STI External Inspection Report

FACILITY: ADM-Fort Collins Rodelle Facility	**FLOC #:** 403377240	**SAP EQUIP #:** 3820361
EQUIPMENT #: 0300-TK-09	**DESCRIPTION:** Large Mix Tank (0300-TK-09)	
DESIGN CODE: ASME Sec. VIII Div.1	**MFG.SN #:** 861029	**NATL BRD #:** **P&ID #:**

TYPE OF INSPECTION	INSPECTOR(S)	INSPECTION DATE
☒- EXTERNAL ☒- UT SURVEY ☐- INTERNAL	Levi Whitney # 84647	3/20/2024

Equipment Overview Picture.

Access & Limitations:

This equipment is located in the Vanilla Production building. A Ladder will be needed to access the top of the head and shell.

STI External Inspection Report

Inspection Summary:

Acuren Inspection completed A STI External Visual Inspection and UTT survey.

The vessel manufacturer is A L Stainless. Nameplate was attached but State of Colorado Jurisdictional paperwork / tag was not located at vessel. Manufacture drawings were provided, but no inspection test plan, U1A or inspection history were available for review. Further review by the company designee will need to be performed to ensure that any / all State of Colorado requirements have been satisfied.

Findings for this inspection:

- No inspection test plan, U1A or inspection history was available for review.
- No piping spec referenced on P&IDs provided.
- No State of Colorado Jurisdictional paperwork / tag was located on vessel.
- Stainless steel tank welded to carbon steel frame support. Dissimilar metal welds on equipment are considered to be an acceptable company practice.
- Heavy mechanical damage at tank shell handle. Metal has been peeled back on jacketing. Not detrimental to the normal service of the tank.

No issues observed during this inspection that would prevent this equipment from continued service at designed operating parameters.

STI External Inspection Report

EXTERNAL INSPECTION		RATING					F/C	COMMENTS	
1.	Documentation	1 ☐	2 ☐	3 ☐	4 ☐	5 ☒	**MI**	**ITP & Inspection history were not available for review. / No pipe spec available for review.**	
2.	Nameplate	1 ☐	2 ☐	3 ☐	4 ☐	5 ☒	**MI**	Nameplate was attached & legible. **/ No State of Colorado Jurisdictional paperwork or tag were located.**	
3.	Foundation	1 ☐	2 ☒	3 ☐	4 ☐	5 ☐		Equipment foundation is building concrete slab, no adverse conditions at slab to equipment support legs.	
4.	Anchor Bolts & Supports	1 ☐	2 ☒	3 ☐	4 ☐	5 ☐		Stainless steel tank welded to carbon steel frame support. Dissimilar metal welds on equipment are considered to be an acceptable company practice	
5.	Static Ground Connection	1 ☐	2 ☒	3 ☐	4 ☐	5 ☐		Equipment is assumed to be grounded through building grounding system.	
6.	Top Head	1 ☐	2 ☒	3 ☐	4 ☐	5 ☐		No signs of mechanical damage or bulging throughout the head. Circ welds appear to be full profile with no adverse conditions.	
7.	Shell	1 ☐	2 ☐	3 ☐	4 ☒	5 ☐	**DA**	Heavy mechanical damage at tank shell handle. Metal has been peeled back on jacketing. Not detrimental to the normal service of the tank.	
8.	Bottom Head	1 ☐	2 ☒	3 ☐	4 ☐	5 ☐		No signs of mechanical damage or bulging throughout the head. Circ welds appear to be full profile with no adverse conditions.	
9.	Ladders/Platforms	1 ☐	2 ☒	3 ☐	4 ☐	5 ☐		No issues with stairs or platform.	
10.	Nozzles / Couplings	1 ☐	2 ☒	3 ☐	4 ☐	5 ☐		No adverse conditions at nozzles.	
11.	Flanges	1 ☐	2 ☒	3 ☐	4 ☐	5 ☐		No issues with flange wingnut clamp bolt up.	
12.	Bolting/Gaskets	1 ☐	2 ☒	3 ☐	4 ☐	5 ☐		Wingnut clamps are sealed, and there is no visual access to gasket. No adverse conditions.	
13.	Small Piping Connections	1 ☐	2 ☒	3 ☐	4 ☐	5 ☐		No adverse conditions at small bore piping branch bolt up.	
14.	Insulation/Jacketing	1 ☒	2 ☐	3 ☐	4 ☐	5 ☐		N/A Equipment not insulated.	
15.	Evidence of CUI	1 ☒	2 ☐	3 ☐	4 ☐	5 ☐		N/A Equipment not insulated.	
16.	Paint/Coating	1 ☒	2 ☐	3 ☐	4 ☐	5 ☐		N/A Equipment is not coated.	
17.	Evidence of leakage	1 ☐	2 ☒	3 ☐	4 ☐	5 ☐		No signs of leaking at nozzle bolt ups or gaskets.	
18.	Evidence of corrosion	1 ☐	2 ☒	3 ☐	4 ☐	5 ☐		No signs of corrosion throughout equipment heads or shell.	
19.	Instrumentation/Gauges	1 ☒	2 ☐	3 ☐	4 ☐	5 ☐		No issues with instrumentation or gauges.	
20.	Valves	1 ☒	2 ☐	3 ☐	4 ☐	5 ☐		No valves installed before equipment flange.	
21.	Davit Arm	1 ☒	2 ☐	3 ☐	4 ☐	5 ☐		N/A	
22.	UTT Survey	1 ☐	2 ☒	3 ☐	4 ☐	5 ☐		Refer to UTT survey for results and remaining life calcs.	
23.	Other (Caution Sign)	1 ☐	2 ☒	3 ☐	4 ☐	5 ☐		Sign in place.	
24.	Primary Relief Device	1 ☒	2 ☐	3 ☐	4 ☐	5 ☐		Set Pressure:	Test Date:
25.	Secondary Relief Device	1 ☒	2 ☐	3 ☐	4 ☐	5 ☐		Set Pressure:	Test Date:

RATINGS:	1) Not Applicable	2) No Findings	3) Not Inspected	4) Within Acceptable Limits	5) Needing Repair or Replacement

Fault Codes

C/A – Corrosion Active
C/I – Corrosion Inactive
CR - Cracked
TR- Temporary Repair
WM – Wrong Material/Component
ER – Eroded/Worn
FO – Fouled/Deposits Presents
ID – Improper design/Installation
DA – Damaged/Broken
LK- Leak
LS - Loose
MI – Missing
PC – Coating Condition

Corresponding Damage

L – Light (Up to 1/32" Deep)
M – Moderate (Up to 1/8" Deep)
S – Severe (> 1/8" Deep)

Coating Condition

F – Fair (Light Oxidation)
P- Poor (Active Corrosion)
R – Required Repair
RR – Required Replacement

STI External Inspection Report

Historical Records Review:
This baseline inspection will be the start of the equipment's permanent and progressive records.

