



BOILERS BRANCH

AFFIDAVIT OF MANUFACTURER

Covering Boiler or Pressure Vessel

As Approved by the Boiler & Pressure Vessel Committee of the C.S.A.

Upon shipment of Boiler or Pressure Vessel this form fully and correctly filled in and attested to must be mailed to the office of the Chief Inspector in the province of installation in accordance with the regulations under The Act governing the construction and installation of boilers and pressure vessels, otherwise the use of same may be prohibited or the working pressure severely penalized.

- Manufactured by James United Steel Limited, 141 - 71st Avenue S.E., Calgary, Alberta.
(Name and Address of Manufacturer)
Manufactured for Blue Flame Propane Limited, P.O. Box 6087, Stn. "C", Edmonton, Alberta.
(Name and Address of Purchaser or Consignee)
Ultimate owner _____
(Name and Address)
Location of installation Grande Prairie, Alberta.
(This address is essential)
- Type of boiler or pressure vessel Propane Storage Tank Mfg. Serial No. RR 2407
Provincial Registration No. 9493 ~~1234~~ Drwg. No. _____
To be used for: (Air, CO₂, Propane, Ammonia, Steam, Hot Water, etc.) Propane
- Dia. 96" Overall length 50' Cu. ft. capacity 2400 Heating surface _____ sq. ft.
- Were test reports checked on all plates used in the fabrication of this vessel? Yes
Does all material meet A.S.M.E. Code requirements? Yes
A.S.M.E., A.S.T.M. or other material specification No. A 212 B Tensile strength 70,000
- Fabrication to A.S.M.E. Code, Para. No. 1966 Preheat _____ °F Post Heat _____ X.R. Spot
(Year) (Yes or No) (Spot or Complete)
Are the following records on mfg's files? X-ray films No Postweld heat procedure No
Were X-ray films examined and found to meet Code requirements? Yes
- Welders employed upon vessel.

Name of welders and Province or State in which qualified	Identifying Symbol	Date of last weld test	Qualified for welding under Code Para.	Name of Inspector supervising tests	National Board No.
<u>W. Groszeki</u>	<u>D</u>	<u>Mar. 67</u>	<u>Sec. 9</u>	<u>J. Gatez</u>	<u>- - -</u>
<u>L. Peng</u>	<u>8</u>	<u>Apr. 67</u>	<u>Sec. 9</u>	<u>J. Pavay</u>	<u>- - -</u>
<u>B. Kaiser</u>	<u>C</u>	<u>Apr. 67</u>	<u>Sec. 9</u>	<u>J. Pavay</u>	<u>- - -</u>

Does all welding on this vessel and the testing of coupons where required meet A.S.M.E. Code requirements? Yes

7. Hydrostatic tests and Working Pressures.

NAME OF PART	Temperature of Testing Medium	Final test psi.	Maximum working pressure psi.	Maximum operating temperature degrees F.
<u>Entire Vessel</u>	<u>67°</u>	<u>375</u>	<u>250</u>	<u>150°</u>

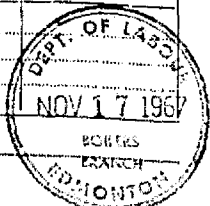
Did the hydrostatic tests fully conform to Code requirements? Yes

8. Boiler rating, max-steaming capacity (rated B.T.U./hr. output for hotwater boilers) _____

9. SAFETY VALVES:-

No. of valves	Maker's Name, Trade Mark or Type No.	Provincial Registration No.	Inlet Diameter	Seat Diameter	Set to relieve at psi.	Free discharge area	Capacity lbs. per hour

Does safety valve stamping, blow-down adjustment, etc., meet A.S.M.E. requirements? _____



10. Actual minimum stamping of the vessel shall conform to the following and shall be reproduced here:
FOR POWER & HEATING BOILERS (on attached plate for cast iron)

Canadian Registration number _____
 National Board number (if manufactured in U.S.A.) _____
 Manufacturer and manufacturers' serial number _____
 Plate mfg's initials, spec. No. and tensile strength (Stelco. SA 285 etc.) _____
 Maximum working pressure _____ (for S and W if both)
 Effective heating surface and year built (1967 etc.) _____
 Initials of authorized shop inspector _____

C.R.N. _____
 Nat. Bd. _____
 Sr. No. _____
 T.S. _____
 Max. W.P. _____ p.s.i. Temp. _____ °F.
 H.S. _____ Sq. Ft. 19 _____

