Y10-10

ABSA
the pressure equipment safety authority

MANUFACTURER'S DATA REPORT FOR INDIRECT FIRED HEATER COILS

AB-28 2006-02

PARTIAL ☐ A# A-620403

Manufactured By: Bluestar Investments Inc, Box 22055 Grande Prairie, Alberta T8V 6X1

Manufactured For: Bluestar Investments Inc, Box 22055 Grande Prairie, Alberta T8V 6X1

Ultimate Owner: Bluestar Investments Inc, Box 22055 Grande Prairie, Alberta T8V 6X1

Location of Installation: Portable Equipment

Manufacturer's Serial No.	Construction Drawing No.	CODE: ASME B31.3				Year Built
BSC-1047	2080-01 Rev 1	Edition	2010	Addenda	2010	2012

CONSTRUCTION

	Coil ID/Purpose	Design Pressure	Design Temp	Design Minimum Temp	Corrosion Allowance	Registered Drawing No.	CRN
a	Coil 1	5031 PSI	200 F	-2 F	1/8"	2080-01 Rev 1	T3046.2
b	Coil 2	5031 PSI	200 F	-2 F	1/8"	2080-01 Rev 1	T3046.2
c							
d							
e							

COIL

	Tubes			End Closures				Openings		
				Return Bend		Flanges				
	Mat'l Spec.	Diameter	Thickness	Mat'l Spec.	Thickness	Mat'l Spec.	Rating	Mat'l Spec.	Size/Type	Rating
a	A333 Gr 6	3.5" OD	0.600 "	A420 WPL6	0.600"					
b	A333 Gr 6	3.5" OD	0.600 "	A420 WPL6	0.600"					
c										
d										
e										

HEADERS/MANIFOLDS

	Purpose	Size	Shell		Ends			Openings		
			Mat'l Spec.	Thickness	Mat'l Spec.	Thickness	No	Mat'l Spec	Size/Type	Rating
f										
g										

TEST PRESSURE, NDE, POSTWELD HEAT TREATMENT AND SIZE

	Hydrostatic Test Pressure	Radiography (100% or % Random)	Other NDE (MT) (PT) (UT)	Postweld Heat Treatment		Overall Length	Heating Surface	Volume
				Temp.	Time			
a	7500 PSI	100%		1150 F	1 Hour	151 Feet	138 FT2	2.18 FT3
b	7500 PSI	100%		1150 F	1 Hour	151 Feet	138 FT2	2.18 FT3
c								
d								
e								
f								
g								

IMPACT TESTING: Exempt per Table 323.2.2 Column A

REMARKS: This coil may not be pressurized when its temperature is colder than -2 F.

CERTIFICATE OF COMPLIANCE

We certify that the statements in this report are correct and that all details of design, material, construction, and workmanship of this coil bundle are in accordance with the above Provincial Registered Design.

Date June 26-2012 Signed _____ (Representative) For BLUESTAR INVESTMENTS INC. (Manufacturer)

CERTIFICATE OF SHOP INSPECTION

I, the undersigned, a duly authorized Safety Codes Officer employed by ABSA has inspected the above Heater Coils and state that, to the best of my knowledge and belief, the construction is in accordance with the Alberta Safety Codes Act and Regulations.

June 26/12 _____ NB-12632A AB-1834.

SANDHEATER #1
A#620403

12 Dunham Close
Red Deer, AB
t4r 2j5
403-505-0378

Client:	BLUESTAR	***Units :***	SandHeater 1
Inspection Date:	JUNE 16,2026	***W0 #:***	
Client Rep:	WADE BRANDVOLD	***Technician:***	GEOFF FENTON

