Y10-9

ABSA
the pressure equipment safety authority

MANUFACTURER'S DATA REPORT FOR INDIRECT FIRED HEATER COILS

AB-28 2006-02

A# 606849

PARTIAL ☐

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
		Edition	2010	Addenda	2010	
BSC-1044	2080-01 Rev 1					2011

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 May 3 - 2011 Signed Wade Brandvold For Bluestar Investments Inc.
(Representative) (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.

Date May 03 2011 Signed [signature] NB 12632A AB-183A.

SANDHEATER #2
A#606849

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

Client:	BLUESTAR	***Units :***	SandHeater 2
Inspection Date:	APRIL 30,2026	***W0 #:***	
Client Rep:	WADE BRANDVOLD	***Technician:***	GEOFF FENTON

Flaw Detector/Thickness Gauge

Make: Dakota	Model: DFX-8	Serial #: 20193	Calibration: May 2025

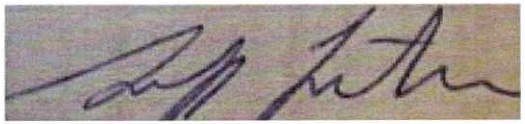
Ultrasonic Transducer

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. 8 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 UT 1
Carmaco Inspections

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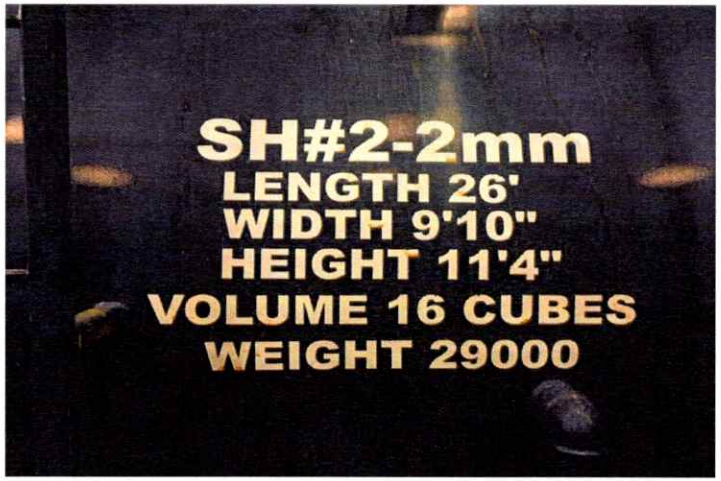

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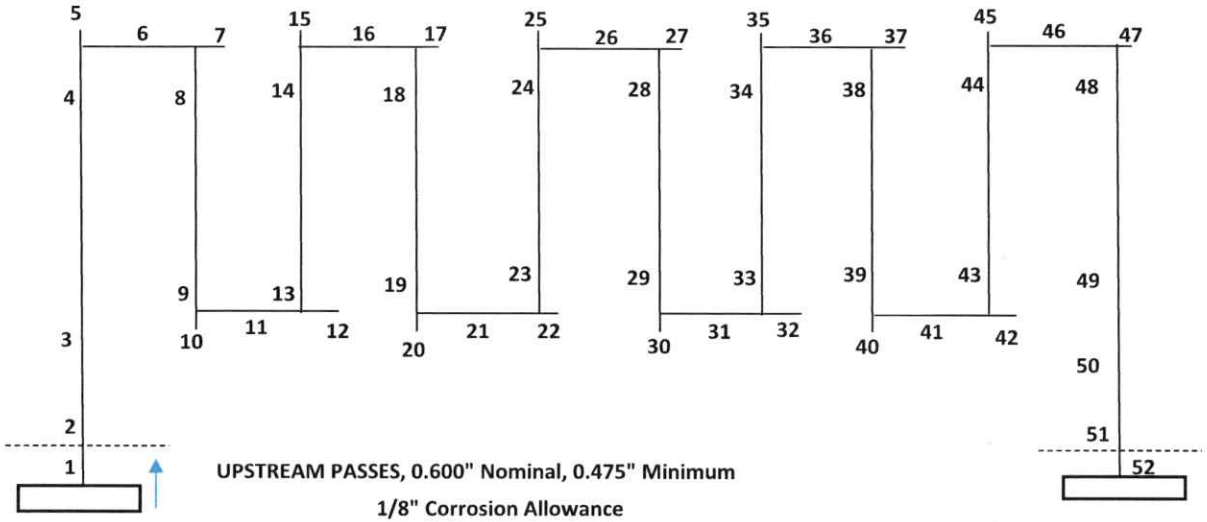
UPSTREAM



UPSTREAM PASSES, 0.600" Nominal, 0.475" Minimum

1/8" Corrosion Allowance

Loc #	Min. Inches	Avg. Inches
45	0.700	0.720
46	0.740	0.760
47	0.690	0.725
48	0.545	0.565
49	0.545	0.580
50	0.538	0.570
51	0.525	0.550
52	0.540	0.572

