



**Commercial Vehicle Inspection Certificate
Traffic Safety Act**

**PART 1 - VEHICLE OWNER AND VEHICLE
IDENTIFICATION**

Vehicle Type:	Truck	Seating Capacity:	
GVW:	60000 kg	Brake Type:	Air
Owner Name:	Big Steam Oilfield Services Ltd		
Address:	Po Box 789		
City:	Brooks	Province:	AB
		Postal Code:	T1R1B7
Telephone Number:	(403) 501-5335		
Vehicle Identification Number:	1NKDX4EX3CR949163		
Make:	Kenworth	Model:	Construct
Year:	2012	Unit Number:	238
Odometer:	333681 KM	Licence Plate Number:	K38949
		Province:	AB

IT IS AN OFFENCE TO FALSIFY AN INSPECTION CERTIFICATE

PART 2 - CERTIFICATION

I certify the vehicle described in Part 1 has passed the inspections and tests established under the Traffic Safety Act for a Commercial Vehicle.

Inspection Facility Name:	Big Steam Oilfield Services Ltd.	Facility Number:	15339
Inspection Technician Name:	Pedro Reimer	Technician Number:	B8398
Inspection Technician Signature:			
Inspection Date:	2022/04/06		

**COMMERCIAL VEHICLE RECORD OF INSPECTION
TRUCK AND TRUCK-TRACTOR**

The original Record of Inspection must be given to the customer regardless of whether the vehicle passes or not.

Type of Vehicle										Gross Vehicle Weight registered											
Truck										60000 kg											
Vehicle Information																					
VIN	1	N	K	D	X	4	E	X	3	C	R	9	4	9	1	6	3				
Unit Number			Year			Make			Model			Odometer									
238			2012			Kenworth			Construct			333,681									
Registered Owner's Name															Plate Number						
Big Steam Oilfield Services Ltd															K38949						
Address										Postal Code					Phone Number						
Po Box 789										T1R1B7					(403) 501-5335						

Drum Brakes: B-Wheel-on Full Inspection

Disc Brakes:

		<u>LEFT</u>		<u>FRONT</u>		<u>RIGHT</u>			
100 psi	20 in	16.54 in	9/16 in	Drums/Rotors	16.544 in	9/16 in	1 in	100 psi	20 in
100 psi	25 in	16.505 in	1/2 in	Linings/Pads	16.507 in	1/2 in	1 in	100 psi	21 in
100 psi	19 in	16.508 in	9/16 in	Push Rod Travel	16.506 in	9/16 in	1 in	100 psi	18 in
100 psi	17 in	16.507 in	9/16 in		16.507 in	9/16 in	1 in	100 psi	15 in
psi	in							psi	in
psi	in							psi	in

Park Brake Lining Left n/a in Right n/a in Trans n/a in
Wheel Torque Checked Inner n/a ft lbs Outer n/a ft lbs

COMMERCIAL VEHICLE RECORD OF INSPECTION TRUCK AND TRUCK-TRACTOR

Section 3A - Air Brakes

Component	P	F	NA	Component	P	F	NA
3A.11. Parking Brake & Emergency Application	✓						

NOTES:

Section 4 - Steering

Component	P	F	NA	Component	P	F	NA
4.1. Steering Control and Linkage	✓			4.4. Kingpin	✓		
4.2. Power Steering System (Hydraulic and Electric)	✓			4.5. Self-Steer and Controlled-Steer Axle	✓		
4.3. Steering Operation (Active Steer Axle)	✓						

NOTES:

Section 5 - Instruments and Auxiliary Equipment

Component	P	F	NA	Component	P	F	NA
5.1. Fire Extinguisher	✓			5.8. Heater & Windshield Defroster	✓		
5.2. Hazard Warning Kit	✓			5.9. Fuel-Burning Auxiliary Heater			✓
5.3. Horn	✓			5.10. Chain/"Headache" Rack			✓
5.5. Speedometer	✓			5.11. Auxiliary Controls and Devices			✓
5.6. Odometer	✓			5.12. Auxiliary Drive Controls	✓		
5.7. Windshield Wiper/Washer	✓						

NOTES:

Section 6 - Lamps

Component	P	F	NA	Component	P	F	NA
6.1. Required Lamps	✓			6.4. Instrument Panel Lamps	✓		
6.2. Reflex Reflector	✓			6.5. Headlamp Aim	✓		
6.3. Retro-Reflective Marking	✓						

NOTES:

Section 7 - Electrical System

Component	P	F	NA	Component	P	F	NA
7.1. Wiring	✓			7.3. Trailer Cord (output to towed vehicle)	✓		
7.2. Battery	✓						

NOTES:

Section 8 - Body

Component	P	F	NA	Component	P	F	NA
8.1. Hood or Engine Enclosure	✓			8.12. Bumper	✓		
8.2. Tilt Cab	✓			8.13. Windshield	✓		
8.3. Air-Suspended Cab	✓			8.14. Side Windows	✓		
8.4. Cab and Passenger-Vehicle Body	✓			8.15. Rear Window	✓		
8.5. Cargo Body	✓			8.16. Interior Sun Visor	✓		
8.6. Frame, Rails & Mounts	✓			8.17. Exterior Windshield Sun Visor	✓		
8.7. Unitized Body Elements	✓			8.18. Rear-View Mirror	✓		
8.8. Cab or Cargo Door	✓			8.19. Seat	✓		
8.9. Cargo Tank or Vessel	✓			8.20. Seat Belt/Occupant Restraint	✓		
8.10. Body, Device or Equipment Attached or Mounted to the	✓			8.21. Fender/Mud Flap	✓		



1791 30th St. S.W.
 Medicine Hat, AB T1B 3N5
 Phone: (403) 527-7272
 Fax: (403) 529-6526
 Facility Registration No. 25-0709

Inspection Report in Accordance with CSA B620-20

TEST DATE: May 31, 2022

TANK OWNER: **Big Steam Oilfield Services**

ADDRESS: **# 5 Boswell Cres Brooks Alberta T1R 1B7**

TELEPHONE: (403) 793-7046

SERIAL NO.: WT0511537

UNIT NO.: 238

MVID/TCRN: Z.05.092.02.08

MANUFACTURER: Westech

ASSEMBLER: Westech

TC SPEC.: 407

MATERIAL: SA 36

CERTIFICATION DATE: 08/2011

MINIMUM THICKNESS SHELL: 5.36 mm

MINIMUM THICKNESS HEAD: 5.26 mm

MAWP: 25 psi

DESIGN PRESSURE:

LINING: YES NO

INSULATED: YES NO

SPECIAL SERVICE CONDITIONS:

COMP. CAPACITY:

1 11652 L

2

3

4

5

INSPECTION PERFORMED V I P K T UC L

PRESSURE RELIEF DEVICES: SET TO DISCHARGE PRESSURE:

#1) TYPE: Fort Vale	SERIAL NO: 1160125	OPEN PSI: 30 psi	RESEAT PSI: 30 psi
REINSTALLED <input checked="" type="checkbox"/>	REPAIRED <input type="checkbox"/>	REPLACED <input type="checkbox"/>	
#2) TYPE:	SERIAL NO:	OPEN PSI:	RESEAT PSI:
REINSTALLED <input type="checkbox"/>	REPAIRED <input type="checkbox"/>	REPLACED <input type="checkbox"/>	
#3) TYPE:	SERIAL NO:	OPEN PSI:	RESEAT PSI:
REINSTALLED <input type="checkbox"/>	REPAIRED <input type="checkbox"/>	REPLACED <input type="checkbox"/>	
#4) TYPE:	SERIAL NO:	OPEN PSI:	RESEAT PSI:
REINSTALLED <input type="checkbox"/>	REPAIRED <input type="checkbox"/>	REPLACED <input type="checkbox"/>	
#5) TYPE:	SERIAL NO:	OPEN PSI:	RESEAT PSI:
REINSTALLED <input type="checkbox"/>	REPAIRED <input type="checkbox"/>	REPLACED <input type="checkbox"/>	

