019-1

VIKING WELDING LTD.
SE21-11-11W2, P.O. Box 307
Fillmore, SK S0G 1N0
PH: 306-457-8078, E-mail: vikingweld@sasktel.net
Facility Registration # 25-1242

Inspection Report in Accordance with CSA B620-20

Test Date:	**October 25, 2021**		
Tank Owner:	**B&V Trucking**	Address:	**Box 69, Frobisher, SK S0C 0Y0**
Phone:	**(306) 421-1535**		
Unit #:	**T4**	Serial #:	**100105**
Manufacturer:	**Dragon Products Ltd**	Manufacturer Date:	**August 2012**
Material:	**Heads:5454-0 Shell:5454-H32**		
Tank Spec:	**TC 407**	MAWP:	**25 psig**
Comp. Capacity:	1. **4200 USG** 2. **6300 USG** 3. **N/A** 4. **N/A** 5. **N/A**		

MC/TC331: QT [ ] NQT [ ] PWHT [ ]

Tests Performed "V" [X] "I" [X]

External Visual Inspection "V" (QC manual reference 12.1)

Item Inspected	QC Man. Reference	Complies	Reject	Retest Complies
Data plate, present and legible	12.1.1.3	X		
Shell & Heads; corrosion, abrasion, dents, overlay patches, leaks, voids, etc.	12.1.1.4	X		
Structural members, outriggers, crossmembers, etc	12.1.1.5		X	X
Upper coupler for cracks, corrosion, distortion, and bolt tightness	12.1.1.6		X	X
Piping and valves for leakage or corrosion. Valve operating systems and all gaskets.	12.1.1.7		X	X
Tank attachments to frame or running gear	12.1.1.8	X		
Gaskets on full opening rear heads	12.1.1.9	N/A		
Hoses for defects, identification and test dates	12.1.1.10	N/A		
Ladders, walkways, platforms, etc	12.1.1.11	X		
Fill cover, manways, and closure devices	12.1.1.12	X		
Relief valves and vents (replace of test if in service with corrosive lading)	12.1.1.13	X		
Accident damage protection; compliance, damage, distortion, or corrosion	12.1.1.14	X		

Inspector: **Ryan Frederiksen** Signature:  Date: **October 25, 2021**

Internal Visual Inspection "I" (QC manual reference 12.2)

Item Inspected	QC Man. Reference	Complies	Reject	Retest Complies
Interior surface, corrosion, distortion, overlay patches, cracking, etc.	12.2.2	X		
Interior welds for defects, cracking, etc.	12.2.3	X		
Internal supports and attachments	12.2.4	X		
Internal valves, piping and vents for leakage, damage, etc.	12.2.5	X		

Inspector: **Ryan Frederiksen** Signature: _____ Date: **October 25, 2021**

Rejection Criteria for Visual Inspections

Any of the following conditions shall cause the tank to be rejected.

- Less than minimum material thickness under any cut, dig or gouge
- Any dent with a depth greater than 1/2" where it includes a weld
- Any dent with a depth greater than 10% of the length of the dent
- Any weld defect including a crack, pinhole, or incomplete fusion of the weld
- Any structural defect or any source of leakage or Any repairs made using overlay patches
- Defective, unidentified or out of test Hose Assemblies

Description of defects found and methods used to repair:

***Hose hanger is bent and cracked.**
***Cracks on rear landing gear support brackets.**
***Emergency air switch dumps air continually.**

***Straightened and repaired cracked hose hanger. Repaired cracked landing gear supports. Switched airlines going to emergency closure air switch. Retest ok.**

TANK DISPOSITION

Removed From Service			Returned to Service	X
Specification Indication Removed	YES		NO	X
Defects or Damage Present	YES		NO	X
Tank marking applied (QC Manual Reference Section 13)	YES	X	NO	

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Facility Registration # 25-1242

Hydrostatic Leakage & Pressure Test Report in Accordance with CSA B620-20

Test Date: **October 25, 2021**
Tank Owner: **B&V Trucking**
Address: **Box 69, Frobisher, SK, S0C 0Y0**
Phone: **(306) 421-1535**
Unit #: **T4** Serial #: **100105**
Manufacturer: **Dragon Products Ltd.** MFR Date: **August 2012**
Material: **Heads:5454-0 Shell:5454-H32** Tank Spec: **TC 407** MAWP: **25 psig**
Comp. Capacity: 1 **4200 USG** 2 **6300 USG** 3 **N/A**
4 **N/A** 5 **N/A**