Flaw Detector/Thickness Gauge

Make: Dakota	Model: DFX-8	Serial #: 20193	Calibration: May 2026

Ultrasonic Transducer

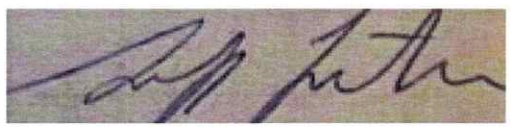
Manufacturer: Olympus S/N 737AB	Size/Type: 0.250"/Lemo	Mhz: 5	Mode:Longitudinal P-ECT

Calibration Block

Type: Step Block	Material: Carbon Steel	Thickness: 0.100" - 0.500"	Serial #: 15-1035

Client Equipment Inspected: 3"5K LINEHEATER BUNDLE, carbon steel, the Temperature was approx. 19 Deg C.
Client should refer to applicable ASME Code or IRP for Guidelines on Pressure Rating for pipe.
Only small areas are tested for remaining wall thickness. Areas prone to erosion/corrosion are checked(IE. elbows,tee crotches,pipe and vessel walls).
Visual Corrosion in vessel and/or on steam coil is NOT a requirement of this report, that is the Owners responsibility.
Each area was scanned to determine the Minimum and Maximum value, therefore creating an average thickness for the scan.
Any CML found to be thin will be in yellow print, so the Owner can determine if its below their minimum specifications.
All components are coated/painted, approx. paint thickness: 0.001" - 0.050"
This report is information only, the Owner has the sole Responsibility to determine Minimum wall thickness allowable.

GEOFF FENTON, CGSB# 21365
Carmaco Inspections



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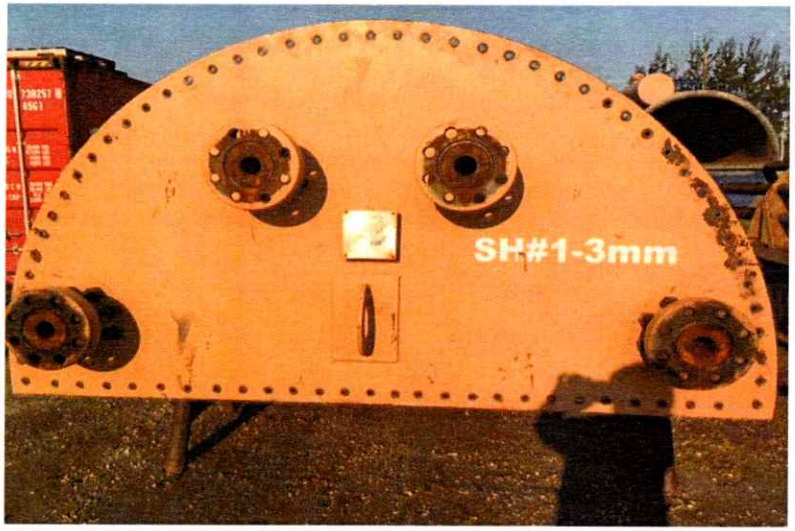



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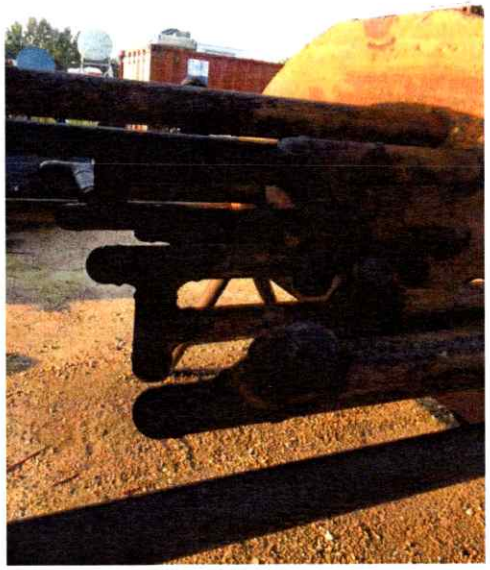



