QUALITY CONTROL MANUAL

VISUAL TEST REPORT

Customer: AGNICO EAGLE

Location: BAKER LAKE

Code Requiring Test: API 650 (section 8.5.2) Reason for Test: New Construction

A weld shall be acceptable by visual examination if the inspection shows the following.

a) There are no crater cracks, other surface cracks or arc strikes in or adjacent to the welded joints.
b) Maximum permissible undercut is 0.4 mm (1/64 in.) in depth for vertical butt joints, vertically oriented permanent attachments, attachment welds for nozzles, manholes, flush-type openings, and the inside shell-to-bottom welds. For horizontal butt joints, horizontally oriented permanent attachments, and annular-ring butt joints, the maximum permissible undercut is 0.8 mm (1/32 in.) in depth.
c) The frequency of surface porosity in the weld does not exceed one cluster (one or more pores) in any 100 mm (4 in.) of length, and the diameter of each cluster does not exceed 2.5 mm (3/32 in.).
d) The reinforcement of the welds on all thicknesses:

Plate Thickness mm (in.)	Maximum Reinforcement Thickness mm (in.)	
	Vertical Joints	Horizontal Joints
≤ 13 (1/2)	2.5 (3/32)	3 (1/8)
> 13 (1/2) to 25 (1)	3 (1/8)	5 (3/16)
> 25 (1)	5 (3/16)	6 (1/4)

Surface Condition (As Welded)

Test Solution: N/A Test Date(s): 2021-08-25

Tested by: Matthew MacKenzie Ambient Conditions: 10 Degrees Celcius

Items Tested:

Vertical and Horizontal Seams

Results:

Acceptable at time of Inspection.

STS Representative Signature: _____ Date: 2021-08-25

Client Representative Signature: Mario Marcil Date: 29-08-21

QUALITY CONTROL MANUAL

VISUAL TEST REPORT

Customer: AGNICO EAGLE

Location: BAKER LAKE

Code Requiring Test: API 650 (section 8.5.2) Reason for Test: New Construction

A weld shall be acceptable by visual examination if the inspection shows the following.

a) There are no crater cracks, other surface cracks or arc strikes in or adjacent to the welded joints.
b) Maximum permissible undercut is 0.4 mm (1/64 in.) in depth for vertical butt joints, vertically oriented permanent attachments, attachment welds for nozzles, manholes, flush-type openings, and the inside shell-to-bottom welds. For horizontal butt joints, horizontally oriented permanent attachments, and annular-ring butt joints, the maximum permissible undercut is 0.8 mm (1/32 in.) in depth.
c) The frequency of surface porosity in the weld does not exceed one cluster (one or more pores) in any 100 mm (4 in.) of length, and the diameter of each cluster does not exceed 2.5 mm (3/32 in.).
d) The reinforcement of the welds on all thicknesses:

Plate Thickness mm (in.)	Maximum Reinforcement Thickness mm (in.)	
	Vertical Joints	Horizontal Joints
≤ 13 (1/2)	2.5 (3/32)	3 (1/8)
> 13 (1/2) to 25 (1)	3 (1/8)	5 (3/16)
> 25 (1)	5 (3/16)	6 (1/4)

Surface Condition (As Welded)

Test Solution: N/A Test Date(s): 2021-08-25

Tested by: Matthew MacKenzie Ambient Conditions: 10 Degrees Celcius

Items Tested:

Vertical and Horizontal Seams at DOOR SHEET AREA.

Results:

Acceptable at time of Inspection.

STS Representative Signature: _____ Date: 2021-08-25

Client Representative Signature: _____ Date: SEPT 8TH 2021

Exhibit 25, Rev 1

DIESEL TEST REPORT (SHELL)

Customer: AGNICO EAGLE

Location: BAKER LAKE

Equipment Tag No.: TK 8

Equipment Type: Above Ground Storage Tank

Equipment Description: Diesel Storage Tank

Code Requiring Test: API 650 (section 7.3.5) Reason for Test: New Construction

(The shell shall be tested by painting all of the joints on the inside with a highly penetrating oil and carefully examining the outside of the joints for leakage.)

Surface Condition (As Welded)

Test Solution: Diesel Test Date(s): 2021-08-25

Tested by: Matthew MacKenzie Ambient Conditions: 10 Degrees Celcius

Items Tested:

Shell to bottom seam weld; excluding door sheet area.

SHELL WELDS, EXCLUDING DOOR SHEET AREA.

Results:

No leaks detected at the time of inspection; acceptable to code.

STS Representative Signature: _____ Date: 2021-08-25

Client Representative Signature: Mario Marcil Date: 08-29-21

Exhibit 26, Rev 1

Exhibit 25, Rev 1

DIESEL TEST REPORT (SHELL)

Customer: AGNICO EAGLE

Location: BAKER LAKE

Equipment Tag No.: TK 8

Equipment Type: Above Ground Storage Tank

Equipment Description: Diesel Storage Tank

Code Requiring Test: API 650 (section 7.3.5) Reason for Test: New Construction

(The shell shall be tested by painting all of the joints on the inside with a highly penetrating oil and carefully examining the outside of the joints for leakage.)

Surface Condition (As Welded)

Test Solution: Diesel Test Date(s): 2021-09-05

Tested by: Matthew MacKenzie Ambient Conditions: 10 Degrees Celcius

Items Tested:

Shell to bottom seam weld at door sheet area.

VERTICAL & HORIZONTAL WELDS ON DOOR SHEET.

Results:

No leaks detected at the time of inspection; acceptable to code.

STS Representative Signature: Matthew MacKenzie Date: 2021-09-05

Client Representative Signature: [signature] Date: Sept 8th 2021

Exhibit 16, Rev 1

DIMENSIONAL CHECK REPORT – PEAKING

Customer: AGNICO EAGLE

Location: BAKER LAKE

Equipment Tag No.: TK 8

Equipment Type: DIESEL STORAGE TANK

Equipment Description:

Code Requiring Test: API 650 Reason for Test: New Construction

(Each vertical seam will be checked for peaking and max. peak dimension recorded for that seam.)

Test Date(s): 2021-08-25

Tested by: Matthew MacKenzie

Seam Test Results:

First Course Shell:	☑ Pass	☐ Fail
Second Course Shell:	☑ Pass	☐ Fail
Third Course Shell:	☑ Pass	☐ Fail
Forth Course Shell:	☑ Pass	☐ Fail
Fifth Course Shell:	☑ Pass	☐ Fail
Door Sheet:	☑ Pass	☐ Fail

STS Representative Signature: Matthew MacKenzie Date: 2021-08-25

Client Representative Signature: [signature] Date: 08-29-21

Exhibit 17, Rev 1

DIMENSIONAL CHECK REPORT – BANDING

Customer: AGNICO EAGLE

Location: BAKER LAKE

Equipment Tag No.: TK 8

Equipment Type: DIESEL STORAGE TANK

Equipment Description:

Code Requiring Test: API 650 Reason for Test: New Construction

(Each circumferential seam will be checked for banding and max. banding dimension recorded for that seam. Circumferential seams will be checked at 45 degree intervals or less, max. 20' spacing)

Test Date(s): 2021-08-25

Tested by: Matthew MacKenzie

Seam Test Results:

First Vertical Seam:	☑ Pass	☐ Fail
Second Vertical Seam:	☑ Pass	☐ Fail
Third Vertical Seam:	☑ Pass	☐ Fail
Fourth Vertical Seam:	☑ Pass	☐ Fail
Door Seams:	☑ Pass	☐ Fail

STS Representative Signature: Matthew MacKenzie Date: 2021-08-25

Client Representative Signature: [signature] Date: 08-29-21

Exhibit 18, Rev 1

DIMENSIONAL CHECK REPORT – ROUNDNESS

Customer: AGNICO EAGLE

Location: BAKER LAKE

Equipment Tag No.: TK 8

Equipment Type: Above Ground Storage Tank

Equipment Description: Diesel Storage Tank

Code Requiring Test: API 650 Reason for Test: New Construction

(The tank shell will be checked for roundness at 12" above the tank floor. Roundness will be checked at 45 degree intervals or less, max. 20' spacing)

Test Date(s): 2021-08-18

Tested by: Matthew MacKenzie

Seam Test Results:

Acceptable at time of Inspection.

STS Representative Signature: Matthew MacKenzie Date: 2021-08-18

Client Representative Signature: [signature] Date: 4 Sept 21

Exhibit 19, Rev 1

DIMENSIONAL CHECK REPORT – PLUMBNESS

Customer: AGNICO EAGLE

Location: BAKER LAKE

Equipment Tag No.: TK 8

Equipment Type: Above Ground Storage Tank

Equipment Description: Diesel Storage Tank

Code Requiring Test: API 650 Reason for Test: New Construction

(The tank shell will be checked for plumb at 12" below the tank roof. Plumb measurements will be checked at 45 degree intervals or less, max. 20' spacing)

Test Date(s): August 21/21

Tested by: Matt MacKenzie

Test Results:

All measurements are acceptable at time of inspection.

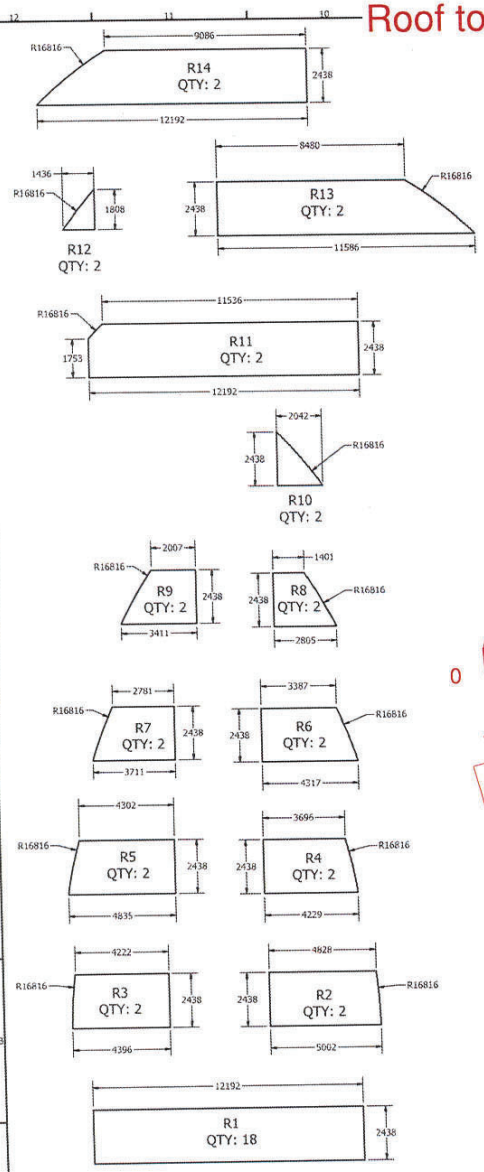
STS Representative Signature: _____ Date: August 21/21

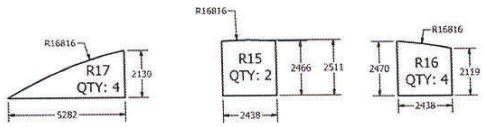
Client Representative Signature: _____ Date: 4th Sept 21