External Visual Inspection Details:

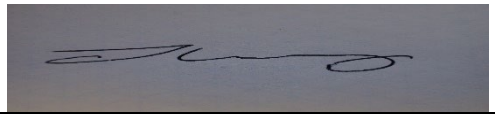
2023 Inspection was an External Visual Inspection.

1. **Documentation:** ITP & Inspection history were not available for review. / No pipe spec available for review.
2. **Nameplate:** Nameplate was attached & legible. / No State of Colorado Jurisdictional paperwork or tag were located.
3. **Foundation:** Equipment foundation is building concrete slab, no adverse conditions at slab to equipment support legs.
4. **Anchor Bolts & Supports:** Stainless steel tank welded to carbon steel frame support. Dissimilar metal welds on equipment are considered to be an acceptable company practice.
5. **Static Ground Connection:** Equipment is assumed to be grounded through building grounding system.
6. **Top Head:** No signs of mechanical damage or bulging throughout the head. Circ welds appear to be full profile with no adverse conditions.
7. **Shell:** Heavy mechanical damage at tank shell handle. Metal has been peeled back on jacketing. Not detrimental to the normal service of the tank.
8. **Bottom Head:** No signs of mechanical damage or bulging throughout the head. Circ welds appear to be full profile with no adverse conditions.
9. **Ladders/Platforms:** No issues with stairs or platform.
10. **Nozzles/Couplings:** No adverse conditions at nozzles.
11. **Flanges:** No issues with flange wingnut clamp bolt up.
12. **Bolting/Gaskets:** Wingnut clamps are sealed, and there is no visual access to gasket. No adverse conditions.
13. **Small Piping Connections:** No adverse conditions at small bore piping branch bolt up.
14. **Insulation/Jacketing:** N/A Equipment not insulated.
15. **Evidence of CUI:** N/A Equipment not insulated.
16. **Paint/Coating:** N/A Equipment is not coated.
17. **Evidence of leakage:** No signs of leaking at nozzle bolt ups or gaskets.
18. **Evidence of Corrosion:** No signs of corrosion throughout equipment heads or shell.
19. **Instrumentation/Gauges:** No issues with instrumentation or gauges.
20. **Valves:** No valves installed before equipment flange.
21. **Davit Arm:** N/A
22. **UTT Survey:** Refer to UTT survey for results and remaining life calcs.
23. **Caution Sign:** Sign in place.
24. **Primary Relief Device:** N/A
25. **Secondary Relief Device:** N/A

Inspection Findings:	**SAP Priorities:**	**0 = Immediate**	**1 = Less Than 1 Week**
	2 = Less Than 3 Weeks	**3 = Less Than 6 Weeks**	**4 = Opportunity/Fill In**

Ref. #	Finding	Corrective Action	Code Reference	SAP Notification	Priority

1	Inspection test plan and inspection history were not provided for review.	Provide inspection test plan and inspection history for future inspections.	API 510, Sec 7.8.2	☐ Yes ☐ No	4
1	Piping specification referenced on P&IDs was not provided for review.	Provide piping spec referenced on P&IDs for future inspections.	Good Industry Practices	☐ Yes ☐ No	4
2	State of Colorado Jurisdictional Paperwork / Tag not present.	Ensure operating permit inspections for equipment are current with the State of Colorado and have new Tag installed at time of next state required inspection.	Code Of Colorado Regulations 7 CCR 1101-5	☐ Yes ☐ No	4
7	Heavy mechanical damage at tank shell handle. Metal has been peeled back on jacketing.	Continue to monitor for further damage and indications at next inspection interval.	Good Industry Practices	☐ Yes ☐ No	4

Inspector Signature:  **Certification #:** 84647

Reviewing Inspector: _____ **Certification #:** _____

Inspection Photographs

Over view

Over view

	
Tank welded to carbon steel frame	Gauge
	
Jacketing handle mechanical damage	Jacketing handle mechanical damage

	
Tank top head	Top head hatch

Acuren Inspection Inc.
2460 Towerview Drive
Neenah, WI, USA 54956
www.acuren.com

Company Name: ADM - RODELLE
Location: FORT COLLINS, CO
Inspection Date: March 29, 2024
External Method: UT, VT
Print Date: May 10, 2024

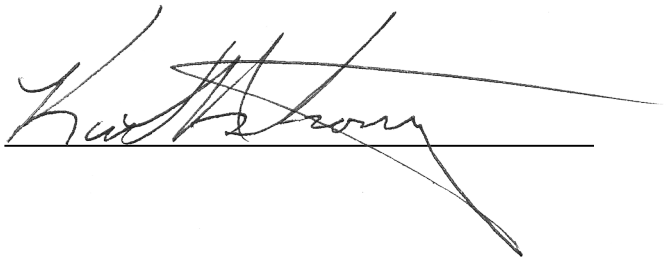
API 653 Low Pressure Storage Tank Report For:
Equipment No.: Large Mix Tank

Equipment Name:	Large Mix Tank (0300-TK-09)
Area:	Extraction
Service/Product:	N/A
Manufacturer:	N/A
Mfr. Dwg. No.:	N/A
Mfr. Date:	Jan 01, 2013
Serial #:	N/A
National Bd. #:	N/A
Registration #:	N/A
Insurance #:	N/A
External Class:	User Defined: (10 Years)
Internal Class:	User Defined: (10 Years)

Design Press.:	N/A	**psig**
Design MAWP:	15, 15	**psig**
Design Temp.:	N/A	**°F**
Press. Relief Setting:	N/A	**psig**

Inspection Company: Acuren Inspection Inc.

Inspector(s)	**Cert. Level(s)**
Armstrong, Kurt	MT-II, PT-II, RT-II, UT-II, VT-II, API 570, PMI
Anderson, Cole	MT-II, PT-II, RT-II, UT-IIL, PMI
Whitney, Levi	API 510, API 570, API 653

Signature: 

EXTERNAL INSPECTIONS

Thickness Insp. Due:	**Mar 29, 2034 [1]**
Visual [User Defined] Due:	**Mar 29, 2029 [2]**

[1] Thickness Insp. Due set to 'User Defined'.
Warning: 'User Defined' value is after DMAPS calculated result of Mar 29, 2029
Authorizing Personnel: Jon Fleming: Bypass DMAPS calculated date when CML data is mossing or higher than nominal.
[2] Method set to 'User Defined'. Warning: 'User Defined' value is after the frequency calculated result of Mar 29, 2028
Authorizing Personnel: Jon Fleming: Bypass DMAPS calculated date when CML data is missing or higher than nominal.

