


Inspection Date: 2022/03/28	
Inspection Technician Signature: 	
Inspection Technician Name: Pedro Reimer	Technician Number: B8398
Inspection Facility Name: Big Steam Oilfield Services Ltd.	Facility Number: 15339

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

**PART 2 - CERTIFICATION**

**IT IS AN OFFENCE TO FALSIFY AN INSPECTION CERTIFICATE**

Odometer: KM	Licence Plate Number: T27899	Province: AB
Year: 2002	Unit Number: 230T	
Make: Quad	Model: Vacuum	
Vehicle Identification Number: 2P9WS14D92N082503		
Telephone Number: (403) 501-5335		
City: Brooks	Province: AB	Postal Code: T1R1B7
Address: Po Box 789		
Owner Name: Big Steam Oilfield Services Ltd		
GW: kg	Brake Type: Air	
Vehicle Type: Trailer	Seating Capacity:	

**IDENTIFICATION**

**PART 1 - VEHICLE OWNER AND VEHICLE**

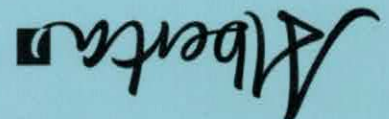
**Commercial Vehicle Inspection Certificate  
Traffic Safety Act**

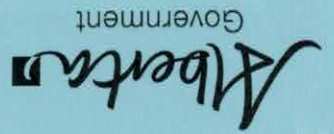
**CERTIFICATE NUMBER**

80087800007200822



**CV7200822**

 Alberta Government



**COMMERCIAL VEHICLE RECORD OF INSPECTION  
TRAILER, SEMI-TRAILER, C-DOLLY, CONVERTER DOLLY**

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																
Trailer													kg																
VIN 2 P 9 W S 1 4 D 9 2 N 0 8 2 5 0 3													Vehicle Information																
Unit Number			Year			Make			Model			Odometer			Registered Owner's Name			Plate Number			Address			Postal Code			Phone Number		
230T			2002			Quad			Vacuum						Big Steam Oilfield Services Ltd			T27899			Po Box 789			T1R1B7			(403) 501-5335		
Drum Brakes:													C-limited Inspection																
Disc Brakes:																													

LEFT													FRONT													RIGHT																																																			
16.591 in			7/16 in			1 in			16.544 in			9/16 in			1 in			16.547 in			9/16 in			1 in			16.551 in			9/16 in			1 in			16.560 in			7/16 in			1 in																																			
Drums/Rotors			Linings/Pads			Push Rod Travel			Drums/Rotors			Linings/Pads			Push Rod Travel			Drums/Rotors			Linings/Pads			Push Rod Travel			Drums/Rotors			Linings/Pads			Push Rod Travel			Drums/Rotors			Linings/Pads			Push Rod Travel																																			
18 in			18 in			100 psi			15 in			17 in			100 psi			15 in			15 in			100 psi			21 in			18 in			100 psi			18 in			100 psi			15 in			15 in																																
psi			in			psi			in			psi			in			psi			in			psi			in			psi			in			psi			in			psi			in																																
Park Brake Lining													Left													Right													Trans																																						
n/a													n/a													n/a													n/a																																						
Wheel Torque Checked													Inner													n/a													ft lbs Outer													500													ft lbs												

**COMMERCIAL VEHICLE RECORD OF INSPECTION  
TRAILER, SEMI-TRAILER, C-DOLLY, CONVERTER DOLLY**

Section 5 - Instruments and Auxiliary Equipment			
Component	P	F	NA
5.1. Fire Extinguisher			✓

Section 6 - Lamps			
Component	P	F	NA
6.1. Required Lamps			✓
6.2. Reflex Reflector			✓
Component	P	F	NA
6.3. Retro-Reflective Marking			✓

Section 7 - Electrical System			
Component	P	F	NA
7.1. Wiring			✓
7.2. Battery			✓
Component	P	F	NA
7.3. Trailer Cord (output to towed vehicle)			✓

Section 8 - Body			
Component	P	F	NA
8.5. Cargo Body			✓
8.6. Frame Rails & Mounts			✓
8.7. Unitized Body Elements			✓
8.8. Cab or Cargo Door			✓
8.9. Cargo Tank or Vessel			✓
8.10. Body, Device or Equipment Attached or Mounted to the Vehicle			✓
Component	P	F	NA
8.11. Refrigeration/Heater Unit Fuel System			✓
8.21. Fender/Mud Flap			✓
8.22. Landing Gear on Trailer			✓
8.23. Sliding Axle Assembly (Sliding Bogie)			✓
8.24. Aerodynamic Device & Attachment			✓
8.25. Rear Impact Guard (RIG)			✓