TC 331, MC 331, MC 330, TC 51, CTC 51, DOT 51 TANKS:

CONSTRUCTED OF QUENCHED AND TEMPERED STEEL: QT YES NO

CONSTRUCTED OF OTHER THAN QUENCHED AND TEMPERED STEEL: NQT YES NO


TANK STRESS RELIEVED AFTER MANUFACTURE: YES NO

TANK STRESS RELIEVED AFTER REPAIR: YES NO


TANK STRESS RELIEF AFTER REPAIR: COMPLETE: LOCAL:

RECORD ALL INFORMATION FROM DATA PLATE AND TAKE PHOTOS OF DATA PLATE AND UNIT FOR FILE:

EXTERNAL VISUAL INSPECTION "V"

Item Inspected	QC Man.Ref.	Complies	Reject	Retest Complies
Data plate, present and legible	12.2.3	X		
Shell & heads; corrosion, dents, overlay patches, leaks, voids, etc.	12.2.4	X		
Structural members, outriggers crossmembers, etc.	12.2.5	X		
Upper coupler for cracks, corrosion, distortion, and bolt tightness	12.2.6	N/A		
Piping and valves for leakage, damage, and corrosion	12.2.7	X		
Valve operating systems, remote closures, and thermal devices	12.2.7	X		
Hoses for defects, identification and test dates	12.2.8	X		
Gaskets on full opening rear heads for damage or cuts	12.2.9	X		
Tank attachments to frame or running gear	12.2.10	X		
Ladders, walkways, platforms, etc.	12.2.11	X		
Fill covers, manways, and closure devices	12.2.12	X		
Relief valves and vents (replace or test if in corrosive lading Service)	12.2.13	X		
Accident damage protection; compliance, damage, distortion, corrosion	12.2.14	X		
Off truck emergency shut down system	12.2.15	X		
Inspector: Dan Laekeman	Signature: 		Date: May 31, 2022	

INTERNAL VISUAL INSPECTION "I"

Item Inspected	QC Man Ref.	Complies	Reject	Retest Complies
Interior surface for corrosion, distortion, overlay patches, cracking, etc.	12.3.2	X		
If required by the tank specification perform Wet Fluorescent Magnetic Particle Inspection and file report in accordance with Dynamic Industrial Solutions Procedure Number QP-16	12.3.3	X		
Interior welds for defects, cracking, etc.	12.3.4	X		
Internal supports and attachments	12.3.5	X		
Internal valves, piping and vents for leakage, damage, etc.	12.3.5	X		
Inspector: Dan Laekeman	Signature: 		Date: May 31, 2022	

Rejection Criteria for Visual Inspections

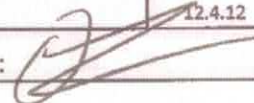
Any of the following conditions shall cause the tank to be rejected:

- Less than minimum material thickness under any cut, dig or gouge
- Any dent with depth greater than 1/2" where it includes a weld
- Any dent with a depth greater than 10 % of the length of the dent
- Any weld defect including a crack, pinhole, or incomplete fusion of the weld
- Any structural defect or any source of leakage or any repairs made using overlay patches
- Defective, unidentified or out of test hose assemblies

HYDROSTATIC LEAKAGE TEST "K" (QC Manual Reference 12.4)

Test Pressure: 20 psi (80% of the MAWP Min.)
 Pressure Gauge Serial No.: 21821460039

Test Medium: Water
 Calibration Date: Jan. 13, 2023

Hydrostatic Leakage Test Item	QC Man.Ref.	Complies	Reject	Retest Complies
All product piping, valves, and accessories in place. Breathing vents rendered inoperative.	12.4.2	X		
Close all internals and open all discharge valves.	12.4.5	X		
Ensure all adjacent compartments and voids are empty and open to atmosphere.	12.4.6	X		
Fill compartment with enough test medium to cover valves.	12.4.7	X		
Pressurize tank to correct pressure and hold for 5 min. (Must have 0 psi pressure drop).	12.4.8	X		
While under pressure check tank, gaskets, internal valves, manhole covers, and vents for leakage.	12.4.9	X		
Close discharge valves and open internal valves. Adjust pressure and check plumbing and discharge valves for leakage.	12.4.10	X		
Restore operation of all vents.	12.4.12	X		
Tester: Dan Laekeman		Signature: 		Date: May 31, 2022

HYDROSTATIC PRESSURE TEST "P" (QC Manual Reference 12.5)

Test Pressure (Tank):

(Refer to Table 7.4 of CSA B620-20 posted in fitting cabinet for appropriate test pressure)

Test Pressure (Piping): (80% of the MAWP)

Test Medium:

Pressure Gauge Serial No.:

Calibration Date:

Hydrostatic Pressure Test Item	QC Man Ref.	Complies	Reject	Retest Complies
Level and adequately support the tank.	12.5.1.3			
Remove self closing relief valves for testing.	12.5.1.4			
Remove or render inoperative all other relief devices and close internal valves.	12.5.1.5			
Ensure all remaining closures are rated at or above test pressure.	12.5.1.6			
Ensure adjacent compartments and voids are empty and open to atmosphere.	12.5.1.7			
Fill compartment completely with water.	12.5.2.1			
Install pressurization line and slowly increase pressure to test pressure.	12.5.2.2 & 3			
Disconnect pressure source and hold pressure for 10 minutes.	12.5.2.4			
With tank under pressure inspect exterior for leaks, defects, or distortion.	12.5.2.5			
Relieve pressure in tank.	12.5.2.6			
Close discharge valves and open internals. Pressurize tank to 80% of the MAWP. Hold for 10 minutes and check plumbing and discharge valves for leaks.	12.5.2.7			
Relieve pressure and drain tank.	12.5.2.9			
Reinstall or return all relief valves to working condition.	12.5.2.10			
Tester:		Signature:		Date:

PNEUMATIC LEAKAGE TEST "K" (QC Manual Reference 12.4)

Test Pressure: (80% of the MAWP Min.)

Test Medium:

Pressure Gauge Serial No.:

Calibration Date:

Pneumatic Leakage Test Item	QC Man.Ref.	Complies	Reject	Retest Complies
All product piping, valves, and accessories in place. Breathing vents rendered Inoperative.	12.4.2			
Close all internals and open all discharge valves.	12.4.5			
Ensure all adjacent compartments and voids are empty and open to atmosphere.	12.4.6			
Fill compartment with enough test medium to cover valves.	12.4.7			
Pressurize tank to correct pressure and hold for 5 min. (Must have 0 psi pressure drop).	12.4.8			
While under pressure check tank, gaskets, internal valves, manhole covers, and vents for leakage.	12.4.9			
Close discharge valves and open internal valves. Adjust pressure and check plumbing and discharge valves for leakage.	12.4.10			
Relieve pressure in tank and restore operation of all vents.	12.4.12			
Tester: _____		Signature: _____		Date: _____

NOTE: A pneumatic pressure test, with the concurrence of the tank owner shall only be performed when there is no suspicion of weakness in the tank and residual water in the tank would adversely react with the lading or the tank, or any lading retention component, or result in the formation of ice causing damage to or adversely affecting the functioning of the tank.