SECTION 11.0

Compression Ring

Roof to Compression Ring Weld Mapping

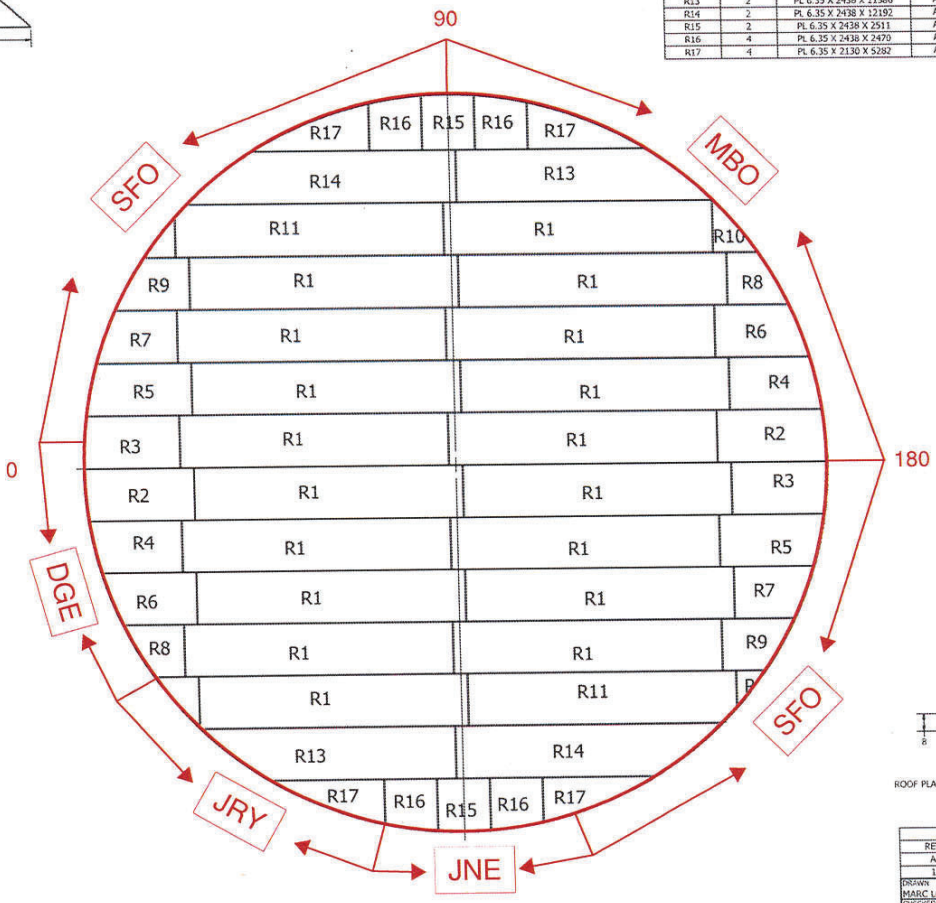


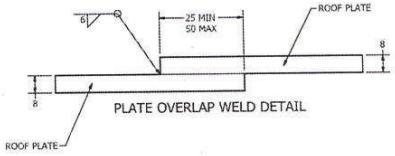


PARTS LIST

ITEM	QTY	DESCRIPTION	MATERIAL	UNIT WT (KG)	TOT WT (KG)
R1	18	PL 6.35 X 2438 X 12192	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	1481	26658
R2	2	PL 6.35 X 2438 X 5002	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	601	1202
R3	2	PL 6.35 X 2438 X 4596	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	527	1054
R4	2	PL 6.35 X 2438 X 4229	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	485	970
R5	2	PL 6.35 X 2438 X 4825	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	559	1118
R6	2	PL 6.35 X 2438 X 4317	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	473	946
R7	2	PL 6.35 X 2438 X 3711	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	398	796
R8	2	PL 6.35 X 2438 X 2805	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	261	522
R9	2	PL 6.35 X 2438 X 3411	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	334	668
R10	2	PL 6.35 X 2438 X 2042	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	132	264
R11	2	PL 6.35 X 2438 X 12192	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	1471	2942
R12	2	PL 6.35 X 1436 X 1808	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	68	136
R13	2	PL 6.35 X 2438 X 11586	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	1235	2470
R14	2	PL 6.35 X 2438 X 12192	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	1308	2616
R15	2	PL 6.35 X 2438 X 2511	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	303	606
R16	4	PL 6.35 X 2438 X 2470	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	282	1128
R17	4	PL 6.35 X 2130 X 5282	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	326	1304

TOT WT: 45,400



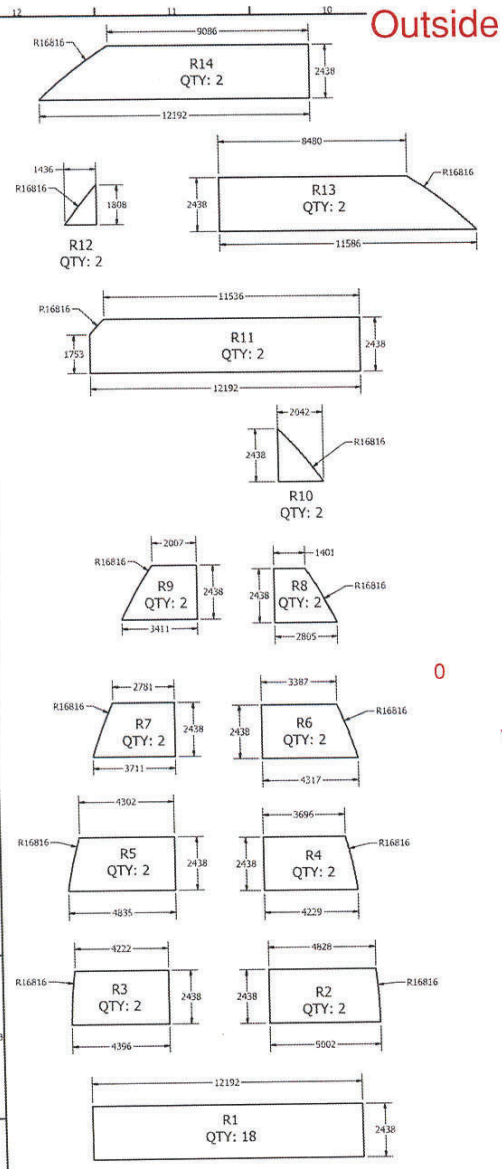


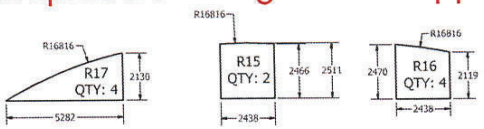
REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUED FOR REVIEW	2/18/2019
1	ISSUED FOR CONSTRUCTION	6/8/2021

DRAWN: MARC LOSIER	2/18/2021	ROOF LAYOUT
CHECKED		TITLE: BAKER LAKE WHALE TAIL PROJECT FLOOR AND ROOF LAYOUT FOR 10,000CUM TANK #8 6170TNK43
QA		
MFG		
APPROVED		SIZE: A1 · DWG NO: 341-M1 · REV: 1
		SCALE: 1 · SHEET 2 OF 2

15-Jun-2021
Permit Number: P471

Outside Compression Ring Weld Mapping

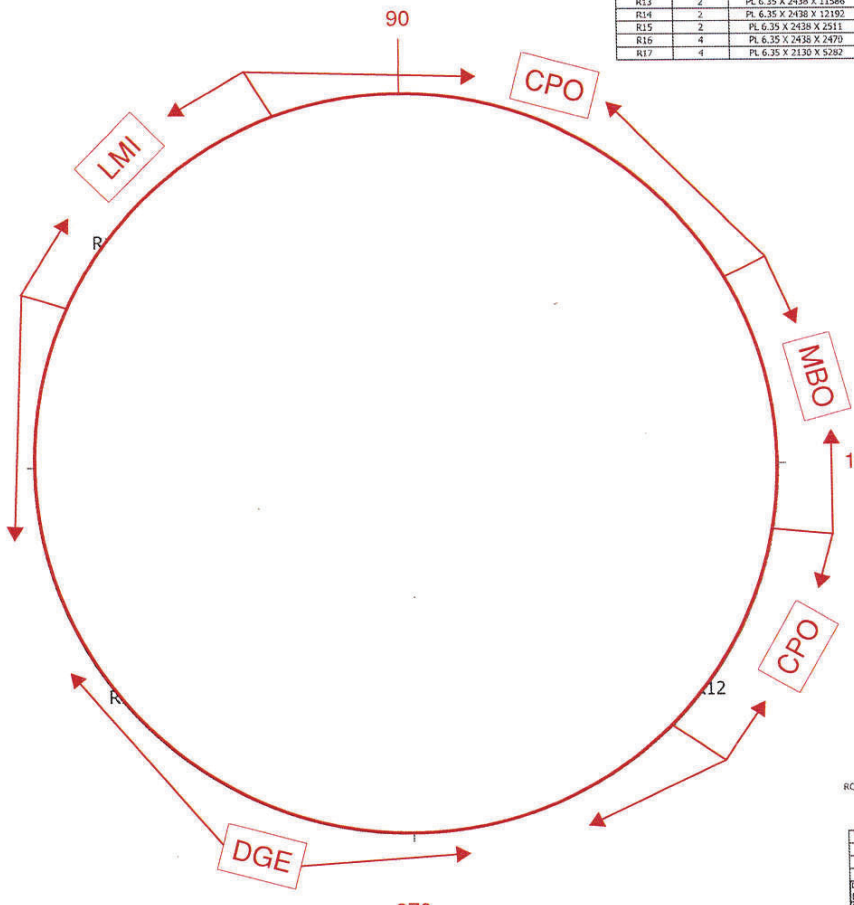


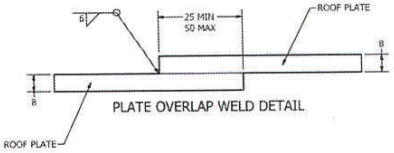


PARTS LIST

ITEM	QTY	DESCRIPTION	MATERIAL	UNIT WT (KG)	TOT WT (KG)
R1	18	PL 6.35 X 2438 X 12192	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	1481	26658
R2	2	PL 6.35 X 2438 X 5002	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	601	1202
R3	2	PL 6.35 X 2438 X 4596	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	527	1054
R4	2	PL 6.35 X 2438 X 4229	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	485	970
R5	2	PL 6.35 X 2438 X 4825	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	559	1118
R6	2	PL 6.35 X 2438 X 4317	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	473	946
R7	2	PL 6.35 X 2438 X 3711	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	398	796
R8	2	PL 6.35 X 2438 X 2805	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	261	522
R9	2	PL 6.35 X 2438 X 3411	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	334	668
R10	2	PL 6.35 X 2438 X 2042	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	132	264
R11	2	PL 6.35 X 2438 X 12192	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	1471	2942
R12	2	PL 6.35 X 1436 X 1808	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	68	136
R13	2	PL 6.35 X 2438 X 11586	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	1235	2470
R14	2	PL 6.35 X 2438 X 12192	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	1308	2616
R15	2	PL 6.35 X 2438 X 2511	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	303	606
R16	4	PL 6.35 X 2438 X 2470	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	282	1128
R17	4	PL 6.35 X 2130 X 5282	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	326	1304

TOT WT: 45,400





REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUED FOR REVIEW	2/18/2019
1	ISSUED FOR CONSTRUCTION	6/8/2021