UNFIRED PRESSURE VESSEL—

Canadian Registration number _____
 National Board number (if manufactured in U.S.A.) _____
 Manufacturer and manufacturers' serial number _____
 Plate mfg's initials, spec. No. and tensile strength (Stelco. SA 285 etc.) _____
 Maximum working pressure and temperature _____
 Thickness of shell and heads _____
 Code paragraph number and year built (1967 etc.) _____
 Initials of Authorized Shop Inspector _____

²¹³⁴
 C.R.N. 9493, 1234
 Nat. Bd. _____
 Sr. No. RR 2407
 A-212-B T.S. 70,000
 Max. W.P. 250 p.s.i. Temp. 150 °F.
 T. Shell .8125 T. Heads .6875
 C.W. 12 (B) 19 66

11. I HEREBY DECLARE that the foregoing statements, having reference to Vessel bearing manufacturers' Serial No. RR 2407 built by James United Steel Limited of 141 - 71st Avenue S.E., Calgary, Alta. and completed on the 6th day of November 19 67 are in all respects correct and true, and that the said Vessel has been built in accordance with Provincial registered design No. 9493, 1234, 2134 and that it complies fully with the A.S.M.E. Code and regulations of the Province of Installation under The Act governing the construction of boilers and pressure vessels.

Sworn before me at Calgary in the Province (or State) of Alberta this 6th day of November 19 67.

Signed [Signature] Shop Foreman.
 For James United Steel Limited,
141 - 71st Avenue S.E., Calgary, Alberta.
 Firm Name and Address.

A Commissioner of Oaths, J.P. or N.J.
 My commission expires December 31, 1968.

12.

CERTIFICATE OF SHOP INSPECTION

I, the undersigned, a duly authorized Inspector of Boilers and Pressure Vessels employed by Government of Alberta do hereby certify that the foregoing statements are correct and that the material, construction and workmanship are in accordance with the A.S.M.E. Code.

Date November 6, 1967.

Signed [Signature] No. _____
 Provincial or National Board Inspector.

TO BE FILLED IN BY ALBERTA INSPECTOR

13. Received _____, 19 _____ Inspector's Pressure Vessel No. (A) 67846
 Checked NOV - 6 1967, 19 _____ HEAD ABOVE NAMEPLATE
 I have allowed a working pressure of 250 p.s.i. at 150 °F. Shell side.
 _____ p.s.i. at _____ °F. Tube side.
 and have issued Certificate No. 35771 therefor.
 Vessel owned by Blue Flame Propane Limited
 Remarks: _____

[Signature]
 (Signature of Alberta Inspector)



67846

9/8/78
gth

AFFIDAVIT OF MANUFACTURER

COVERING BOILER OR PRESSURE VESSEL

LABOUR

General Safety Services Division
Boilers Branch

PURCHASE ORDER No. 11-1351

Partial Affidavit covers
Additional Fitting as per Drg. #7806-12D(O)

As Approved by the Boiler & Pressure Vessel Committee of the C.S.A.

AUG 25 1978

Upon shipment of Boiler or Pressure Vessel this form fully and correctly filled in and attested to must be mailed to the office of the Chief Inspector in the province of installation in accordance with the regulations under the Act governing the construction and installation of boilers and pressure vessels, otherwise the use of same may be prohibited or the working pressure severely penalized.

1. Manufactured by Alterations: Western Rock Bit Company Limited, 510-77th Ave. S.E., Calgary, Alberta
(Name and Address of Manufacturer)
 Manufactured for Canadian Propane Oil & Gas Ltd. 355-4th Ave. S.W., Calgary, Alberta
(Name and Address of Purchaser or Consignee)
 Ultimate owner Canadian Propane Oil & Gas Ltd. 355-4th Ave. S.W., Calgary, Alberta
(Name and Address)
 Location of installation Edmonton (Mobile)
(This address is essential)
2. Type of boiler or pressure vessel Storage (Mobile) Mfg. Serial No. RR2407
 Provincial Registration No. 9493-1234 Drwg. No. 7806-12D(O)
 To be used for: (Air, CO₂, Propane, Ammonia, Steam, Hot Water, etc.) Propane Service
2400
3. Dia. 96" Overall length 50'0 Cu. ft. capacity 18,000 USWG Heating surface 1313 sq. ft.
4. Were test reports checked on all plates used in the fabrication of this boiler or pressure vessel? Yes (fittings only)
 Does the material meet A.S.M.E. Code requirements? YES
 A.S.M.E., A.S.T.M. or other material specification No. _____ Tensile strength _____
5. Fabrication to A.S.M.E. Code, Para. No. UW-12.1(a)/77 Preheat 70 °F Postheat no X.R. complete
(year) (Yes or No) (Spot or Complete)
 Are the following records on mfg's files? X-ray films YES Postweld heat procedure NO
 Were X-ray films examined and found to meet Code requirements? YES
6. Welders employed upon boiler or pressure vessel.