PNEUMATIC PRESSURE TEST "P" (QC Manual Reference 12.5)

Test Pressure (Tank):

(Refer to Table 7.4 of CSA B620-20 posted in fitting cabinet for appropriate test pressure)

Test Pressure (Piping): (80% of the MAWP)

Test Medium:

Pressure Gauge Serial No.:

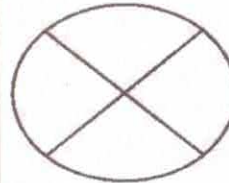
Calibration Date:

Pneumatic Pressure Test Item	QC Man Ref.	Complies	Reject	Retest Complies
Level and adequately support the tank.	12.5.1.3			
Remove self closing relief valves for testing.	12.5.1.4			
Remove or render Inoperative all other relief devices and close internal valves.	12.5.1.5			
Ensure all remaining closures are rated at or above test pressure.	12.5.1.6			
Ensure adjacent compartments and voids are empty and open to atmosphere.	12.5.1.7			
Advise all personnel that a pneumatic test is being performed and that they must stay clear of the tank being tested.	12.5.3.2			
Apply pressurization line and slowly increase pressure in tank. Pressure to one half the test pressure then increase by 1/10 of test pressure until pressure is reached.	12.5.3.3- 12.5.3.5			
Hold pressure for 10 minutes, then reduce it to the MAWP.	12.5.3.6			
Maintain pressure while using soap and water to coat entire surface of all joints and around all venting and piping.	12.5.3.7			
Relieve pressure in tank, close discharge valves and open internal valves.	12.5.3.8 & 9			
Re pressurize tank to 80 % of the MAWP and hold for 10 min. Soap surface of all joints and connections in the section of plumbing being tested.	12.5.3.10 & 11			
Relieve pressure in tank.	12.5.3.12			
Reinstall or return to working condition all relief devices.	12.5.3.14			
Tester: _____		Signature: _____		Date: _____

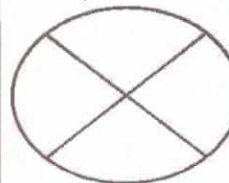
THICKNESS TEST "T" (QC Manual Reference 12.6)

	12:00	3:00	6:00	9:00	
					HEAD
1					1
2					2
3					3
4					4
5					5
6					6
7					7
8					8
9					9
10					10
11					11
					HEAD
	12:00	3:00	6:00	9:00	

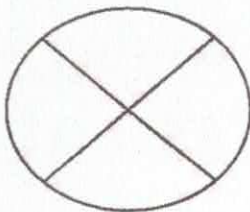
FRONT HEAD



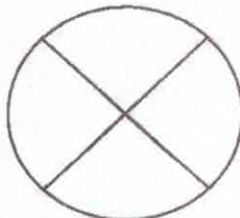
REAR HEAD



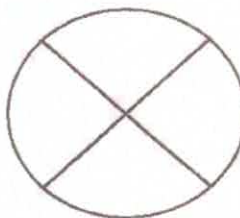
MANWAY



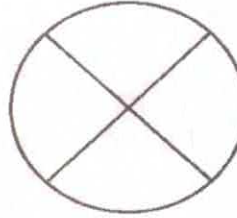
SUMP



NOZZLE



NOZZLE



Manufacture's Thickne Head: _____ Shell: _____
 Minimum Thickness Head: _____ Shell: _____

Inspector: _____ Signature: _____ Date: _____

HEATING SYSTEM TEST (QC Manual Reference 12.10)

Test Pressure

Test Medium:

Pressure Gauge Serial No.:

Calibration Date:

Heating Stsyem Test Inspection Item	QC Man.Ref.	Complies	Reject	Retest Complies
Ensure all tank compartments are empty and at atmospheric pressure	12.10.1			
Fill heating system with fluid and pressurize to 1.5 times the heating systems MAWP	12.10.2			
Hold test pressure for 5 min. And inspect for Intenal and external leakage	12.10.3			
If equipped with flues, inspect for product leakage into flues	12.10.4			

Inspector: _____ Signature: _____ Date: _____



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 Medicine Hat, AB T1B 3N5
 Phone: (403) 527-7272
 Fax: (403) 529-6526
 Facility Registration No. 25-0709

Inspection Report in Accordance with CSA B620-20

TEST DATE: November 19, 2021

TANK OWNER: **Big Steam Oilfield Services**

ADDRESS: **# 5 Boswell Cres Brooks Alberta T1R 1B7**

TELEPHONE: (403) 793-7046	SERIAL NO.: WT0511537	
UNIT NO.: 238	MVID/TCRN: Z.05.092.02.08	
MANUFACTURER: Westech	ASSEMBLER: Westech	
TC SPEC.: 407	MATERIAL: SA 36	CERTIFICATION DATE: 08/2011
MINIMUM THICKNESS SHELL: 5.36 mm	MINIMUM THICKNESS HEAD: 5.26 mm	
MAWP: 25 psi	DESIGN PRESSURE:	
LINING: YES <input type="checkbox"/> NO <input checked="" type="checkbox"/>	INSULATED: YES <input type="checkbox"/> NO <input checked="" type="checkbox"/>	
SPECIAL SERVICE CONDITIONS:		

COMP. CAPACITY: 1 11652 L 2 3
4 5

INSPECTION PERFORMED V I P K T UC L
 PRESSURE RELIEF DEVICES: SET TO DISCHARGE PRESSURE:


#1) TYPE: Fort Vale	SERIAL NO: 1160125	OPEN PSI: 30 psi	RESEAT PSI: 30 psi
REINSTALLED <input checked="" type="checkbox"/>	REPAIRED <input type="checkbox"/>	REPLACED <input type="checkbox"/>	
#2) TYPE:	SERIAL NO:	OPEN PSI:	RESEAT PSI:
REINSTALLED <input type="checkbox"/>	REPAIRED <input type="checkbox"/>	REPLACED <input type="checkbox"/>	
#3) TYPE:	SERIAL NO:	OPEN PSI:	RESEAT PSI:
REINSTALLED <input type="checkbox"/>	REPAIRED <input type="checkbox"/>	REPLACED <input type="checkbox"/>	
#4) TYPE:	SERIAL NO:	OPEN PSI:	RESEAT PSI:
REINSTALLED <input type="checkbox"/>	REPAIRED <input type="checkbox"/>	REPLACED <input type="checkbox"/>	
#5) TYPE:	SERIAL NO:	OPEN PSI:	RESEAT PSI:
REINSTALLED <input type="checkbox"/>	REPAIRED <input type="checkbox"/>	REPLACED <input type="checkbox"/>	

TC 331, MC 331, MC 330, TC 51, CTC 51, DOT 51 TANKS:

CONSTRUCTED OF QUENCHED AND TEMPERED STEEL: QT YES NO
 CONSTRUCTED OF OTHER THAN QUENCHED AND TEMPERED STEEL: NQT YES NO
 TANK STRESS RELIEVED AFTER MANUFACTURE: YES NO
 TANK STRESS RELIEVED AFTER REPAIR: YES NO
 TANK STRESS RELIEF AFTER REPAIR: COMPLETE: LOCAL:

RECORD ALL INFORMATION FROM DATA PLATE AND TAKE PHOTOS OF DATA PLATE AND UNIT FOR FILE:

EXTERNAL VISUAL INSPECTION "V"

Item Inspected	QC Man.Ref.	Complies	Reject	Retest Complies
Data plate, present and legible	12.2.3	X		
Shell & heads; corrosion, dents, overlay patches, leaks, voids, etc.	12.2.4	X		
Structural members, outriggers crossmembers, etc.	12.2.5	X		
Upper coupler for cracks, corrosion, distortion, and bolt tightness	12.2.6	N/A		
Piping and valves for leakage, damage, and corrosion	12.2.7	X		
Valve operating systems, remote closures, and thermal devices	12.2.7	X		
Hoses for defects, identification and test dates	12.2.8	X		
Gaskets on full opening rear heads for damage or cuts	12.2.9	X		
Tank attachments to frame or running gear	12.2.10	X		
Ladders, walkways, platforms, etc.	12.2.11	X		
Fill covers, manways, and closure devices	12.2.12	X		
Relief valves and vents (replace or test if in corrosive lading Service)	12.2.13	X		
Accident damage protection; compliance, damage, distortion, corrosion	12.2.14	X		
Off truck emergency shut down system	12.2.15	X		
Inspector: Dan Laekeman	Signature: 	Date: November 19, 2021		