DRAWN	MARC LOSIER	2/18/2021
CHECKED		
QA		
MFG		
APPROVED		

ROOF LAYOUT

TITLE: BAKER LAKE WHALE TAIL PROJECT FLOOR AND ROOF LAYOUT FOR 10,000CUM TANK #8 6170TNK43

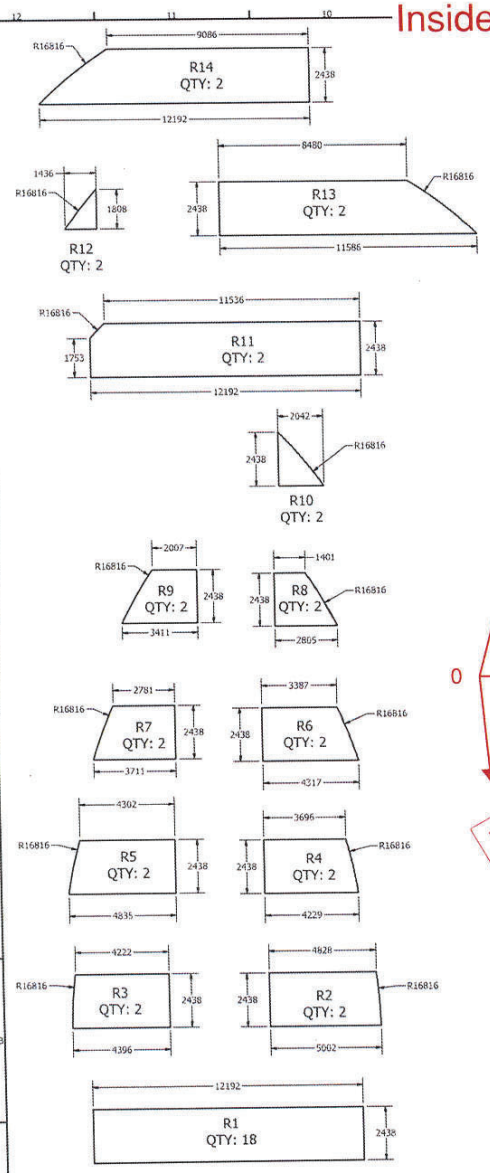
SIZE: A1 | DWG NO: 341-M1 | REV: 1

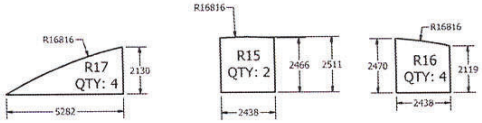
SCALE: 1 | SHEET 2 OF 2

15-Jun-2021

Permit Number: P471

Inside Compression Ring Weld Mapping





PARTS LIST					
ITEM	QTY	DESCRIPTION	MATERIAL	UNIT WT (KG)	TOT WT (KG)
R1	18	PL 6.35 X 2438 X 12192	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	1481	26658
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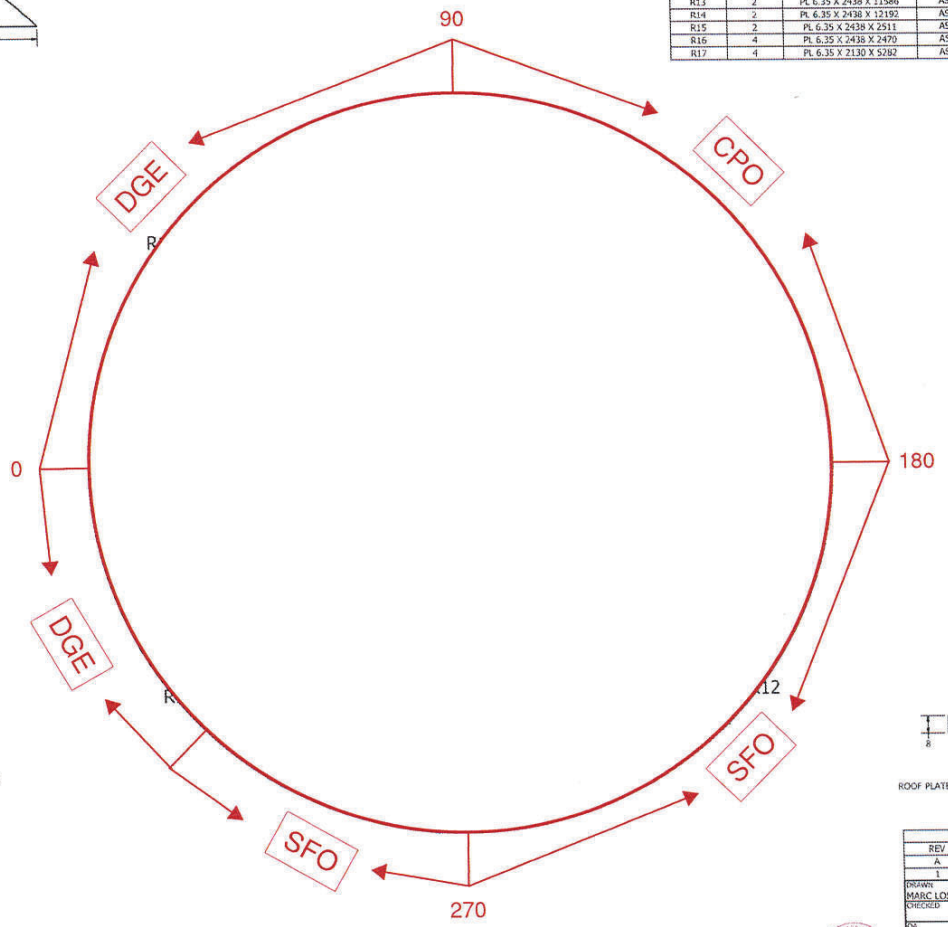
R3	2	PL 6.35 X 2438 X 4596	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	527	1054
R4	2	PL 6.35 X 2438 X 4229	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	485	970
R5	2	PL 6.35 X 2438 X 4825	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	559	1118
R6	2	PL 6.35 X 2438 X 4317	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	473	946
R7	2	PL 6.35 X 2438 X 3711	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	398	796
R8	2	PL 6.35 X 2438 X 2805	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	261	522
R9	2	PL 6.35 X 2438 X 3411	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	334	668
R10	2	PL 6.35 X 2438 X 2042	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	132	264
R11	2	PL 6.35 X 2438 X 12192	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	1471	2942
R12	2	PL 6.35 X 1436 X 1808	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	68	136
R13	2	PL 6.35 X 2438 X 11586	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	1235	2470
R14	2	PL 6.35 X 2438 X 12192	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	1308	2616
R15	2	PL 6.35 X 2438 X 2511	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	303	606
R16	4	PL 6.35 X 2438 X 2470	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	282	1128
R17	4	PL 6.35 X 2130 X 5282	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	326	1304

TOT WT: 45,400



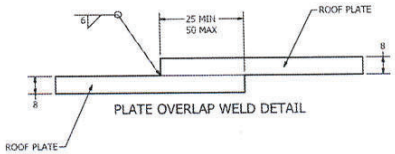


PLATE OVERLAP WELD DETAIL

REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUED FOR REVIEW	2/18/2019
1	ISSUED FOR CONSTRUCTION	6/8/2021

DRAWN: MARC LOSIER 2/18/2021
CHECKED:
QA:
MFG:
APPROVED:

TITLE: ROOF LAYOUT

BAKER LAKE WHALE TAIL PROJECT FLOOR AND ROOF LAYOUT FOR 10,000CUM TANK #8 6170TNK43

SIZE: A1 | DWG NO: 341-M1 | REV: 1

SCALE: 1 | SHEET 2 OF 2

15-Jun-2021

Permit Number: P471

QUALITY CONTROL MANUAL

VISUAL TEST REPORT

Customer: AGNICO EAGLE

Location: BAKER LAKE

Code Requiring Test: API 650 (section 8.5.2) Reason for Test: New Construction

A weld shall be acceptable by visual examination if the inspection shows the following.

a) There are no crater cracks, other surface cracks or arc strikes in or adjacent to the welded joints.
b) Maximum permissible undercut is 0.4 mm (1/64 in.) in depth for vertical butt joints, vertically oriented permanent attachments, attachment welds for nozzles, manholes, flush-type openings, and the inside shell-to-bottom welds. For horizontal butt joints, horizontally oriented permanent attachments, and annular-ring butt joints, the maximum permissible undercut is 0.8 mm (1/32 in.) in depth.
c) The frequency of surface porosity in the weld does not exceed one cluster (one or more pores) in any 100 mm (4 in.) of length, and the diameter of each cluster does not exceed 2.5 mm (3/32 in.).
d) The reinforcement of the welds on all thicknesses:

Plate Thickness mm (in.)	Maximum Reinforcement Thickness mm (in.)	
	Vertical Joints	Horizontal Joints
≤ 13 (1/2)	2.5 (3/32)	3 (1/8)
> 13 (1/2) to 25 (1)	3 (1/8)	5 (3/16)
> 25 (1)	5 (3/16)	6 (1/4)

Surface Condition (As Welded)

Test Solution: N/A Test Date(s): 2021-08- 21

Tested by: Matthew MacKenzie Ambient Conditions: 10 Degrees Celcius

Items Tested:

Compression Ring Welds.

Results:

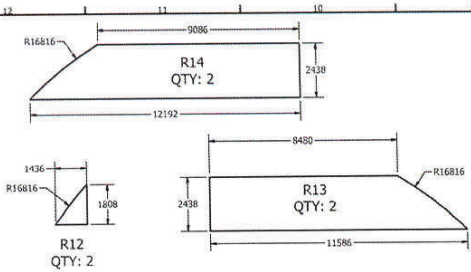
Acceptable at the time of Inspection.

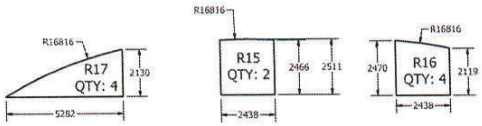
STS Representative Signature: _____ Date: 2021-08- 21

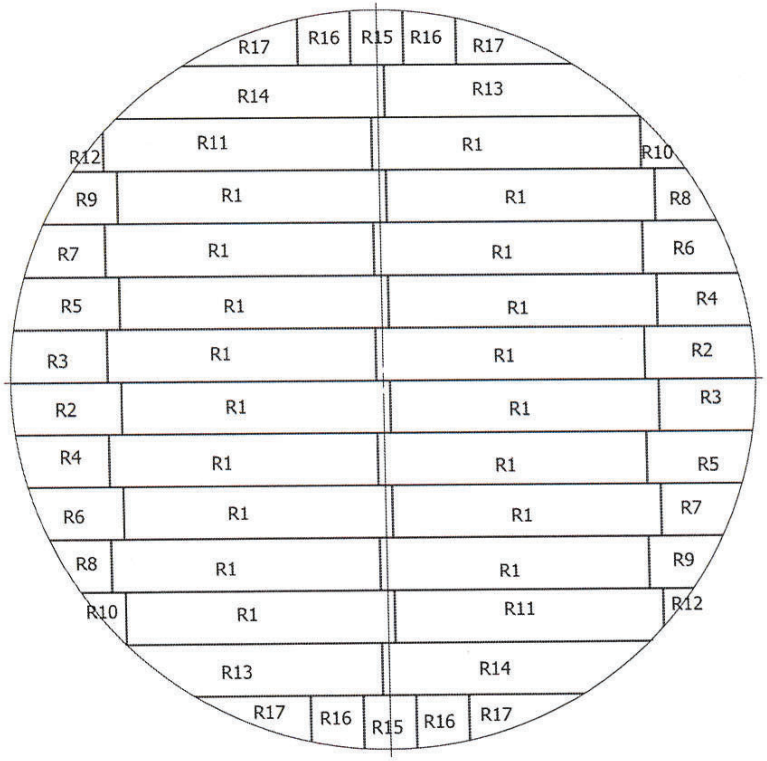
Client Representative Signature: _____ Date: 4 TH Sept 21

SECTION 12.0

Roof







ROOF LAYOUT
SCALE 1 / 100

PARTS LIST

ITEM	QTY	DESCRIPTION	MATERIAL	UNIT WT (KG)	TOT WT (KG)
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R2	2	PL 6.35 X 2438 X 5002	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	601	1202
R3	2	PL 6.35 X 2438 X 4596	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	527	1054
R4	2	PL 6.35 X 2438 X 4229	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	485	970
R5	2	PL 6.35 X 2438 X 4825	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	559	1118
R6	2	PL 6.35 X 2438 X 4317	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	473	946
R7	2	PL 6.35 X 2438 X 3711	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	398	796
R8	2	PL 6.35 X 2438 X 2805	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	261	522
R9	2	PL 6.35 X 2438 X 3411	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	334	668
R10	2	PL 6.35 X 2438 X 2042	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	132	264
R11	2	PL 6.35 X 2438 X 12192	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	1471	2942
R12	2	PL 6.35 X 1436 X 1808	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	68	136
R13	2	PL 6.35 X 2438 X 11586	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	1235	2470
R14	2	PL 6.35 X 2438 X 12192	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	1308	2616
R15	2	PL 6.35 X 2438 X 2511	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	303	606
R16	4	PL 6.35 X 2438 X 2470	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	282	1128
R17	4	PL 6.35 X 2130 X 5282	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	326	1304