Section 9 - Tires and Wheels			
Component	P	F	NA
9.1. Tire Tread Depth			✓
9.2. Tire Tread Condition			✓
9.3. Tire Sidewall & Manufacturer Markings			✓
9.9. Spoke Wheel/Demountable Rim System			✓
9.10. Disc Wheel System			✓
9.11. Wheel Fasteners (Nuts, Bolts, & Studs)			✓
Component	P	F	NA
9.7. Wheel/Rim			✓

Section 10 - Couplers and Hitches			
Component	P	F	NA
10.1. Hitch Assembly, Structure & Attaching Components			✓
10.2. Secondary Attachment (Safety Chain or Cable)			✓
10.3. Pintle Hook, Pin Hitch, or Coupler Hitch			✓
10.8. Oscillating Fifth Wheel Coupler			✓
10.9. Ball-Bearing Type Turntable on Trailer			✓
Component	P	F	NA
10.6. Automated Coupling Device			✓
10.7. Fifth Wheel Coupler			✓

**NOTES:**

**NOTES:**

**NOTES:**

**NOTES:**

**NOTES:**

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

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: NOT  YES  NO  
 TANK STRESS RELIEVED AFTER MANUFACTURE:  YES  NO  
 TANK STRESS RELIEVED AFTER REPAIR:  YES  NO  
 TANK STRESS RELIEF AFTER REPAIR:  COMPLETE  LOCAL:  YES  NO

#1) TYPE: Fort Vale	REPAIRED	REPLACED	OPEN PSI: 30 psi	RESEAT PSI: 30 psi
#2) TYPE:	REPAIRED	REPLACED	OPEN PSI:	RESEAT PSI:
#3) TYPE:	REPAIRED	REPLACED	OPEN PSI:	RESEAT PSI:
#4) TYPE:	REPAIRED	REPLACED	OPEN PSI:	RESEAT PSI:
#5) TYPE:	REPAIRED	REPLACED	OPEN PSI:	RESEAT PSI:

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

COMP. CAPACITY:	1 21,700 L	2	3	4	5
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TEST DATE: April 1, 2022  
 TANK OWNER: Big Steam Oilfield Services  
 ADDRESS: # 5 Boswell Cres Brooks Alberta T1R 1B7  
 TELEPHONE: (403) 793-7046  
 UNIT NO.: 2307  
 MANUFACTURER: Steel Head  
 ASSEMBLER: Steel Head  
 TC SPEC: TC407/412 MATERIAL: SA36  
 CERTIFICATION DATE: 10/2002  
 MINIMUM THICKNESS SHELL: 6.4 mm  
 MINIMUM THICKNESS HEAD: 5.52 mm  
 MAWP: 25 psi  
 DESIGN PRESSURE:  
 LINING: YES  NO   
 INSULATED: YES  NO   
 SPECIAL SERVICE CONDITIONS:


Inspection Report in Accordance with CSA B620-20

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



**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

Item Inspected		QC Man	Complies	Reject	Retest
INTERNAL VISUAL INSPECTION "I"					
Inspector: Joal Lebel					
Signature: 					
Date: April 1, 2022					
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			

Item Inspected		QC Man, Ref.	Complies	Reject	Retest
EXTERNAL VISUAL INSPECTION "V"					
Inspector: Joal Lebel					
Signature: 					
Date: April 1, 2022					
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	N/A			
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	N/A			

Tester: Joal Lebel		Signature: <i>[Signature]</i>		Date: April 1, 2022
QC Man	Ref.	Complies	Reject	Retest
12.5.13				
12.5.14				
12.5.15				
12.5.16				
12.5.17				
12.5.21				
12.5.22 & 3				
12.5.24				
12.5.25				
12.5.26				
12.5.27				
12.5.29				
12.5.30				

**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: Water  
 Pressure Gauge Serial No.:  
 Calibration Date:

Tester: Joal Lebel		Signature: <i>[Signature]</i>		Date: April 1, 2022
QC	Man, Ref.	Complies	Reject	Retest
12.4.2		X		
12.4.5		X		
12.4.6		X		
12.4.7		X		
12.4.8		X		
12.4.9		X		
12.4.10		X		
12.4.12		X		

**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

Tester:		Signature:		Date:	
Level and adequately support the tank.	12.5.13				
Remove self closing relief valves for testing.	12.5.14				
Remove or render inoperative all other relief devices and close internal valves.	12.5.15				
Ensure all remaining closures are rated at or above test pressure.	12.5.16				
Ensure adjacent compartments and voids are empty and open to atmosphere.	12.5.17				
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				

**Pneumatic Pressure Test Item**  
 QC Man Ref. Complies Reject Retest Complies  
 Pressure Gauge Serial No.:  
 Calibration Date:  
 (QC Manual Reference 12.5)  
 PNEUMATIC PRESSURE TEST "P"  
 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: Test Medium

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.