INTERNAL VISUAL INSPECTION "I"

Item Inspected	QC Man Ref.	Complies	Reject	Retest Complies
Interior surface for corrosion, distortion, overlay patches, cracking, etc.	12.3.2			
If required by the tank specification perform Wet Fluorescent Magnetic Particle Inspection and file report in accordance with Dynamic Industrial Solutions Procedure Number QP-16	12.3.3			
interior welds for defects, cracking, etc.	12.3.4			
Internal supports and attachments	12.3.5			
Internal valves, piping and vents for leakage, damage, etc.	12.3.5			
Inspector:	Signature:	Date:		

Rejection Criteria for Visual Inspections

Any of the following conditions shall cause the tank to be rejected:

- Less than minimum material thickness under any cut, dig or gouge
- Any dent with depth greater than 1/2" where it includes a weld
- Any dent with a depth greater than 10 % of the length of the dent
- Any weld defect including a crack, pinhole, or incomplete fusion of the weld
- Any structural defect or any source of leakage or any repairs made using overlay patches
- Defective, unidentified or out of test hose assemblies

HYDROSTATIC LEAKAGE TEST "K" (QC Manual Reference 12.4)

Test Pressure:

(80% of the MAWP Min.)

Test Medium:

Pressure Gauge Serial No.:

Calibration Date:

Hydrostatic Leakage Test Item	QC Man.Ref.	Complies	Reject	Retest Complies
All product piping, valves, and accessories in place. Breathing vents rendered inoperative.	12.4.2			
Close all internals and open all discharge valves.	12.4.5			
Ensure all adjacent compartments and voids are empty and open to atmosphere.	12.4.6			
Fill compartment with enough test medium to cover valves.	12.4.7			
Pressurize tank to correct pressure and hold for 5 min. (Must have 0 psi pressure drop).	12.4.8			
While under pressure check tank, gaskets, internal valves, manhole covers, and vents for leakage.	12.4.9			
Close discharge valves and open internal valves. Adjust pressure and check plumbing and discharge valves for leakage.	12.4.10			
Restore operation of all vents.	12.4.12			
Tester:		Signature:		Date:

HYDROSTATIC PRESSURE TEST "P" (QC Manual Reference 12.5)

Test Pressure (Tank):

(Refer to Table 7.4 of CSA B620-20 posted in fitting cabinet for appropriate test pressure)

Test Pressure (Piping):

(80% of the MAWP)

Test Medium:

Pressure Gauge Serial No.:

Calibration Date:

Hydrostatic Pressure Test Item	QC Man Ref.	Complies	Reject	Retest Complies
Level and adequately support the tank.	12.5.1.3			
Remove self closing relief valves for testing.	12.5.1.4			
Remove or render inoperative all other relief devices and close internal valves.	12.5.1.5			
Ensure all remaining closures are rated at or above test pressure.	12.5.1.6			
Ensure adjacent compartments and voids are empty and open to atmosphere.	12.5.1.7			
Fill compartment completely with water.	12.5.2.1			
Install pressurization line and slowly increase pressure to test pressure.	12.5.2.2 & 3			
Disconnect pressure source and hold pressure for 10 minutes.	12.5.2.4			
With tank under pressure inspect exterior for leaks, defects, or distortion.	12.5.2.5			
Relieve pressure in tank.	12.5.2.6			
Close discharge valves and open internals. Pressurize tank to 80% of the MAWP. Hold for 10 minutes and check plumbing and discharge valves for leaks.	12.5.2.7			
Relieve pressure and drain tank.	12.5.2.9			
Reinstall or return all relief valves to working condition.	12.5.2.10			
Tester:		Signature:		Date:

PNEUMATIC LEAKAGE TEST "K" (QC Manual Reference 12.4)

Test Pressure:

(80% of the MAWP Min.)

Test Medium:

Pressure Gauge Serial No.:

Calibration Date:

Pneumatic Leakage Test Item	QC Man.Ref.	Complies	Reject	Retest Complies
All product piping, valves, and accessories in place. Breathing vents rendered inoperative.	12.4.2			
Close all internals and open all discharge valves.	12.4.5			
Ensure all adjacent compartments and voids are empty and open to atmosphere.	12.4.6			
Fill compartment with enough test medium to cover valves.	12.4.7			
Pressurize tank to correct pressure and hold for 5 min. (Must have 0 psi pressure drop).	12.4.8			
While under pressure check tank, gaskets, internal valves, manhole covers, and vents for leakage.	12.4.9			
Close discharge valves and open internal valves. Adjust pressure and check plumbing and discharge valves for leakage.	12.4.10			
Relieve pressure in tank and restore operation of all vents.	12.4.12			
Tester:	Signature:	Date:		

NOTE: A pneumatic pressure test, with the concurrence of the tank owner shall only be performed when there is no suspicion of weakness in the tank and residual water in the tank would adversely react with the lading or the tank, or any lading retention component, or result in the formation of ice causing damage to or adversely affecting the functioning of the tank.

PNEUMATIC PRESSURE TEST "P"

(QC Manual Reference 12.5)

Test Pressure (Tank):

(Refer to Table 7.4 of CSA B620-20 posted in fitting cabinet for appropriate test pressure)

Test Pressure (Piping):

(80% of the MAWP)

Test Medium:

Pressure Gauge Serial No.:

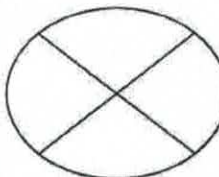
Calibration Date:

Pneumatic Pressure Test Item	QC Man Ref.	Complies	Reject	Retest Complies
Level and adequately support the tank.	12.5.1.3			
Remove self closing relief valves for testing.	12.5.1.4			
Remove or render inoperative all other relief devices and close internal valves.	12.5.1.5			
Ensure all remaining closures are rated at or above test pressure.	12.5.1.6			
Ensure adjacent compartments and voids are empty and open to atmosphere.	12.5.1.7			
Advise all personnel that a pneumatic test is being performed and that they must stay clear of the tank being tested.	12.5.3.2			
Apply pressurization line and slowly increase pressure in tank. Pressure to one half the test pressure then increase by 1/10 of test pressure until pressure is reached.	12.5.3.3- 12.5.3.5			
Hold pressure for 10 minutes, then reduce it to the MAWP.	12.5.3.6			
Maintain pressure while using soap and water to coat entire surface of all joints and around all venting and piping.	12.5.3.7			
Relieve pressure in tank, close discharge valves and open internal valves.	12.5.3.8 & 9			
Re pressurize tank to 80 % of the MAWP and hold for 10 min. Soap surface of all joints and connections in the section of plumbing being tested.	12.5.3.10 & 11			
Relieve pressure in tank.	12.5.3.12			
Reinstall or return to working condition all relief devices.	12.5.3.14			
Tester:	Signature:	Date:		

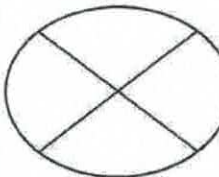
THICKNESS TEST "T" (QC Manual Reference 12.6)

	12:00	3:00	6:00	9:00	
					HEAD
1					1
2					2
3					3
4					4
5					5
6					6
7					7
8					8
9					9
10					10
11					11
					HEAD
	12:00	3:00	6:00	9:00	