TOT WT: 45,400

STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

☐ CHANGE ☒ NO CHANGE

NAME: Lindsay C Bolton
SIGNATURE:
DATE: September 6, 2021

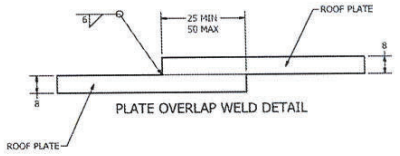
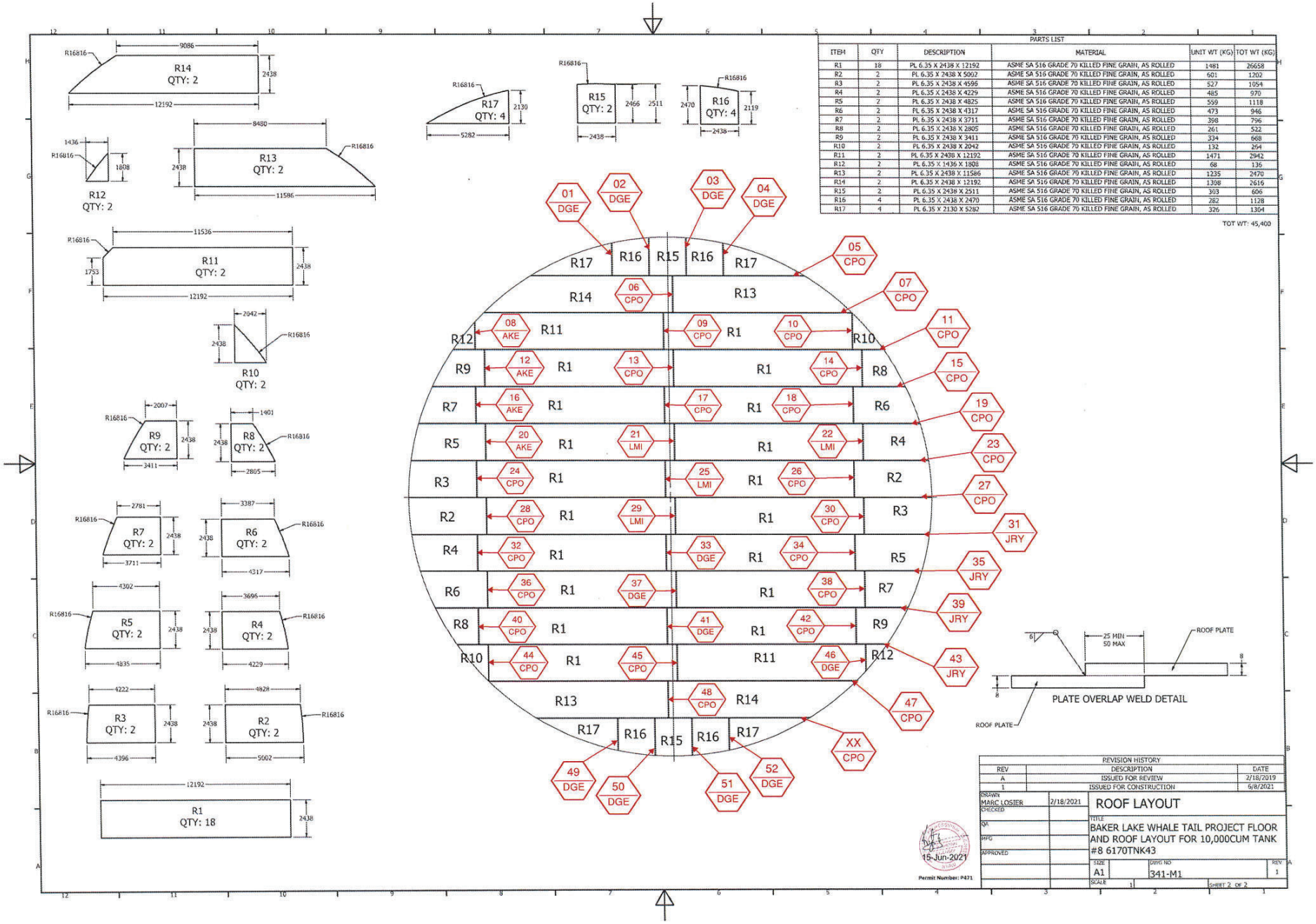


PLATE OVERLAP WELD DETAIL

15-Jun-2021
Permit Number: P471

REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUED FOR REVIEW	2/18/2019
1	ISSUED FOR CONSTRUCTION	6/8/2021

DRAWN: MARC LOSIER	2/18/2021	TITLE: ROOF LAYOUT
CHECKED		BAKER LAKE WHALE TAIL PROJECT FLOOR AND ROOF LAYOUT FOR 10,000CUM TANK #8 6170TNK43
QA		
MFG		
APPROVED		SIZE: A1 · DWG NO: 341-M1 · REV: 1
		SCALE: 1 · SHEET 2 OF 2



PARTS LIST

ITEM	QTY	DESCRIPTION	MATERIAL	UNIT WT (KG)	TOT WT (KG)
R1	18	PL 6.35 X 2438 X 12192	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	1481	26658
R2	2	PL 6.35 X 2438 X 5002	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	601	1202
R3	2	PL 6.35 X 2438 X 4596	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	527	1054
R4	2	PL 6.35 X 2438 X 4229	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	485	970
R5	2	PL 6.35 X 2438 X 4825	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	559	1118
R6	2	PL 6.35 X 2438 X 4317	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	473	946
R7	2	PL 6.35 X 2438 X 3711	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	398	796
R8	2	PL 6.35 X 2438 X 2805	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	261	522
R9	2	PL 6.35 X 2438 X 3411	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	334	668
R10	2	PL 6.35 X 2438 X 2042	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	132	264
R11	2	PL 6.35 X 2438 X 12192	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	1471	2942
R12	2	PL 6.35 X 1436 X 1808	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	68	136
R13	2	PL 6.35 X 2438 X 11586	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	1235	2470
R14	2	PL 6.35 X 2438 X 12192	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	1308	2616
R15	2	PL 6.35 X 2438 X 2511	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	303	606
R16	4	PL 6.35 X 2438 X 2470	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	282	1128
R17	4	PL 6.35 X 2130 X 5282	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	326	1304

TOT WT: 45,400

REVISION HISTORY

REV	DESCRIPTION	DATE
A	ISSUED FOR REVIEW	2/18/2019
1	ISSUED FOR CONSTRUCTION	6/8/2021

DRAWN	MARC LOSIER	2/18/2021
CHECKED		
QA		
MFG		
APPROVED		

ROOF LAYOUT

BAKER LAKE WHALE TAIL PROJECT FLOOR AND ROOF LAYOUT FOR 10,000CUM TANK #8 6170TNK43

SIZE	DWG NO	REV
A1	341-M1	1

SCALE 1 | SHEET 2 OF 2

15-Jun-2021

Permit Number: P471

QUALITY CONTROL MANUAL

VISUAL TEST REPORT

Customer: AGNICO EAGLE

Location: BAKER LAKE

Code Requiring Test: API 650 (section 8.5.2) Reason for Test: New Construction

A weld shall be acceptable by visual examination if the inspection shows the following.

a) There are no crater cracks, other surface cracks or arc strikes in or adjacent to the welded joints.
b) Maximum permissible undercut is 0.4 mm (1/64 in.) in depth for vertical butt joints, vertically oriented permanent attachments, attachment welds for nozzles, manholes, flush-type openings, and the inside shell-to-bottom welds. For horizontal butt joints, horizontally oriented permanent attachments, and annular-ring butt joints, the maximum permissible undercut is 0.8 mm (1/32 in.) in depth.
c) The frequency of surface porosity in the weld does not exceed one cluster (one or more pores) in any 100 mm (4 in.) of length, and the diameter of each cluster does not exceed 2.5 mm (3/32 in.).
d) The reinforcement of the welds on all thicknesses:

Plate Thickness mm (in.)	Maximum Reinforcement Thickness mm (in.)	
	Vertical Joints	Horizontal Joints
≤ 13 (1/2)	2.5 (3/32)	3 (1/8)
> 13 (1/2) to 25 (1)	3 (1/8)	5 (3/16)
> 25 (1)	5 (3/16)	6 (1/4)

Surface Condition (As Welded)

Test Solution: N/A Test Date(s): 2021-09-01

Tested by: Matthew MacKenzie Ambient Conditions: 10 Degrees Celsius

Items Tested:

Roof Welds.

Results:

Acceptable at the time of Inspection.

STS Representative Signature: [signature] Date: 2021-09-01

Client Representative Signature: [signature] Date: 4th Sept 21

Exhibit 15, Rev 1

VACUUM BOX TEST REPORT – ROOF PLATE WELDS

Customer: AGNICO EAGLE

Location: BAKER LAKE

Equipment Tag No.: TANK 8

Equipment Type:

Equipment Description:

Code Requiring Test: API 650 Reason for Test: New Construction

(A vacuum box/soap solution test for roof plate weld seams is required for new construction or major alterations, no visible leaks should be observed)

Test Solution: Water / Snoop

Ambient Conditions: 10 Degrees Celsius

Test Date(s): 2021-09-01

Surface Condition: Clean

Tested by: NICK/BODE

Surface Test Temperature: 10 Degrees Celsius

Pressure Gauge:

Items Tested:

ROOF PLATES WELDS

Results:

NO LEAK DETECTED

Acceptable at time of Inspection.

STS Representative Signature: [signature] Date: 2021-09-01

Client Representative Signature: [signature] Date: 4th Sept 21

SECTION 13.0

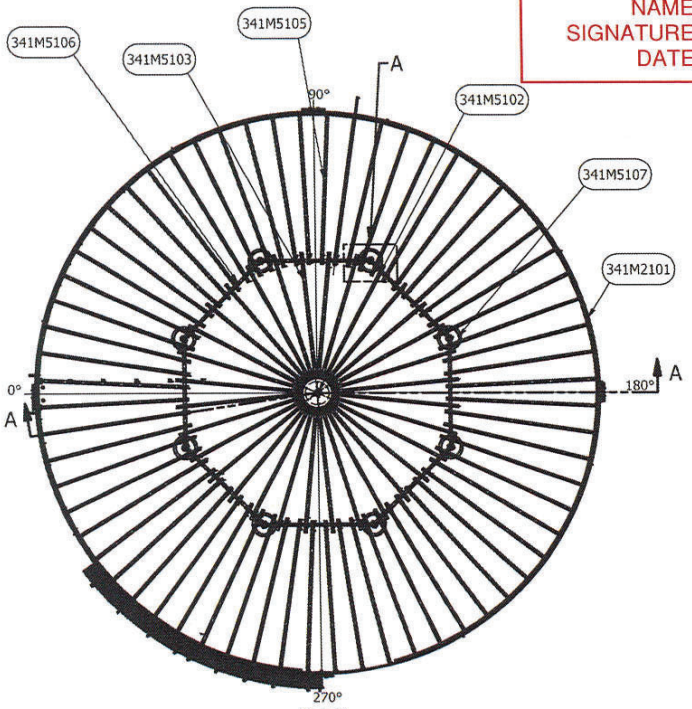
Roof Structure

STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

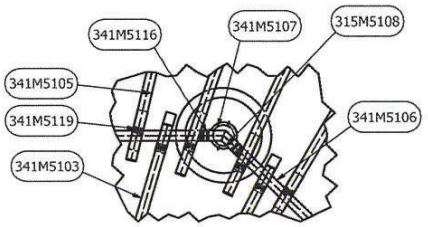
☐ CHANGE ☒ NO CHANGE

NAME: Lindsay C Bolton
SIGNATURE: LCB
DATE: September 6, 2021

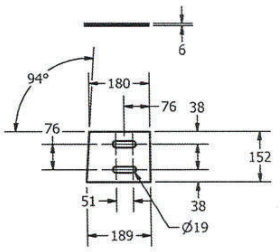
PARTS LIST				
ITEM	QTY	DESCRIPTION	MATERIAL	MASS
341M2101	10	RIM ANGLE 76X76X10 [3"X3"X3/8"] SEE DRG 315-M2	G40.21-300W	125 kg
341M5102	1	CENTRE COLUMN, SEE SHT 5		2741 kg
341M5103	32	INNER RAFTER W250X33 [W10"X22] SEE SHT 2	G40.21-350W	248 kg
341M5104	64	SHELL CLIP, PLATE 6 THK 152 X 189, SEE DETAIL	G40.21-300W	1 kg
341M5105	64	OUTER RAFTER W250X33 [W10"X22] SEE SHT 2	G40.21-350W	295 kg
341M5106	8	INTERMEDIATE GIRDER ASSEMBLY SEE SHT 4		570 kg
341M5107	8	INTERMEDIATE COLUMN ASSEMBLY SEE SHT 6		1285 kg
341M5108	8	GIRDER CONNECTION PLATE 13 [1/2"] THK 279 X 688 SEE DETAIL	G40.21-300W	10 kg
341M5116	128	BOLT, HEAVY HEX, 5/8" X 2.5" LG	A325	0 kg
341M5117	512	NUT, HEAVY HEX, 5/8" UNC	A325	0 kg
341M5118	1024	WASHER, PLAIN, TYPE A, 5/8"	A325	0 kg
341M5119	320	BOLT, HEAVY HEX, 5/8" X 2." LG	A325	0 kg
341M5120	64	BOLT, HEAVY HEX, 5/8" X 3" LG	A325	0 kg