MC/TC331 QT [ ] NQT [ ] PWHT [ ]

Tests Performed "K" [X] "P" [X]

Leakage Test "K" (QC Manual Reference 12.3)
Test Pressure: **20 psi** (80% of the MAWP Min., QC Manual Reference 12.3.2)
Test Medium: **Water**

Hydrostatic Leakage Test Item	QC Man. Ref.	Complies	Reject	Retest Complies
All product piping , valves, & accessories in place. Breathing vents rendered inoperative.	12.3.2	X		
Close all internals & open all discharge valves.	12.3.4	X		
Ensure adjacent compartments & voids are empty & open to atmosphere.	12.3.5	X		
Fill compartment with enough test medium to cover valves.	12.3.6	X		
Pressurize tank to correct pressure & hold to 5 min. (must have 0 psi pressure drop).	12.3.7		X	X
While under pressure check tank, gaskets, internal valves, manhole covers, & vents for leakage.	12.3.8		X	X
Close discharge valves & open internal valves. Adjust pressure & check plumbing & discharge valves for leakage.	12.3.9		X	X
Restore operation of all vents.	12.3.11	X		

Tank Tester: **Ryan Frederiksen** Signature: Date: **October 25, 2021**

Pressure Test "P" (QC Manual Reference 12.4)
Test Pressure (Tank): **40 psi**
Test Pressure (Piping): **20 psi** (80% of the MAWP): Test Medium: **Water**
(Refer to Table 7.3 of CSA B620-20 for appropriate test pressure)

Hydrostatic Pressure Test Item	QC Man. Ref.	Complies	Reject	Retest Complies
Prior to pressure test, tank successfully passed External & Internal Visual.	12.4.1	X		
Level & adequately support the tank.	12.4.1.1	X		
Remove self closing relief valves for testing.	12.4.1.2	X		
Remove or render inoperative all other relief devices & close internal valves.	12.4.1.2	X		
Ensure all remaining closures are rated at or above test pressure.	12.4.1.3	X		
Ensure adjacent compartments & voids are empty & open to atmosphere.	12.4.1.4	X		
Verify calibration of all pressure gauges being used.	12.4.1.5	X		
Fill compartment completely with water.	12.4.2.1	X		
Install pressurization line & 2 gauges at top of tank.	12.4.2.2	X		
Increase pressure to test pressure shown in Table 7.3 of clause 7 of B620.	12.4.2.3	X		
Disconnect pressure source & hold pressure for 10 minutes.	12.4.2.4		X	X
With tank under pressure inspect exterior for leak, defects or distortion.	12.4.2.5	X		
Relieve pressure in tank.	12.4.2.6	X		
Close discharge valves & open internals. Pressurize tank to 80% of the MAWP. Hold for 10 min & check plumbing & discharge valves for leaks.	12.4.2.7		X	X
Repeat 12.4.2.7 for each valve in discharge line untill all valves are tested.	12.4.2.8	X		
Relieve pressure and drain tank.	12.4.2.9	X		
Reinstall or return all relief valves to working condition.	12.4.2.10	X		

Tank Tester: **Ryan Frederiksen** Signature: Date: **October 25, 2021**

Description of defects found and methods used to repair:
***Rear vent valve is stuck open.**
***Both crossover valves on top of tank leak.**
***Both flanges for crossover valves to tank leak.**
***Two vic clamps in pump box leak.**

***Rebuilt rear vent valve and both crossover valves. Removed both crossover piping flanges to tank and re-sealed. Replaced vic gaskets in both vic clamps that were leaking. Retest ok.**

TANK DISPOSITION

Removed from Service		Returned to Service	X	
Safety Mark (Specification Indication Removed)	YES		NO	X
Defect or Damage present	YES		NO	X
Tank marking applied (QC Manual Reference Section 15)	YES	X	NO	

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Facility Registration # 25-1242

Upper Coupler Inspection Report in Accordance with CSA B620-20

Test Date: **October 25, 2021**
Tank Owner: **B&V Trucking** Address: **Box 69, Frobisher, SK, S0C 0Y0**
Phone: **(306) 421-1535**
Unit #: **T4** Serial #: **100105**
Manufacturer: **Dragon Products Ltd.** Manufacturer Date: **August 2012**
Material: **Heads:5454-0 Shell:5454-H32**
Tank Spec: **TC 407** MAWP: **25 psig**
Comp. Capacity: 1. **4200 USG** 2. **6300 USG** 3. **N/A**
4. **N/A** 5. **N/A**