Tester:		Signature:		Date:	
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				

**Pneumatic Leakage Test Item**  
 QC Man Ref. Complies Reject Retest Complies  
 Pressure Gauge Serial No.:  
 Calibration Date:  
 (QC Manual Reference 12.4)  
 PNEUMATIC LEAKAGE TEST "K"  
 Test Pressure:  
 (80% of the MAWP Min.)  
 Test Medium: Test Medium

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

Pressure Gauge Serial No.:

Calibration Date:

Test Pressure

Test Medium:

**HEATING SYSTEM TEST (QC Manual Reference 12.10)**

Inspector:		Signature:		Date:	
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Manufacturer's Thickness

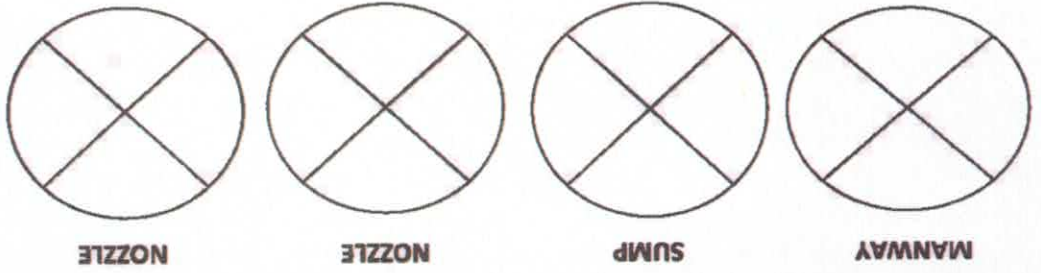
Head:

Minimum Thickness

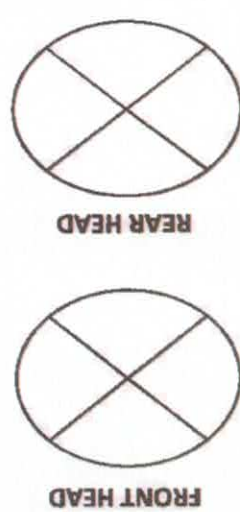
Head:

Shell:

Shell:



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



**THICKNESS TEST "T" (QC Manual Reference 12.6)**



**TANK DISPOSITION**

Removed from service    YES     NO

Safety Mark (Specification Indication) removed    YES     NO

Returned to Service    YES     NO

Tank marking applied (QC Manual Reference Section 15)    YES     NO

Description of defects found and methods used to repair:

**LINING INSPECTION 1** (QC Manual Reference 12.7.2)

Inspector:		Signature:		Date:	
Inspect rubber liners using a spark tester and following manufacturers instructions		12.7.1.1			
Inspect all linings other than rubber of 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			
<b>Upper Coupler Inspection Item</b>	Man.Ref.	Complies	Complies	Reject	Complies

**UPPER COUPLER INSPECTION UC** (QC Manual Reference 12.2.6)

Inspector:		Signature:		Date:	
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			
<b>Upper Coupler Inspection Item</b>	QC	Complies	Complies	Reject	Retest

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

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:

#1) TYPE: Fort Vale	SERIAL NO: 1090165	OPEN PSI: 30 psi	RESEAT PSI: 30 psi	REPAIRED	REPLACED	REINSTALLED <input checked="" type="checkbox"/>
#2) TYPE:	SERIAL NO:	OPEN PSI:	RESEAT PSI:	REPAIRED	REPLACED	REINSTALLED <input type="checkbox"/>
#3) TYPE:	SERIAL NO:	OPEN PSI:	RESEAT PSI:	REPAIRED	REPLACED	REINSTALLED <input type="checkbox"/>
#4) TYPE:	SERIAL NO:	OPEN PSI:	RESEAT PSI:	REPAIRED	REPLACED	REINSTALLED <input type="checkbox"/>
#5) TYPE:	SERIAL NO:	OPEN PSI:	RESEAT PSI:	REPAIRED	REPLACED	REINSTALLED <input type="checkbox"/>

INSPECTION PERFORMED V  I  P  K  T  UC  L

COMP. CAPACITY: 1 21,700 L 2 3 4 5

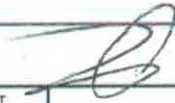
TEST DATE: April 14, 2021  
 TANK OWNER: Big Steam Oilfield Services  
 ADDRESS: # 5 Boswell Cres Brooks Alberta T1R 1B7  
 TELEPHONE: (403) 793-7046  
 SERIAL NO.: 0902097  
 UNIT NO.: 230T  
 MANUFACTURER: Steel Head  
 ASSEMBLER: Steel Head  
 TC SPEC.: TC407/412 MATERIAL: SA36  
 CERTIFICATION DATE: 10/2002  
 MINIMUM THICKNESS SHELL: 6.4 mm  
 MINIMUM THICKNESS HEAD: 5.52 mm  
 MAWP: 25 psi DESIGN PRESSURE:  
 LINING: YES  NO   
 INSULATED: YES  NO   
 SPECIAL SERVICE CONDITIONS:

