

Head Office: 4810 - 93 Street NW, Edmonton, Alberta, Canada T6E 5M4

Tel: 780-469-2401 Fax: 780-468-2422 www.raeengineering.ca

Report No: KM004790

Client	Canadian Natural Resources Ltd.	Inspection Date	Jul 2, 2019				
Prov. Reg. #	AB 0662699	Inspection Type	VE / UT				
Equipment Type	Horizontal Glycol Cooler	Location	Gold Creek				
Tag/Equip.		LSD	AB 13-26-067-05W6				
Status	In Service	Downhole LSD					
Manufacturer	Calhex Industries Ltd	Area					
Serial Number	16-1139	Year Built	2016				
CRN#	Y2702.2	Service	Glycol				
Comp/Unit Id	Glycol Area	Manway	None				
Nat.Board #		Coating					
Interim Insp'n		Interim Type					
Next Thorough Insp	2024	Next Insp Type	VE / UT				
Length		Height					
Volume		Client Reference					
Owner	Canadian Natural Resources Ltd.	RT	HT YES				
Foreman	Chris Maxsom	RAE Job No.	8364				
ABSA	Plant: H Vessel: T Process: H	Special: B	ASME Sec. VIII div. 1				
History Log							

Component	Shell											
MAWP	230	230.0 PSI @ 351 °F MDMT -49 °F @ 230.0 PSI										
Material			Material Th	ickness								
Diameter			Length									
Corrosion A	llowance											

Date Printed: Sep 27, 2019

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,			
Valve Tag No	25	Relief Type	Pressure Safety Valve
Manufacturer	Consolidated	Set Pressure	150 PSI
Serial Number	69C2085	Capacity	4519 lb/hr
Model	1905 GC S1	Last Service	May 31, 2014
CRN		Next Service	2019
Service Co.	Unified Valve	Service Interval	60 Months
Service Co. Tag	1288V	Inlet Size	1.5 in
ASME Stamp	UV	Outlet Size	2.5 in
NB Stamp	YES	Connection	Flanged
Relief Dest.	To Flare	Valve Loc.	On Vessel
Comments	PSV located on Glycol Surge Tank	Client Reference	

Comments

The following RAE Procedure(s) was/were used in inspecting this vessel: INS-669B Air Cooler Exchanger Inspection Procedure NDE-701B UT-1 Ultrasonic Thickness Measurement Procedure



Building Observations

The cooler was located outside any building structures.

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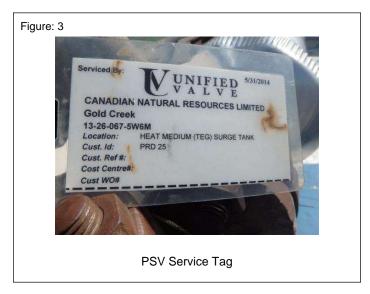
Piping Observations

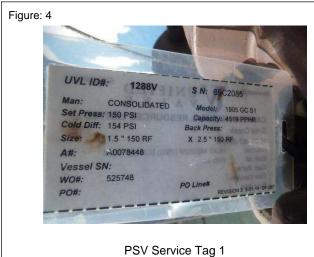
The attached piping was generally in serviceable condition. It was sufficiently supported with no damage, distortion or undue stress evident. The flanged and threaded joints were properly connected, and exhibited no signs of leakage.

PSV Observations

The Pressure Safety Valve (PSV) was installed outside. The PSV for this particular vessel was attached to the piping. The orientation of the PSV was vertical. It was also noted that the PSV was in good condition. The seal on the PSV was intact and the PSV was easily accessible for inspection. The set pressure of this particular PSV is acceptable to the maximum allowable working pressure of the vessel.







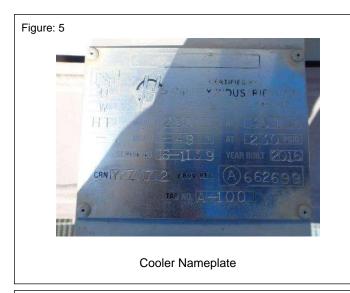
Date Printed: Sep 27, 2019 Page: 3 of 5

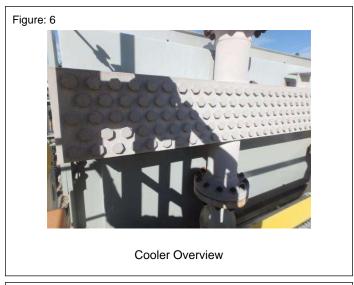
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External Observations

The cooler was located outside of any building structures. The cooler was identified by it's A/serial number. The cooler was in good condition. No dents or damage evident on the surface of the cooler. This cooler was mounted horizontally. The louvers appeared to be in good operating condition. The cooler was supported by the cooler housing.