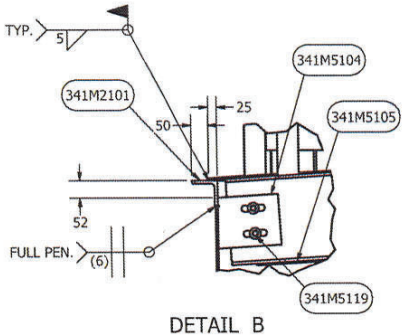
PLAN
SCALE 1/200



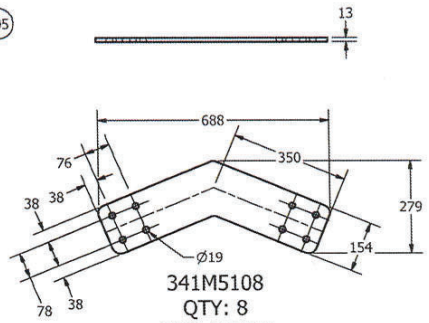
DETAIL A
SCALE 1/50



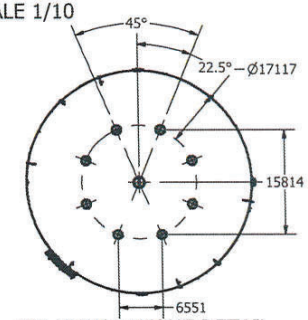
341M5104
SHELL CLIP
QTY: 64
SCALE 1/10



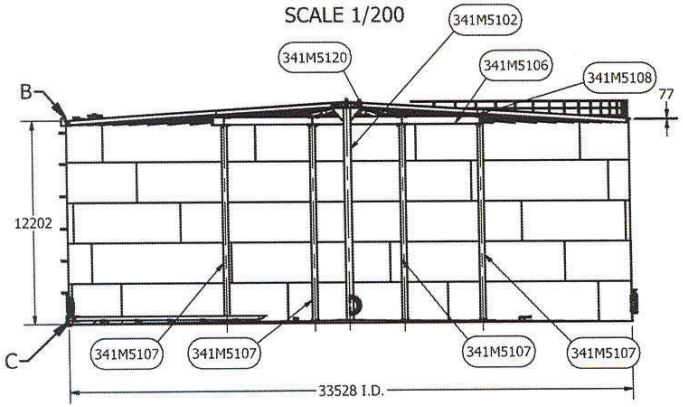
DETAIL B
SCALE 1/10



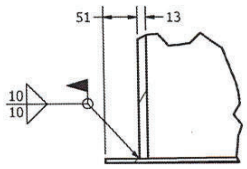
341M5108
QTY: 8
SCALE 1/10



COLUMNS LAYOUT DETAIL
SCALE 1/500



SECTION A-A
SCALE 1/200

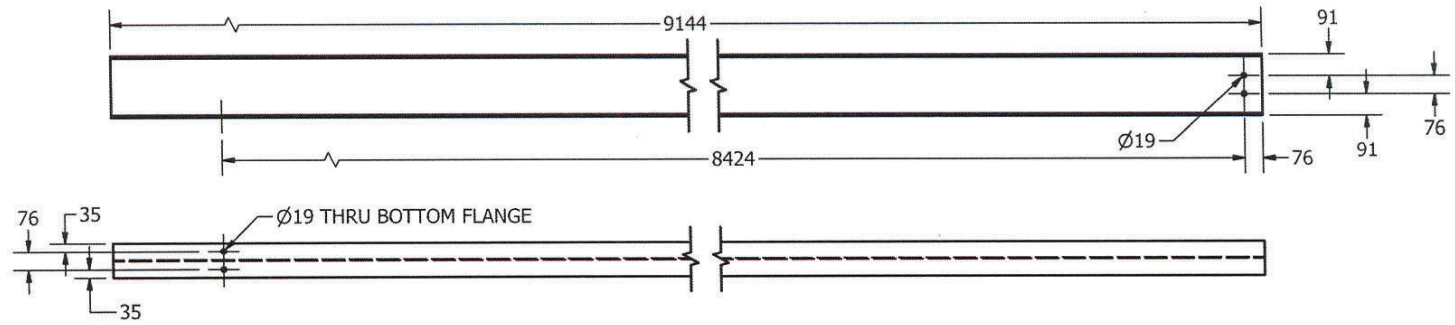


DETAIL C
SCALE 1/5

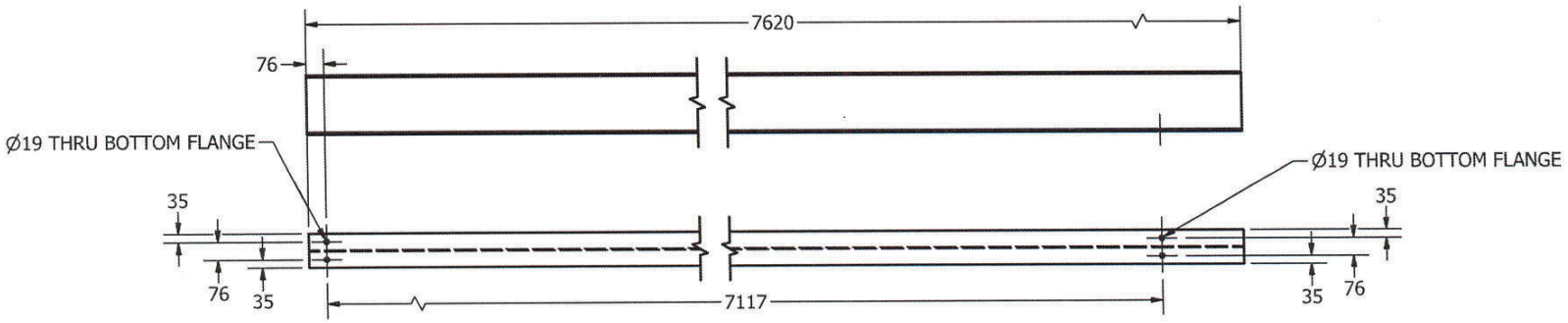
REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUED FOR REVIEW	3/9/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

DRAWN MARC LOSIER	3/8/2021	ROOF STRUCTURE LAYOUT
CHECKED KYLE BROWN	3/7/2019	TITLE
QA		BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43 - ROOF STRUCTURE
MFG		
APPROVED		SIZE A2 / DWG NO 341-M5 / REV 1
		SCALE 1/200 / SHEET 1 OF 6

PROFESSIONAL ENGINEERS — KYLE BROWN — LICENSEE — NT/NU
15-Jun-2021
Permit Number: P471



OUTER RAFTER
QTY: 64
SCALE 1/20



INNER RAFTER
QTY: 32
SCALE 1/20

STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

☐ CHANGE ☒ NO CHANGE

NAME: Lindsay C Bolton
SIGNATURE:
DATE: September 6, 2021

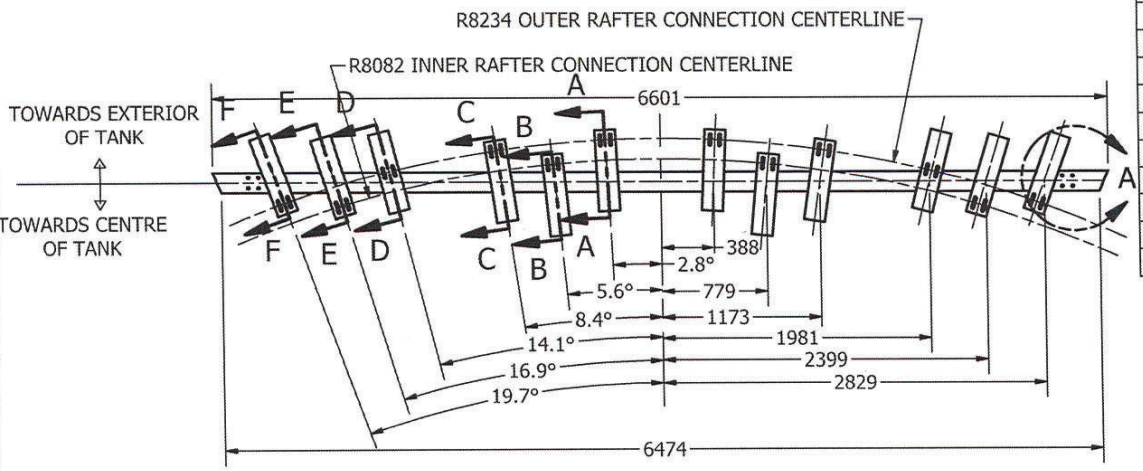
Permit Number: P471

REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUED FOR REVIEW	3/9/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

DRAWN MARC LOSIER	3/8/2021	RAFTER DETAILS
CHECKED KYLE BROWN	3/7/2019	
QA		TITLE
MFG		BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43 - ROOF STRUCTURE
APPROVED		

SIZE	DWG NO	REV
A3	341-M5	1

SCALE 1/20 SHEET 2 OF 6



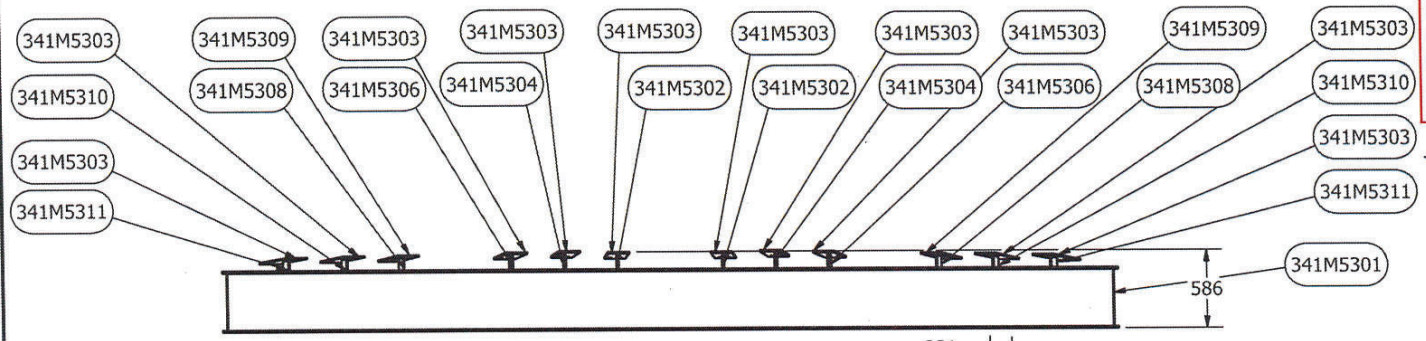
PARTS LIST				
ITEM	QTY	DESCRIPTION	MATERIAL	MASS
341M5301	1	W460X68 [W18x46]	A572 50/50W	443 kg
341M5302	2	10X108X125 SEE DET SHT 4	G40.21-300W	1 kg
341M5303	10	10X154X610 SEE DET SHT 4	G40.21-300W	7 kg
341M5304	2	10X106X125 SEE DET SHT 4	G40.21-300W	1 kg
341M5306	2	10X103X125 SEE DET SHT 4	G40.21-300W	1 kg
341M5308	2	10X94X125 SEE DET SHT 4	G40.21-300W	1 kg
341M5309	2	10X154x610 SEE DET SHT 4	G40.21-300W	7 kg
341M5310	2	10X87X125 SEE DET SHT 4	G40.21-300W	1 kg
341M5311	2	10X78X125 SEE DET SHT 4	G40.21-300W	1 kg

MATERIAL FOR ONE (1) SHOWN, EIGHT (8) REQUIRED PER TANK
WEIGHT PER ASSEMBLY:535 KG

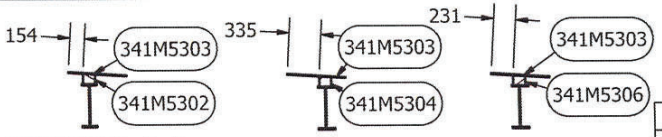
STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

☐ CHANGE ☒ NO CHANGE

NAME: Lindsay C Bolton
SIGNATURE:
DATE: September 6, 2021



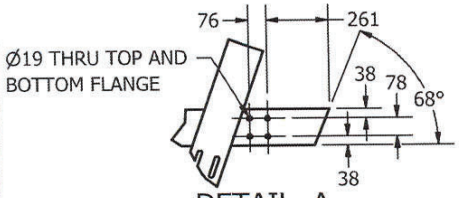
Permit Number: P471



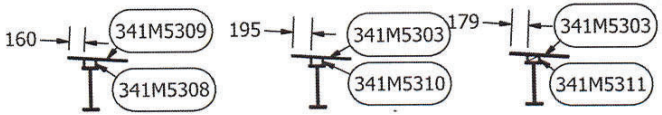
SECTION A-A SCALE 1/50

SECTION B-B SCALE 1/50

SECTION C-C SCALE 1/50



DETAIL A SCALE 1/20



SECTION D-D SCALE 1/50

SECTION E-E SCALE 1/50

SECTION F-F SCALE 1/50

REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUED FOR REVIEW	3/9/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

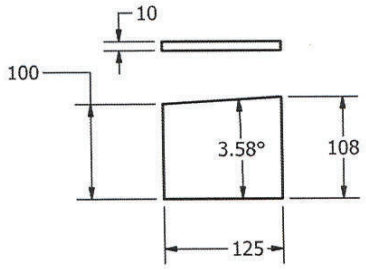
DRAWN	MARC LOSIER	3/8/2021
CHECKED	KYLE BROWN	3/7/2019
QA		
MFG		
APPROVED		

INTERMEDIATE GIRDER DETAIL

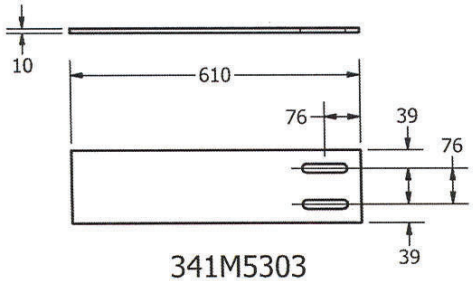
TITLE
BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43 - ROOF STRUCTURE