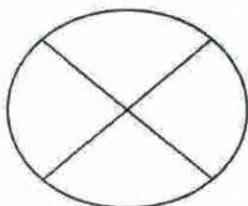
FRONT HEAD



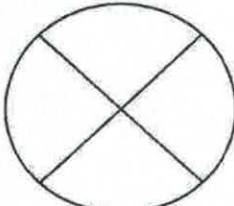
REAR HEAD



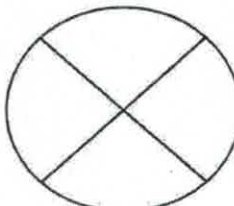
MANWAY



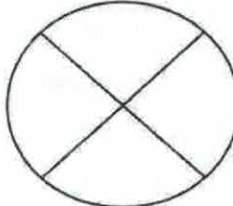
SUMP



NOZZLE



NOZZLE



Manufacture's Thickne Head: _____ Shell: _____
 Minimum Thickness Head: _____ Shell: _____

Inspector: _____	Signature: _____	Date: _____
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HEATING SYSTEM TEST (QC Manual Reference 12.10)

Test Pressure _____

Test Medium: _____

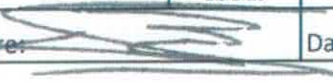
Pressure Gauge Serial No.: _____

Calibration Date: _____


Heating Stsyem Test Inspection Item	QC Man.Ref.	Complies	Reject	Retest Complies
Ensure all tank compartments are empty and at atmospheric pressure	12.10.1			
Fill heating system with fluid and pressurize to 1.5 times the heating systems MAWP	12.10.2			
Hold test pressure for 5 min. And inspect for intenal and external leakage	12.10.3			
If equipped with flues, inspect for product leakage into flues	12.10.4			

Inspector: _____	Signature: _____	Date: _____
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EXTERNAL VISUAL INSPECTION "V"

Item Inspected	QC Man.Ref.	Complies	Reject	Retest Complies
Data plate, present and legible	12.2.3	X		
Shell & heads; corrosion, dents, overlay patches, leaks, voids, etc.	12.2.4	X		
Structural members, outriggers crossmembers, etc.	12.2.5	X		
Upper coupler for cracks, corrosion, distortion, and bolt tightness	12.2.6	N/A		
Piping and valves for leakage, damage, and corrosion	12.2.7	X		
Valve operating systems, remote closures, and thermal devices	12.2.7	X		
Hoses for defects, identification and test dates	12.2.8	X		
Gaskets on full opening rear heads for damage or cuts	12.2.9	X		
Tank attachments to frame or running gear	12.2.10	X		
Ladders, walkways, platforms, etc.	12.2.11	X		
Fill covers, manways, and closure devices	12.2.12	X		
Relief valves and vents (replace or test if in corrosive lading Service)	12.2.13	X		
Accident damage protection; compliance, damage, distortion, corrosion	12.2.14	X		
Off truck emergency shut down system	12.2.15	X		
Inspector: Donovan Bellamy	Signature: 	Date: May 10, 2021		

INTERNAL VISUAL INSPECTION "I"

Item Inspected	QC Man Ref.	Complies	Reject	Retest Complies
Interior surface for corrosion, distortion, overlay patches, cracking, etc.	12.3.2	X		
If required by the tank specification perform Wet Fluorescent Magnetic Particle Inspection and file report in accordance with Dynamic Industrial Solutions Procedure Number QP-16	12.3.3	X		
interior welds for defects, cracking, etc.	12.3.4	X		
Internal supports and attachments	12.3.5	X		
Internal valves, piping and vents for leakage, damage, etc.	12.3.5	X		
Inspector: Donovan Bellamy	Signature: 	Date: May 10, 2021		

Rejection Criteria for Visual Inspections

Any of the following conditions shall cause the tank to be rejected:

- Less than minimum material thickness under any cut, dig or gouge
- Any dent with depth greater than 1/2" where it includes a weld
- Any dent with a depth greater than 10 % of the length of the dent
- Any weld defect including a crack, pinhole, or incomplete fusion of the weld
- Any structural defect or any source of leakage or any repairs made using overlay patches
- Defective, unidentified or out of test hose assemblies

HYDROSTATIC LEAKAGE TEST "K" (QC Manual Reference 12.4)

Test Pressure: 20 psi


(80% of the MAWP Min.)

Test Medium: Water

Pressure Gauge Serial No.:

218181D0040

Calibration Date: Feb.3,2021

Hydrostatic Leakage Test Item	QC Man.Ref.	Complies	Reject	Retest Complies
All product piping, valves, and accessories in place. Breathing vents rendered inoperative.	12.4.2	X		
Close all internals and open all discharge valves.	12.4.5	X		
Ensure all adjacent compartments and voids are empty and open to atmosphere.	12.4.6	X		
Fill compartment with enough test medium to cover valves.	12.4.7	X		
Pressurize tank to correct pressure and hold for 5 min. (Must have 0 psi pressure drop).	12.4.8	X		
While under pressure check tank, gaskets, internal valves, manhole covers, and vents for leakage.	12.4.9	X		
Close discharge valves and open internal valves. Adjust pressure and check plumbing and discharge valves for leakage.	12.4.10	X		
Restore operation of all vents.	12.4.12	X		
Tester: Donovan Bellamy		Signature: 		Date: May 10,2021

HYDROSTATIC PRESSURE TEST "P" (QC Manual Reference 12.5)

Test Pressure (Tank): 37.5 psi

(Refer to Table 7.4 of CSA B620-20 posted in fitting cabinet for appropriate test pressure)

Test Pressure (Piping): 20 psi

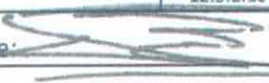
(80% of the MAWP)

Test Medium: Water

Pressure Gauge Serial No.:

218181D0040

Calibration Date: Feb.3,2021

Hydrostatic Pressure Test Item	QC Man Ref.	Complies	Reject	Retest Complies
Level and adequately support the tank.	12.5.1.3	X		
Remove self closing relief valves for testing.	12.5.1.4	X		
Remove or render inoperative all other relief devices and close internal valves.	12.5.1.5	X		
Ensure all remaining closures are rated at or above test pressure.	12.5.1.6	X		
Ensure adjacent compartments and voids are empty and open to atmosphere.	12.5.1.7	X		
Fill compartment completely with water.	12.5.2.1	X		
Install pressurization line and slowly increase pressure to test pressure.	12.5.2.2 & 3	X		
Disconnect pressure source and hold pressure for 10 minutes.	12.5.2.4	X		
With tank under pressure inspect exterior for leaks, defects, or distortion.	12.5.2.5	X		
Relieve pressure in tank.	12.5.2.6	X		
Close discharge valves and open internals. Pressurize tank to 80% of the MAWP. Hold for 10 minutes and check plumbing and discharge valves for leaks.	12.5.2.7	X		
Relieve pressure and drain tank.	12.5.2.9	X		
Reinstall or return all relief valves to working condition.	12.5.2.10	X		
Tester: Donovan Bellamy		Signature: 		Date: May 10,2021

PNEUMATIC LEAKAGE TEST "K" (QC Manual Reference 12.4)

Test Pressure: (80% of the MAWP Min.)

