E019-2

THOMAS-K WELDING AND FABRICATING

Facility Name:	Thomas-K Welding and Fabricating	Facility Registration Number	**25-1387**
Facility Address:	611 Railway Avenue Midale Saskatchewan S0C 1S0	Customer Address	B & V Trucking Ltd.
Telephone Number:	1 (306) 421 8593	Telephone Number:	

Cover Page

Company Unit Number	T3	Certification Date	May 2012
Manufacturer	Tremcar	Manufacture Date	May 2012
Assembler	Tremcar	TCRN or MDIN	8003
Serial Number	9846	Tank Specification	☐ DOT ☒ TC 407
MAWP / Design Pressure	172 ☐ PSI ☒ KPA	Material	5454-H32 Aluminum
Compartment Capacity	1) 40 125 2) _____	☒ Liters ☐ Gallons ☐ US Gallons	
Exterior Insulation	☐ Yes ☒ No	Interior Lining	☒ Yes ☐ No Type Devchem 253
Minimum Thickness Of Head	4.47	Minimum Thickness Of Shell	4.93 ☐ Inches ☒ Millimeters
Corrosive Service	☐ Yes ☐ No		

Test and or Inspection Performed ☒ (V) Visual ☒ (K) Leakage ☒ (I) Internal ☒ (P) Pressure ☒ (UC) Upper Coupler ☐ (L) Lining ☒ Pressure Relief Valve ☐ Hoses

Date of completion April 5 2025

Defects Found & *Correction*

Manual off side valve fails. *It was replaced*
Manual vent valve fails. *It was replaced*
Pneumatic vent valve fails. *It was replaced*
Titan gauge rod coupling is cracked. *It was replaced*

Tank Successfully Retested After Repairs ☒ Yes ☐ No

Tank Disposition ☒ Returned To Service ☐ Removed From Service ☐ Specification Removed

Tank Marking Applied On Front Driver side ☒ Yes ☐ No

Tank Markings Applied (QC Section 13)

☐ V			1387
☒ VK	04	25	1387
☒ I P	04	25	1387
☒ UC	04	25	1387
☐ L			1387

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(V) External Visual

The frequency for External Visual inspection shall be as indicated in Table 7.2 Clause 7 of CSA B620. In addition this inspection shall be conducted when any of the conditions in Clause 7.1.1 of CSA B620 exist.

ITEM INSPECTED	COMPLIES	REJECT	RETEST
Data plate, placards and safety decals present, info complete and legible	☒	☐	☐
Exterior surface area including heads for signs of corrosion, abrasion, gouges, dents, or repairs made using overlay patches	☒	☐	☐
Surface of all welds for signs of defects or cracks	☒	☐	☐
~~Void drains are unplugged~~	☒	☐	☐
Structural members, outriggers, crossmembers etc.	☒	☐	☐
All valves and vents for proper operation	☒	☐	☐
All gaskets for indication of leaking	☒	☐	☐
Piping and valves for leakage, damage or corrosion	☒	☐	☐
Inspect and function all valve operating systems and remote closures	☒	☐	☐
Crash or shear protection and thermal means of closing outlet valves	☒	☐	☐
~~Hoses for defects, identification tags and test dates~~	☐	☐	☐
~~Gasket on full opening rear head (*vacuum unit only*)~~	☐	☐	☐
Tank attachment to frame or running gear	☒	☐	☐
Ladders, walkways etc.	☒	☐	☐
Fill covers, manways and closure devices	☒	☐	☐
Relief valves and vents	☒	☐	☐
Accident damage protection (*rear bumper, rollover protection and piping guards*)	☒	☐	☐
Unit equipped with one or more dry chemical fire extinguishers (*total of 40BC*)	☒	☐	☐

NOTE: EXERT FROM CSA B620:20

7.2.1.8 Rejection criteria for external inspection

In addition to any other criteria in Clause 7.2.1, tanks shall be rejected when any of the following defects are found during an external inspection:

(a) less than the minimum thickness remaining under a cut, dig, or gouge;
(b) any dent with a a depth of more than 12.7 mm (0.5 in) where it includes a weld;
(c) any dent with a depth of greater than 10% of the length of the dent;
(d) any weld defect, including a crack, pinhole, or incomplete fusion of the weld;
(e) any structural defect;
(f) any source of leakage; or
(g) repairs made to liquid-retaining components using overlay patches.