Name of welders and Province or State in which qualified	Identifying Symbol	Date of last weld test	Qualified for welding under Code Para.	Name of Inspector supervising tests	National Board No.
<u>D. STEFANIW</u>	<u>D</u>	<u>9/77</u>		<u>MANN</u>	
<u>J. KEITH</u>	<u>✓</u>	<u>3/77</u>		<u>WILBERG</u>	

Does all welding on this vessel and the testing of coupons where required meet A.S.M.E. Code requirements? yes

7. Hydrostatic tests

and
Working Pressures.

NAME OF PART	Temperature of Testing Medium	Final test psi.	Maximum working pressure psi.	Maximum operating temperature degrees F.
<u>entire vessel</u>	<u>70°F</u>	<u>375</u>	<u>250</u>	<u>150</u>

Did the hydrostatic tests fully conform to Code requirements? yes

8. Boiler rating, max. steaming capacity (rated B.T.U./hr. output for hotwater boilers)

9. SAFETY VALVES:

No. of valves	Maker's Name, Trade Mark or Type No.	Provincial Registration No.	Inlet Diameter	Seat Diameter	Set to relieve at psi.	Free discharge area	Capacity lbs. per hour

Does safety valve stamping, blow-down adjustment, etc., meet A.S.M.E. requirements? _____

A 67846

10. Actual minimum stamping of the boiler or pressure vessel shall conform to the following and shall be reproduced here **BOILERS** (on attached plate for cast iron)

Canadian Registration number C.R.N.

National Board number (if manufactured in U.S.A.) Nat. Bd.

Manufacturer and manufacturer's serial number Sr. No.

Plate mfg's initials, spec. No. and tensile strength (Stelco. SA 285 etc.) T.S.

Maximum working pressure (for S and W if both) Max. W.P. p.s.i. Temp. °F.

Effective heating surface and year built (1967 etc.) H.S. Sq. Ft. 19.....

Initials of authorized shop inspector

PRESSURE VESSEL -

Canadian Registration number C.R.N. 9493-1234

National Board number (if manufactured in U.S.A.) Nat. Bd.

Manufacturer and manufacturer's serial number **Original: James Equipment Ltd.** Sr. No. RR2407

Plate mfg's initials, spec. No. and tensile strength (Stelco. SA 285 etc.) **Shell A-212-B** T.S. 70,000

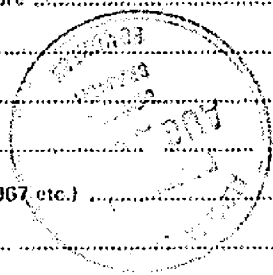
Maximum working pressure and temperature **Heads A-212-B** T.S. 70,000

..... Max. W.P. 250 p.s.i. Temp. 150 °F.

..... T.Shell 0.8125" T.Heads 0.6875"

Code paragraph number and year built (1967 etc.) U.W. 12-1(a) 19 77

Initials of Authorized Shop Inspector



11. I HEREBY DECLARE that the foregoing statements, having reference to boiler or pressure Vessel bearing manufacturer's Serial No. RR2407 built by **Alterations: Western Rock Bit Company Limited** **Calgary, Alberta**

..... and completed on the **26th** day of **July** 19 **78**

are in all respects correct and true, and that the said boiler or pressure Vessel has been built in accordance with Provincial registered design No. **9493-1234** and that it complies fully with the A.S.M.E. Code and regulations of the Province of Installation under the Act governing the construction of boilers and pressure vessels.

Sworn before me at **Calgary** Signed *[Signature]* Shop Foreman.

in the Province (or State) of **Alberta** For **Western Rock Bit Company Limited**

this **28** day of **July** 19 **78**

[Signature]
A Commissioner for Oaths, J.P. or N.P.

My commission expires **March 27, 1979** **510-77th Ave. S.E., Calgary, Alberta**
Firm Name and Address.

12.

CERTIFICATE OF SHOP INSPECTION

I, the undersigned, a duly authorized Inspector of Boilers and Pressure Vessels employed by

Provincial Government of **Alberta**

do hereby certify that the foregoing statements are correct and that the material, construction and workmanship are in accordance with the A.S.M.E. Code.

