

# Lining Inspections (WT1106207)

Created By: TYLER LEONARD

Tel: 17805074179

## Facility

Northwest Machine and Welding  
(1994) LTD  
5208-40th St  
High Prairie, AB, T0G 1E0  
780-523-3073

## Client

PVT PERFORMANCE VAC & TRUCK SERVICES LTD.  
P.O BOX 783 STN MAIN  
GRAND PRAIRIE, AB, T8V 3R5  
Ph. No. - 780-830-0045

## Tank

<b>Ser. No.</b>	WT1106207	<b>Unit Number</b>	TP3011
<b>TC Spec.</b>	DOT 407	<b>Date of mfr.</b>	2006-09-08
<b>Cert. date</b>	2006-09-08	<b>Tank mfr.</b>	WESTECH
<b>CTMV Orig. Test Date</b>	2006-09-08	<b>MAWP</b>	25 psi
<b>Test P.</b>	40 psi	<b>Mfd. head thick</b>	.312 in
<b>Min. head thick</b>	.270 in	<b>Mfd. shell thick</b>	.312 in
<b>Min. shell thick</b>	.250 in	<b>Exposed Surface</b>	388.86 ft2
<b>Cap.</b>	3857 gallons	<b>Design Temp. Range</b>	-20 F to 200 F
<b>Max. Lading Density</b>	1.0 lbs/gal	<b>Shell Material</b>	SA 36
<b>Head Material</b>	SA516G70	<b>Weld Material</b>	EM12K & ER70S.6
<b>Max. Payload</b>	32126 lbs	<b>Max. Load Rate</b>	190 gal/m at 25 psi
<b>Max. Unload Rate</b>	28 gal/m at 25 psi	<b>Heating Sys. Press</b>	14.7 psi
<b>Heating Sys. Temp.</b>	200 F	<b>Original Test Date</b>	2006-09-08

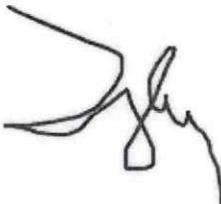
## Lining Inspection

<b>Inspection Date</b>	2026-01-07	<b>Inspection Expiry Date</b>	2027-01-31
<b>Inspection Test Method</b>	VISUAL INSPECTION		
<b>Result of lining test</b>	Pass		

## Tank Disposition

<b>Current Disposition</b>	Passed / No Defects Found
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## Approval



# Pressure Tests (WT1106207)

**Created By:** TYLER LEONARD

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<b>Max. Unload Rate</b>	28 gal/m at 25 psi	<b>Heating Sys. Press</b>	14.7 psi
<b>Heating Sys. Temp.</b>	200 F	<b>Original Test Date</b>	2006-09-08

## Pressure Test

<b>Inspection Date</b>	2026-01-07		
<b>Inspection Expiry Date</b>	2028-01-31		
<b>Test Medium</b>	Water		
<b>No. of Compartments</b>	1		
<b>Compartment 1</b>	<b>Start (psi)</b>	<b>End (psi)</b>	<b>Hold Time</b>
	40	40	10

## Test Results

**When venting devices are removed, they are bench tested and meet the requirements for the tank**

Pass

**Product piping with all valves and accessories in place and operative must be pressure tested at not less than 80% MAWP**

Pass

**When removed from the pressure supply, the test pressure is retained for the specified time for the pneumatic or hydrostatic test**

Pass

**Inspect the entire area of the head, shell and welds for leaks or deformation. If defects found note the location on the report**

Pass

## Defects

No defects found.

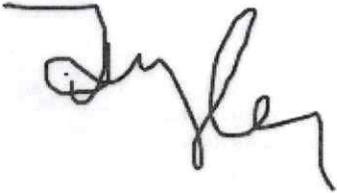
## PRV List

#	Type of PRV	Manufacturer	PRV Criteria	Discharge Pressure	Opening Pressure	Reseating Pressure	Disposition
1	FORT VALE				31	30	Reinstalled

**Tank Disposition**

<b>Current Disposition</b>	Passed / No Defects Found
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**Approval**