Test Medium:

Pressure Gauge Serial No.:

Calibration Date:

Pneumatic Leakage Test Item	QC Man.Ref.	Complies	Reject	Retest Complies
All product piping, valves, and accessories in place. Breathing vents rendered inoperative.	12.4.2			
Close all internals and open all discharge valves.	12.4.5			
Ensure all adjacent compartments and voids are empty and open to atmosphere.	12.4.6			
Fill compartment with enough test medium to cover valves.	12.4.7			
Pressurize tank to correct pressure and hold for 5 min. (Must have 0 psi pressure drop).	12.4.8			
While under pressure check tank, gaskets, internal valves, manhole covers, and vents for leakage.	12.4.9			
Close discharge valves and open internal valves. Adjust pressure and check plumbing and discharge valves for leakage.	12.4.10			
Relieve pressure in tank and restore operation of all vents.	12.4.12			
Tester: _____		Signature: _____		Date: _____

NOTE: A pneumatic pressure test, with the concurrence of the tank owner shall only be performed when there is no suspicion of weakness in the tank and residual water in the tank would adversely react with the lading or the tank, or any lading retention component, or result in the formation of ice causing damage to or adversely affecting the functioning of the tank.

PNEUMATIC PRESSURE TEST "P" (QC Manual Reference 12.5)

Test Pressure (Tank):

(Refer to Table 7.4 of CSA B620-20 posted in fitting cabinet for appropriate test pressure)

Test Pressure (Piping): (80% of the MAWP)

Test Medium:

Pressure Gauge Serial No.:

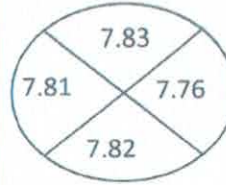
Calibration Date:

Pneumatic Pressure Test Item	QC Man Ref.	Complies	Reject	Retest Complies
Level and adequately support the tank.	12.5.1.3			
Remove self closing relief valves for testing.	12.5.1.4			
Remove or render inoperative all other relief devices and close internal valves.	12.5.1.5			
Ensure all remaining closures are rated at or above test pressure.	12.5.1.6			
Ensure adjacent compartments and voids are empty and open to atmosphere.	12.5.1.7			
Advise all personnel that a pneumatic test is being performed and that they must stay clear of the tank being tested.	12.5.3.2			
Apply pressurization line and slowly increase pressure in tank. Pressure to one half the test pressure then increase by 1/10 of test pressure until pressure is reached.	12.5.3.3- 12.5.3.5			
Hold pressure for 10 minutes, then reduce it to the MAWP.	12.5.3.6			
Maintain pressure while using soap and water to coat entire surface of all joints and around all venting and piping.	12.5.3.7			
Relieve pressure in tank, close discharge valves and open internal valves.	12.5.3.8 & 9			
Re pressurize tank to 80 % of the MAWP and hold for 10 min. Soap surface of all joints and connections in the section of plumbing being tested.	12.5.3.10 & 11			
Relieve pressure in tank.	12.5.3.12			
Reinstall or return to working condition all relief devices.	12.5.3.14			
Tester: _____		Signature: _____		Date: _____

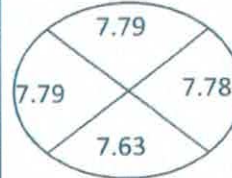
THICKNESS TEST "T" (QC Manual Reference 12.6)

	12:00	3:00	6:00	9:00	
					HEAD
1	7.86	7.84	7.87	7.84	1
2	7.87	7.81	7.84	7.85	2
3	7.84	7.77	7.78	7.78	3
4	7.75	7.86	7.76	7.76	4
5	7.76	7.79	7.81	7.79	5
6	7.85	7.81	7.85	7.81	6
7	7.78	7.76	7.89	7.89	7
8	7.86	7.79	7.78	7.77	8
9	7.81	7.76	7.89	7.84	9
10	7.84	7.81	7.77	7.84	10
11	7.79	7.84	7.79	7.79	11
					HEAD
	12:00	3:00	6:00	9:00	

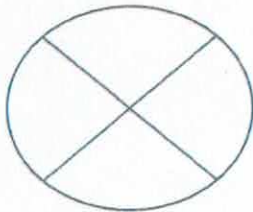
FRONT HEAD



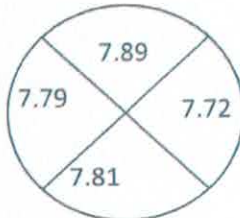
REAR HEAD



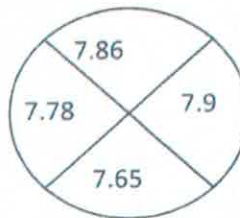
MANWAY



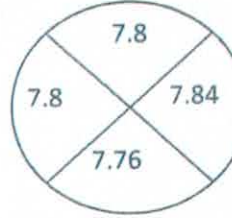
NOZZLE # 1



NOZZLE # 2



NOZZLE # 3



Manufacture's Thickne Head: 7.94 Shell: 7.94
 Minimum Thickness Head: 5.26 Shell: 5.36

Inspector: Donovan Bellamy Signature:  Date: May 10, 2021

HEATING SYSTEM TEST (QC Manual Reference 12.10)

Test Pressure _____ Test Medium: _____
 Pressure Gauge Serial No.: _____ Calibration Date: _____

Heating Stsyem Test Inspection Item	QC Man.Ref.	Complies	Reject	Retest Complies
Ensure all tank compartments are empty and at atmospheric pressure	12.10.1			
Fill heating system with fluid and pressurize to 1.5 times the heating systems MAWP	12.10.2			
Hold test pressure for 5 min. And inspect for intenal and external leakage	12.10.3			
If equipped with flues, inspect for product leakage into flues	12.10.4			
Inspector: _____	Signature: _____	Date: _____		

SUMMARY OF REPAIRS AND MAINTENANCE

UNIT: 238

- MAY 2022 – TANK INSPECTION – DYNAMIC INDUSTRIAL
- APR 2022 – ISX 15 EMISSION OFF TUNING – D/C HEAVY DUTY MECHANIC INV 2976
- APR 2022 – BELT AND YOKE – SUMMIT MOTORS INV 03P18396
- JAN 2022 – CARRIER 4 – SUMMIT MOTORS INV 03P15943
- APR 2022 – 4 NEW TIRES – KIRKS TIRE INV B163072
- SEPT 2021 – PTO AND PUMP SHAFTS – HOPF MECHANICAL INV 17462
- SEPT 2021 – NEW CLUTCH – SUMMIT MOTORS INV 03P13183
- AUG 2021 – ALIGNMENT – CROSSTOWN TRUCK INV BKS-115422
- AUG 2021 – HYDRAULIC LEAK REPAIR – HOPF MECHANICAL INV 17209
- JULY 2021 – REPAIR A/C – SUMMIT MOTORS INV 03W1919
- APR 2021 – NEW WINDSHIELD – BROOKS CAR CARE INV 01-26878
- APR 2021 – SHOCKS AND SEALS – SUMMIT MOTORS INV 03P9652
- JAN 2021 – NEW RADIATOR – SUMMIT MOTORS INV 03P7449
- SEPT 2019 – NEW AIR BAG AND SHOCK FRONT RIGHT SIDE – SUMMIT MOTORS INV B165331



**Commercial Vehicle Inspection Certificate
Traffic Safety Act**

**PART 1 - VEHICLE OWNER AND VEHICLE
IDENTIFICATION**

Vehicle Type:	Truck	Seating Capacity:	
GVW:	60000 kg	Brake Type:	Air
Owner Name:	Big Steam Oilfield Services Ltd		
Address:	Po Box 789		
City:	Brooks	Province:	AB
		Postal Code:	T1R1B7
Telephone Number:	(403) 501-5335		
Vehicle Identification Number:	1NKDX4EX3CR949163		
Make:	Kenworth	Model:	Construct
Year:	2012	Unit Number:	238
Odometer:	333681 KM	Licence Plate Number:	K38949
		Province:	AB

IT IS AN OFFENCE TO FALSIFY AN INSPECTION CERTIFICATE

PART 2 - CERTIFICATION

I certify the vehicle described in Part 1 has passed the inspections and tests established under the Traffic Safety Act for a Commercial Vehicle.