MC/TC331: QT [ ] NQT [ ] PWHT [ ]

UPPER COUPLER INSPECTION "UC" (QC Manual reference 12.1.1.6)

Item Tested	Pass	Fail	Retest Complies
Drop upper couple from tank.	X		
Inspect areas covered by the upper couplerfor corrosion, abrasion, dents, distortion, or weld defects.	X		
While removed, inspect upper coupler for cracks, corrosion, or distortion. Reinstall upper coupler.	X		

Tank Inspector: **Ryan Frederiksen** Signature:  Date: **October 25, 2021**

Description of defects found and methods used to repair:
***None.**

TANK DISPOSITION

Removed From Service [ ] Returned to Service [X]

Specification Indication Removed YES [ ] NO [X]

Defect or Damage present YES [ ] NO [X]

Tank marking applied (QC Manual Reference Section 13) YES [X] NO [ ]

Inspection, Test and Repair Report in accordance with CSA B620 7.2. Page 1 of 7

Name of Inspection and Test Facility: Hadco Services Inc. 1 Railway Ave. Frobisher SK. S0C 0Y0 Facility Registration No. 25-1361	**Name Owner/Carrier:** B+V Trucking Address: Frobisher, SK S0C 0Y0 Telephone No:

Tank Spec	**Mfr. Certification Date** Month/Yer 08/12 **Assembler Certification Date** Month/Year 08/12	**ASME Code Stamp** ☐	**National Board No,**	**RT** ☐
TC 407				

TC 331 51, MC 330 QT ☐ **NQT** ☐ **PWHT After Mfr** ☐	**Tank Service** Corrosive ☐ LPG ☐ NH3 ☐ Other _____ Lined ☐ Insulated and Jacketed ☐

Owner Unit No	**Tank Mfr Serial No.**	**Tank Mfr Date** Month/Year	**Tank Manufacturer**	**Assembler**
T 4	100105 **VIN** 1UNST503XCS100105	08/12	Dragon	Dragon

Design Temp. Range	**Max. Density Lading**	**Max. Product Payload**	**Heating Sys Pressure**	**Heating Sys Temp**
-20°F To 180°F	8.5 lbs Gal	70,10016	N/A	N/A

Tank Design / MAWP kPa ☐ PSI ☑	**Original Tank Test Pressure** kPa ☐ PSI ☑	**MDIN/TCRN**
25	45	N/A

Max. Load Rate	**Max. Load Pressure** kPa	**Max. Unload Rate**	**Max. Unload Pressure**
600 GPM	25 psi	600 GPM	25 psi

Tank Vol. Cap Liters ☐ USG ☑

Comp 1 4200 Comp 2 6300 Comp 3 _____

Comp 4 _____ Comp 5 _____ Comp 6 _____

Exposed Surface Area SQ.M ☐ **SQ.FT** ☑

Comp 1 396 Comp 2 593 Comp 3 _____

Comp 4 _____ Comp 5 _____ Comp 6 _____

Shell Manufactured Thickness MM ☐ INCHES ☐

Top .250 Sides .250 Bottom .313 Heads Mfd. Thk. .375

Shell Minimum Thickness MM ☐ INCHES ☐

Top .200 Sides .200 Bottom .300 Heads Min Thk .300

Shell Mat.Spec/Grade 5454-H32 **Heads Mat. Spec/Grade** 5454-O **Weld Material** 5356

Types of inspections and tests performed.

External Visual ☑ Leak Test ☑ Internal Visual ☐ Upper Coupler ☐ Thickness Test ☐ Pressure Test ☐

Legible pictures of the MIP and the ASME Nameplates are attached to this Inspection Test and Repair Report ☐