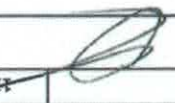
Inspection Report in Accordance with CSA B620-20

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

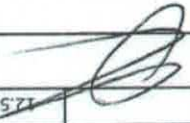


**Rejection Criteria for Visual Inspections**  
 Any of the following conditions shall cause the tank to be rejected:  
 Less than minimum material thickness under any cut, dig or gouge  
 Any dent with depth greater than 1/2" where it includes a weld  
 Any dent with a depth greater than 10% of the 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

Item Inspected		QC Man	Ref.	Complies	Reject	Retest
INTERNAL VISUAL INSPECTION "I"						
Inspector: Dan Laekeman						
Signature: 						
Date: April 14, 2021						
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				

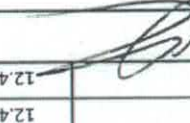
Item Inspected		QC Man	Ref.	Complies	Reject	Retest
EXTERNAL VISUAL INSPECTION "V"						
Inspector: Dan Laekeman						
Signature: 						
Date: April 14, 2021						
Data plate, present and legible	12.2.3	X				
Shell & heads; corrosion, dents, overlay patches, leaks, voids, etc.	12.2.4	X				
Structural 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				

Hydrostatic Pressure Test Item		QC Man	Complies	Reject	Retest
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: Dan Laekeman  
 Signature:   
 Date: April 14, 2021

Hydrostatic Pressure Test "P" (QC Manual Reference 12.5)  
 Test Pressure (Tank): 37.5 psi  
 Test Pressure (Piping): 20 psi (80% of the MAWP)  
 Test Medium: Water  
 Pressure Gauge Serial No.: 218181D0040  
 Calibration Date: Feb. 3, 2021

Hydrostatic Leakage Test Item		QC	Man. Ref.	Complies	Reject	Retest
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: April 14, 2021

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

Tester:		Signature:		Date:
				12.5.3.14
				12.5.3.12
				12.5.3.10 & 11
				12.5.3.8 & 9
				12.5.3.7
				12.5.3.6
				12.5.3.5
				12.5.3.3-
				12.5.3.2
				12.5.1.7
				12.5.1.6
				12.5.1.5
				12.5.1.4
				12.5.1.3
Complies	Reject	Complies	QC Man Ref.	

Level and adequately support the tank. Pressure Gauge Serial No.: Calibration Date:

Remove self closing relief valves for testing. Remove or render inoperative all other relief devices and close internal valves. (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: PNEUMATIC PRESSURE TEST "P" (QC Manual Reference 12.5)

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 component, or result in the formation of ice causing damage to or adversely affecting the functioning of the tank.

Tester:		Signature:		Date:
				12.4.12
				12.4.10
				12.4.9
				12.4.8
				12.4.7
				12.4.6
				12.4.5
				12.4.2
Complies	Reject	Complies	Man. Ref.	

All product piping, valves, and accessories in place. Breathing vents rendered inoperative. Close all internals and open all discharge valves. Ensure all adjacent compartments and voids are empty and open to atmosphere. Fill compartment with enough test medium to cover valves. Pressurize tank to correct pressure and hold for 5 min. (Must have 0 psi pressure drop). While under pressure check tank, gaskets, internal valves, manhole covers, and vents for leakage. Close discharge valves and open internal valves. Adjust pressure and check plumbing and discharge valves for leakage. Relieve pressure in tank and restore operation of all vents.

Pressure Gauge Serial No.: Calibration Date: PNEUMATIC LEAKAGE TEST "K" (QC Manual Reference 12.4) Test Pressure: (80% of the MAWP Min.) Test Medium:

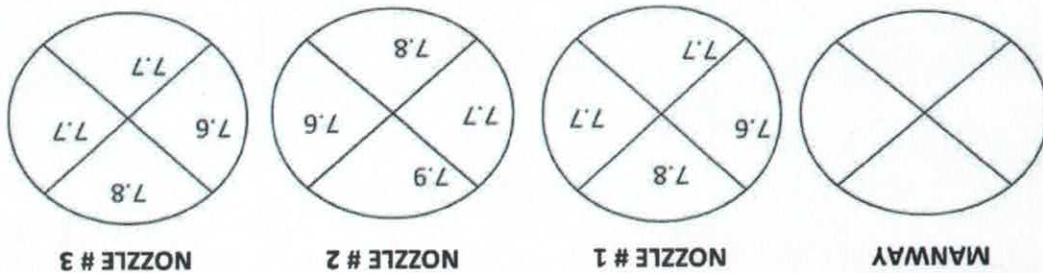
Inspector:		Signature:		Date:	
If equipped with flues, inspect for product leakage into flues		12.10.4			
Hold test pressure for 5 min. And inspect for internal and external leakage		12.10.3			
MAWP		12.10.2			
Fill heating system with fluid and pressurize to 1.5 times the heating systems		12.10.1		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

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

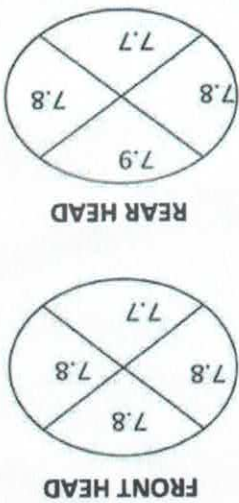
**HEATING SYSTEM TEST** (QC Manual Reference 12.10)

Inspector: Dan Laekeman		Signature: 		Date: April 14, 2021	
-------------------------	--	--	--	----------------------	--

Manufacturer's Thickness: Head: 7.1 Shell: 7.9  
 Minimum Thickness: Head: 5.52 Shell: 6.4



	12:00	3:00	6:00	9:00
HEAD				
11	7.8	7.7	7.6	7.8
10	7.8	7.7	7.7	7.8
9	7.7	7.7	7.7	7.6
8	7.8	7.8	7.8	7.7
7	7.8	7.7	7.6	7.7
6	7.6	7.8	7.7	7.8
5	7.7	7.6	7.8	7.7
4	7.8	7.8	7.7	7.7
3	7.7	7.7	7.6	7.8
2	7.6	7.8	7.8	7.7
1	7.8	7.7	7.6	7.8
HEAD				
	12:00	3:00	6:00	9:00



**THICKNESS TEST "T"** (QC Manual Reference 12.6)

**TANK DISPOSITION**

Removed from service  YES  NO

Safety Mark (Specification Indication) removed  YES  NO

Returned to Service  YES  NO

Tank marking applied (QC Manual Reference Section 15)  YES  NO

Description of defects found and methods used to repair:

**LINING INSPECTION 1** (QC Manual Reference 12.7.2)

Inspector:	Signature:	Date:
Inspect rubber liners using a spark tester and following manufacturers instructions	12.7.1.1	
Inspect all linings other than rubber of 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	
<b>Upper Coupler Inspection Item</b>	<b>Man.Ref.</b>	<b>Complies</b>
		<b>Reject</b>
		<b>Complies</b>

**UPPER COUPLER INSPECTION UC** (QC Manual Reference 12.2.6)

Inspector:	Signature:	Date:
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	
<b>Upper Coupler Inspection Item</b>	<b>Man.Ref.</b>	<b>Complies</b>
		<b>Reject</b>
		<b>Complies</b>

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

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 RELIEVED AFTER REPAIR:  COMPLETE:  LOCAL:

#1) TYPE: 407	SERIAL NO: 9810523	OPEN PSI: 30 psi	RESEAT PSI: 30 psi	REPAIRED	REPLACED	REINSTALLED
#2) TYPE:	SERIAL NO:	OPEN PSI:	RESEAT PSI:	REPAIRED	REPLACED	REINSTALLED
#3) TYPE:	SERIAL NO:	OPEN PSI:	RESEAT PSI:	REPAIRED	REPLACED	REINSTALLED
#4) TYPE:	SERIAL NO:	OPEN PSI:	RESEAT PSI:	REPAIRED	REPLACED	REINSTALLED
#5) TYPE:	SERIAL NO:	OPEN PSI:	RESEAT PSI:	REPAIRED	REPLACED	REINSTALLED

INSPECTION PERFORMED V  I  P  K  T  UC  L   
 PRESSURE RELIEF DEVICES: SET TO DISCHARGE PRESSURE: 30 psi

COMP. CAPACITY: 1 21,700 L 2 3 4 5

TEST DATE: October 15, 2021  
 TANK OWNER: Big Steam Oilfield Services  
 ADDRESS: # 5 Boswell Cres Brooks Alberta T1R 1B7  
 TELEPHONE: (403) 793-7046  
 SERIAL NO.: 0902097  
 MVID/TCRN: 2054750204  
 UNIT NO.: 230T  
 MANUFACTURER: Steel Head  
 ASSEMBLER: Steel Head  
 TC SPEC: TC407/412 MATERIAL: SA36  
 CERTIFICATION DATE: 10/2002  
 MINIMUM THICKNESS SHELL: 6.4 mm  
 MINIMUM THICKNESS HEAD: 5.52 mm  
 MAWP: 25 psi DESIGN PRESSURE: 37.5 psi  
 LINING: YES  NO  INSULATED: YES  NO   
 SPECIAL SERVICE CONDITIONS:

Inspection Report in Accordance with CSA B620-20

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





**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: Calibration Date:

Pressure Gauge Serial No.:

Tester:		Signature:		Date:	
Restore operation of all vents.		12.4.12			
plumbing and discharge valves for leakage.		12.4.10			
Close discharge valves and open internal valves. Adjust pressure and check		12.4.9			
and vents for leakage.		12.4.8			
While under pressure check tank, gaskets, internal valves, manhole covers,		12.4.7			
pressure drop).		12.4.6			
Pressurize tank to correct pressure and hold for 5 min. (Must have 0 psi		12.4.5			
Fill compartment with enough test medium to cover valves.		12.4.2			
atmosphere.		12.4.1			
Ensure all adjacent compartments and voids are empty and open to		12.4.0			
Close all internals and open all discharge valves.		12.3.9			
All product piping, valves, and accessories in place. Breathing vents rendered		12.3.8			
inoperative.		12.3.7			
Close all internals and open all discharge valves.		12.3.6			
Ensure all adjacent compartments and voids are empty and open to		12.3.5			
atmosphere.		12.3.4			
Fill compartment with enough test medium to cover valves.		12.3.3			
Pressurize tank to correct pressure and hold for 5 min. (Must have 0 psi		12.3.2			
pressure drop).		12.3.1			
While under pressure check tank, gaskets, internal valves, manhole covers,		12.3.0			
and vents for leakage.		12.2.9			
Close discharge valves and open internal valves. Adjust pressure and check		12.2.8			
plumbing and discharge valves for leakage.		12.2.7			
Restore operation of all vents.		12.2.6			

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

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

Test Medium: Calibration Date:

Pressure Gauge Serial No.:

Tester:		Signature:		Date:	
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		12.5.2.7			
MAWP. Hold for 10 minutes and check plumbing and discharge valves for		12.5.2.9			
leaks.		12.5.2.10			
Relieve pressure and drain tank.		12.5.2.11			
Reinstall or return all relief valves to working condition.		12.5.2.12			

QC Man  
 Complies  
 Retest  
 Complies

**Hydrostatic Pressure Test Item**

QC Man  
 Complies  
 Retest  
 Complies

Pneumatic Pressure Test Item			QC Man	Ref.	Complies	Reject	Retest
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:		

Pressure Gauge Serial No.: Calibration Date:

Test Pressure: (80% of the MAWP) Test Medium: (Refer to Table 7.4 of CSA B620-20 posted in fitting cabinet for appropriate test pressure)

**PNEUMATIC PRESSURE TEST "P"** (QC Manual Reference 12.5) Test Pressure (Tank):

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 Leakage Test Item			QC	Man. Ref.	Complies	Reject	Retest
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:		

Pressure Gauge Serial No.: Calibration Date:

Test Pressure: (80% of the MAWP Min.) Test Medium: (QC Manual Reference 12.4)

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

Pressure Gauge Serial No.:

Calibration Date:

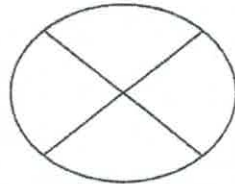
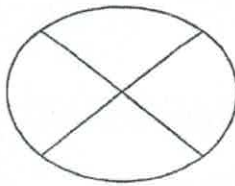
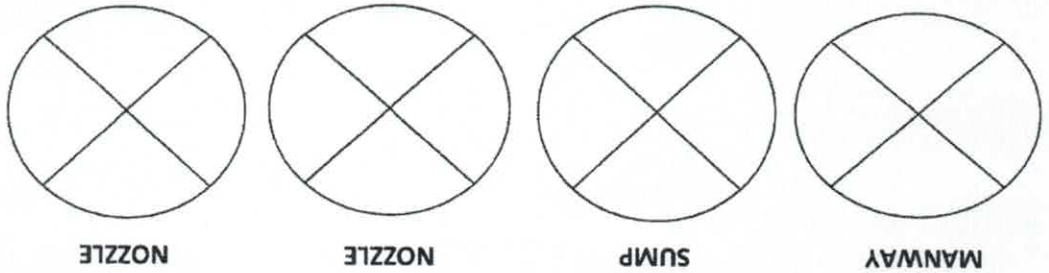
Test Pressure

Test Medium:

**HEATING SYSTEM TEST** (QC Manual Reference 12.10)

Inspector:		Signature:		Date:	
------------	--	------------	--	-------	--

Manufacturer's Thickness Head: \_\_\_\_\_ Shell: \_\_\_\_\_  
 Minimum Thickness Head: \_\_\_\_\_ Shell: \_\_\_\_\_



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

**THICKNESS TEST "T"** (QC Manual Reference 12.6)

**TANK DISPOSITION**

Removed from service  YES  NO

Safety Mark (Specification Indication) removed  YES  NO

Returned to Service  YES  NO

Tank marking applied (QC Manual Reference Section 15)  YES  NO

Description of defects found and methods used to repair:

**LINING INSPECTION 1** (QC Manual Reference 12.7.2)

Inspector:	Signature:	Date:
Inspect rubber liners using a spark tester and following manufacturers instructions	12.7.1.1	
Inspect all linings other than rubber of 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	

**UPPER COUPLER INSPECTION UC** (QC Manual Reference 12.2.6)

Inspector:	Signature:	Date:
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	



Inspection Report in Accordance with CSA B620-20

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

TEST DATE: April 1, 2022

TANK OWNER: Big Steam Oilfield Services

ADDRESS: # 5 Boswell Cres Brooks Alberta T1R 1B7

TELEPHONE: (403) 793-7046

SERIAL NO.: 0902097

UNIT NO.: 230T

MVID/TCRN: 2054750204

MANUFACTURER: Steel Head

ASSEMBLER: Steel Head

TC SPEC.: TC407/412 MATERIAL: SA36

CERTIFICATION DATE: 10/2002

MINIMUM THICKNESS SHELL: 6.4 mm

MINIMUM THICKNESS HEAD: 5.52 mm

MAWP: 25 psi DESIGN PRESSURE:

LINING: YES  NO  INSULATED: YES  NO

SPECIAL SERVICE CONDITIONS:

COMP. CAPACITY: 1 21,700 L 2 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: 9810523	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

CONSTRUCTED OF OTHER THAN QUENCHED AND TEMPERED STEEL: NOT

TANK STRESS RELIEVED AFTER MANUFACTURE:

TANK STRESS RELIEVED AFTER REPAIR:

TANK STRESS RELIEF AFTER REPAIR:

YES  NO   
YES  NO   
YES  NO   
YES  NO   
COMPLETE:  LOCAL:

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

**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

Item Inspected		QC Man	Ref.	Complies	Reject	Retest
Inspector: Joal Label		Signature: <i>[Signature]</i>				
Date: April 1, 2022						
Internal valves, piping and vents for leakage, damage, etc.	12.3.5	X				
Internal supports and attachments	12.3.5	X				
Interior welds for defects, cracking, etc.	12.3.4	X				
Solutions Procedure Number QP-16	12.3.3	X				
If required by the tank specification perform Wet Fluorescent Magnetic Particle Inspection and file report in accordance with Dynamic Industrial						
Interior surface for corrosion, distortion, overlay patches, cracking, etc.	12.3.2	X				

**INTERNAL VISUAL INSPECTION "I"**

Item Inspected		QC Man	Ref.	Complies	Reject	Retest
Inspector: Joal Label		Signature: <i>[Signature]</i>				
Date: April 1, 2022						
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	N/A				
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	N/A				

**EXTERNAL VISUAL INSPECTION "V"**

Hydrostatic Pressure Test Item		QC Man	Complies	Reject	Retest
Level and adequately support the tank.					
Remove self closing relief valves for testing.					
Remove or render inoperative all other relief devices and close internal valves.					
Ensure all remaining closures are rated at or above test pressure.					
Ensure adjacent compartments and voids are empty and open to atmosphere.					
Fill compartment completely with water.					
Install pressurization line and slowly increase pressure to test pressure.					
Disconnect pressure source and hold pressure for 10 minutes.					
With tank under pressure inspect exterior for leaks, defects, or distortion.					
Relieve pressure in tank.					
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.					
Relieve pressure and drain tank.					
Reinstall or return all relief valves to working condition.					
Tester: _____		Signature: _____		Date: _____	

**HYDROSTATIC PRESSURE TEST "P"** (QC Manual Reference 12.5)  
 Test Pressure (Tank):  
 Test Pressure (Piping): (80% of the MAWP)  
 Test Pressure (Piping):  
 Pressure Gauge Serial No.:  
 Calibration Date: \_\_\_\_\_