Equipment and Calibration: Olympus 38DL Plus thickness gauges and Olympus D790-SM 5 MHz 0.375" transducers along with Sonoglide FE-20 couplant were utilized for the ultrasonic thickness examinations.

DMAPS software was utilized for calculations and reporting of data.

Static Data Assumptions: If ADM facilities fail to provide static data for required DMAPS calculated values on the equipment examined, a 70% of assumed nominal thickness will be used as a flag value in the reports. Further engineering should be performed by Archer Daniels Midland (ADM) mechanical integrity and engineering personnel to determine suitability for continued service.

Nominal thickness values will be assumed based on the readings obtained from the examination and the nearest average value on ASTM standard pipe wall and plate steel gauge thickness charts.

Order of Acknowledgement: The agreement of Acuren Inspection to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested inspection of specific equipment and the preparation of reports or similar documents reflecting the inspection data obtained or the opinion formulated on the basis of such inspection. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinion or observations of the examiner and are not intended nor can they be construed as representations or warranties as to the actual circumstances. Acuren Inspection is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, repair and use decisions as a result of the inspection data or other information provided by Acuren Inspection. In no event shall Acuren Inspection's liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care:

In performing the services provided, Acuren Inspection uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Inspection.

Limitations of Liability:

Nothing in this Agreement shall be construed to mean that Acuren Inspection assumes any liability on account of injury to persons or property, including death, except those directly caused by negligent acts of Acuren Inspection or its employees and that Purchaser's own responsibility for injury to persons or properties while on or about Purchaser's equipment is in no way affected by this Agreement. Acuren Inspection shall not be held responsible or liable for any loss, damage, detention or delay caused by accidents, strikes, lock-outs, fire, flood, acts of civil or military authorities, or by insurrection or riot, or by any other cause that is unavoidable or beyond Acuren Inspection's control or in any event for consequential damages.

Acuren Inspection Inc.
2460 Towerview Drive
Neenah, WI, USA 54956
www.acuren.com

COMPONENT OVERVIEW REPORT
Equipment No.: Large Mix Tank

Inspection Date: March 29, 2024

GENERAL INFORMATION

Equipment Name: Large Mix Tank (0300-TK-09)

Risk Class: User Def.: (10 Years)

EXTERNAL OVERVIEW

Component Overview					Corrosion Rate Overview						Summary				
					Short Term [S]			Long Term [L]							
Group	Component Name	Min. Rdg. (in.)	Max. Rdg. (in.)	Avg. Rdg. (in.)	Avg. Corr. (mils/yr)	Max. Corr. (mils/yr)	Rem. Life (yrs)	Avg. Corr. (mils/yr)	Max. Corr. (mils/yr)	Rem. Life (yrs)	Gov. Corr. Rate	Corr. Rate Mult.	Next Insp. Date	MAWP* at Rdg (psig)	Retirement Date
H01	Top Head	0.109	0.123	0.112	N/A	N/A	Rdg >= Prev Rdg	N/A	N/A	Rdg >= Prev Rdg		x1	03/29/2034	15	N/A
H02	Bottom Jacket Head	0.079	0.082	0.080	N/A	N/A	Rdg >= Prev Rdg	N/A	N/A	Rdg >= Prev Rdg		x1	03/29/2034	15	N/A
N01	N01	0.000	0.000	0.000	N/A	N/A	No T-flag	N/A	N/A	No T-flag		x1	03/29/2034	N/A	N/A
N02	N02	0.131	0.135	0.133	0.18	0.27	>20	0.18	0.27	>20		x1	03/29/2034	15	>20 Years
N03	N03	0.000	0.000	0.000	N/A	N/A	No T-flag	N/A	N/A	No T-flag		x1	03/29/2034	N/A	N/A
N04	N04	0.123	0.126	0.124	0.12	0.18	>20	0.12	0.18	>20		x1	03/29/2034	15	>20 Years
N05	N05	0.066	0.067	0.067	N/A	N/A	Rdg >= Prev Rdg	N/A	N/A	Rdg >= Prev Rdg		x1	03/29/2034	15	N/A
N06	N06	0.068	0.072	0.070	N/A	N/A	Rdg >= Prev Rdg	N/A	N/A	Rdg >= Prev Rdg		x1	03/29/2034	15	N/A
N07	N07	0.000	0.000	0.000	N/A	N/A	No T-flag	N/A	N/A	No T-flag		x1	03/29/2034	N/A	N/A
N08	N08	0.000	0.000	0.000	N/A	N/A	No T-flag	N/A	N/A	No T-flag		x1	03/29/2034	N/A	N/A
N09	N09	0.063	0.067	0.065	0.18	0.18	>20	0.18	0.18	>20		x1	03/29/2034	15	>20 Years
N10	N10	0.000	0.000	0.000	N/A	N/A	No T-flag	N/A	N/A	No T-flag		x1	03/29/2034	N/A	N/A
S01	Shell	0.082	0.110	0.096	0.86	1.04	16	0.86	1.04	16		x1	03/29/2034	15	03/29/2040
S02	Jacket Shell	0.062	0.079	0.070	0.04	0.04	>20	0.04	0.04	>20		x1	03/29/2034	15	>20 Years
Total					0.28	1.04	16	0.28	1.04	16			03/29/2034	15	03/29/2040

Component Overview Legend
- Greater than (T-min + CorAlw / 2)
- Greater than T-min, but less than or equal to (T-min + CorAlw / 2)
- Less than or equal to T-min

Corrosion Rate Overview Legend
- 0 - N/A
- Greater than 0, but less than or equal to 10 (mils/yr)
- Greater than 10, but less than or equal to 20 (mils/yr)
- Greater than 20 (mils/yr)

Note: Values in [Brackets] are from a previous Inspection

Gov. Corr. Rate Code
- UD = User Defined
- UN = Unused
- UL = User Long Term
- US = User Short Term

MAWP
- > 25% + O.P.
- ≤ 25% + O.P.
- ≤ 10% + O.P.
- < O.P. [ ] = User Defined

Based on simple calculations.
See Calculation Report

Ret. Date Legend
- Greater Than 30 Days
- Within 30 Days
- Past Due

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Acuren Inspection Inc.
2460 Towerview Drive
Neenah, WI, USA 54956
www.acuren.com