**Inspector**

Signed by TYLER LEONARD

Service provided by **eStandardSolutions**

# Leakage Tests (WT1106207)

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Ph. No. - 780-830-0045

## Tank

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<b>TC Spec.</b>	DOT 407	<b>Date of mfr.</b>	2006-09-08
<b>Cert. date</b>	2006-09-08	<b>Tank mfr.</b>	WESTECH
<b>CTMV Orig. Test Date</b>	2006-09-08	<b>MAWP</b>	25 psi
<b>Test P.</b>	40 psi	<b>Mfd. head thick</b>	.312 in
<b>Min. head thick</b>	.270 in	<b>Mfd. shell thick</b>	.312 in
<b>Min. shell thick</b>	.250 in	<b>Exposed Surface</b>	388.86 ft2
<b>Cap.</b>	3857 gallons	<b>Design Temp. Range</b>	-20 F to 200 F
<b>Max. Lading Density</b>	1.0 lbs/gal	<b>Shell Material</b>	SA 36
<b>Head Material</b>	SA516G70	<b>Weld Material</b>	EM12K & ER70S.6
<b>Max. Payload</b>	32126 lbs	<b>Max. Load Rate</b>	190 gal/m at 25 psi
<b>Max. Unload Rate</b>	28 gal/m at 25 psi	<b>Heating Sys. Press</b>	14.7 psi
<b>Heating Sys. Temp.</b>	200 F	<b>Original Test Date</b>	2006-09-08

## Leakage Test

<b>Inspection Date</b>	2026-01-07	<b>Inspection Expiry Date</b>	2027-01-31
<b>Test Medium</b>	Air	<b>No. of Compartments</b>	1

Compartment #	Start (psi)	End (psi)	Hold Time (min)	Capacity
1	20	20	10	

**Venting devices hold pressure as required, if removed they are bench tested and hold pressure as required**

Pass

**Product piping and valves hold pressure without leakage**

Pass

**Manways and closures inspected for leaks or deformation**

Pass

**Flanged connections checked for leakage**

Pass

**Inspect the entire area of the head, shell and welds for leaks or deformation including voids and adjacent compartments**

Pass

**Test pressure maintained for minimum of 5 minutes**

Pass

**All leaks are repaired before the tank is marked**

Pass

**Inspect head shell**

### Defects

No defects found.

**PRV List**

#	Type of PRV	Manufacturer	PRV Criteria	Discharge Pressure	Opening Pressure	Reseating Pressure	Disposition
1	FORT VALE				31	30	Reinstalled

**Tank Disposition**

<b>Current Disposition</b>	Passed / No Defects Found
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**Approval**



**Inspector**  
Signed by TYLER LEONARD

Service provided by **eStandardSolutions**

# Thickness Tests (WT1106207)

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## Tank

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<b>Cert. date</b>	2006-09-08	<b>Tank mfr.</b>	WESTECH
<b>CTMV Orig. Test Date</b>	2006-09-08	<b>MAWP</b>	25 psi
<b>Test P.</b>	40 psi	<b>Mfd. head thick</b>	.312 in
<b>Min. head thick</b>	.270 in	<b>Mfd. shell thick</b>	.312 in
<b>Min. shell thick</b>	.250 in	<b>Exposed Surface</b>	388.86 ft2
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<b>Max. Lading Density</b>	1.0 lbs/gal	<b>Shell Material</b>	SA 36
<b>Head Material</b>	SAS16G70	<b>Weld Material</b>	EM12K & ER70S.6
<b>Max. Payload</b>	32126 lbs	<b>Max. Load Rate</b>	190 gal/m at 25 psi
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<b>Heating Sys. Temp.</b>	200 F	<b>Original Test Date</b>	2006-09-08

## External Visual Inspection

**Inspection Date** 2026-01-07

### Inspection

**Visibly corroded or abraded areas are thickness tested**

Pass

**Area around lading retaining piping**

Pass

**High stress areas of the shell, such as the bottom of the tank**

Pass

**Areas around openings, weld joints, shell reinforcements, appurtenance attachment points**

Pass

**Near the upper coupler, suspension attachments and connecting structures**

Not Applicable

**Known thin areas in the tank**

Pass

**Structures adjoining self supporting transport units**

Pass

**Lowest Measurement**

**Head:** .275 in

**Shell:** .245 in

### Defects

No defects found.