SIZE	DWG NO	REV
A3	341-M5	1

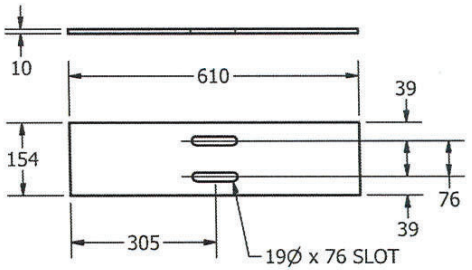
SCALE 1/35 SHEET 3 OF 6



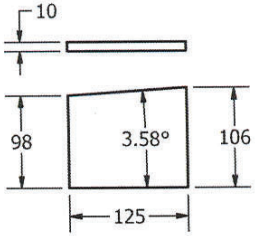
ITEM 341M5302
QTY: 2
SCALE 1/5



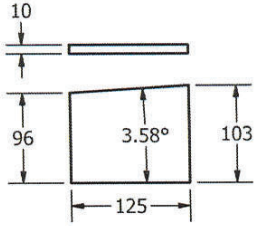
341M5303
QTY: 10
SCALE 1/10



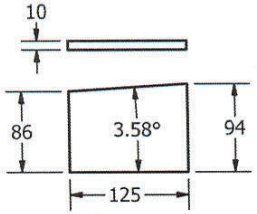
341M5309
QTY: 2
SCALE 1/10



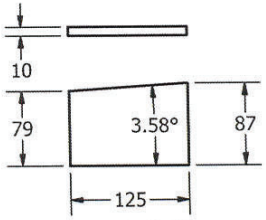
341M5304
QTY: 2
SCALE 1/5



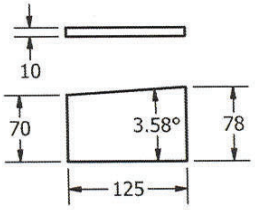
341M5306
QTY: 2
SCALE 1/5



341M5308
QTY: 2
SCALE 1/5



341M5310
QTY: 2
SCALE 1/5



341M5311
QTY: 2
SCALE 1/5

STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

☐ CHANGE ☒ NO CHANGE

NAME: Lindsay C Bolton
SIGNATURE: LCB
DATE: September 6, 2021

Permit Number: P471

REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUED FOR REVIEW	3/9/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

DRAWN MARC LOSIER	3/8/2021	INTERMEDIATE GIRDER DETAIL
CHECKED KYLE BROWN	3/7/2019	
QA		TITLE: BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43 - ROOF STRUCTURE
MFG		
APPROVED		

SIZE	DWG NO	REV
A3	341-M5	1

SCALE 1/5 SHEET 4 OF 6

STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

☐ CHANGE ☒ NO CHANGE

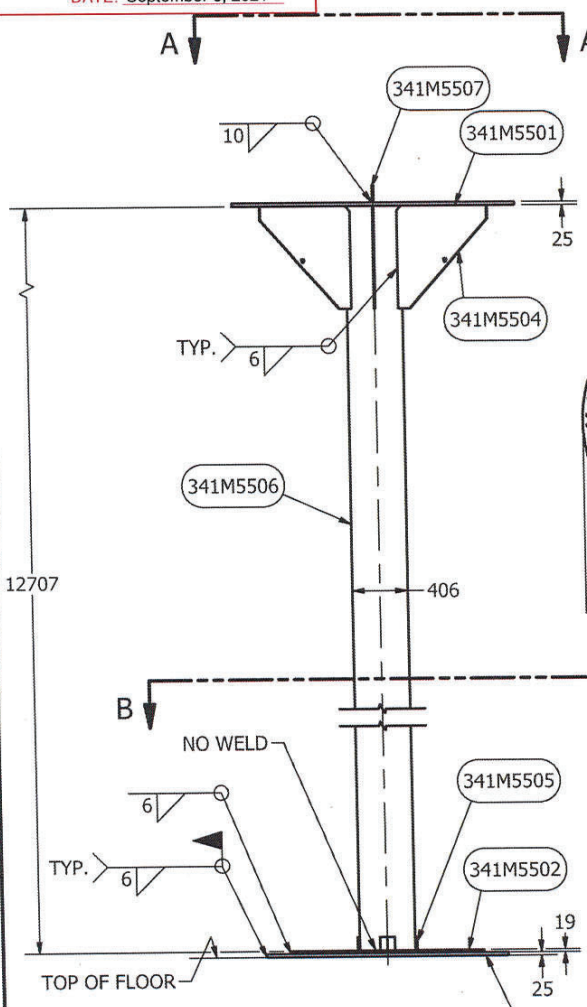
NAME: Lindsay C Bolton
SIGNATURE:
DATE: September 6, 2021

APEGGN PROFESSIONAL ENGINEER KYLE BROWN LICENSEE NT/NU
15-Jun-2021

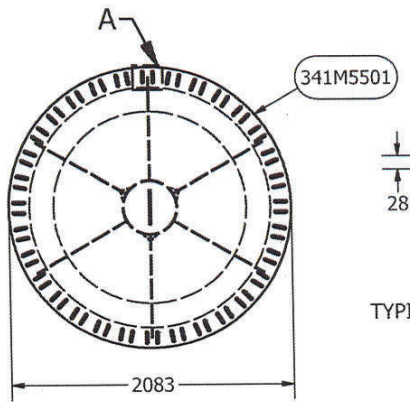
Permit Number: P471

PARTS LIST				
MARK	QTY	DESCRIPTION	MATERIAL	MASS
341M5501	1	PLATE 25 [1"] THK X 2083 OD	G40.21-300W	657 kg
341M5502	1	PLATE 19 [3/4"] X 1422 OD	G40.21-300W	238 kg
341M5503	1	PLATE 25 [1"] THK X 1778 OD	G40.21-300W	495 kg
341M5504	6	PLATE 10 [3/8"] THK X 762 X 762	G40.21-300W	27 kg
341M5505	3	ANGLE 76X76X6 [3"X3"X1/4"] x 102 lg	G40.21-300W	1 kg
341M5506	1	PIPE 406 [16"] OD X 10 [0.375"] WALL X 12700 LG	A-500	1185 kg
341M5507	1	PLATE 13 [1/2"] THK X 127 X 254	G40.21-300W	2 kg

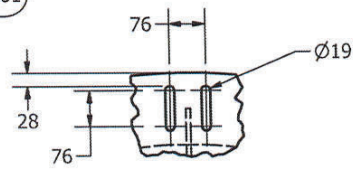
TOTAL WEIGHT PER ASSEMBLY: 2325KG



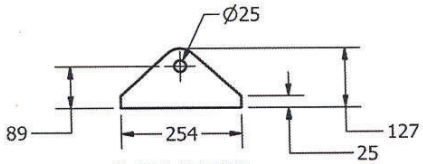
ELEVATION VIEW
CENTRE COLUMN
SCALE 1/35



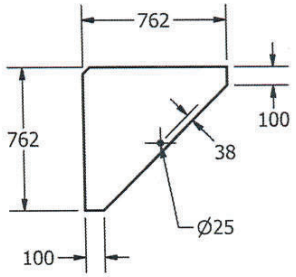
VIEW A-A



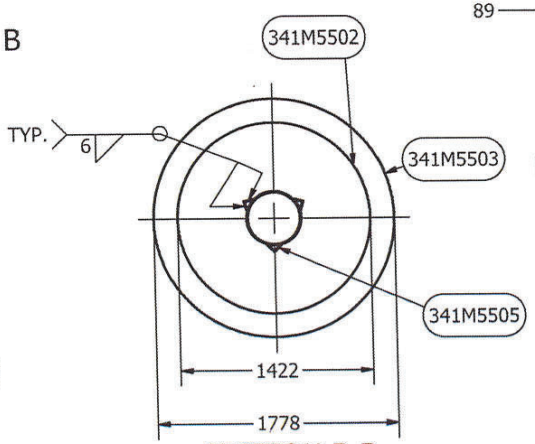
DETAIL A
TYPICAL (32) LOCATIONS EQUALLY SPACED



341M5507
SCALE 1/10



341M5504
QTY: 6
SCALE 1/25



SECTION B-B

REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUED FOR REVIEW	6/7/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

DRAWN MARC LOSIER	3/8/2021	CENTRE COLUMN
CHECKED KYLE BROWN	3/7/2019	
QA		TITLE: BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43 - ROOF STRUCTURE
MFG		
APPROVED		

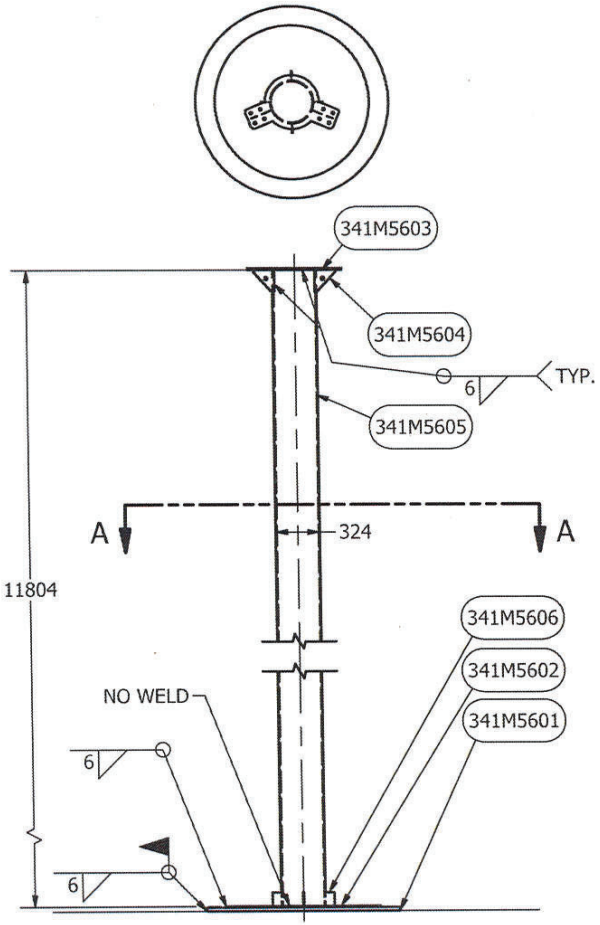
SIZE A3 | DWG NO 341-M5 | REV 1
SCALE 1/35 | SHEET 5 OF 6

PARTS LIST				
ITEM	QTY	DESCRIPTION	MATERIAL	MASS
341M5601	1	PLATE 25 [1"] X 1422 DIA	G40.21-300W	317 kg
341M5602	1	PLATE 10 [3/8"] X 1138 DIA	G40.21-300W	76 kg
341M5603	1	PLATE 13 [1/2"] THK X 395 X 687	G40.21-300W	17 kg
341M5604	2	PLATE 6 [1/4"] THK X 164 X 164	G40.21-300W	1 kg
341M5605	1	PIPE 324 [12.75"] OD X 10 [.375"] WALL X 11804	A-500	872 kg
341M5606	4	PLATE 6 [1/4"] THK X 76 X 102	G40.21-300W	0 kg

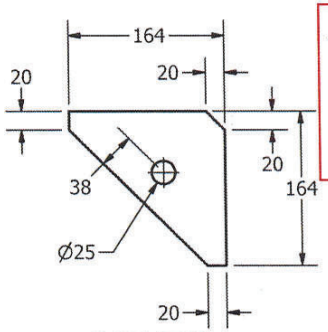
MATERIAL FOR ONE (1) SHOWN, EIGHT (8) REQUIRED PER TANK
WT PER ASSEMBLY: 1057KG

APEGGA PROFESSIONAL ENGINEER
K. BROWN
LICENSEE
15-Jun-2021
NT/NU
Permit Number: P471

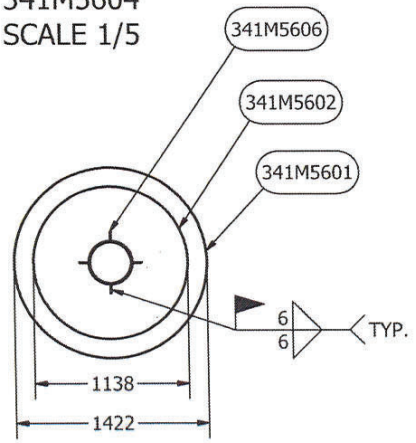
STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**
☐ CHANGE ☒ NO CHANGE
NAME: Lindsay C Bolton
SIGNATURE:
DATE: September 6, 2021