Date **9/8/78** Signed *[Signature]* No.
Provincial or National Board Inspector.

① 67846

FORM U-1A MANUFACTURERS' DATA REPORT FOR PRESSURE VESSELS
(Alternate Form for Single Chamber, Completely Shop-Fabricated Vessels Only)
As Required by the Provisions of the ASME Code Rules, Section VIII, Division 1

15/8/78
13-1551
Partial Only

1. Manufactured by Western Rock Bit Co. Ltd., 510-77th Ave. S.E., Calgary, Alberta
2. Manufactured for Canadian Propane, 355-4th Ave. S.W., Calgary, Alberta
3. Location of Installation Storage (Mobile) Propane
4. Type Horiz. RR2407 (Horiz. or vert. tank) (Mfg'r's Serial No.) 9495.1234 (CRN) 722-1D(2) (Drawing No.) (Nat'l Cro No.) (Year Built) 1978
5. The chemical and physical properties of all parts meet the requirements of material specifications of the ASME BOILER AND PRESSURE VESSEL CODE. The design, construction, and workmanship conform to ASME Rules, Section VIII, Division 1 and Addenda to and Code Case Nos.
Special Service per UG-120(d)
Manufacturers' Partial Data Reports properly identified and signed by Commissioned Inspectors have been furnished for the following items of the report:

AUG 25 1978

5. Shell: Matl. A212-B (Spec. No., Grade) Nom. Thk. in. Corr. Allow. in. in. Diam. 96" in. Lgth 50' ft 0" in.
7. Seams: Long. (Welded, Dbl. Sngl. Lap, Butt) R.T. (Spot or Full) Efficiency % H.T. Temp. F Time hr
Girth (Welded, Dbl. Sngl. Lap, Butt) R.T. (Spot, Partial, or Full) No. of Courses
8. Heads: (a) Material A-212-B (Spec. No., Grade) (b) Material A-212-B (Spec. No., Grade)

Location (Top, Bottom, Ends)	Min. Thk.	Corr. Allow.	Crown Radius	Knuckle Radius	Ellipse Ratio	Critical Apex Angle	Hemisp. Radius	Flat Diam.	Side to Pressure (Convex or Concave)
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If removable, bolts used (describe other fastenings)
9. Constructed for max. allowable working pressure less than -20 F) psi at max. temp. F. Min. temp. (when less than -20 F) F. Hydrostatic, pneumatic, or combination test pressure psi.
10. Safety Valve Outlets: Number Size Location
11. Nozzles and Inspection Openings:

Purpose (Inlet, Outlet, Drain)	No.	Diarn. or Size	Type	Matl.	Nom. Thk.	Reinforcement Matl.	How Attached	Location
Liquid	1	3"	6000# HF CPLG.	A-105-II		Integral	Welded	Bottom
Liquid	2	2"	6000# HF Cplg.	A-105-II		Integral	Welded	Bottom
Vapour	2	1 1/4"	6000# Full CPLG	A-105-II		Integral	Welded	Bottom
Drain	1	2"	6000# HF Cplg.	A-105-II		Integral	Welded	Bottom
Liquid	1	2"	6000# HF Cplg.	A-105-II		Integral	Welded	Bottom

12. Supports: Skin Lugs Legs Other Attached (Where and how)
13. Remarks: Doublers Pads(A-516-70 Material) welded to vessel per DRG. #722-1D(2).

18,000 USWG STORAGE (96" Dia.) for Mobile. Vessel surface area = 1324 ft.
Original Manu. James Equipment Limited Calgary(1967)

CERTIFICATE OF 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 Code for Pressure Vessels, Section VIII, Division 1.
Date 78/08/18 Signed Western Rock Bit Co. Ltd. by (Manufacturer) expires September 17, 19 79

CERTIFICATE OF SHOP INSPECTION

Vessel made by Western Rock Bit Co. Ltd. at Calgary, Alberta
I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State or Province of Alberta and employed by Govt. Alberta have inspected the pressure vessel described in this Manufacturers' Data Report on 15/8/78 19 and state that to the best of my knowledge and belief, the Manufacturer has constructed this pressure vessel in accordance with ASME Code, Section VIII, Division 1. By signing this certificate neither the Inspector nor his employer makes any warranty, expressed or implied, concerning the pressure vessel described in the Manufacturers' Data Report. Furthermore, neither the Inspector nor his employer shall be liable in any manner for any personal injury or property damage or a loss of any kind arising from connected with this inspection.
Signed (Inspector) Date 15/8/78 Commissions (Nat'l Board, State, Province and No.)