## Tank Disposition

**Current Disposition**

Passed / No Defects Found

**Approval**



**Inspector**  
Signed by TYLER LEONARD

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Service provided by **eStandardSolutions**

## External Visual Inspections (WT1106207)

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<b>Heating Sys. Temp.</b>	200 F	<b>Original Test Date</b>	2006-09-08

## External Visual Inspection

Inspection Date 2026-01-07 Inspection Expiry Date 2026-07-31

### Inspection

Inspect jacketing for dents, digs, scrapes, gouges, perforations, stains, or other defects or signs of damage to the inner vessel or any other condition that might make it unsafe as per 7.2.1(a)  
Not Applicable

Inspect the entire area of head and shell for dents, gouges, bulges, corrosion, abrasion, cracks, or signs of leakage or other conditions that might render it unsafe for transport as per 7.2.1(a)  
Pass

Inspect the entire length of every weld for cracks, defects or signs of leakage as per 7.2.1(a)  
Pass

Ensure devices for tightening manhole covers are operative and covers are leak tight as per 7.2.1(b)  
Pass

Check all valves, vents, emergency devices and remote closures for corrosion, distortion, cracks, signs of weakness and loose or missing fasteners as per 7.2.1(c)  
Pass

Ensure all required markings are legible including manway, PRV, couplings, valves and specification plate as per 7.2.1(e)  
Pass

Inspect supporting structures, pads, bolsters, tie-downs and protective devices for dents, distortion, cracks, signs of weakness and loose or missing fasteners as per 7.2.1(f)  
Pass

Ensure accompanying or mounted hoses comply with inspection and marking requirements as per 7.2.10.4 and 7.2.10.6  
Pass

Check to ensure voids are unplugged and show no signs of leakage as per 7.2.1.2  
Not Applicable

Corroded or abraded areas are thickness tested as per 7.2.1.3  
Not Applicable

All pressure relief devices are inspected for corrosion or damage as per 7.2.1.4

Pass

If lading is corrosive to PRV: re-closing pressure relief valves are replaced or tested as per 7.2.1.4(b)

Not Applicable

Gaskets on full opening rear head is inspected and replaced if cut, cracked or split as per 7.2.1.5

Pass

Internal self closing valve and off truck emergency shut down system tested as per 7.2.1.6

Pass

Ensure that all bolts or nuts on any flanged connection or blank flange are in place and properly tightened

Pass

**Defects**

No defects found.

**PRV List**

#	Type of PRV	Manufacturer	PRV Criteria	Discharge Pressure	Opening Pressure	Reseating Pressure	Disposition
1	FORT VALE				31	30	Reinstalled

**Tank Disposition**

Current Disposition	Passed / No Defects Found
---------------------	---------------------------

**Approval**



**Inspector**

Signed by TYLER LEONARD



# WESTECH

VAC SYSTEMS LTD.

1002 - 15<sup>th</sup> Avenue  
Nisku Alberta  
Canada T9E 7S5  
Phone: (780) 955-3030  
Fax: (780) 955-3826  
www.westechvac.com

## Certificate of Compliance

Registered Facility: Westech Vac System Ltd. Date: 07/06/06  
1002-15 Avenue,  
Nisku, Alberta, T9E 7S5 Work Order #: 36301

DOT Registration #: CT-8189 / TC Registration #: 25-092 Customer: AEPL  
Vehicle Identification Number: 2AESPVK426E005193 Vehicle: STIFF POLE TRAILER  
Canadian Registration Number (CRN): R1037.2 ASME Code Vessel: Yes  
DOT / TC Specification: CFR 49 US DOT 407 TCRN: N/A National Board #: 344

Tank Manufacturer: Westech Vac System Ltd. Main Tank Size: 72" dia. X 17' 0" S-S  
Original Test Date: 08/09/06 Manufacture Date: 08/09/06  
Certification Date: Sept. 2006 when completed Serial Number: WT1106207

Pressure Relief Device Set Pressure: 30 PSI Certified By: Fort Vale Inc., Houston TX  
Pressure Relief Registration #: OG1859.2 Full Flow Rating: 14799 M3/HR