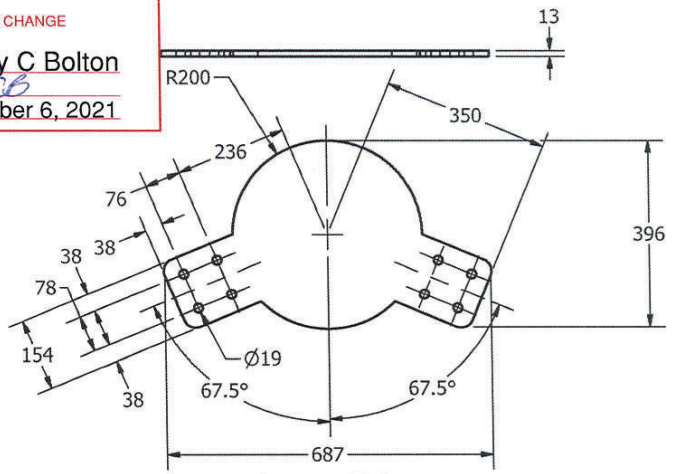
ELEVATION VIEW
INTERMEDIATE COLUMN
QTY: 8
SCALE 1/35



341M5604
SCALE 1/5



SECTION A-A
SCALE 1/35



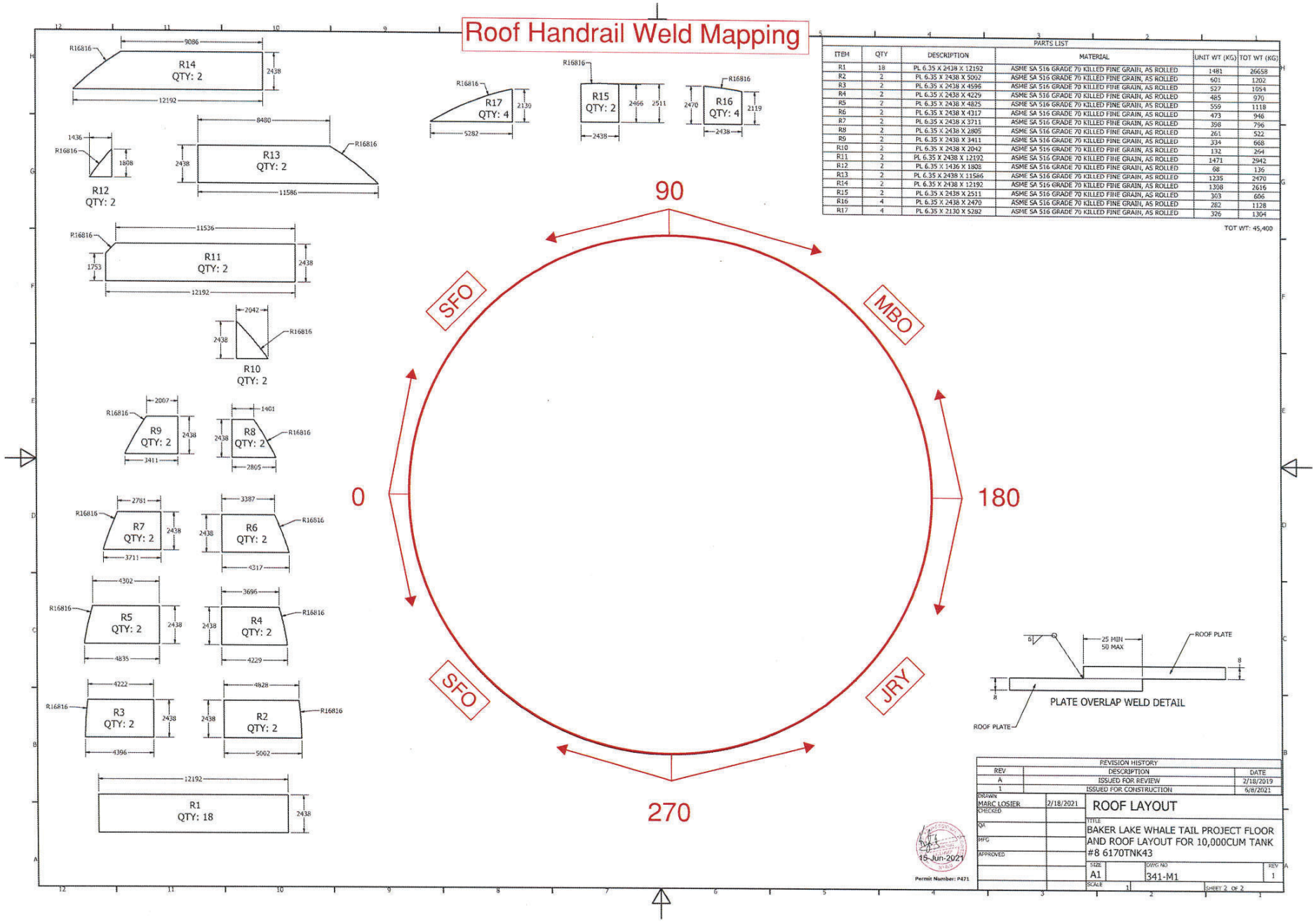
341M5603
SCALE 1/10

REVISION HISTORY		
REV	DESCRIPTION	DATE
A	Issued for Review	6/7/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

DRAWN MARC LOSIER	3/8/2021	INTERMEDIATE COLUMN
CHECKED KYLE BROWN	3/7/2019	
QA		TITLE: BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43 - ROOF STRUCTURE
MFG		
APPROVED		

SIZE A3 | DWG NO 341-M5 | REV 1
SCALE 1/35 | SHEET 6 OF 6

Roof Handrail Weld Mapping



PARTS LIST

ITEM	QTY	DESCRIPTION	MATERIAL	UNIT WT (KG)	TOT WT (KG)
R1	18	PL 6.35 X 2438 X 12192	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	1481	26658
R2	2	PL 6.35 X 2438 X 5002	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	601	1202
R3	2	PL 6.35 X 2438 X 4596	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	527	1054
R4	2	PL 6.35 X 2438 X 4229	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	485	970
R5	2	PL 6.35 X 2438 X 4825	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	559	1118
R6	2	PL 6.35 X 2438 X 4317	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	473	946
R7	2	PL 6.35 X 2438 X 3711	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	398	796
R8	2	PL 6.35 X 2438 X 2805	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	261	522
R9	2	PL 6.35 X 2438 X 3411	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	334	668
R10	2	PL 6.35 X 2438 X 2042	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	132	264
R11	2	PL 6.35 X 2438 X 12192	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	1471	2942
R12	2	PL 6.35 X 1436 X 1808	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	68	136
R13	2	PL 6.35 X 2438 X 11586	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	1235	2470
R14	2	PL 6.35 X 2438 X 12192	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	1308	2616
R15	2	PL 6.35 X 2438 X 2511	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	303	606
R16	4	PL 6.35 X 2438 X 2470	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	282	1128
R17	4	PL 6.35 X 2130 X 5282	ASME SA 516 GRADE 70 KILLED FINE GRAIN, AS ROLLED	326	1304

TOT WT: 45,400

REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUED FOR REVIEW	2/18/2019
1	ISSUED FOR CONSTRUCTION	6/8/2021

DRAWN	MARC LOSIER	2/18/2021
CHECKED		
QA		
MFG		
APPROVED		

TITLE: ROOF LAYOUT

BAKER LAKE WHALE TAIL PROJECT FLOOR AND ROOF LAYOUT FOR 10,000CUM TANK #8 6170TNK43

SIZE: A1 | DWG NO: 341-M1 | REV: 1 | SCALE: 1 | SHEET 2 OF 2

15-Jun-2021

Permit Number: P471

QUALITY CONTROL MANUAL

VISUAL TEST REPORT

Customer: AGNICO EAGLE

Location: BAKER LAKE

Code Requiring Test: API 650 (section 8.5.2) Reason for Test: New Construction

A weld shall be acceptable by visual examination if the inspection shows the following.

a) There are no crater cracks, other surface cracks or arc strikes in or adjacent to the welded joints.
b) Maximum permissible undercut is 0.4 mm (1/64 in.) in depth for vertical butt joints, vertically oriented permanent attachments, attachment welds for nozzles, manholes, flush-type openings, and the inside shell-to-bottom welds. For horizontal butt joints, horizontally oriented permanent attachments, and annular-ring butt joints, the maximum permissible undercut is 0.8 mm (1/32 in.) in depth.
c) The frequency of surface porosity in the weld does not exceed one cluster (one or more pores) in any 100 mm (4 in.) of length, and the diameter of each cluster does not exceed 2.5 mm (3/32 in.).
d) The reinforcement of the welds on all thicknesses:

Plate Thickness mm (in.)	Maximum Reinforcement Thickness mm (in.)	
	Vertical Joints	Horizontal Joints
≤ 13 (1/2)	2.5 (3/32)	3 (1/8)
> 13 (1/2) to 25 (1)	3 (1/8)	5 (3/16)
> 25 (1)	5 (3/16)	6 (1/4)

Surface Condition (As Welded)

Test Solution: N/A Test Date(s): 2021-08-31

Tested by: Matthew MacKenzie Ambient Conditions: 10 Degrees Celcius

Items Tested:

RAFTER CLIPS / COLUMN BRACES / COLUMN STOPPERS.

Results:

ALL WELDING ACCEPTABLE AT TIME OF INSPECTION.

STS Representative Signature: Matthew MacKenzie Date: 2021-08-31

Client Representative Signature: Date: 4TH SEPT 21

Exhibit 19, Rev 1

DIMENSIONAL CHECK REPORT – PLUMBNESS

Customer: AGNICO EAGLE

Location: BAKER LAKE

Equipment Tag No.: TK 8

Equipment Type: Above Ground Storage Tank

Equipment Description: Diesel Storage Tank

Code Requiring Test: API 650 Reason for Test: New Construction

(The tank shell will be checked for plumb at 12" below the tank roof. Plumb measurements will be checked at 45 degree intervals or less, max. 20' spacing)

Test Date(s): 2021-08-31

Tested by: Matthew MacKenzie

Test Results:

The Maximum out of plumbness of the **columns** does not exceed 1/200 of the total height

Acceptable at time of Inspection.