Ref.	External Visual Inspection. CSA B620 – 7.2.1	Pass	Fail	Corrected	NA
1	Metal identification plate, tank markings: Inspect to ensure plate is secured, entries legible - no paint or corrosion. Ensuring that specification markings and all other required markings on the tank are present and legible.	☑	☐	☐	☐
2	Without removing insulation or jacketing, inspect tank for corroded areas, dents, distortions, defects in welds, and any other condition, including leakage, that indicates weakness in the tank that might render it unsafe for transportation. Corroded or abraded areas shall be thickness tested and documented. Overlay patches are prohibited. Insulated tanks – Outer Jacket. Condition of attachments, dents, digs, scrapes, perforations, loose sheeting, cracks and distortion.	☑	☐	☐	☐
3	Inspect structural supports, crossmembers, outriggers, pads, tank frame, reinforcement rings, major appurtenances and attachments, connecting structures, and those elements of the upper coupler (fifth wheel) assembly that can be inspected without dismantling that assembly, are not damaged or corroded so as to affect safe operation of the vehicle	☑	☐	☐	☐
4	Inspect piping, valves and gaskets for operation, leakage, corrosion. Ensure proper functioning of all valves, vents, pressure and emergency devices, including self-closing stop valves, excess-flow valves, and remote closure devices – ensuring that they are free of corrosion, distortion or any other condition or damage that would prevent their normal operation. Ensure all bottom outlet valves have shear sections or accident damage protection Ensure that fusible links, and fusible elements are present and operative	☑	☐	☐	☐
5	Inspect all ladders, catwalks, platforms and fall protection devices for damage, defects in welds, ensuring their safe operation.	☑	☐	☐	☐
6	Inspect manway covers, all closure devices, caps, nipples and plugs for leaks, tightness and operation. Check all gaskets for leaks. Inspect all bolts and nuts on any flanged connections or blank flange – ensure all bolts, nuts are in place and properly secured	☑	☐	☐	☐
7	All vacuum and reclosing pressure-relief devices shall be externally inspected for any corrosion or damage that could prevent their safe operation.	☑	☐	☐	☐
8	For tanks in corrosive service, all vacuum and reclosing pressure-relief devices shall be removed for inspection and shall be bench tested to ensure that they open at the required set-to-discharge pressure for the tank's MAWP and reseat at not less than 90% of that pressure or at the reseat pressure prescribed for the tank specification	☐	☐	☐	X
9	Inspect accident damage protection devices – condition of welds, damage, distortion, corrosion abrasion and any other condition that might render the tank unsafe for transportation or cause the tank to be out of compliance.	☑	☐	☐	☐
10	TC/MC 331-Inspect the internal self-closing valve in the liquid discharge opening for leakage through the valve. Off-truck emergency shutdown system shall be inspected to ensure that the system will stop the flow of product from the tank or shall stop motive power to the tank transfer pump. Complete and attach Emergency Shutdown Test Report	☐	☐	☐	X
11	The gasket on any full opening rear head shall be visually inspected for cuts, cracks, or splits and replace if cuts, cracks, or splits are likely to cause leakage, or are of a depth greater than 12.7 mm (0.5 in).	☐	☐	☐	☑
12	Inspect hose assemblies mounted on or accompanying the tank to ensure that they do not display any defects. Inspect hose assemblies to ensure that the required markings are legible, and that the markings indicate that the hose assemblies are pressure tested within the prescribed period.	☐	☐	☐	☑
13	Tank marking: Date (month and year), Symbol (V), Facility Registration Number applied after all defects corrected, inspected, and tested	☑	☐	☐	☐
14	Wet Test. Ensure minimum of 250 liters of head space.	☐	☐	☐	X

No Defects Found ☑ Defects Found ☐ Defects Corrected, Inspected and Tested - Pass ☐.

Mark Brock — Name of Tank Inspector

Mark Brock — Signature of Tank Inspector

Oct. 25 2022. — Date Inspection Completed

Ref	Leak Test CSA B620 7.2.5	Pass	Fail	Corrected	NA
1	Product piping and all associated valves and accessories shall be in place and operative. Each valve and closure shall be tested in sequence. With internal valve closed and external valve open inspect for signs of leakage, and no pressure drop.	☑	☐	☐	☐
2	Product piping and all associated valves and accessories shall be in place and operative. Each valve and closure shall be tested in sequence. With external valve closed and internal valve open inspect for signs of leakage, and no pressure drop.	☑	☐	☐	☐
3	Vacuum test tank valves	☐	☐	☐	☑
4	Tank marking: Date (month and year), Symbol (K), Facility Registration Number applied after all defects corrected, inspected and tested	☑	☐	☐	☐

Leak Test Pressure 20 psi. Length of Time Leak Test Held 15 min.

Test Medium: Air ☐ Water ☑ Other _____

No Defects Found ☑ Defects Found ☐ Defects Corrected, Inspected and Tested - Pass ☐.