Tank Inspector: Thomas K Oman Signature: _____ Date: April 5 2025

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(L) Leakage

The leakage test shall ensure the tank closures, piping, valves, and gaskets are in good condition and do not leak within the piping or to the exterior. The leakage test shall be performed in conjunction with the external inspection (see Clause 7.2.1.1) in accordance with the following:

(a) The test pressure shall be no less than 80% of the tank design pressure or MAWP, whichever is less

◎ Test Pressure (80% Of MAWP Minimum) 20 ☒ PSI ☐ KPA ◎ Test Medium Used: Compressed Air

◎ Test Hold Time 5 Minutes

ITEM INSPECTED	COMPARTMENT 1			COMPARTMENT 2		
				☒ Not Applicable		
◎ Required pressure verified	☒ Yes	☐ No		☐ Yes	☐ No	
◎ Required Test equipment installed	☒ Yes	☐ No		☐ Yes	☐ No	
◎ Compartment reached test pressure	☒ Yes	☐ No		☐ Yes	☐ No	
	COMPLIES	REJECT	RETEST	COMPLIES	REJECT	RETEST
◎ Inspect all tank and plumbing welds for signs of leakage	☒	☐	☐	☐	☐	☐
◎ Inspect all gaskets, blinds, manhole covers and valve seats	☒	☒	☒	☐	☐	☐
◎ Internal valve function and seal	☒	☒	☒	☐	☐	☐
◎ Discharge valve function and seal	☒	☒	☒	☐	☐	☐
◎ Tank and plumbing held for 5 minutes with 0 PSI drop	☒	☐	☐	☐	☐	☐
◎ Tank safely vented	☒ Yes	☐ No		☐ Yes	☐ No	
TC/DOT 406 Requirement	☒ Not Applicable			☐ Not Applicable		
◎ PRV removed from fill lid, replaced with plug	☐ Yes	☐ No		☐ Yes	☐ No	
◎ PRV condition and function	☐	☐	☐	☐	☐	☐
◎ PRV reinstalled on fill lid	☐ Yes	☐ No		☐ Yes	☐ No	

NOTE: EXERT FROM CSA B620:20

7.2.5.1 Leakage test

(e) One of the following shall be used as the test medium:

(i) the normal lading of the tank;

(ii) a less hazardous lading of equal or less viscosity;

(iii) water;

(iv) inert gas;

(v) air; or

(vi) vacuum.

Note: *When using air as a test medium, the tester should be aware of the need for proper purging and ensure that there is no possibility of creating a mixture of product and air withing the explosive limits of the product.*

(f) When air or other gas is used as the test medium,

(i) a soapy water mixture or other material that will foam or bubble to indicate the presence of leaks shall be used to locate leaks; or

(ii) another method that is at least as sensitive as the method required in Item (f)(i) shall be used to locate leaks

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(I) Internal

The Internal requires a confined space permit approved by a supervisor prior to any tank entry and must be attached with the inspection report document

CONFINED SPACE

- Tank interior atmosphere verified with bump tested monitor for suitable atmosphere ☒ Yes ☐ No
- Confined space entry permit completed and approved by supervisor ☒ Yes ☐ No
- Permit is clearly displayed on closest point of tank access ☒ Yes ☐ No

SUPERVISOR

Thomas K Oman
Print

Sign

ITEM INSPECTED	COMPARTMENT 1			COMPARTMENT 2 (☒ Not Applicable)		
	COMPLIES	REJECT	RETEST	COMPLIES	REJECT	RETEST
Inspect tanks shell, heads and baffles for cracks, corroded areas, dents or distortion	☒	☐	☐	☐	☐	☐
Inspect piping for corrosion and loose couplings	☒	☐	☐	☐	☐	☐
All gaskets for signs of leakage	☒	☐	☐	☐	☐	☐
All welds for defect, cracks or corrosion	☒	☐	☐	☐	☐	☐
Any other condition that could render the tank unsafe for transport service	☒	☐	☐	☐	☐	☐
~~Internal lining for defects~~	☒	☐	☐	☐	☐	☐

NOTE: EXERT FROM CSA B620:20

7.2.2.2 Rejection criteria for internal inspections

In addition to any other criteria in Clause 7.2.2.1, tanks shall be rejected when any of the following defects are found during the internal inspection:

(a) less than the minimum thickness remaining under a cut, dig, or gouge;
(b) any dent with a depth of more than 12.7 mm (0.5 in) where it includes a weld;
(c) any dent with a depth of greater than 10% of the length of the dent;
(d) any weld defect, including a crack, pinhole, or incomplete fusion of the weld;
(e) any structural defect;
(f) any source of leakage; or

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(P) Pressure

Prior to conducting a pressure test, the tank shall have passed an external visual inspection, a leakage test and an internal inspection for any sign that can render the test unsafe under test pressure

◎ Required Test Pressure As Indicated On Data Plate or 150% Of MAWP 310 ☐ PSI ☒ KPA

◎ HYDROSTATIC TEST ☒ PNEUMATIC TEST ☐ ◎ Test Hold Time 10 Minutes

TEST EQUIPMENT	COMPARTMENT 1	COMPARTMENT 2
		☒ Not Applicable
◎ Pressure gauges are calibrated	☒ Yes ☐ No	☐ Yes ☐ No
◎ Pressure protection in place	☒ Yes ☐ No	☐ Yes ☐ No
◎ Pressurization line and gage installed at top of tank	☒ Yes ☐ No	☐ Yes ☐ No
◎ PRV is removed and open port is blanked	☒ Yes ☐ No	☐ Yes ☐ No
◎ Tank reached test pressure	☒ Yes ☐ No	☐ Yes ☐ No

