 1 Full 100% N/A N/A Type 1 Full 100% 2
[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 N/A (b) Material SA-516-70N N/A
(Spec. no., grade, PWHT) (Spec. no., grade, PWHT)

	Location (Top, Bot, Ends)	Minimum Thickness	Corrosion Allowance	Crown Radius	Knuckle Radius	Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Dia.	Side to Pressure	Category A		
											TYPE	Ful, Spot, None	Eff
(a)	Head 1	0.4385"	0.0625"			2:1				Concave			
(b)	Head 2	0.4385"	0.0625"			2:1				Concave			
(c)	Boot Head	0.4375"	0.0625"			2:1				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)													

9. MAWP 152 PSI FV at max temp. 113°F 113°F
(Internal) (External) (Internal) (External)

Min. design metal temp. -49°F At 152 PSI Hydro., pneu., or comb. test press. 199 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	
N1, N10 - Inlet, Vent	2	6 NPS	RFWN CL150	SA-333-6	SA-350-FL2 CL1	0.562"	0.0625"	N/A	UW-16.1(e)	Type 1	Shell
N2 - Thief Hatch/Future Outlet	1	8 NPS	RFWN CL150	SA-333-6	SA-350-FL2 CL1	0.500"	0.0625"	SA-516-70N	UW-16.1(e)	Type 1	Shell
N3, N6 - Truck Out, Future Purge Gas	2	2 NPS	RFWN CL150	SA-333-6	SA-350-FL2 CL1	0.344"	0.0625"	N/A	UW-16.1(e)	Type 1	Shell
N4, N5 - LIT	2	4 NPS	RFWN CL150	SA-333-6	SA-350-FL2 CL1	0.438"	0.0625"	N/A	UW-16.1(e)	Type 1	Shell
N7 - Bucket Drain	1	3 NPS	RFWN CL150	SA-333-6	SA-350-FL2 CL1	0.438"	0.0625"	N/A	UW-16.1(e)	Type 1	Shell
N8 - Pump Inlet	1	4 NPS	RFLWN CL150	SA-350-LF2 CL1	N/A	0.750"	0.0625"	N/A	UW-16.1(e)	N/A	M1 Blind Cover
N9 - Clean Out	1	1 NPS	RFWN CL150	SA-333-6	SA-350-FL2 CL1	0.250"	0.0625"	N/A	UW-16.1(e)	Type 1	M1 Blind Cover
M1 - Manway	1	24 NPS	RFWN CL150	SA-333-6	SA-350-FL2 CL1	0.500"	0.0625"	SA-516-70N	UW-16.1(e)	Type 1	Shell
B1 - Boot	1	24 NPS	-	SA-333-6	N/A	0.500"	0.0625"	SA-516-70N	UW-16.1(e)	N/A	Shell
-	-	-	-	-	-	-	-	-	-	-	-

11. Supports: Skirt No Lugs 0 Leg 0 Other 2 Saddles Attached Welded to Shell
(Yes Or No) (Number) (Number) (Describe) (Where and how)

FORM U-1A

Manufactured By Bilton Welding and Manufacturing LTD.
 Manufacturer's Serial No. 19463 CRN AA6790.2 National Board No. N/A

12. Remarks: Manufacturer's Partial Data Reports properly identified and signed by Commissioned Inspectors have been furnished for the following items of the report: None

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

Const. Dwg: D7766-100 Rev 1, D7766-201 Rev 1, D7766-202 Rev 1, D7766-203 Rev 0

PSVs on piping installed by Owner per UG-151.

Volume: 1,158 ft³ (32.77 m³)

Hot Formed Head, Shell, and Repad Material: SA-516-70N: Impacts exempt per UCS-66 Curve D. Shell impacts exempt per UCS-66.1(b)(1)(-b)

Flange Material: SA-350-LF2 CL1: Impact exempt per UCS-66(g)

Pipe Material: SA-333-6: Impacts exempt per UCS-66(g)

Bolting Material: SA-193-B7M / SA-194-2HM: Impact exempt as per Fig. UCS-66(c)

Production Welds: Impact exempt as per UCS-67(a)(3)

M1: 24" CL150 RF Blind SA-350-LF2 CL1, Bolting: UNC: (20) 1 1/4" X 7" LG studs, (40) 1 1/4" hex nuts.

Loadings Considered as per U-2(a)(2)(-a)(-1) as per UG-22(c) and U-2(a)(2)(-a)(-3) as per UG-22(f)

Hydro Tested in Horizontal Position

Radiography: RT-1 as per UW-11(a) and 100% of all pressure retaining butt welds

Vessel Type: Flare Knock Out Drum/Sump Tank

Empty Weight: 19,432 LBS

Bilton Welding and Manufacturing LTD. Job # D7766

The vessel design has been validated for the specified requirements and external loadings. Operation Outside these parameters requires re-evaluation

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 33470 expires August 11, 2027.

Date May 27 / 2026 Co. name Bilton Welding and Manufacturing LTD. Signed [Signature]
 (Manufacturer) (Representative)

CERTIFICATE OF SHOP/FIELD INSPECTION

Vessel constructed by Bilton Welding and Manufacturing LTD at 5815 - 37th Street, Innisfail, AB T4G 1S8, Canada

I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and employed by Alberta Boilers Safety Association (ABSA) of Alberta

have inspected the component described in this Manufacturer's Data Report on May 27, 2026, 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 May 27, 2026 Signed [Signature] Commissions NB17200 D00010464
 (Authorized Inspector) (National Board Authorized Inspector Commission number)