EXTERNAL CML REPORT

Test Point	CML Number	T-nominal (in.)	T-min (in.)	Corrosion Rate (mils/yr)	MAWP at Rdg (psig)	Base		Previous		Current Reading (in.)	Total Wall Loss %	Retirement Date
						Thickness (in.)	Date	Thickness (in.)	Date			
001	H02-+2"-000°	0.078	0.055	N/A	15	0.078	01/01/2013	0.078	01/01/2013	0.082	N/A	Rdg >= Prev Rdg
002	H02-+2"-090°	0.078	0.055	N/A	15	0.078	01/01/2013	0.078	01/01/2013	0.080	N/A	Rdg >= Prev Rdg
003	H02-+2"-180°	0.078	0.055	N/A	15	0.078	01/01/2013	0.078	01/01/2013	0.080	N/A	Rdg >= Prev Rdg
004	H02-+2"-270°	0.078	0.055	N/A	15	0.078	01/01/2013	0.078	01/01/2013	0.079	N/A	Rdg >= Prev Rdg
005	H02-+20"-000°	0.078	0.055	N/A	15	0.078	01/01/2013	0.078	01/01/2013	0.081	N/A	Rdg >= Prev Rdg
006	H02-+20"-090°	0.078	0.055	N/A	15	0.078	01/01/2013	0.078	01/01/2013	0.081	N/A	Rdg >= Prev Rdg
007	H02-+20"-180°	0.078	0.055	N/A	15	0.078	01/01/2013	0.078	01/01/2013	0.080	N/A	Rdg >= Prev Rdg
008	H02-+20"-270°	0.078	0.055	N/A	15	0.078	01/01/2013	0.078	01/01/2013	0.080	N/A	Rdg >= Prev Rdg
009	H02-C/L	0.078	0.055	N/A	15	0.078	01/01/2013	0.078	01/01/2013	0.079	N/A	Rdg >= Prev Rdg
010	S02-+2"-000°	0.063	0.044	N/A	15	0.063	01/01/2013	0.063	01/01/2013	0.077	N/A	Rdg >= Prev Rdg
011	S02-+2"-090°	0.063	0.044	0.04 [LS]	15	0.063	01/01/2013	0.063	01/01/2013	0.062	0.8%	>20 Years
012	S02-+2"-180°	0.063	0.044	0.04 [LS]	15	0.063	01/01/2013	0.063	01/01/2013	0.062	0.8%	>20 Years
013	S02-+2"-270°	0.063	0.044	N/A	15	0.063	01/01/2013	0.063	01/01/2013	0.078	N/A	Rdg >= Prev Rdg
014	S02-C/L-000°	0.063	0.044	N/A	15	0.063	01/01/2013	0.063	01/01/2013	0.078	N/A	Rdg >= Prev Rdg
015	S02-C/L-090°	0.063	0.044	N/A	15	0.063	01/01/2013	0.063	01/01/2013	0.063	N/A	Rdg >= Prev Rdg
016	S02-C/L-180°	0.063	0.044	N/A	15	0.063	01/01/2013	0.063	01/01/2013	0.063	N/A	Rdg >= Prev Rdg
017	S02-C/L-270°	0.063	0.044	N/A	15	0.063	01/01/2013	0.063	01/01/2013	0.078	N/A	Rdg >= Prev Rdg
018	S02-+33"-000°	0.063	0.044	N/A	15	0.063	01/01/2013	0.063	01/01/2013	0.075	N/A	Rdg >= Prev Rdg
019	S02-+33"-090°	0.063	0.044	N/A	15	0.063	01/01/2013	0.063	01/01/2013	0.063	N/A	Rdg >= Prev Rdg
020	S02-+33"-180°	0.063	0.044	N/A	15	0.063	01/01/2013	0.063	01/01/2013	0.063	N/A	Rdg >= Prev Rdg
021	S02-+33"-270°	0.063	0.044	N/A	15	0.063	01/01/2013	0.063	01/01/2013	0.079	N/A	Rdg >= Prev Rdg
022	S01-+35.5"-000°	0.094	0.066	1.04 [LS]	15	0.094	01/01/2013	0.094	01/01/2013	0.082	12.5%	03/29/2040
023	S01-+35.5"-090°	0.094	0.066	N/A	15	0.094	01/01/2013	0.094	01/01/2013	0.110	N/A	Rdg >= Prev Rdg
024	S01-+35.5"-180°	0.094	0.066	N/A	15	0.094	01/01/2013	0.094	01/01/2013	0.106	N/A	Rdg >= Prev Rdg
025	S01-+35.5"-270°	0.094	0.066	0.68 [LS]	15	0.094	01/01/2013	0.094	01/01/2013	0.086	8.2%	>20 Years

T-min Color Legend
- Black for Calculated
- [Black for Structural Min]
- [Purple for Structural Alert]
- Purple for user Defined

Corrosion Rate Color Legend
- 0 - N/A
- Greater than 0, but less than or equal to 10 (mils/yr)
- Greater than 10, but less than or equal to 20 (mils/yr)
- Greater than 20 (mils/yr)

Note: [L] = Long Term, [S] = Short Term, [UD] = User Def.

MAWP
- > 25% + O.P.
- ≤ 25% + O.P.
- ≤ 10% + O.P.
- < O.P. [ ] = User Defined

Based on simple calculations.
See Calculation Report

CML/Readings Color Legend
- Greater than (T-min + CorAlw / 2)
- Greater than T-min, but less then or equal to (T-min + CorAlw / 2)
- Less than or equal to T-min

¹ = Verified

Wall Loss Color Legend
- Greater than or equal to 50%

* Total % Wall Loss from T-Nominal value.

Ret. Date Legend
- > 5 Years
- 1 to 5 Years
- 30 Days to 1 Year
- < 30 Days

ACUREN
Acuren Inspection Inc.
2460 Towerview Drive
Neenah, WI, USA 54956
www.acuren.com

EXTERNAL CML REPORT (Continued)