Mark Brock Mark Brock

Name of Tank Tester Signature of Tank Tester Date Leak Test Completed

Ref	Internal Visual Inspection CSA B620 7.2.2	Pass	Fail	Corrected	NA
1	When the tank is not equipped with a manway or inspection opening, or the tank precludes an internal inspection due to lining, the tank shall be pressure tested.	☐	☐	☐	☐
2	Inspect entire interior surface of shell and heads for signs of corrosion, abrasion, pitting, dents or cracks. Overly patches are prohibited. Corroded or abraded areas shall be thickness tested and documented. Inspect linings and coatings.	☐	☐	☐	☐
3	If the tank is coated an inspection shall conform with the procedures and equipment specified by the coating manufacturer or installer.				
4	Inspect all welded connections of tank shell and heads and all structural supports: inspect for corrosion, abrasion, dents, digs, gouges, distortions, defects in welds and other conditions that might render the tank unsafe for transportation. Check areas a round baffle openings for sign of distortion or cracks. Corroded or abraded areas shall be thickness tested and documented.	☐	☐	☐	☐
5	Inspect all piping, valves, vents, fittings and gaskets for corrosion, abrasion, and defects in welds, leakage and other conditions that may render the tank unsafe for transportation. Corroded or abraded areas shall be thickness tested and documented.	☐	☐	☐	☐
6	Tank marking: Date (month and year), Symbol (I), Facility Registration Number applied after all defects corrected, inspected and tested	☐	☐	☐	☐

No Defects Found ☐ Defects Found ☐ Defects Corrected, Inspected and Tested - Pass ☐.

Name of Tank Inspector Signature of Tank Inspector Date Leak Test Completed

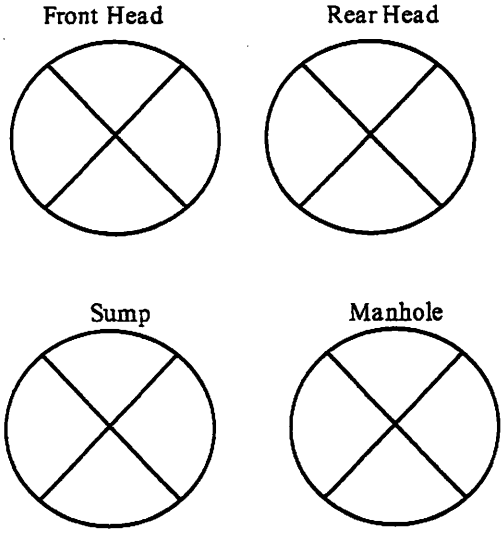
Ref	Upper Coupler Inspection CSA B620 7.2.4	Pass	Fail	Corrected	NA
1	For tanks in corrosive service, once in each 2-year period and in conjunction with the External Visual Inspection, the upper coupler assembly and the areas covered by the upper coupler assembly shall be inspected for corroded and abraded areas, dents, distortions, defects in welds, and any other condition that might render the tank unsafe for transportation. The upper coupler assembly must be removed for this inspection. Corroded and abraded areas shall be thickness tested and documented.	☐	☐	☐	☐
2	Once in each 5-year period and in conjunction with the Pressure Test, the upper coupler assembly and areas covered by the upper coupler assembly shall be inspected for corroded or abraded areas, cracks, dents, distortions, defects in welds, and any other condition that may render the tank unsafe for use in transportation. The upper coupler assembly shall be removed for this inspection. Corroded and abraded areas shall be thickness tested and documented.	☐	☐	☐	☐
3	Tank marking: Date (month and year), Symbol (UC), Facility Registration Number applied after all defects corrected, inspected, and tested.	☐	☐	☐	☐

No Defects Found ☐ Defects Found ☐ Defects Corrected, Inspected and Tested - Pass ☐.

Name of Tank Inspector Signature of Tank Inspector Date Upper Coupler Inspection Completed

Ref	Thickness Test CSA B620 7.2.6	Pass	Fail	Corrected	NA
1	The shell and head thickness of all unlined tanks used for materials corrosive to the tank shell or heads must be tested at 2-year intervals.	☐	☐	☐	☐
2	Tank marking: Date (month and year), Symbol (T), Facility Registration Number applied after all defects corrected, inspected, and tested.	☐	☐	☐	☐

	12:00	3:00	6:00	9:00	
					HEAD
1					1
2					2
3					3
4					4
5					5
6					6
7					7
8					8
9					9
10					10
11					11
					HEAD
	12:00	3:00	6:00	9:00	



No Defects Found ☐ Defects Found ☐ Defects Corrected, Inspected and Tested - Pass ☐.