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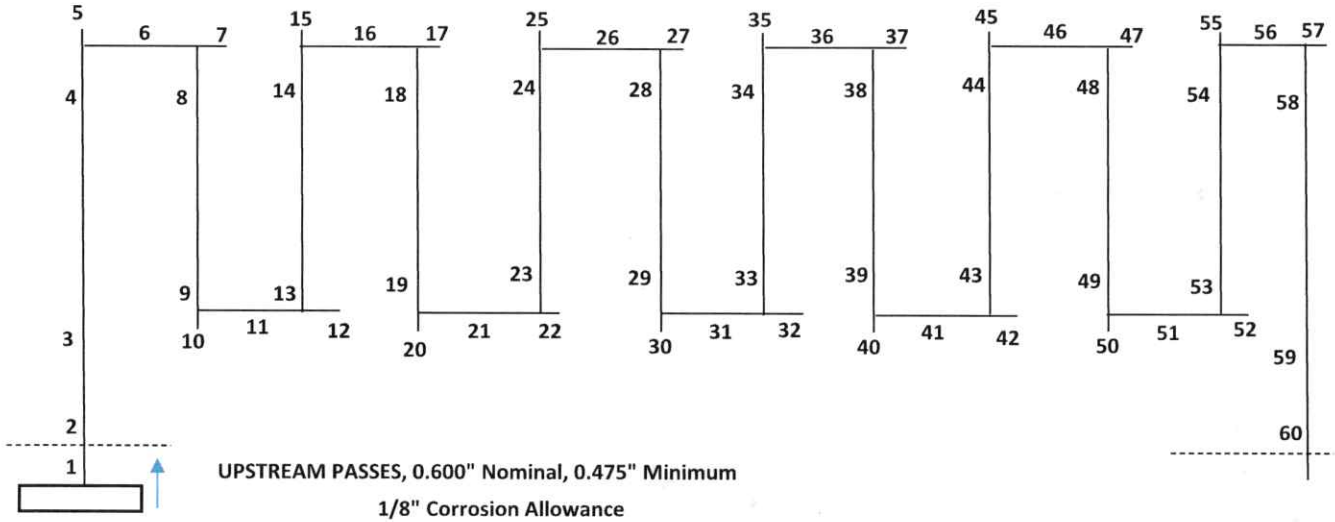
UPSTREAM



UPSTREAM PASSES, 0.600" Nominal, 0.475" Minimum

1/8" Corrosion Allowance

Loc #	Min. Inches	Avg. Inches
45	0.535	0.569
46	0.750	0.770
47	0.539	0.567
48	0.548	0.575
49	0.548	0.583
50	0.540	0.560
51	0.745	0.765
52	0.537	0.575
53	0.545	0.568
54	0.550	0.570
55	0.535	0.560
56	0.738	0.760
57	0.536	0.570
58	0.540	0.570
59	0.540	0.567
60	0.542	0.574

Loc #	Min. Inches	Avg. Inches	Loc #	Min. Inches	Avg. Inches	Loc #	Min. Inches	Avg. Inches	Loc #	Min. Inches	Avg. Inches
1	0.545	0.578	12	0.540	0.579	23	0.550	0.590	34	0.545	0.575
2	0.555	0.585	13	0.550	0.578	24	0.552	0.587	35	0.540	0.500
3	0.560	0.590	14	0.545	0.580	25	0.540	0.560	36	0.745	0.774
4	0.552	0.580	15	0.538	0.580	26	0.735	0.758	37	0.539	0.569
5	0.540	0.575	16	0.750	0.770	27	0.535	0.560	38	0.550	0.580
6	0.740	0.760	17	0.545	0.586	28	0.568	0.587	39	0.554	0.585
7	0.539	0.570	18	0.562	0.580	29	0.570	0.586	40	0.538	0.567
8	0.540	0.584	19	0.554	0.582	30	0.536	0.564	41	0.744	0.765
9	0.550	0.582	20	0.538	0.568	31	0.750	0.770	42	0.539	0.568
10	0.560	0.575	21	0.740	0.765	32	0.538	0.560	43	0.545	0.587
11	0.750	0.762	22	0.548	0.589	33	0.561	0.580	44	0.560	0.576

