

Lawrence's Welding (1987) Ltd.

Box 685 • High Level, Alberta • T0H 1Z0
Telephone: (780) 683-2392 — Zama
Fax (780) 683-2363

FAX TRANSMISSION

Date July 29 2011
Faxed to Number 403 729 3879
Total Pages including this Page 06
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TO: Rob S
FROM: Lawrence Hnatuk
Re: 4 Fire Tubes for Zama Apache 7-34 + 9-28
Message _____

I Talked TO Wayne Smith. with ABSA
that I Faxed Repair Request
ON 4 Tube for Zama He said TO
go Ahead with Them.

I am sending Request TO Repair
TO you same I sent TO ABSA
will Fax Final AB 40 when Completed

Thanks

Lawrence Hnatuk

Phone 780 683 2392
or
Cell 780 915 4944

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TO: Wayne Smith c/o ABSA

FROM: Lawrence Hnatuk

Re: 2 Apaches Fire Tubes to Repair From 7-34-114-6-W6
2 Apaches Fire Tubes to Repair From 9-28-117-4-W6

Message Apache has Two Fire Tubes
From 7-34-114-6-W6 and Two

From 9-28-117-4-W6. with

but All need Repairs there

are spare Tubes & They would like

Them Repaired Sent Repair

Request in. I will call by
phone Later To Day.

Thanks

Lawrence Hnatuk

Phone: 780 683 2392

or
cell 780 915 4944



BOILERS AND PRESSURE VESSELS REPAIR AND ALTERATION REPORT

(A) #: A-27 815 43OWNER EQUIP NO.: 9-28 Twin 18" Fire Tubes

Repair Request only

REPAIR ☒

and/or

ALTERATION ☐Partial ☒ Final ☐

1. Name and Address of Organization doing Repair/Alteration LAWRENCE'S Welding 1987 LTD
Box 685 High Level Alberta AQP No. & Expiry Date 2278 Aug 31 2011
 Location of Installation 9-28-117-4-06

2. Name of Owner Apache CanadaAddress 24ma Alta (also Calgary)3. Boiler/Pressure Vessel Description NATCO Theater Twin Fire Tubes CRN K 6455.2Manufacturer's Name NATCO 18" X 20 Twin Serial No. L-8-340
Fire Tubes

4. Design Conditions:

a) Vessel/Shellside/Boiler: Max Allowable Working Press. 75 PSI Min/Max Design Temp 250°
 b) Jacket/Tubeside: Max Allowable Working Press. 1 Min/Max Design Temp 1

5. Description of defects (location and types of deterioration that resulted in the repair/alteration).

Tube A has crack on inside tube sheet side
Tube B has to be checked MPI for defects

6. ASME Code Edition and Addenda used for work: ASME Sect. VIII Year 2007 Addenda 2008A

7. Repair/Alter. Description of Work. Step by step description of repair/alteration method, attach additional sheets as needed.

Note 1: Repair/Alteration Procedure to be accepted by Alberta Boilers Safety Association SCO prior to start of work.

Both Tubes to be Blasted clean to Take Thickness
Readings and MPI all welds to locate defects
gouger or grind clean and MPI to remove
all defects. Pre heat 350°-450°F Repair
Post heat 250°F to 450°F hold 20 min
Insulate to cool down MPI after cool
Down

8. Material - List any material used in repair/alteration and any base material welded on:

Item	Mat'l Spec.	Thick/Sch	Diam	Item	Mat'l Spec.	Thick/Sch	Diam
Shell/Drum				Heads/ Ends			
Tubesheet				Tubes			
Nozzles				Flanges/Fittings		Class	

9. Welding Procedure - Alberta Registration Number WP- 1306.2 WPS Numbers used: LW-1 Rev 310. Heat Treatment: Bake Out (Temp./Time) 350F 1450F Preheat Temp 350F to 450F Post Weld HT (Temp./Time) 20 min

11. Non Destructive Examination (Specify type and extent).

Thickness Readings on Pipe & elbows
MPI all welds plus all Repairs

Repair Request only (A) #: A2781543

OWNER EQUIP. NO. Apache 9-28 Twin 18" Fire Tube

2. Pressure Test

Vessel/Boiler/Shellside

Tubeside/Jacket

a) Hydrostatic

b) Other Test

TICKWESS Readings & MPI

13. Welded Replacement Parts: Attached are Manufacturer's Partial Data Reports or Repair/Alteration Reports properly identified and signed by Authorized Inspectors for the following items of this report: (Welded parts supplied by others).

14. Responsibility Owner/Client. Identify below items that the owner/client has assumed responsibility for, Note (2)

a) Design Submission

b) Repair/Alteration Procedure:

c) Material Control

d) Welding Control

e) NDE

f) Heat Treatment

g) Pressure Test

Note 2: Owner/client must have a valid Alberta Quality Program (AQP), for the scope of work, to assume responsibility for function c, d, e, f, or g.

15. REMARKS:

MPI by whoever is available
Apache Personnel Mark Harris 780-683 8021

16.

CERTIFICATE OF COMPLIANCE

We certify that the statements made in this Report are correct and that all design, material, construction and workmanship on this repair/alteration conform to the requirements of the Alberta Safety Codes Act and Regulations.

a) For all items except for items identified in 14:

Lawrences Welding 1987 LTD.
(Repair/Alteration Organization Name)
22782 Aug 31 2011
(AQP Number & Expiry Date)
Lawrence Harris
(Signature & Date)
Lawrence Harris
(Print Name)

b) For items identified in 14 only:

(Owner/Client Organization Name)
(AQP Number & Expiry Date)
(Signature & Date)
(Print Name)

17. DATE WORK WAS COMPLETED:

May start on Aug 1/2011
or when MPI

18. PERSONNEL ARE AVAILABLE. CERTIFICATE OF INSPECTION

I have inspected the repairs and/or alterations described in this report. To the best of my knowledge this work has been done in accordance with the Safety Codes Act and Regulations.

a) Owner-User Inspection Certification (Field Only)

(Required when Owner-User inspects the work under their ABSA Authorized Owner-User Quality Program).

Owner-User AQP# & Expiry Date

Owner-User In-Service Inspector Signature & Date

Owner-User In-Service Inspector Name (Please Print)

Owner-User In-Service Inspector Alberta Cert #

b) ABSA Safety Codes Officer Certification

(when work is inspected by ABSA).

ABSA SCO Signature & Date

Print Name

Report Received by ABSA SCO

Date