Hydrostatic Leakage Test Item		QC	Man. Ref.	Complies	Reject	Retest
All product piping, valves, and accessories in place. Breathing vents rendered inoperative.						
Close all Internals and open all discharge valves.						
Ensure all adjacent compartments and voids are empty and open to atmosphere.						
Fill compartment with enough test medium to cover valves.						
Pressurize tank to correct pressure and hold for 5 min. (Must have 0 psi pressure drop).						
While under pressure check tank, gaskets, internal valves, manhole covers, and vents for leakage.						
Close discharge valves and open internal valves. Adjust pressure and check plumbing and discharge valves for leakage.						
Restore operation of all vents.						
Tester: Joel Label		Signature: _____		Date: April 1, 2022		

**HYDROSTATIC LEAKAGE TEST "K"** (QC Manual Reference 12.4)  
 Test Pressure: 20 psi  
 (80% of the MAWP Min.)  
 Pressure Gauge Serial No.: 21821460039  
 Calibration Date: Jan. 13, 2023

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

Calibration Date:

Pressure Gauge Serial No.:

Test Pressure (Piping): (80% of the MAWP)  
 Test Medium: \_\_\_\_\_  
 (Refer to Table 7.4 of CSA B620-20 posted in fitting cabinet for appropriate test pressure)

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

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

Calibration Date:

Pressure Gauge Serial No.:

Test Pressure: \_\_\_\_\_  
 (80% of the MAWP Min.)  
 (QC Manual Reference 12.4)

Test Medium: \_\_\_\_\_



Inspector:		Signature:		Date:	
Hold test pressure for 5 min. And inspect for internal and external leakage		12.10.3			
If equipped with flues, inspect for product leakage into flues		12.10.4			
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			
Heating System Test Inspection Item		QC		Complies	
Man.Ref.		Complies		Reject	
Retest		Complies		Complies	

Pressure Gauge Serial No.:

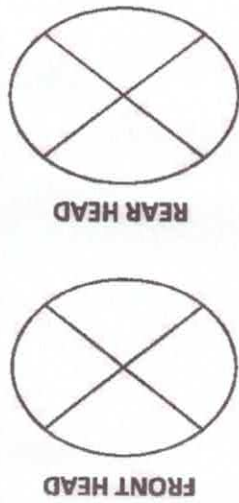
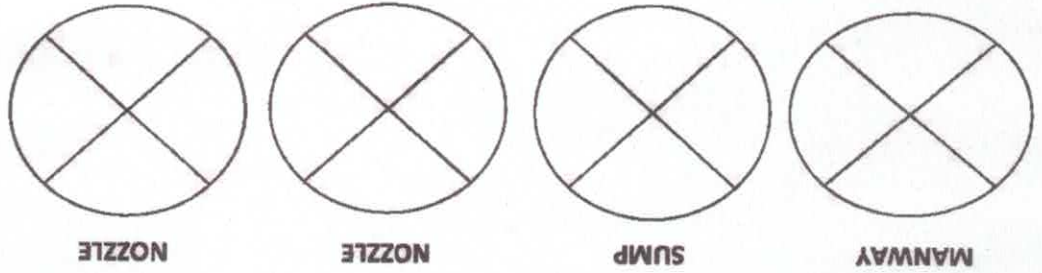
Test Pressure:

Test Medium:

HEATING SYSTEM TEST (QC Manual Reference 12.10)

Inspector:		Signature:		Date:	
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Manufacturer's Thickness Head: \_\_\_\_\_ Shell: \_\_\_\_\_  
 Minimum Thickness Head: \_\_\_\_\_ Shell: \_\_\_\_\_



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

THICKNESS TEST "T" (QC Manual Reference 12.6)

**TANK DISPOSITION**

Removed from service  YES  NO

Safety Mark (Specification Indication) removed  YES  NO

Returned to Service  YES  NO

Tank marking applied (QC Manual Reference Section 15)  YES  NO

Description of defects found and methods used to repair:

**LINING INSPECTION 1** (QC Manual Reference 12.7.2)

Inspector:	Signature:	Date:
Inspect rubber liners using a spark tester and following manufacturers instructions		
Inspect all linings other than rubber of FRP corrosion barriers according to the lining manufacturers instructions		
If lining damage is discovered inspect the tank wall under the damaged lining and thickness test if required.		
Man. Ref.	12.7.1	12.7.3.1
Complies	Complies	Complies
Reject	Reject	Reject

**UPPER COUPLER INSPECTION UC** (QC Manual Reference 12.2.6)

Inspector:	Signature:	Date:
Remove Upper Coupler or Turntable from unit		
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		
While removed inspect Upper Coupler assembly for cracks, distortion, plate wear and kingpin wear.		
If equipped, inspect Turntable for wear, distortion and cracks		
Install Upper Coupler or Turntable assembly		
Man. Ref.	12.2.6	12.2.6.4
Complies	Complies	Complies
Reject	Reject	Reject
Retest	Retest	Retest