Test Point	CML Number	T-nominal (in.)	T-min (in.)	Corrosion Rate (mils/yr)	MAWP at Rdg (psig)	Base		Previous		Current Reading (in.)	Total Wall Loss %	Retirement Date
						Thickness (in.)	Date	Thickness (in.)	Date			
026	H01-+6"-000°	0.094	0.066	N/A	15	0.094	01/01/2013	0.094	01/01/2013	0.111	N/A	Rdg >= Prev Rdg
027	H01-+6"-090°	0.094	0.066	N/A	Unknown	0.094	01/01/2013	0.094	01/01/2013	N/A	N/A	No Rdgs
028	H01-+6"-180°	0.094	0.066	N/A	15	0.094	01/01/2013	0.094	01/01/2013	0.110	N/A	Rdg >= Prev Rdg
029	H01-+6"-270°	0.094	0.066	N/A	15	0.094	01/01/2013	0.094	01/01/2013	0.109	N/A	Rdg >= Prev Rdg
030	H01-+20"-000°	0.094	0.066	N/A	15	0.094	01/01/2013	0.094	01/01/2013	0.111	N/A	Rdg >= Prev Rdg
031	H01-+20"-090°	0.094	0.066	N/A	Unknown	0.094	01/01/2013	0.094	01/01/2013	N/A	N/A	No Rdgs
032	H01-+20"-180°	0.094	0.066	N/A	15	0.094	01/01/2013	0.094	01/01/2013	0.114	N/A	Rdg >= Prev Rdg
033	H01-+20"-270°	0.094	0.066	N/A	15	0.094	01/01/2013	0.094	01/01/2013	0.109	N/A	Rdg >= Prev Rdg
034	H01-C/L	0.094	0.066	N/A	15	0.094	01/01/2013	0.094	01/01/2013	0.123	N/A	Rdg >= Prev Rdg
035	N01-000°	0.322	0.000	N/A	Unknown	0.322	01/01/2013	0.322	01/01/2013	N/A	N/A	No T-flag
036	N01-090°	0.322	0.000	N/A	Unknown	0.322	01/01/2013	0.322	01/01/2013	N/A	N/A	No T-flag
037	N01-180°	0.322	0.000	N/A	Unknown	0.322	01/01/2013	0.322	01/01/2013	N/A	N/A	No T-flag
038	N01-270°	0.322	0.000	N/A	Unknown	0.322	01/01/2013	0.322	01/01/2013	N/A	N/A	No T-flag
039	N02-000°	0.134	0.094	N/A	15	0.134	01/01/2013	0.134	01/01/2013	0.135	N/A	Rdg >= Prev Rdg
040	N02-090°	0.134	0.094	0.27 [LS]	15	0.134	01/01/2013	0.134	01/01/2013	0.131	2.2%	>20 Years
041	N02-180°	0.134	0.094	N/A	Unknown	0.134	01/01/2013	0.134	01/01/2013	N/A	N/A	No Rdgs
042	N02-270°	0.134	0.094	0.09 [LS]	15	0.134	01/01/2013	0.134	01/01/2013	0.133	0.7%	>20 Years
043	N03-000°	0.133	0.000	N/A	Unknown	0.133	01/01/2013	0.133	01/01/2013	N/A	N/A	No T-flag
044	N03-090°	0.133	0.000	N/A	Unknown	0.133	01/01/2013	0.133	01/01/2013	N/A	N/A	No T-flag
045	N03-180°	0.133	0.000	N/A	Unknown	0.133	01/01/2013	0.133	01/01/2013	N/A	N/A	No T-flag
046	N03-270°	0.133	0.000	N/A	Unknown	0.133	01/01/2013	0.133	01/01/2013	N/A	N/A	No T-flag
047	N04-000°	0.125	0.088	N/A	15	0.125	01/01/2013	0.125	01/01/2013	0.126	N/A	Rdg >= Prev Rdg
048	N04-090°	0.125	0.088	0.09 [LS]	15	0.125	01/01/2013	0.125	01/01/2013	0.124	0.8%	>20 Years
049	N04-180°	0.125	0.088	0.18 [LS]	15	0.125	01/01/2013	0.125	01/01/2013	0.123	1.6%	>20 Years
050	N04-270°	0.125	0.088	0.09 [LS]	15	0.125	01/01/2013	0.125	01/01/2013	0.124	0.8%	>20 Years

T-min Color Legend
- Black for Calculated
- [Black for Structural Min]
- [Purple for Structural Alert]
- Purple for user Defined

Corrosion Rate Color Legend
- 0 - N/A
- Greater than 0, but less than or equal to 10 (mils/yr)
- Greater than 10, but less than or equal to 20 (mils/yr)
- Greater than 20 (mils/yr)

Note: [L] = Long Term, [S] = Short Term, [UD] = User Def.

MAWP
- > 25% + O.P.
- ≤ 25% + O.P.
- ≤ 10% + O.P.
- < O.P. [ ] = User Defined

Based on simple calculations.
See Calculation Report

CML/Readings Color Legend
- Greater than (T-min + CorAlw / 2)
- Greater than T-min, but less then or equal to (T-min + CorAlw / 2)
- Less than or equal to T-min

¹ = Verified

Wall Loss Color Legend
- Greater than or equal to 50%

* Total % Wall Loss from T-Nominal value.

Ret. Date Legend
- > 5 Years
- 1 to 5 Years
- 30 Days to 1 Year
- < 30 Days

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EXTERNAL CML REPORT (Continued)

Test Point	CML Number	T-nominal (in.)	T-min (in.)	Corrosion Rate (mils/yr)	MAWP at Rdg (psig)	Base		Previous		Current Reading (in.)	Total Wall Loss %	Retirement Date
						Thickness (in.)	Date	Thickness (in.)	Date			
051	N05-000°	0.065	0.046	N/A	15	0.065	01/01/2013	0.065	01/01/2013	0.067	N/A	Rdg >= Prev Rdg
052	N05-090°	0.065	0.046	N/A	15	0.065	01/01/2013	0.065	01/01/2013	0.067	N/A	Rdg >= Prev Rdg
053	N05-180°	0.065	0.046	N/A	15	0.065	01/01/2013	0.065	01/01/2013	0.066	N/A	Rdg >= Prev Rdg
054	N05-270°	0.065	0.046	N/A	15	0.065	01/01/2013	0.065	01/01/2013	0.067	N/A	Rdg >= Prev Rdg
055	N06-000°	0.065	0.046	N/A	15	0.065	01/01/2013	0.065	01/01/2013	0.068	N/A	Rdg >= Prev Rdg
056	N06-090°	0.065	0.046	N/A	15	0.065	01/01/2013	0.065	01/01/2013	0.069	N/A	Rdg >= Prev Rdg
057	N06-180°	0.065	0.046	N/A	15	0.065	01/01/2013	0.065	01/01/2013	0.072	N/A	Rdg >= Prev Rdg
058	N06-270°	0.065	0.046	N/A	15	0.065	01/01/2013	0.065	01/01/2013	0.069	N/A	Rdg >= Prev Rdg
059	N07-000°	0.280	0.000	N/A	Unknown	0.280	01/01/2013	0.280	01/01/2013	N/A	N/A	No T-flag
060	N07-090°	0.280	0.000	N/A	Unknown	0.280	01/01/2013	0.280	01/01/2013	N/A	N/A	No T-flag
061	N07-180°	0.280	0.000	N/A	Unknown	0.280	01/01/2013	0.280	01/01/2013	N/A	N/A	No T-flag
062	N07-270°	0.280	0.000	N/A	Unknown	0.280	01/01/2013	0.280	01/01/2013	N/A	N/A	No T-flag
063	N08-000°	0.375	0.000	N/A	Unknown	0.375	01/01/2013	0.375	01/01/2013	N/A	N/A	No T-flag
064	N08-090°	0.375	0.000	N/A	Unknown	0.375	01/01/2013	0.375	01/01/2013	N/A	N/A	No T-flag
065	N08-180°	0.375	0.000	N/A	Unknown	0.375	01/01/2013	0.375	01/01/2013	N/A	N/A	No T-flag
066	N08-270°	0.375	0.000	N/A	Unknown	0.375	01/01/2013	0.375	01/01/2013	N/A	N/A	No T-flag
067	N09-000°	0.065	0.046	N/A	15	0.065	01/01/2013	0.065	01/01/2013	0.066	N/A	Rdg >= Prev Rdg
068	N09-090°	0.065	0.046	N/A	15	0.065	01/01/2013	0.065	01/01/2013	0.065	N/A	Rdg >= Prev Rdg
069	N09-180°	0.065	0.046	N/A	15	0.065	01/01/2013	0.065	01/01/2013	0.067	N/A	Rdg >= Prev Rdg
070	N09-270°	0.065	0.046	0.18 [LS]	15	0.065	01/01/2013	0.065	01/01/2013	0.063	3.1%	>20 Years
071	N10-000°	0.216	0.000	N/A	Unknown	0.216	01/01/2013	0.216	01/01/2013	N/A	N/A	No T-flag
072	N10-090°	0.216	0.000	N/A	Unknown	0.216	01/01/2013	0.216	01/01/2013	N/A	N/A	No T-flag
073	N10-180°	0.216	0.000	N/A	Unknown	0.216	01/01/2013	0.216	01/01/2013	N/A	N/A	No T-flag
074	N10-270°	0.216	0.000	N/A	Unknown	0.216	01/01/2013	0.216	01/01/2013	N/A	N/A	No T-flag