Name of Tank Tester Signature of Tank Tester Date Thickness Test Completed

Pressure Test CSA B620 7.2.7	Pass	Fail	Corrected	NA
Prior to performing the Pressure Test, the External Visual Inspection and Internal Visual Inspection shall be completed satisfactorily.	☐	☐	☐	☐
Heating System Hydrostatic Pressure Test. Completed prior to pressure test.	☐	☐	☐	☐
In conjunction with the Pressure Test all self-closing pressure relief devices shall be removed and bench tested or replaced.	☐	☐	☐	☐
When isolated from the pressure supply, the test pressure shall be retained for minimum 10 minutes, and a visual inspection of all external surfaces reveals no leaks, deformation and bulging.	☐	☐	☐	☐
Tank marking: Date (month and year), Symbol (P), and Facility Registration Number applied after all defects corrected, inspected and tested.	☐	☐	☐	☐

Tank Test Pressure_____psi Length of Time Pressure Test Held _____minutes.

Tank Pressure Test Method: Hydrostatic ☐ Number of Tank Compartments Successfully Pressure Tested ____

No Defects Found ☐ Defects Found ☐ Defects Corrected, Inspected and Tested - Pass ☐.

Name of Tank Tester Signature of Tank Tester Date Pressure Test Completed

SELF CLOSING PRESSURE RELIEF DEVICE TEST CSA B620 7.2.7.6

Each self-closing pressure relief device that is an emergency relief vent shall be replaced or bench tested to ensure that they open at the required set-to-discharge pressure for the tank's MAWP and reseat at not less than 90% of that pressure or at the reseat pressure prescribed for the tank specification.

Comp.______ Set to discharge____________psi ☐ in/Hg ☐ Flow capacity ____________________ scf/hr

Device opened at_______________psi ☐ in/Hg ☐ Reseated at_______________psi ☐ in/Hg ☐

Disposition: Pass and reinstalled ☐ Fail, repaired, tested and reinstalled ☐ Replaced ☐

Comp.______ Set to discharge____________psi ☐ in/Hg ☐ Flow capacity ____________________ scf/hr

Device opened at_______________psi ☐ in/Hg ☐ Reseated at_______________psi ☐ in/Hg ☐

Disposition: Pass and reinstalled ☐ Fail, repaired, tested and reinstalled ☐ Replaced ☐

Comp.______ Set to discharge____________psi ☐ in/Hg ☐ Flow capacity ____________________ scf/hr

Device opened at_______________psi ☐ in/Hg ☐ Reseated at_______________psi ☐ in/Hg ☐

Disposition: Pass and reinstalled ☐ Fail, repaired, tested and reinstalled ☐ Replaced ☐

Comp.______ Set to discharge____________psi ☐ in/Hg ☐ Flow capacity ____________________ scf/hr

Device opened at_______________psi ☐ in/Hg ☐ Reseated at_______________psi ☐ in/Hg ☐

Disposition: Pass and reinstalled ☐ Fail, repaired, tested and reinstalled ☐ Replaced ☐

Comp.______ Set to discharge____________psi ☐ in/Hg ☐ Flow capacity ____________________ scf/hr

Device opened at_______________psi ☐ in/Hg ☐ Reseated at_______________psi ☐ in/Hg ☐

Disposition: Pass and reinstalled ☐ Fail, repaired, tested and reinstalled ☐ Replaced ☐

Comp.______ Set to discharge____________psi ☐ in/Hg ☐ Flow capacity ____________________ scf/hr

Device opened at_______________psi ☐ in/Hg ☐ Reseated at_______________psi ☐ in/Hg ☐

Disposition: Pass and reinstalled ☐ Fail, repaired, tested and reinstalled ☐ Replaced ☐

NORMAL VENTS 306/406 Tanks:

Normal vents shall be tested according to the testing criteria established by the vent manufacturer. Normal vents shall be replaced, or bench tested.

Normal Vents: Pass ☐ Fail, repaired, tested, and reinstalled ☐ Replaced ☐

____

Name of Tank Tester | Signature of Tank Tester | Date Test Completed

Describe all defects; Describe nature, location, method of repair and corrective action taken.

Ref Item #	Deficiencies

Tank and/or piping repaired by welding ☐ WPS used for repair WPS# _____

Name of Authorized Welder Signature of Authorized Welder Date Welding Repair Completed

Tank Disposition Statement: Tank Returned to Service ☐ Tank Removed from Service