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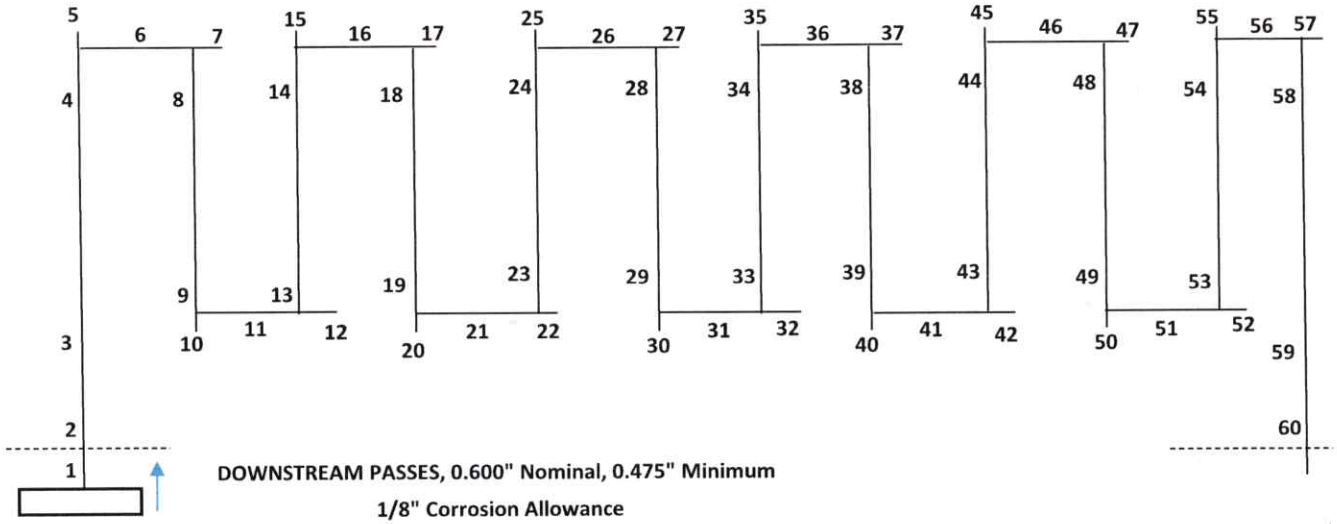
DOWNSTREAM



DOWNSTREAM PASSES, 0.600" Nominal, 0.475" Minimum

1/8" Corrosion Allowance

Loc #	Min. Inches	Avg. Inches
45	0.537	0.560
46	0.726	0.759
47	0.540	0.560
48	0.545	0.575
49	0.545	0.583
50	0.539	0.560
51	0.725	0.770
52	0.540	0.560
53	0.545	0.563
54	0.550	0.560
55	0.540	0.559
56	0.740	0.761
57	0.538	0.570
58	0.545	0.569
59	0.543	0.564
60	0.542	0.560

Loc #	Min. Inches	Avg. Inches	Loc #	Min. Inches	Avg. Inches	Loc #	Min. Inches	Avg. Inches	Loc #	Min. Inches	Avg. Inches
1	0.540	0.560	12	0.542	0.560	23	0.545	0.565	34	0.542	0.559
2	0.535	0.549	13	0.540	0.560	24	0.545	0.562	35	0.535	0.560
3	0.536	0.550	14	0.540	0.558	25	0.540	0.570	36	0.735	0.764
4	0.542	0.548	15	0.539	0.545	26	0.740	0.763	37	0.540	0.560
5	0.535	0.549	16	0.750	0.770	27	0.541	0.566	38	0.541	0.560
6	0.720	0.750	17	0.542	0.568	28	0.540	0.558	39	0.541	0.561
7	0.537	0.560	18	0.538	0.558	29	0.540	0.555	40	0.539	0.564
8	0.541	0.553	19	0.536	0.554	30	0.541	0.561	41	0.749	0.768
9	0.541	0.556	20	0.543	0.568	31	0.760	0.780	42	0.543	0.555
10	0.536	0.560	21	0.746	0.769	32	0.540	0.570	43	0.540	0.561
11	0.735	0.760	22	0.542	0.563	33	0.540	0.562	44	0.541	0.564