UT1 Observations

Please see the attached Appendices for UT Data.

Recommendations

Based on the scope of this inspection, the vessel appears suitable for continued service.

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Field Inspection Report

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Tel: 780-469-2401 Fax: 780-468-2422 www.raeengineering.ca

Report No: KM004790

Ken McNeil

Alberta IBPV #A-75085 API 510 #39628, API 570 #66961 API 653 #47993, CWB Level III #483 Trevor Paananen, P.Eng.

Alberta IBPV #A-55680 CWB Level I #4816, API 570 #76796 API 653 #22574, NACE Level I #12488

Inspector : Ken McNeil Reviewed By: Trevor Paananen

Date Printed: Sep 27, 2019

A810 - 93 Street Edmonton, AB, T6E 5M4			R	AE En	g an	d Inspe	ection L	td	Inspection Date:				2-Jul-19 Ultrasonic Th					hickness				
ph:: 780-469-2401 fx: 780-468-2422 RAE Reports: 19-8364-LCUT65 Canadian Natural Resources Ld. Propted 18: 3846 Address: Sub-2500, 855-251, SW, Calgary, AB, 172-418 (Location/150). Coloid Creek J. 11-26-067-05 WG. Client Representative: NA Receptions Code: AME VIII, Div. 1.8 ASME 831.3 Term Tested: Vessel & Piping Material: Carbon Steet Propted 18: ABC Condition. Term Tested: Vessel & Piping Material: Carbon Steet Propted 18: ABC Condition. Term Tested: Vessel & Piping Material: Carbon Steet Propted 18: ABC Condition. Term Tested: Vessel & Piping Material: Carbon Steet Propted 18: ABC Condition. Term Tested: Vessel & Piping Material: Carbon Steet Propted 18: ABC Condition. Term Number: AGG-2509 Strace Carbon Steet Matchined Carbon Steet Propted 18: ABC Condition. Term Number: AGG-2509 Strace Carbon Steet Matchined Carbon Steet Propted 18: ABC Condition. Term Number: AGG-2509 Strace Carbon Steet Matchined Carbon Steet Description: Carbon Steet Matchined Carbon Steet Propted Inc. Carbon Steet Material: Carbon Steet Material: Carbon Steet Matchined Carbon Steet Description: Carbon Steet Material: Carbo	RAE 481							_						- Examination								
Address: Subtra 2000, 855-251, SW, Calgary, AB, T2PAIR (Location/ASD): Cold Creek / 13-26-067-05 WG (Location Representative: NA Acceptance Code: ASME VIII, Div. 1 & ASME B31.3 (Location/ASD): Cold Creek / 13-26-067-05 WG (Location Representative: NA Acceptance Code: ASME VIII, Div. 1 & ASME B31.3 (Location/ASD): Carbon Representative: NA Acceptance Code: ASME VIII, Div. 1 & ASME B31.3 (Location/ASD): Carbon Representative: NA ACCEPTION (Location Representative: NA ACCEPTION (Location Representative: ASCEPTION Representative: ASCEPTION (Location Representative: ASCEPTION Representative: ASCEPTION Representative: ASCEPTION (Location Representative: ASCEPTION Representati	ph			780-	-469·	-2401	1	fx: 78	0-468-2	422			t:		1 0 4							
Results: The measurements obtained from the inspection locations showed the thickness of all of the components inspected to be consistent in thickness, however no nominal thicknesses were available. There were no signs of wall thinning, internal corrosion, erosion, laminations or inclusions at the imediate please see the following pages for the pictures of the nameplate and the overall view, the isometric drawings, and the thickness measurements. Client NA	Client:			Canad	lian N	latural	Res	ources L	.td.		Proj	ject #:			8364							
Client Representative: NA Receptance Code: SAME VIII, Div. 1 & ASME B 31.3	Address:			Suite 2	2500,	855-2	St.,	SW, Calg	gary, AB,	T2P4J8	Loca	ation/LSD):		Gold Creek	c / 13-26-0	67-05 \	N6				
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The Number A0662699 Surface Surface Surface An Gound Short Blasted An Welder Surface Temps Cord Color		·										SCRIPTION										
Comparison Com	Items Tested:				١	Vessel	& Pi	iping			_					C	arbon s	Steel				
Results: The measurements obtained from the inspection locations showed the thickness of all of the components inspected to corrosion, erosion, laminations or inclusions at the time of inspection. All piping measurements were within the 12.5% mill tolerance, as per ASTM specifications. Results: The measurements obtained from the inspection locations showed the thickness of all of the components inspected to corrosion, laminations or inclusions at the time of inspection. All piping measurements were within the 12.5% mill tolerance, as per ASTM specifications. Client	Item Number	:									Surf	ace		1	Painted	В	are Ste	el	l N	/lachir	ned	
Results: The measurements obtained from the inspection locations showed the thickness of all of the components inspected to be consistent in thickness, however no nominal thicknesses were available. There were no signs of wall thinning due to corrosion, erosion, alminations or inclusions at the time of inspection. All piping measurements were within the 12.5% mill tolerance, as per ASTM specifications. Probleman	5											dition:			As Ground	S	hot Bla	sted	Δ	s Wel	ded	
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Cale Block S/Nc								EQUI	PMENT	, TECHN	viQL	JE & CA	LIBF	RAT	ION							
Probe Prob	Instrument N	lfr:		GE		Model	:		DM	S Go+	S/N	:	(GOP	LS17070020	0	Cal. D	ue:	1	8-Apr	-20	
Model Mart Marge (in) Single Dual Manufacturer Senal length line (m/sec) Value dB %45H Scan da mm)	Cal Block S/N		12	-4693		1 or 2	Poir	nt Cal:	1	√ 2	Cali	brated Ra	inge:		0.250	"-1.000"	Coupl	ant:	9	Sono 6	500	
To Foreign So O' 0.25	Probe	Freq	Analo	Dia.	Pro	be Ty	ре	Manu	facturer	Corio	і 4	Cable	De	lay	Vel.	Transfer	Ref	Ref	Coon	٩n	Range	
Scope: Conduct 0° straight beam ultrasonic testing on a glycol cooler while looking for any signs of wall thinning due to corrosion, erosion, laminations or inclusions. Results: The measurements obtained from the inspection locations showed the thickness of all of the components inspected to be consistent in thickness, however no nominal thicknesses were available. There were no signs of wall thinning, internal corrosion, erosion, laminations or inclusions at the time of inspection. All piping measurements were within the 12.5% mill tolerance, as per ASTM specifications. Please see the following pages for the pictures of the nameplate and the overall view, the isometric drawings, and the thickness measurements. Client NA Representative PRINT SIGNATURE 1º Technician PRINT SIGNATURE ISTANDATURE ISTANDATURE SIGNATURE SIGNATURE ISTANDATURE SIGNATURE ISTANDATURE SIGNATURE SI	Model	MHz	Angle	(in)	Sing	gle D	ual	ivianu	racturer	Seria	I #	length	lir	ne	(m/sec)	Value	dB	%FSH	Scan	ив	(mm)	
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			ind Inspection Ltd	Date:	2-Jul-19	Ultrasonic Thickness						
<rae></rae>	481	0 - 93 Street Edm	onton, AB, T6E 5M4	Page:	2 of 4	Examination						
	ph	: 780-469-2401	fx: 780-468-2422	RAE Report #:	19-8364-LC-UT-65							
Client:		Canadian Natural Re	sources Ltd.	Project #:	8364							
Item Number:		A0662699		Location/LSD:	Gold Creek / 13-26-067-05 W6							
Item Description:		G	ycol Cooer	Procedure:	NDE-701B UT-1 REV. 7							
item bescription.		di	ycoi codei	Acceptance Code:	ASME VIII, Div. 1 & ASME B31.3							
	Photographs of Equipment and Nameplate											