T-min Color Legend
- Black for Calculated
- [Black for Structural Min]
- [Purple for Structural Alert]
- Purple for user Defined

Corrosion Rate Color Legend
- 0 - N/A
- Greater than 0, but less than or equal to 10 (mils/yr)
- Greater than 10, but less than or equal to 20 (mils/yr)
- Greater than 20 (mils/yr)

Note: [L] = Long Term, [S] = Short Term, [UD] = User Def.

MAWP
- > 25% + O.P.
- ≤ 25% + O.P.
- ≤ 10% + O.P.
- < O.P. [ ] = User Defined

Based on simple calculations.
See Calculation Report

CML/Readings Color Legend
- Greater than (T-min + CorAlw / 2)
- Greater than T-min, but less then or equal to (T-min + CorAlw / 2)
- Less than or equal to T-min

¹ = Verified

Wall Loss Color Legend
- Greater than or equal to 50%

* Total % Wall Loss from T-Nominal value.

Ret. Date Legend
- > 5 Years
- 1 to 5 Years
- 30 Days to 1 Year
- < 30 Days

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LOW PRESSURE STORAGE TANK STATIC INFORMATION
Equipment No.: Large Mix Tank

GENERAL INFORMATION

Equipment No.: Large Mix Tank
Equipment Name: Large Mix Tank (0300-TK-09)
Serial #: N/A
National Bd. #: N/A
Area/Unit: Extraction

Manufacturer: N/A
Manufacture Date: Jan 01, 2013
Mfr. Drawing No.: N/A
Insurance #: N/A
Registration #: N/A

Service: N/A
Ext. Risk Class: User Def.: (10 Years)
Int. Risk Class: User Def.: (10 Years)
Orientation: Vertical

TANK INFORMATION

Design Liquid Level: N/A
Specific Gravity: N/A
Insulation: N/A

HEAD INFORMATION

Number of Components: 1

Head Number	Install Date	Head Type	Head ID (in.)	Head Material	Allow. Stress (ksi)	Joint Eff.	Corr. Allow. (in.)	Thickness (in.)		Design		Operating		MAWP (psig)	½ Cone Apex Angle	Knuckle Radius (in.)	Crown Radius (in.)
								Nom.	Min.	Press. (psig)	Temp. °F	Press. (psig)	Temp. °F				
1 Top	Jan 01, 2013	2:1 Ellipsoidal	63.813	STD STNLS STL	18.8	0.85	0.000	0.094	0.066	N/A	100	N/A	N/A	15	N/A	N/A	N/A
	Comments: Assumed All Static Data																

SHELL INFORMATION

Number of Components: 1

Shell Number	Install Date	Shell Height (ft)	Shell ID (in.)	Shell Material	Allow. Stress (ksi)	Joint Eff.	Corr. Allow. (in.)	Thickness (in.)		Design		Operating		Hydro Test Press. (psig)	MAWP (psig)
								Nom.	Min.	Press. (psig)	Temp. °F	Press. (psig)	Temp. °F		
1	Jan 01, 2013	3	63.813	STD STNLS STL	18.8	0.70	0.000	0.094	0.066	N/A	100	N/A	N/A	N/A	15
	Comments: Assumed All Static Data														

JACKET INFORMATION

Design Liquid Level: N/A
Specific Gravity: N/A
Insulation: N/A

JACKET HEAD INFORMATION

Number of Components: 1

Head Number	Install Date	Head Type	Head ID (in.)	Head Material	Allow. Stress (ksi)	Joint Eff.	Corr. Allow. (in.)	Thickness (in.)		Design		Operating		MAWP (psig)	½ Cone Apex Angle	Knuckle Radius (in.)	Crown Radius (in.)
								Nom.	Min.	Press. (psig)	Temp. °F	Press. (psig)	Temp. °F				
1 Bottom	Jan 01, 2013	Conical	65.844	STD STNLS STL	18.8	0.85	0.000	0.078	0.055	N/A	100	N/A	N/A	15	15	N/A	N/A
	Comments: Assumed All Static Data																

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LOW PRESSURE STORAGE TANK STATIC INFORMATION
Equipment No.: Large Mix Tank

JACKET SHELL INFORMATION

Number of Components: 1

Shell Number	Install Date	Shell Height (ft)	Shell ID (in.)	Shell Material	Allow. Stress (ksi)	Joint Eff.	Corr. Allow. (in.)	Thickness (in.)		Design		Operating		Hydro Test Press. (psig)	MAWP (psig)
								Nom.	Min.	Press. (psig)	Temp. °F	Press. (psig)	Temp. °F		
1	Jan 01, 2013	35	65.875	STD STNLS STL	18.8	0.70	0.000	0.063	0.044	N/A	100	N/A	N/A	N/A	15
	Comments: Assumed All Static Data														

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NOZZLE STATIC DATA SHEET
Equipment No.: Large Mix Tank

Equipment Name: Large Mix Tank (0300-TK-09)