Loc #	Min. Inches	Avg. Inches	Loc #	Min. Inches	Avg. Inches	Loc #	Min. Inches	Avg. Inches	Loc #	Min. Inches	Avg. Inches
1	0.520	0.584	12	0.680	0.700	23	0.545	0.560	34	0.540	0.560
2	0.520	0.580	13	0.552	0.578	24	0.550	0.580	35	0.690	0.720
3	0.515	0.585	14	0.550	0.580	25	0.700	0.720	36	0.735	0.760
4	0.530	0.582	15	0.500	0.520	26	0.740	0.760	37	0.710	0.730
5	0.680	0.710	16	0.700	0.740	27	0.710	0.730	38	0.545	0.560
6	0.710	0.765	17	0.495	0.520	28	0.565	0.575	39	0.550	0.585
7	0.700	0.720	18	0.560	0.578	29	0.560	0.570	40	0.700	0.720
8	0.520	0.584	19	0.555	0.580	30	0.700	0.730	41	0.740	0.765
9	0.530	0.582	20	0.500	0.520	31	0.740	0.760	42	0.710	0.730
10	0.700	0.720	21	0.745	0.770	32	0.720	0.740	43	0.540	0.580
11	0.715	0.770	22	0.510	0.520	33	0.554	0.575	44	0.555	0.570

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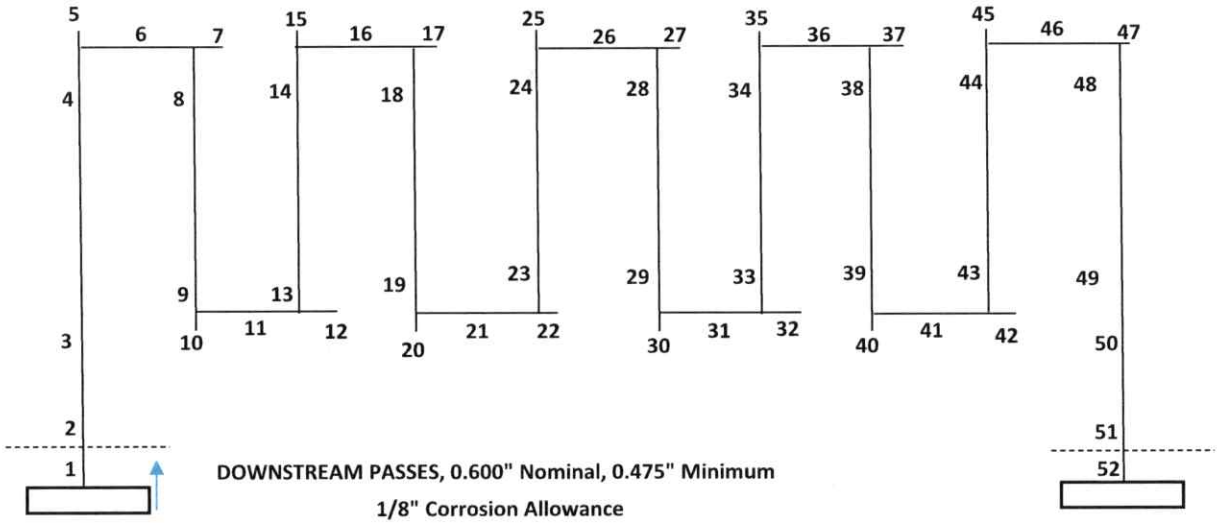
DOWNSTREAM



DOWNSTREAM PASSES, 0.600" Nominal, 0.475" Minimum

1/8" Corrosion Allowance

Loc #	Min. Inches	Avg. Inches
45	0.700	0.720
46	0.740	0.760
47	0.690	0.725
48	0.545	0.565
49	0.545	0.580
50	0.538	0.570
51	0.525	0.550
52	0.540	0.572

Loc #	Min. Inches	Avg. Inches	Loc #	Min. Inches	Avg. Inches	Loc #	Min. Inches	Avg. Inches	Loc #	Min. Inches	Avg. Inches
1	0.520	0.584	12	0.680	0.700	23	0.545	0.560	34	0.540	0.560
2	0.520	0.580	13	0.552	0.578	24	0.550	0.580	35	0.690	0.720
3	0.515	0.585	14	0.550	0.580	25	0.700	0.720	36	0.735	0.760
4	0.530	0.582	15	0.480	0.500	26	0.740	0.760	37	0.710	0.730
5	0.680	0.710	16	0.749	0.775	27	0.710	0.730	38	0.545	0.560
6	0.710	0.765	17	0.480	0.510	28	0.565	0.575	39	0.550	0.585
7	0.700	0.720	18	0.560	0.578	29	0.560	0.570	40	0.700	0.720
8	0.520	0.584	19	0.555	0.580	30	0.700	0.730	41	0.740	0.765
9	0.530	0.582	20	0.700	0.720	31	0.740	0.760	42	0.710	0.730
10	0.700	0.720	21	0.745	0.770	32	0.720	0.740	43	0.540	0.580
11	0.715	0.770	22	0.690	0.725	33	0.554	0.575	44	0.555	0.570

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

LOC #	Description	Min. Inches	Avg. Inches
1	TEE	0.650	0.670
2	PIPE	0.520	0.540
3	CAP	0.530	0.550
4	PIPE	0.510	0.530
5	PIPE	0.530	0.540
6	PIPE	0.520	0.530
7	CAP	0.515	0.525
8	PIPE	0.510	0.520
9	CROSS BRANCH	0.650	0.690
10	CAP	0.520	0.530
11	PIPE	0.510	0.530
12	TEE	0.650	0.680
13	CAP	0.630	0.540
14	PIPE	0.520	0.530
15	PIPE	0.520	0.530
16	CAP	0.670	0.690
17	TEE	0.610	0.640