



111, 4808 - 87 Street, Edmonton, Alberta T6E 5W3
Phone: (780) 469-2401 Fax: (780) 468-2422

Report No: MDP000487

Client	Harvest Operations Corporation	Inspection Date	Jul 17, 2009		
Prov. Reg. #	AB 3055474	Inspection Type	VE / VI		
Equipment Type	FWKO	LSD	AB 12-15-040-08W4		
Tag/Equip.	V-130	Location	Amisk		
Status	In Service	Area	Hardisty East		
Manufacturer	PROCESS INDUSTRIES INC.	Year Built	1994		
Serial Number	94-C2883-3000	Service	Sour		
CRN #	M6442.2	Manway	None		
Comp/Unit Id		Coating	No		
Nat.Board #		Owned By	Harvest Operations Corp.		
Interim Insp'n		Interim Type			
Next Inspection	2013	Next Insp Type	VE / VI		
Length	480 in	Height			
Volume		RT	1	HT	No
Job No.	09-0279	Client Reference			
Foreman	Darren Olofson				
ABSA	Plant: H Vessel: K Process: W Special: B	ASME	Sec. VIII div. 1		
History Log	AB-10 submitted April 6, 2009 - Vessel owned by Harvest				

Component	Vessel Shell				
MAWP	100.0 PSI @ 140 °F		MDMT	-20 °F @ 100.0 PSI	
Material	SA-516-70		Material Thickness	0.375 in	
Diameter	144 in		Length		
Corrosion Allowance	0 in				



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Valve Tag No	PSV130	Relief Type	Pressure Safety Valve
Manufacturer	Farris	Set Pressure	100 PSI
Serial Number	CE40565A14	Capacity	3186 USGPM
Model	26GA10L12056SP	Last Service	Jun 14, 2006
CRN	OG2369.5C	Next Service	2008
Service Co.	Bee Gee Valve	Service Interval	24 Months
Service Co. Tag		Inlet Size	6 in
ASME Stamp	UV	Outlet Size	8 in
NB Stamp	YES	Connection	Flanged
Relief Dest.	To Close Drain Header	Valve Loc.	On Piping
Comments			

Component	Heads of Vessel		
Material	SA-516-70	Material Thickness	0.43 in
Corrosion Allowance	0 in		

Comments

The vessel was located at LSD: 12-05-38-07-W4 well site.

Building Observations

The building is generally in good condition and well supported. The floor was clean and was checker plate steel. The building is well lit and the door functions well. There were no combustibles in the building. There was generally good access to the equipment in the building.

Piping Observations

The attached piping was generally in good condition. There is no damage, distortion or stress evident on piping. The piping was painted and the paint was in good condition. There was no significant surface corrosion on the piping. The piping was well supported. The piping was threaded and there were no visible leaks at any of the joints. Flow direction was not indicated.

PSV Observations

The PSV was removed for servicing at the time of inspection.



External Observations

The vessel was located inside (30%) and outside (70%) a building. The nameplate was legible and securely mounted to the vessel. The vessel was identified per A-number and serial number stamped on the nameplate of the vessel. The heads, shell, nozzles and bolting appeared to be in good condition. There was no stress evident on piping or nozzle connections. There was no damage or distortion evident on the vessel surface. The vessel was insulated outside the building. The vessel was painted inside the building and the paint was generally in good condition. There was scattered external corrosion visible on the vessel surfaces. The gauges were in good condition.

Figure: 1



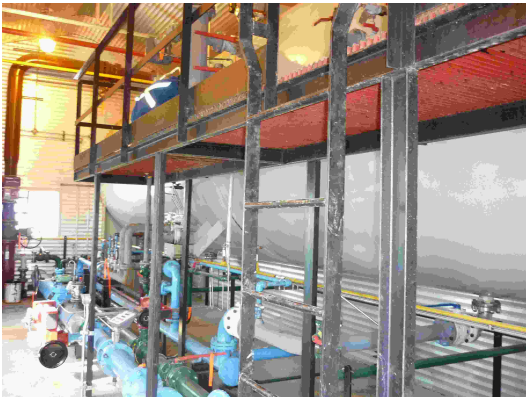
Nameplate General Overview

Figure: 2



General Overview Outside Building

Figure: 3



General Overview Inside Building

**Internal Observations**

The anodes rods were only stumps remaining. The anodes were 100% consumed. There was some steel exposed at the structural clips. Some corrosion was found on the bottom of the coalescer plates. The vessel was 100% coated. There were a few locations where the coating requires repairs. The exposed steel was not corroded. The internal de-sand lines were in good condition and secure. There was scale forming on the lines. The coalescer was secure. The back end was in good condition with no deficiencies on the shell on head. There was one coalescer sheet that was severely corroded at the bottom. The oil box and door were secure and in good condition. The internal piping was stainless steel and in good condition. There were no isolation kits installed.

Figure: 4



general condition of internal components.

Figure: 5



image showing general condition of the vessel internal

Figure: 6

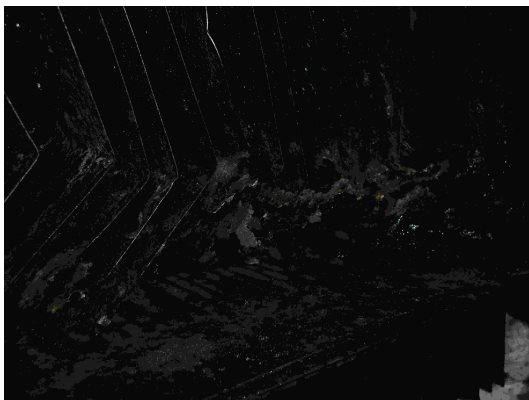
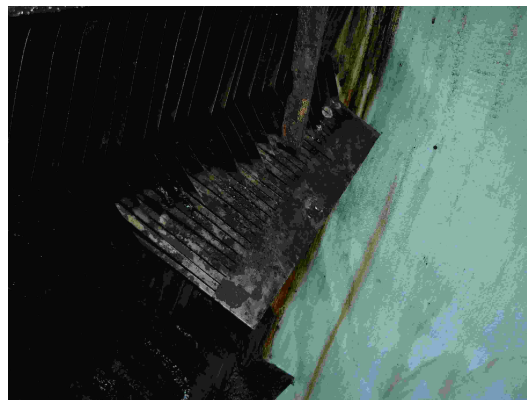


image showing corroded coalescer plates

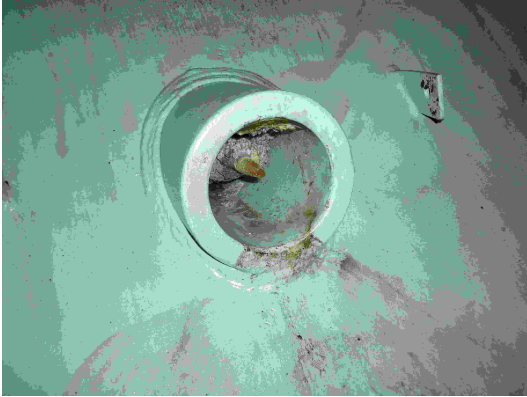
Figure: 7



coalescer sheet spacer general overview



Figure: 8



consumed anode general overview

Figure: 9



anode's after being removed from vessel.

Figure: 10



nozzle general overview

Recommendations

- 1) Change anodes after 2 years.
- 2) Repair marked coating chips.
3. The vessel is otherwise fit for service.



RAE Engineering and Inspection Ltd.

Field Inspection Report

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Inspector: Marnes du Plessis

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IBPV INSPECTOR
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