NOZZLE INFORMATION

Number of Nozzles: 10

Nozzle Name	Nozzle Purpose	Nozzle Install Date	Attached To	Height / Location	Nozzle Material	Joint Eff.	Nozzle		Corr. Allow. (in.)	Thickness (in.)	
							O.D.(in.)	Sch.		Nom.	Min.
N01	N/A	Jan 01, 2013	H02	N/A	STD STNLS STL	0.70	8.625	STD	N/A	0.322	N/A
	Comments: Assumed All Static Data										
N02	N/A	Jan 01, 2013	H02	N/A	STD STNLS STL	0.70	6.625	10	0.0000	0.134	0.094
	Comments: Assumed All Static Data										
N03	N/A	Jan 01, 2013	S02	N/A	STD STNLS STL	0.70	1.315	STD	0.0000	0.133	N/A
	Comments: Assumed All Static Data										
N04	N/A	Jan 01, 2013	H01	N/A	STD STNLS STL	0.70	16.00	C1	0.0000	0.125	0.088
	Comments: Assumed All Static Data										
N05	N/A	Jan 01, 2013	H01	N/A	STD STNLS STL	0.70	2.00	CTM	0.0000	0.065	0.046
	Comments: Assumed All Static Data										
N06	N/A	Jan 01, 2013	H01	N/A	STD STNLS STL	0.70	3.00	5	0.0000	0.065	0.046
	Comments: Assumed All Static Data										
N07	N/A	Jan 01, 2013	H01	N/A	STD STNLS STL	0.70	6.625	STD	0.0000	0.280	N/A
	Comments: Assumed All Static Data										
N08	N/A	Jan 01, 2013	H01	N/A	STD STNLS STL	0.70	14.00	STD	0.0000	0.375	N/A
	Comments: Assumed All Static Data										
N09	N/A	Jan 01, 2013	H01	N/A	STD STNLS STL	0.70	1.50	5	0.0000	0.065	0.046
	Comments: Assumed All Static Data										
N10	N/A	Jan 01, 2013	H01	N/A	STD STNLS STL	0.70	3.50	STD	0.0000	0.216	N/A
	Comments: Assumed All Static Data										

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Report Number: NEE546389

ULTRASONIC EXAMINATION REPORT

CUSTOMER: Rodelle - ADM Nutrition	ACUREN SERVICE CALL #: 502-J125527	DATE: 03/29/2024
LOCATION/ADDRESS: 3461 Precision Dr Fort Collins CO USA 80528	CUSTOMER CONTACT: Mady Wanek / Jon Fleming	
PART # / DRAWING #: 0300-TK-09	CUSTOMER PO #: WAN231207	CUSTOMER WO #: N/A
ITEM DESCRIPTION: LARGE MIX TANK	STAGE OF MANUFACTURE: Final	SURFACE CONDITION: Clean bare metal

SURFACE PREPARATION:	COMMENT:	PARTS INSPECTED:	ACCEPTED:	REJECTED:
N/A	2024 Vessel/Equipment Extraction Inspections	1	Info	Info

NDE PROCEDURE	REV.	SPECIFICATION/CODE	REV./EDITION	ACCEPTANCE STANDARD
UT-2A	10	ASME Sec. V	2023	API 510 / Customer Information

MATERIAL:	EXAMINATION SURFACE:	THICKNESS:	QUANTITY:	ITEM TEMP.: / CAL. BLK TEMP.:
Carbon Steel / Stainless Steel (See Attached Report)	External	Varies in.	1	68 °F / 68 °F

TECHNIQUE:	TYPE OF EXAM:	COUPLANT TYPE:	BATCH NO.:
☑ Longitudinal ☐ Shearwave ☐ Other	Thickness Survey	Sonoglide FE20	18B01K

INSTRUMENT MANUFACTURER:	MODEL:	SERIAL NO.:	ANNUAL CAL. DUE DATE:	SEARCH CABLE LENGTH:	SEARCH CABLE TYPE:
Olympus	38DL Plus	151022601	09/25/2024	4'	LEMO

TRANSDUCER:	FREQUENCY:	WEDGE ANGLE:	MANUFACTURER:	SERIAL NO.:	SIZE:	MEASURED ANGLE:	DELAY:
☐ Single ☑ Dual	5 MHz	N/A	Panametrics D790	1173307	0.375"	0°	N/A

CALIBRATION BLOCK:	TYPE:	MATERIAL:	MANUFACTURER:	S/N:
☐ Curved ☑ Flat	0.100" - 0.500" Step Wedge	Carbon Steel / Stainless Steel	Olympus	1543-13 / 5365-19

Items	Quantity	Comments	Accept/Reject
0300-TK-09	1	An ultrasonic thickness examination was performed on all accessible areas on vessel/equipment. See the following API Summary and DMAPS report for actual thickness readings and their locations.	Info. Only

Sensitivity Level: + 62dB | Calibration Time Check: 12:30 PM | Calibration Time Initial: 8:00 AM | Calibration Time Final: 4:30 PM

☐ High Temp	Wire Wheel: N/A	Other: N/A	Customer Contact: Mady Wanek

Per Diem:	Unit #:	No. on Job:	Travel if Applicable:	Hours Worked:	Total Hours:
N/A	N/A	N/A	Hours: N/A Miles Total: N/A	7:00 to AM and to 5:00 PM	N/A

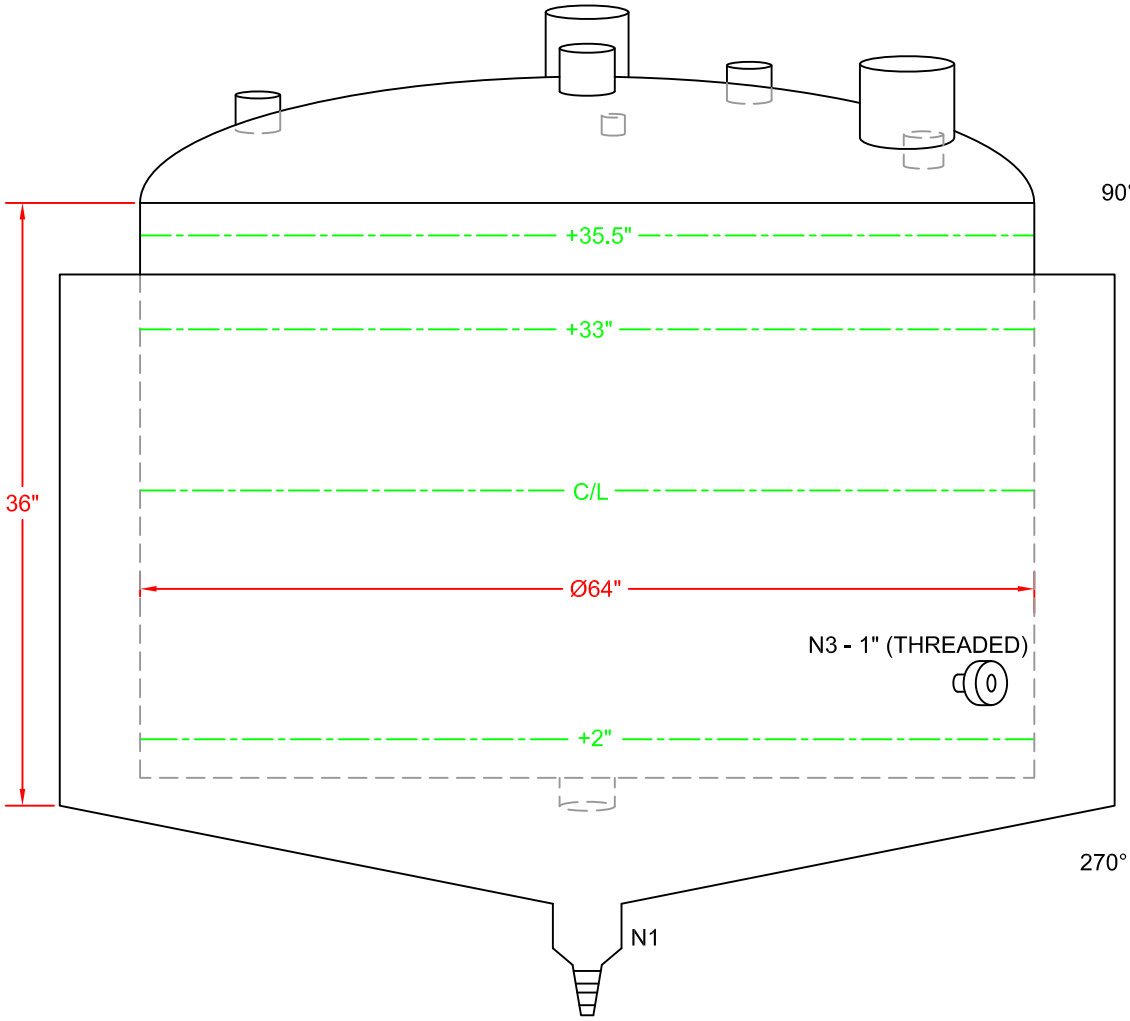
CLIENT REPRESENTATIVE		ACUREN INSPECTOR		
		Cole Anderson / Kurt Armstrong	03/29/2024	UT Level II
Print Name / Signature	Date	Print Name / Signature	Date	Inspection Level