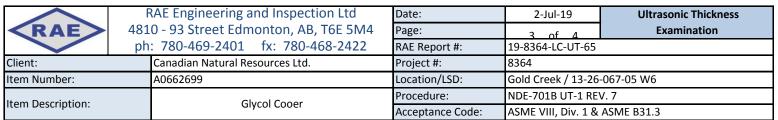
View of Nameplate



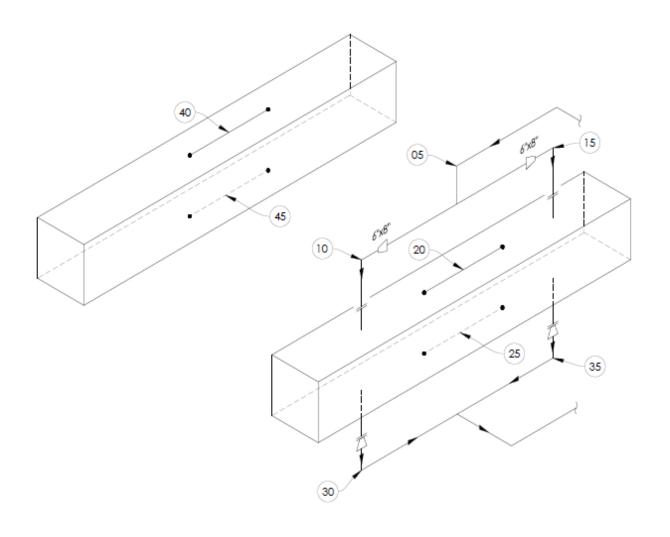


Overall View of Equipment

Client	NA					
Representative	PRINT	SIGNATURE				
1 ST Technician	Hyekyong Colp		CGSE	#: 17600	CGSB LvI:	I
1 Technician	PRINT	SIGNATURE	SNT	: 710B-010	SNT LvI:	I
2 ND Technician	Stuart Ashman		CGSE	#: 18886	CGSB LvI:	П
2 rechnician	PRINT	SIGNATURE	SNT	:	SNT LvI:	