ITEM INSPECTED	COMPARTMENT 1 COMPLIES	REJECT	RETEST	COMPARTMENT 2 COMPLIES	REJECT	RETEST
◎ Inspect exterior of tank for signs of leakage, defects or distortion	☒	☐	☐	☐	☐	☐
◎ Inspect all welds for signs of leakage	☒	☐	☐	☐	☐	☐
◎ Inspect all gaskets for signs of leakage	☒	☐	☐	☐	☐	☐
◎ Inspect drain holes at bottom of reinforcement rings for drips	☒	☐	☐	☐	☐	☐
◎ Pneumatic tank valve seams checked	☒	☐	☐	☐	☐	☐
◎ Test pressure held for 10 minutes with no drop in pressure	☒	☐	☐	☐	☐	☐
◎ Inspect plumbing for signs of leakage	☒	☐	☐	☐	☐	☐
◎ Test Pneumatic tank valve seal	☒	☐	☐	☐	☐	☐
◎ Test plumbing manual valve seal	☒	☐	☐	☐	☐	☐

NOTE: EXERT FROM CSA B620:20

7.2.7.7 Hydrostatic test

The hydrostatic test shall be conducted as follows:

(a) The tank, including its domes, shall be completely filled with water, or other liquid having similar properties, at a temperature not exceeding 38 C (100 F).

(b) During the test, precautions shall be taken to prevent over pressurization of the tank.

(c) Pressure shall be gauged at the top of the tank.

(d) Tank test pressure shall be established in accordance with Table 7.3.

(e) All piping and accessories shall be pressure tested at not less than 80% of the tank's MAWP

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Upper Coupler

The upper coupler inspection shall be inspected in accordance with Table 7.2 and/ or at the time of a pressure test

- Upper coupler removed from tank sub frame ☒ Yes ☐ No
- Upper coupler equipped with grade 8 hardware ☒ Yes ☐ No

ITEM INSPECTED	COMPLIES	REJECT	RETEST
Inspect for any downward bows mare than 1/4" within 19" from king pin	☒	☐	☐
Inspect for any downward bows mare than 1/16" within 19" from king pin	☒	☐	☐
Inspect for corroded or abraded areas, dents or distortions	☒	☐	☐
Inspect welds for corrosion, defects or cracks	☒	☐	☐
Ensure Kingpin is not bent, broken, cracked deformed or loose	☒	☐	☐
Kingpin is not worn more than 1/8"	☒	☐	☐
Upper coupler reinstalled with grade 8 bolts and locknuts	☒	☐	☐

Tank Inspector: Thomas K Oman Signature: _____ Date: April 5 2025

(UC) Upper Coupler Area

The upper coupler area inspection shall be inspected in accordance with Table 7.2 and/ or at the time of a pressure test

- Upper coupler removed from tank sub frame ☒ Yes ☐ No

ITEM INSPECTED	COMPLIES	REJECT	RETEST
Inspect area for corrosion, abrasion, dents or distortion	☒	☐	☐
Inspect welds for corrosion, defects or cracks	☒	☐	☐
mounting frame rails are fee of corrosion, distortion or cracks	☒	☐	☐
Inspect bolt holes for distortion or cracks	☒	☐	☐

NOTE: EXERT FROM CSA B620:20

7.2.4 Upper coupler area inspection

Areas covered by the upper coupler(i.e., King pin plate) or turntable assembly shall be inspected for corroded or abraded areas, cracks, dents, distortions, defects in welds, and any other condition that might render the tank unsafe for use in transportation. The upper coupler assembly shall be removed for this inspection. A turntable assembly need not be removed if the areas of the tank where it is attached are clearly visible for inspection. Following the inspection, a written report shall be completed by the inspection facility in accordance with Clause 7.3

Tank Inspector: Thomas K Oman Signature: _____ Date: April 5 2025

019-2

TK Thomas-K Welding and Fabricating
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+13064218593
thomaskwf88@gmail.com
GST/HST Registration No.: 726048804
RT0001
PST SK Registration No.: 7717515

Paid APR 16/25 CHQ-324 CU

BILL TO
B & V Trucking Ltd.

ENTERED VB

INVOICE 960

DATE 04/07/2025

DUE DATE 05/07/2025

UNIT #
T3

	DESCRIPTION	QTY	RATE	AMOUNT
B620 Inspection	VK Inspection	1	800.00	800.00
B620 Inspection	IP UC Inspection	1	800.00	800.00
Materials	Materials	1	33.76	33.76

SUBTOTAL	1,633.76
GST @ 5%	81.69
PST (SK) @ 6%	98.03
TOTAL	1,813.48
TOTAL DUE	**$1,813.48**

Payment due upon receipt. A service charge of 4% per month compounded monthly (48% per annum) will be charged on accounts after 30 days.