Exposed Surface Area: 388.86 sq ft (36.12 sq m) Nominal Capacity: 3857 US gal (14602 L)  
Max. Lading Density: 10 lb / gallon (1 Kg/L) Max. Product Load: 32126 lbs (14572 Kg.)  
MAWP: 25 PSI at 200° F (173 kPa at 93° C) MDMT: -20° F at 25 PSI (-29° C at 173 kPa)  
Design Temp Range: -20° F to 200° F (-29° C to +93° C) Test Pressure: 40 PSI (276 kPa)

Full Spec.: NO Short Spec. Tank to Chassis Ass'y: Yes Short Spec. Bumper Installation: Yes  
Short Spec. Tank Valves: Yes Short Spec. Rear Protection: Yes Short Spec. PRV Vent: NO

*Advance Engineered Products Ltd. to complete body to chassis, lading valves, and complete vehicle.*

Load Rate: 228 gal./ min. ( 865 L/min.) at Maximum Load Pressure 25 PSI (173 kPa)  
Unload Rate: 343 gal./min. (1300 L/min.) at Maximum Unload Pressure 25 PSI (173 kPa)  
Wash Compartment Capacity: N/A Lining Material: N/A  
Corrosion Allowance: N/A Pressure Heating System: N/A

Shell Material: <u>SA-36</u>	Head Material: <u>SA 516 -- Gr 70</u>
Weld Materials: <u>EM12K &amp; ER70S-6</u>	Post Weld Heat Treatment: <u>N/A</u>
Manufactured Shell Thickness: <u>0.312" (7.90 mm)</u>	Manufactured Head Thickness: <u>0.312" (7.90 mm)</u>
Minimum Shell Thickness: <u>0.250" (6.35mm)</u>	Minimum Head Thickness: <u>0.270" (6.40 mm)</u>

This cargo tank has been visually inspected and hydro tested using a water medium. The rear valves have been air tested. Caps are required on the rear valves during transport. Westech Vac Systems Ltd. certifies that this new cargo tank; its fittings, valves, piping, and protective devices, to the extent of the spec as noted, has been designed, constructed, inspected and tested and complies with the applicable CFR 49 US DOT and CSA B620 as of the original date of manufacture.

Purpose	Number	Dimension	Type	Material	Location
Load/unload	2	6"	pipe	SA106 B	on rear head
Load/unload	1	4"	pipe	SA106 B	on rear head
Vent, 407	1	3"	pipe	SA106 B	on top of tank
Suction	1	10"	pipe	SA106 B	on top of tank
Level indicator	1	12"	pipe cap	SA234 WPB	left side of tank
Level indicator nozzle	1	1"	pipe	SA106 B	in pipe cap
Dip port	1	6"Npt	pipe	SA106 B	in top of tank

Pressure Test Inspector: [Signature] A. Denys Registration #: CT-8189 / 25-092  
Registered Inspector: [Signature] Z. Bene Registration #: CT-8189 / 25-092

Doc-2

**FORM U-1 A 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 Code Rules, Section VIII, Division 1

1. Manufactured and certified by: Westech Vac Systems Ltd., 1002-15 Avenue, Nisku, Alberta, T9E 7S5  
(Name and address of manufacturer)

2. Manufactured for: Advance Engineered Products, 10498-17 Street, Edmonton, Alberta, T6P 1V8  
(Name and address of purchaser)

3. Location of installation: Portable  
(Name and address)

4. Type: Horizontal tank WT1106207 R1037.2 PV167-000 rev 03 344 2006  
(Horiz. or vert., tank) (Mfgr. Serial No.) (CRN) (Drawing No.) (Nat. Bd. No.) (Yr. built)

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 conforms to ASME Rules, Section VIII, Division 1, 2004 to: 2005  
(Year) (Addenda (date))

N/A N/A  
Code Case No's. Special Services per UG-120 (d)

6. Shells: SA 36 0.3125" 0" 72" OD 17' 0"  
Material (Spec. No., Grade) Nom. thick(in) Corr. Allow (in) Diameter ID (ft & in) Length (overall) (ft & in.)