Inspection Facility Name:	Facility Number:
Big Steam Oilfield Services Ltd.	15339
Inspection Technician Name:	Technician Number:
Pedro Reimer	B8398
Inspection Technician Signature:	
Inspection Date:	2022/04/06



1791 30th St. S.W.
 Medicine Hat, AB T1B 3N5
 Phone: (403) 527-7272
 Fax: (403) 529-6526
 Facility Registration No. 25-0709

Inspection Report in Accordance with CSA B620-20

TEST DATE: May 31, 2022

TANK OWNER: **Big Steam Oilfield Services**

ADDRESS: **# 5 Boswell Cres Brooks Alberta T1R 1B7**

TELEPHONE: (403) 793-7046

SERIAL NO.: WT0511537

UNIT NO.: 238

MVID/TCRN: Z.05.092.02.08

MANUFACTURER: Westech

ASSEMBLER: Westech

TC SPEC.: 407

MATERIAL: SA 36

CERTIFICATION DATE: 08/2011

MINIMUM THICKNESS SHELL: 5.36 mm

MINIMUM THICKNESS HEAD: 5.26 mm

MAWP: 25 psi

DESIGN PRESSURE:

LINING: YES NO

INSULATED: YES NO

SPECIAL SERVICE CONDITIONS:

COMP. CAPACITY:

1 11652 L

2

3

4

5

INSPECTION PERFORMED V I P K T UC L

PRESSURE RELIEF DEVICES: SET TO DISCHARGE PRESSURE:

#1) TYPE: Fort Vale	SERIAL NO: 1160125	OPEN PSI: 30 psi	RESEAT PSI: 30 psi
REINSTALLED <input checked="" type="checkbox"/>	REPAIRED <input type="checkbox"/>	REPLACED <input type="checkbox"/>	
#2) TYPE:	SERIAL NO:	OPEN PSI:	RESEAT PSI:
REINSTALLED <input type="checkbox"/>	REPAIRED <input type="checkbox"/>	REPLACED <input type="checkbox"/>	
#3) TYPE:	SERIAL NO:	OPEN PSI:	RESEAT PSI:
REINSTALLED <input type="checkbox"/>	REPAIRED <input type="checkbox"/>	REPLACED <input type="checkbox"/>	
#4) TYPE:	SERIAL NO:	OPEN PSI:	RESEAT PSI:
REINSTALLED <input type="checkbox"/>	REPAIRED <input type="checkbox"/>	REPLACED <input type="checkbox"/>	
#5) TYPE:	SERIAL NO:	OPEN PSI:	RESEAT PSI:
REINSTALLED <input type="checkbox"/>	REPAIRED <input type="checkbox"/>	REPLACED <input type="checkbox"/>	

TC 331, MC 331, MC 330, TC 51, CTC 51, DOT 51 TANKS:

CONSTRUCTED OF QUENCHED AND TEMPERED STEEL: QT

YES NO

CONSTRUCTED OF OTHER THAN QUENCHED AND TEMPERED STEEL: NQT

YES NO

TANK STRESS RELIEVED AFTER MANUFACTURE:

YES NO

TANK STRESS RELIEVED AFTER REPAIR:


YES NO

TANK STRESS RELIEF AFTER REPAIR:

COMPLETE: LOCAL:

RECORD ALL INFORMATION FROM DATA PLATE AND TAKE PHOTOS OF DATA PLATE AND UNIT FOR FILE:

EXTERNAL VISUAL INSPECTION "V"

Item Inspected	QC Man.Ref.	Complies	Reject	Retest Complies
Data plate, present and legible	12.2.3	X		
Shell & heads; corrosion, dents, overlay patches, leaks, voids, etc.	12.2.4	X		
Structural members, outriggers crossmembers, etc.	12.2.5	X		
Upper coupler for cracks, corrosion, distortion, and bolt tightness	12.2.6	N/A		
Piping and valves for leakage, damage, and corrosion	12.2.7	X		
Valve operating systems, remote closures, and thermal devices	12.2.7	X		
Hoses for defects, identification and test dates	12.2.8	X		
Gaskets on full opening rear heads for damage or cuts	12.2.9	X		
Tank attachments to frame or running gear	12.2.10	X		
Ladders, walkways, platforms, etc.	12.2.11	X		
Fill covers, manways, and closure devices	12.2.12	X		
Relief valves and vents (replace or test if in corrosive lading Service)	12.2.13	X		
Accident damage protection; compliance, damage, distortion, corrosion	12.2.14	X		
Off truck emergency shut down system	12.2.15	X		
Inspector: Dan Laekeman	Signature: 		Date: May 31, 2022	

INTERNAL VISUAL INSPECTION "I"

Item Inspected	QC Man Ref.	Complies	Reject	Retest Complies
Interior surface for corrosion, distortion, overlay patches, cracking, etc.	12.3.2	X		
If required by the tank specification perform Wet Fluorescent Magnetic Particle Inspection and file report in accordance with Dynamic Industrial Solutions Procedure Number QP-16	12.3.3	X		
Interior welds for defects, cracking, etc.	12.3.4	X		
Internal supports and attachments	12.3.5	X		
Internal valves, piping and vents for leakage, damage, etc.	12.3.5	X		
Inspector: Dan Laekeman	Signature: 		Date: May 31, 2022	

Rejection Criteria for Visual Inspections

Any of the following conditions shall cause the tank to be rejected:

- Less than minimum material thickness under any cut, dig or gouge
- Any dent with depth greater than 1/2" where it includes a weld
- Any dent with a depth greater than 10 % of the length of the dent
- Any weld defect including a crack, pinhole, or incomplete fusion of the weld
- Any structural defect or any source of leakage or any repairs made using overlay patches
- Defective, unidentified or out of test hose assemblies

HYDROSTATIC LEAKAGE TEST "K" (QC Manual Reference 12.4)

Test Pressure: 20 psi


(80% of the MAWP Min.)

Test Medium: Water

Pressure Gauge Serial No.:

21821460039

Calibration Date: Jan. 13, 2023

Hydrostatic Leakage Test Item	QC Man.Ref.	Complies	Reject	Retest Complies
All product piping, valves, and accessories in place. Breathing vents rendered inoperative.	12.4.2	X		
Close all internals and open all discharge valves.	12.4.5	X		
Ensure all adjacent compartments and voids are empty and open to atmosphere.	12.4.6	X		
Fill compartment with enough test medium to cover valves.	12.4.7	X		
Pressurize tank to correct pressure and hold for 5 min. (Must have 0 psi pressure drop).	12.4.8	X		
While under pressure check tank, gaskets, internal valves, manhole covers, and vents for leakage.	12.4.9	X		
Close discharge valves and open internal valves. Adjust pressure and check plumbing and discharge valves for leakage.	12.4.10	X		
Restore operation of all vents.	12.4.12	X		
Tester: Dan Laekeman	Signature: 	Date: May 31, 2022		

HYDROSTATIC PRESSURE TEST "P" (QC Manual Reference 12.5)

Test Pressure (Tank):

(Refer to Table 7.4 of CSA B620-20 posted in fitting cabinet for appropriate test pressure)

Test Pressure (Piping):

(80% of the MAWP)

Test Medium:

Pressure Gauge Serial No.:

Calibration Date:

Hydrostatic Pressure Test Item	QC Man Ref.	Complies	Reject	Retest Complies
Level and adequately support the tank.	12.5.1.3			
Remove self closing relief valves for testing.	12.5.1.4			
Remove or render inoperative all other relief devices and close internal valves.	12.5.1.5			
Ensure all remaining closures are rated at or above test pressure.	12.5.1.6			
Ensure adjacent compartments and voids are empty and open to atmosphere.	12.5.1.7			
Fill compartment completely with water.	12.5.2.1			
Install pressurization line and slowly increase pressure to test pressure.	12.5.2.2 & 3			
Disconnect pressure source and hold pressure for 10 minutes.	12.5.2.4			
With tank under pressure inspect exterior for leaks, defects, or distortion.	12.5.2.5			
Relieve pressure in tank.	12.5.2.6			
Close discharge valves and open internals. Pressurize tank to 80% of the MAWP. Hold for 10 minutes and check plumbing and discharge valves for leaks.	12.5.2.7			
Relieve pressure and drain tank.	12.5.2.9			
Reinstall or return all relief valves to working condition.	12.5.2.10			
Tester:	Signature:	Date:		

PNEUMATIC LEAKAGE TEST "K" (QC Manual Reference 12.4)

Test Pressure: (80% of the MAWP Min.)