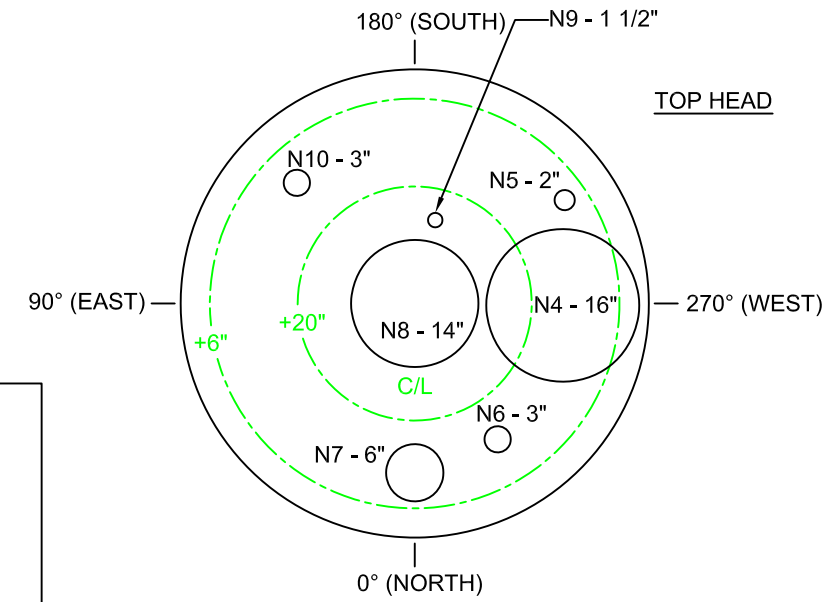
Client acknowledges receipt and custody of the report or other work ("Deliverable"). Client agrees that it is responsible for assuring that acceptance standards, specifications and criteria in the Deliverable and Statement of Work ("SOW") are correct. Client acknowledges that Acuren is providing the Deliverable according to the SOW, and not any other standards.

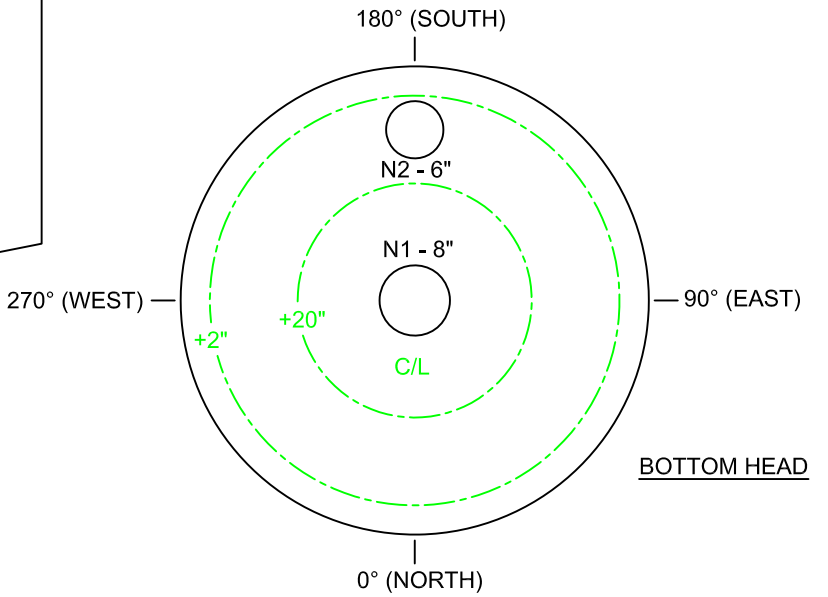
PEER REVIEW (IF APPLICABLE):
N/A
Print Name / Signature | Date

Client acknowledges that it is responsible for the failure of any items inspected to meet standards, and for remediation. Client has 15 business days following the date Acuren provides the Deliverable to inspect it, identify deficiencies in writing, and provide written rejection, or else the Deliverable will be deemed accepted. The Deliverable and other services provided by Acuren are governed by a Master Services Agreement ("MSA"). If the parties have not entered into an MSA, then the Deliverable and services are governed by the SOW and the "Acuren Standard Service Terms" (www.acuren.com/serviceterms) in effect when the services were ordered.

0° = NORTH - VIEW FACING SOUTH







NOTES
MATERIAL: S/S

ACUREN	SERVICE CALL #	502-J125527	ADM / RODELLE FORT COLLINS, CO	EQUIPMENT: LARGE MIX TANK (0300-TK-09)	DRAWN BY	K.A. / C.A.	CAD BY	J.K
	DATE OF INSP.	3/29/2024			SHEET NO.	1 OF 1	REV.	0
	TECHNICIAN(S)	K.A. / C.A.			DWG - LARGE MIX TANK (0300-TK-09).DWG			