7. Seams Type 1 N/A 70 N/A N/A Type 1 N/A 70 2  
Long Long (welded, dbl., singl., lap, butt) R T (spot, full) Eff (%) H.T. temp (deg F) Time (hr) Girth (weld, dbl., singl., lap, butt) R T (spot, or full) Eff. % No. of courses

8. Heads: (a) matl. SA 516 grade 70 (b) matl. SA 516 grade 70  
(Spec. No., Grade) (Spec. No., Grade)

Location (Top, Bottom, Ends)	Minimum Thickness	Corrosion Allowance	Crown Radius	Knuckle Radius	Elliptical Ratio	Conical Apex Angle	Hemispher. Radius	Flat Diameter	Side to Pressure (Convex or Concave)
(a) end	0.270"	0"	72"	4.32"	N/A	N/A	N/A	N/A	CONCAVE
(b) end	0.270"	0"	72"	4.32"	N/A	N/A	N/A	N/A	CONCAVE

If removeable, the bolts used (describe other fastenings): SA 193, grade B-7, 1.375" diameter, 6 bolts  
(Matl., Spec No., Grade, Size, No)

9. MAWP 25 (internal) 15 (external) psi at max. temp. 200 (internal) 200 (external) degrees F  
(internal) (external) (Internal) (external)

Min design metal temp. -20 degrees F at 25 psi. Hydro., pneu., or comb. test pressure Hyd. / 40 psi.

10. Nozzles, inspection and safety valve openings:

Purpose (Inlet, Outlet, Drain)	No.	Diameter or Size	Type	Material	Nom. Thickness	Reinforcement Material	How Attached	Location
Inlet / outlet	2	6"	CL 150 RFSO	SA 105 N / SA 106 B	0.280"	SA 36	UW16.1(i)	head
Inlet / outlet	1	4"	CL 150 RFSO	SA 105 N / SA 106 B	0.237"	SA 36	UW16.1(i)	head
Pressure relief	1	3"	CL 150 RFSO	SA 105 N / SA 106 B	0.216"	N/A	UW16.1(i)	shell
Shut off	1	10"	CL 150 RFSO	SA 105 N / SA 106 B	0.365"	SA 36	UW16.1(i)	shell
Level indicator	1	12"	pipe cap	SA 234 WPB	0.375"	SA 36	UW16.1(e)	shell
Level indicator nozzle	1	1"	pipe	SA 106 B	0.250"	N/A	UW16.1(i)	pipe cap
Dip Port	1	6"	Pipe	SA 106 B	0.432"	N/A	UW16.1(i)	shell

11. Supports: Skirt: No Lugs: 3 Legs: No Other: 4 Pedestals Attached: Weld on shells and head  
(Yes / No) (No.) (No.) (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:

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

3212 imp gallons (14602 l) (3857 US gal), 388.86 sq feet (36.12 sq m), 515.70 cubic feet (14.60 cubic m).  
Vessel constructed to working drawing PV167-36301. Impact testing exempt as per UG 20 (f) & Fig UCS 66 note (e).  
Inspection conducted on pressure vessel to registered design. 4 stiffning rings @ 49 1/2"

**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 Code for Pressure Vessels, Section VIII, Division 1. "U" Certificate of Authorization No.: 31563 and expires: Jan 04, 2009  
 Date: Aug. 17/06 Co. name: Westech Vac Systems Ltd. Signed: [Signature]  
(Manufacturer) (Representative)

**CERTIFICATE OF SHOP/FIELD INSPECTION**

Vessel constructed by Westech Vac Systems Ltd. at 1002-15 Avenue, Nisku, Alberta, T9E 7S5  
 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 ABSA have inspected the component described in this  
 Manufacturer's Data Report dated: Aug. 09/06, 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 this Manufacturer's Data Report. Furthermore, neither the inspector nor his employer shall be liable in any manner for personal injury or property damage or loss of any kind arising from or connected with this inspection.  
 Date: Aug. 17/06 Signed: [Signature] Commissions: NB# 11990A, B AB#87  
(Authorized Inspector) (Nat. Bd. Incl. endorsements, State, Prov. And No.)