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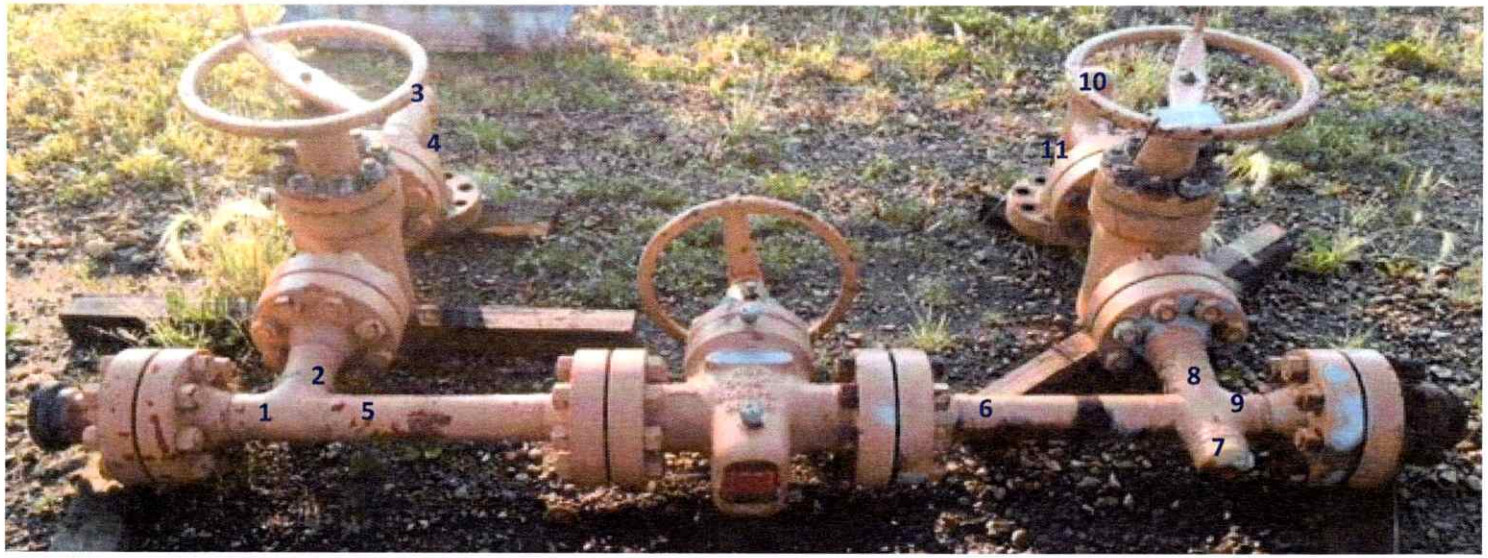



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Manifold Pipe Nominal Thickness 0.600" , Min. Thickness 0.475"

LOC #	Description	Min. Inches	Avg. Inches
1	TEE	0.672	0.702
2	PIPE	0.545	0.569
3	CAP	0.570	0.580
4	PIPE	0.558	0.570
5	PIPE	0.540	0.560
6	PIPE	0.545	0.562
7	CAP	0.540	0.560
8	PIPE	0.550	0.580
9	CROSS BRANCH	0.675	0.700
10	CAP	0.545	0.560
11	PIPE	0.550	0.565
12	TEE	0.630	0.660
13	CAP	0.540	0.560
14	PIPE	0.537	0.559
15	PIPE	0.547	0.570
16	CAP	0.702	0.720
17	TEE	0.632	0.650