Test Medium:

Pressure Gauge Serial No.:

Calibration Date:

Pneumatic Leakage Test Item	QC Man.Ref.	Complies	Reject	Retest Complies
All product piping, valves, and accessories in place. Breathing vents rendered Inoperative.	12.4.2			
Close all internals and open all discharge valves.	12.4.5			
Ensure all adjacent compartments and voids are empty and open to atmosphere.	12.4.6			
Fill compartment with enough test medium to cover valves.	12.4.7			
Pressurize tank to correct pressure and hold for 5 min. (Must have 0 psi pressure drop).	12.4.8			
While under pressure check tank, gaskets, internal valves, manhole covers, and vents for leakage.	12.4.9			
Close discharge valves and open internal valves. Adjust pressure and check plumbing and discharge valves for leakage.	12.4.10			
Relieve pressure in tank and restore operation of all vents.	12.4.12			
Tester:	Signature:	Date:		

NOTE: A pneumatic pressure test, with the concurrence of the tank owner shall only be performed when there is no suspicion of weakness in the tank and residual water in the tank would adversely react with the lading or the tank, or any lading retention component, or result in the formation of ice causing damage to or adversely affecting the functioning of the tank.

PNEUMATIC PRESSURE TEST "P" (QC Manual Reference 12.5)

Test Pressure (Tank):

(Refer to Table 7.4 of CSA B620-20 posted in fitting cabinet for appropriate test pressure)

Test Pressure (Piping): (80% of the MAWP)

Test Medium:

Pressure Gauge Serial No.:

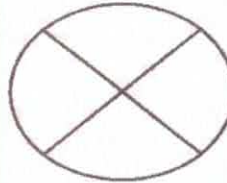
Calibration Date:

Pneumatic Pressure Test Item	QC Man Ref.	Complies	Reject	Retest Complies
Level and adequately support the tank.	12.5.1.3			
Remove self closing relief valves for testing.	12.5.1.4			
Remove or render Inoperative all other relief devices and close internal valves.	12.5.1.5			
Ensure all remaining closures are rated at or above test pressure.	12.5.1.6			
Ensure adjacent compartments and voids are empty and open to atmosphere.	12.5.1.7			
Advise all personnel that a pneumatic test is being performed and that they must stay clear of the tank being tested.	12.5.3.2			
Apply pressurization line and slowly increase pressure in tank. Pressure to one half the test pressure then increase by 1/10 of test pressure until pressure is reached.	12.5.3.3- 12.5.3.5			
Hold pressure for 10 minutes, then reduce it to the MAWP.	12.5.3.6			
Maintain pressure while using soap and water to coat entire surface of all joints and around all venting and piping.	12.5.3.7			
Relieve pressure in tank, close discharge valves and open internal valves.	12.5.3.8 & 9			
Re pressurize tank to 80 % of the MAWP and hold for 10 min. Soap surface of all joints and connections in the section of plumbing being tested.	12.5.3.10 & 11			
Relieve pressure in tank.	12.5.3.12			
Reinstall or return to working condition all relief devices.	12.5.3.14			
Tester:	Signature:	Date:		

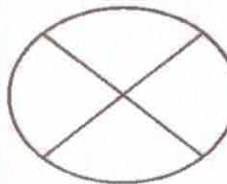
THICKNESS TEST "T" (QC Manual Reference 12.6)

	12:00	3:00	6:00	9:00	
					HEAD
1					1
2					2
3					3
4					4
5					5
6					6
7					7
8					8
9					9
10					10
11					11
					HEAD
	12:00	3:00	6:00	9:00	

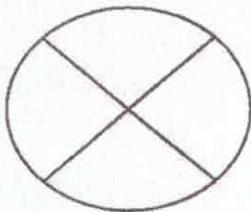
FRONT HEAD



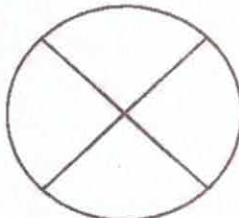
REAR HEAD



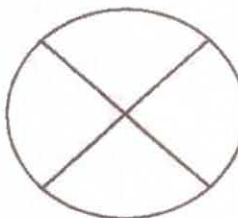
MANWAY



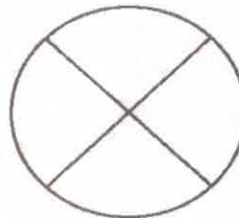
SUMP



NOZZLE



NOZZLE



Manufacture's Thickne Head: _____ Shell: _____
 Minimum Thickness Head: _____ Shell: _____

Inspector: _____ Signature: _____ Date: _____

HEATING SYSTEM TEST (QC Manual Reference 12.10)

Test Pressure _____ Test Medium: _____
 Pressure Gauge Serial No.: _____ Calibration Date: _____

Heating Stsyem Test Inspection Item	QC Man.Ref.	Complies	Reject	Retest Complies
Ensure all tank compartments are empty and at atmospheric pressure	12.10.1			
Fill heating system with fluid and pressurize to 1.5 times the heating systems MAWP	12.10.2			
Hold test pressure for 5 min. And inspect for Intenal and external leakage	12.10.3			
If equipped with flues, inspect for product leakage into flues	12.10.4			

Inspector: _____ Signature: _____ Date: _____

UPPER COUPLER INSPECTION UC (QC Manual Reference 12.2.6)

Upper Coupler Inspection Item	QC Man.Ref.	Complies	Reject	Retest Complies
Remove Upper Coupler or Turntable from unit	12.2.6			
Inspect areas covered by the Upper Coupler or Turntable assembly for corrosion, abrasion, dents, distortion or any other condition that would render the tank unsafe	12.2.6.1			
While removed inspect Upper Coupler assembly for cracks, distortion, plate wear and kingpin wear.	12.2.6.2			
If equipped, inspect Turntable for wear, distortion and cracks	12.2.6.3			
Install Upper Coupler or Turntable assembly	12.2.6.4			
Inspector:	Signature:	Date:		

LINING INSPECTION L (QC Manual Reference 12.7.2)

Upper Coupler Inspection Item	Man.Ref.	Complies	Reject	Complies
Inspect rubber liners using a spark tester and following manufacturers instructions	12.7.1.1			
Inspect all linings other than rubber or FRP corrosion barriers according to the lining manufacturers instructions	12.7.2.1			
If lining damage is discovered inspect the tank wall under the damaged lining and thickness test if required.	12.7.3.1			
Inspector:	Signature:	Date:		

Description of defects found and methods used to repair:

TANK DISPOSITION	Removed from service	YES	<input type="checkbox"/>	NO	<input checked="" type="checkbox"/>
	Safety Mark (Specification Indication) removed	YES	<input type="checkbox"/>	NO	<input checked="" type="checkbox"/>
	Returned to Service	YES	<input checked="" type="checkbox"/>	NO	<input type="checkbox"/>
	Tank marking applied (QC Manual Reference Section 15)	YES	<input checked="" type="checkbox"/>	NO	<input type="checkbox"/>