ISO Drawing of Equipment and TMLs



Client	NA						
Representative	PRINT	SIGNATURE					
1 ST Technician	Hyekyong Colp			CGSB#:	17600	CGSB Lvl:	I
1 rechnician	PRINT	SIGNATURE		SNT#:	710B-010	SNT LvI:	1
2 ND Technician	Stuart Ashman		[CGSB#:	18886	CGSB LvI:	П
2 Technician	PRINT	SIGNATURE		SNT#:		SNT LvI:	

/							nd Insp			Date:			2-Jul	-19	Ultrasonic Thickness			
4810 - 93 Street Edn ph: 780-469-2401						•		Page:			4 0		Examination					
Client:			þπ				sources L		2422	Project	eport #:		19-8364-L 8364	.C-U1-65				
Item Nu	mher:			A0662		urai ne	sources L	.tu.		_	on/LSD:		Gold Cree	k / 13-26	-067-05 \	V6		
				7.0002	-033					Proced			NDE-701B	•		••		
Item Description: Glycol Cooer Acceptance Code: ASME VIII, Div. 1 & ASME B31.3																		
Measur	rement	s in:	millime	eters						·		TM	L Data					
TML			Desci	ription			1	2	3	4	5	6	7	8	9	10	11	12
	8''	STD		90° I	Elbow		8.4	8.6	8.6	8.6	8.6	8.4	8.4	8.6	8.6	8.6	8.6	8.6
05	Nom.	8.2	Min.	7.2	Direc.	Т-В									Min. =	8.4	Ave. =	8.6
	6''	STD		90° I	Elbow		7.9	7.6	7.6	7.6	7.6	8.4	7.6	7.6				
10	Nom.	7.1	Min.	6.2	Direc.	Т-В							+		Min. =	7.6	Ave. =	7.7
	6"		141111.			1.5	7.0	7.1	7.4	7.1	7.4	7.4	7.4	7.4	141111. –	7.0	Avc	7.7
15		STD	1	1	Elbow		7.6	7.1	7.4	7.1	7.4	7.4	7.4	7.4				_
	Nom.	7.1	Min.	6.2	Direc.	T-B									Min. =	7.1	Ave. =	7.3
20				Head	der		14.0	13.7	13.7	13.7	13.7	13.7	13.7	13.7	13.7	13.7	13.7	13.7
	Nom.	N/S	Min.	N/S	Direc.	L-R									Min. =	13.7	Ave. =	13.7
35				Head	der		13.7	13.7	13.7	13.7	13.7	13.7	13.5	13.7	13.7	13.7	13.7	13.7
25	Nom.	N/S	Min.	N/S	Direc.	L-R									Min. =	13.5	Ave. =	13.7
	8''	STD		90° I	Elbow		8.9	8.6	8.6	8.6	8.9	8.9	8.9	8.9	8.6	8.9	1	
30	Nom.	8.2	Min.	7.2	Direc.	Т-В							1		Min. =	8.6	Ave. =	8.8
	8"	STD	141111.		Elbow	1 5	8.1	8.4	8.6	8.6	8.6	8.1	8.4	8.1	8.1	8.4	Avc	0.0
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	Nom.	8.2	Min.	7.2	Direc.	T-B									Min. =	8.1	Ave. =	8.4
40				Head	der	T	13.5	13.5	13.5	13.5	13.5	13.7	14.0	13.7	13.7	14.0	13.5	13.5
	Nom.	N/S	Min.	N/S	Direc.	L-R									Min. =	13.5	Ave. =	13.6
45				Head	der		13.5	13.5	13.5	13.5	13.5	13.5	13.5	13.7	13.5	13.5	13.5	13.5
45	Nom.	N/S	Min.	N/S	Direc.	L-R									Min. =	13.5	Ave. =	13.5
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ND	Stuart Achman					n				SIGINA				CGSB#:	710B-0 1888		GSB LvI:	ı II
2 ND Te	echnicia	n —			RINT					SIGNA	ATURE			SNT#:			NT LvI:	
	TANK																	