STS Representative Signature: Matthew MacKenzie Date: 2021-08-31

Client Representative Signature: [signature] Date: 4 Sept 21

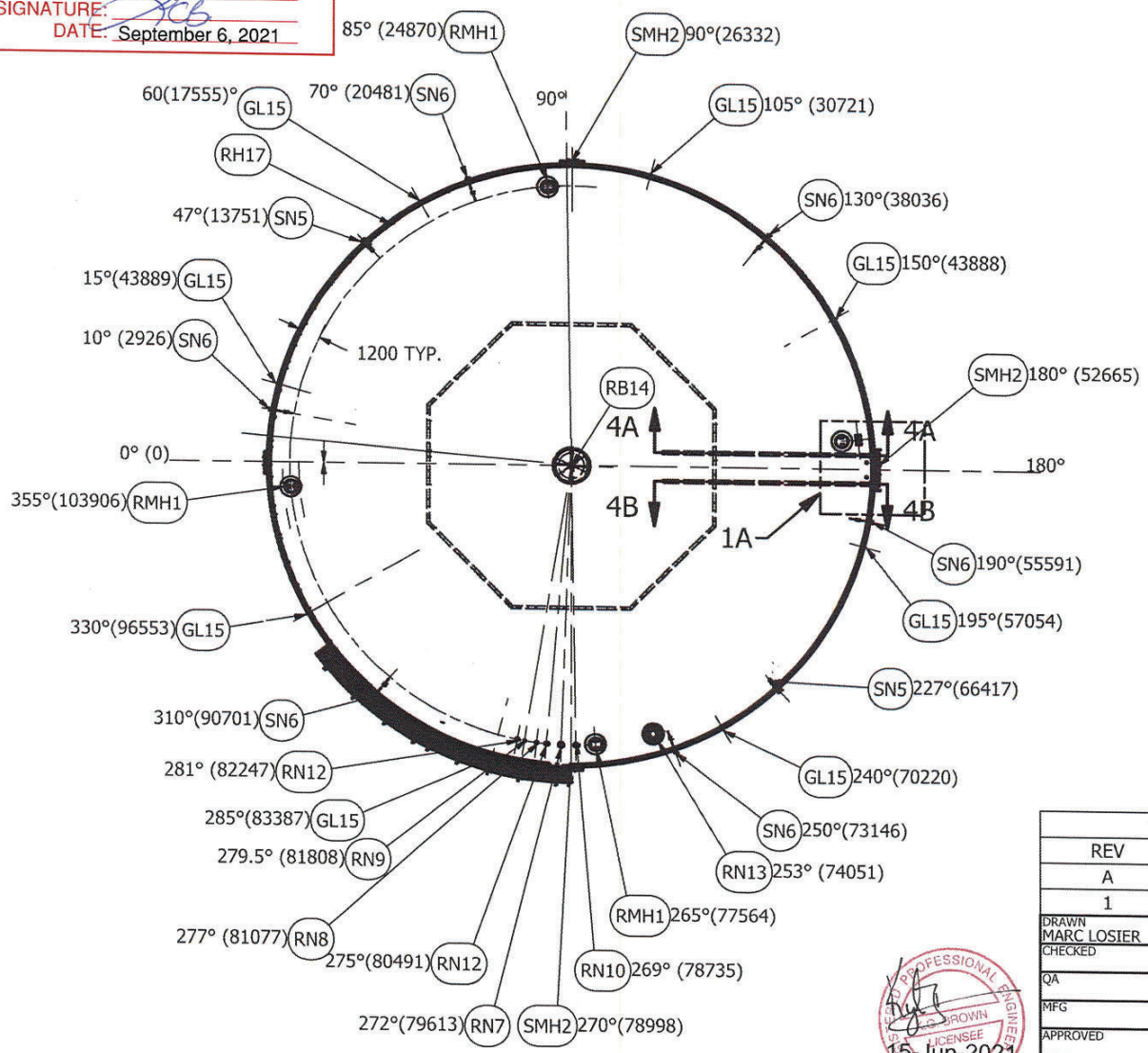
SECTION 14.0

Nozzles

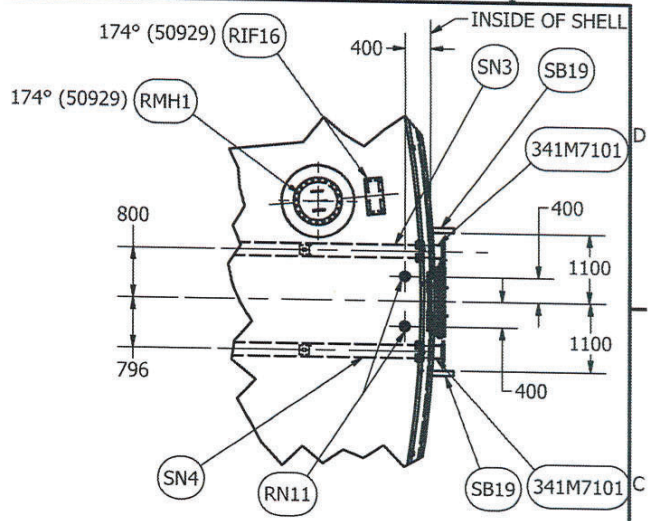
STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

☐ CHANGE ☒ NO CHANGE

NAME: Lindsay C Bolton
SIGNATURE:
DATE: September 6, 2021



PLAN VIEW



DETAIL 1A
SCALE 1/75

DIMENSION IN () DENOTES
ARC LENGTH ON THE EXTERIOR OF
THE SHELL FROM 0° IN MILLIMETRES
MEASURED ON COURSE ONE (1) FOR SHELL NOZZLES
AND ON COURSE FIVE (5) FOR ROOF NOZZLES

REGISTERED PROFESSIONAL ENGINEER
J. S. BROWN
LICENSEE
NT/NU
15-Jun-2021

Permit Number: P471

REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUE FOR REVIEW	6/1/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

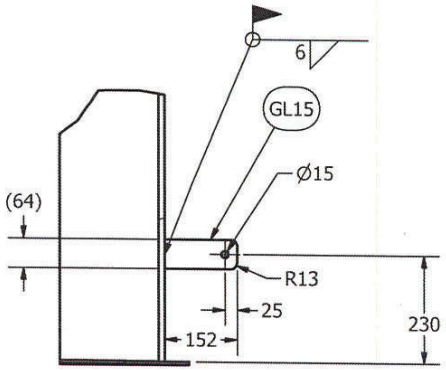
DRAWN MARC LOSIER	5/31/2021	GENERAL ARRANGEMENT AND NOZZLE LAYOUT
CHECKED		
QA		TITLE
MFG		BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43 33.516M I.D.
APPROVED		

SIZE	DWG NO	REV
A3	341-M6	1

SCALE 1/250 SHEET 1 OF 6

PARTS LIST

ITEM	QTY	DIA	DESCRIPTION
RN7	1	200	GAUGE HATCH SHAND & JURS MODEL 95021-030201 -SEE DRG 341-M7 SHT 8 & DETAIL 6C FOR NOZZLE DETAIL
RN8	1	75	OVERFILL PROTECTION - SEE DRG 341-M7 SHT 9 FOR NOZZLE DETAIL
RN9	1	50	TEMPERATURE & WATER DETECTION PROBE - SEE DRG 341-M7 SHT 10 FOR NOZZLE DETAIL
SN3	1	200	FIXED PIPE - TANK LOADING 11.5M LG -SEE DRG 341-M7 SHT 3 & PART SECTION 4A-4A FOR NOZZLE DETAIL
SN4	1	200	FIXED PIPE - TANK UNLOADING 11.5M LG -SEE DRG 341-M7 SHT 4 & PART SECTION 4B-4B FOR NOZZLE DETAIL
SN5	2	150	PUMPING LOW SUCTION -SEE DRG 341-M7 SHT 6 & DETAIL 4A FOR NOZZLE DETAIL
SN6	6	75	WATER DRAW-OFF -SEE DRG 341-M7 SHT 7 & DETAIL 4B FOR NOZZLE DETAIL
GL15	8	-	GROUNDING LUG - FB6 X 65 X 152LG 316SS - SEE DETAIL 2A
RB14	1	100	PAINTER SCAFFOLD CABLE SUPPORT -SEE DRG 341-M7 SHT 5 FOR NOZZLE DETAIL
RH17	1	-	ROOF GUARDRAIL & HANDRAIL - SEE DRG 341-M8
RMH1	4	600	ROOF MANHOLE - SEE DRG 341-M4 SHT 2
RN10	1	150	RADAR - LEVEL DETECTION - SEE DRG 341-M7 SHT 11 & DETAIL 6B
RN11	2	50	ROOF PRESSURE RELIEF LINE CONNECTION SEE DRG 315-M7 FOR NOZZLE DETAIL
RN12	2	100	SPARE -SEE DRG 341-M7 SHT 12 & DETAIL 6B FOR NOZZLE DETAIL
RN13	1	600	FREE VENT, ALUMINUM HOOD, 125# F.F. FLANGE SHAND & JURS MODEL 94241-14-00 - SEE DRG 341-M7 SHT 13 FOR NOZZLE DETAIL
SB19	12		L75X75X6 X 400LG BRACKET FOR PRV PIPING
SMH2	4	900	SHELL MANHOLE - SEE DRG 341-M4 SHT 1
RIF16	1	-	ROOF INSPECTION FRAME SEE DETAIL 6D
341M301	1	900/200	SHELL REPAD AT 180 DEG - SEE DRG 341-M3
341M302	3	900	REPAD FOR SHELL MANHOLES AT 0DEG, 90DEG, 270DEG - SEE DRG 341-M3
341M303	2	150	REPAD FOR LOWPUMPING SUCTION SEE DRG. 341-M3
RMH1	4	600	REPAD FOR ROOF MANHOLE - SEE DRG 341-M3
341M306	6	80	REPAD FOR N6 WATER DRAWOFFF VALVE SEE DRG 341-M3
341M1100	4	900	SHELL MANHOLE DAVIT SEE DRG 341-M11
341M6401	16		PIPE SUPPORT - SEE SHEET 5
341M7102	2	150	PUMPING LOW LEVEL -SEE DRG 341-M7 FOR NOZZLE DETAIL
341M7101	2	200	DOUBLE FLANGE NOZZLES - SEE DRG 341-M7 FOR NOZZLE DETAIL



DETAIL 2A
GROUNDING LUG
SCALE 1/10

STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

☐ CHANGE ☒ NO CHANGE

NAME: Lindsay C Bolton
SIGNATURE: LCB
DATE: September 6, 2021

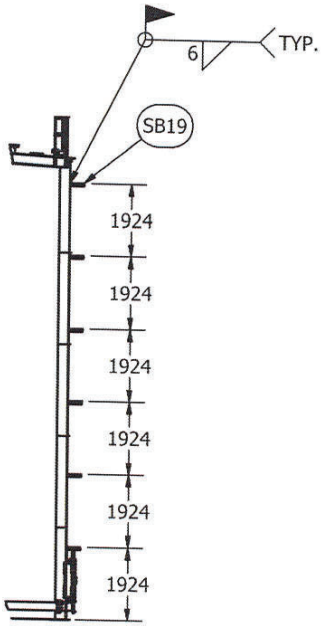
REVISION HISTORY

REV	DESCRIPTION	DATE
A	ISSUED FOR REVIEW	6/1/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

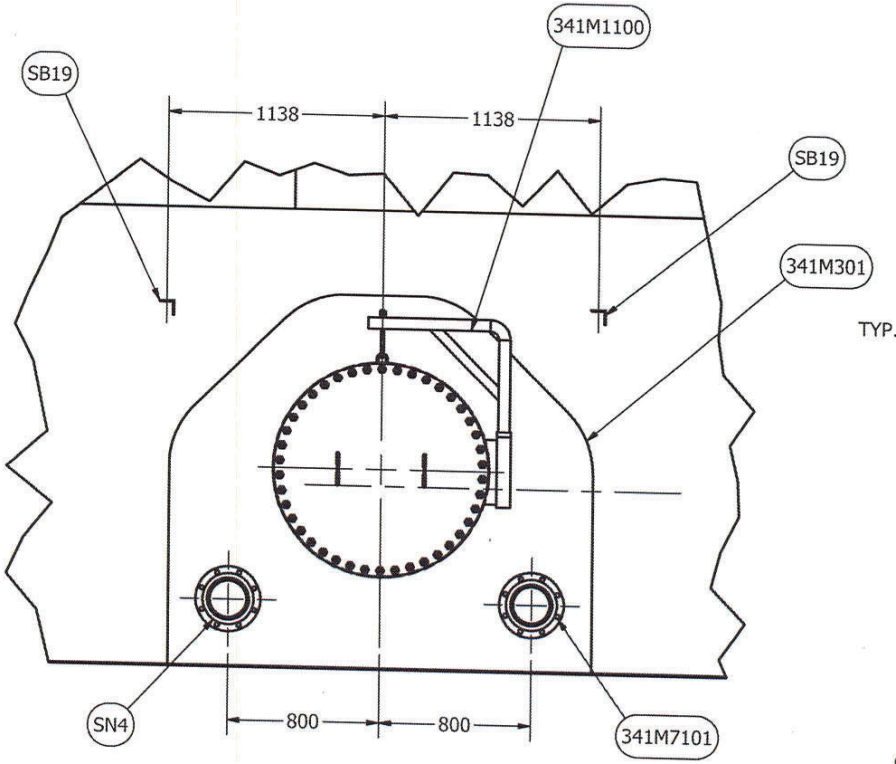
DRAWN MARC LOSIER	5/31/2021	GENERAL ARRANGEMENT AND NOZZLE LAYOUT
CHECKED		
QA		TITLE
MFG		BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43 33.516M I.D.
APPROVED		

SIZE		DWG NO	REV
A3		341-M6	1
SCALE 1/500		SHEET 2 OF 6	

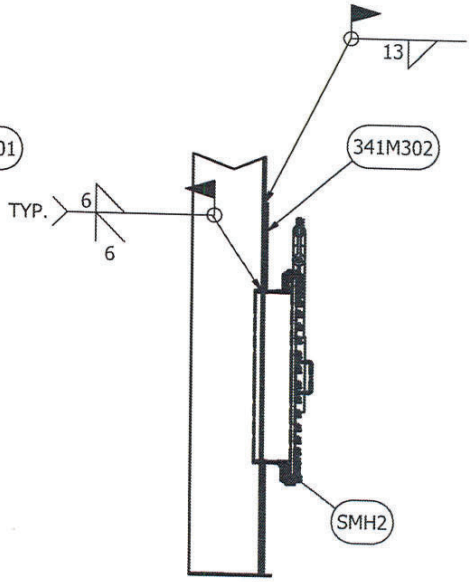
PROFESSIONAL ENGINEER
BRIAN BROWN
LICENSEE
NT/NU
15-Jun-2021
Permit Number: P471



DETAIL 3A
SCALE 1/125



DETAIL 3B
VIEW AT SMH2 AT 180°
SCALE 1/25



DETAIL 3C
SECTION THROUGH MANHOLE
TYP. AT 0°, 90°, 270°
SCALE 1/25

STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

☐ CHANGE ☒ NO CHANGE

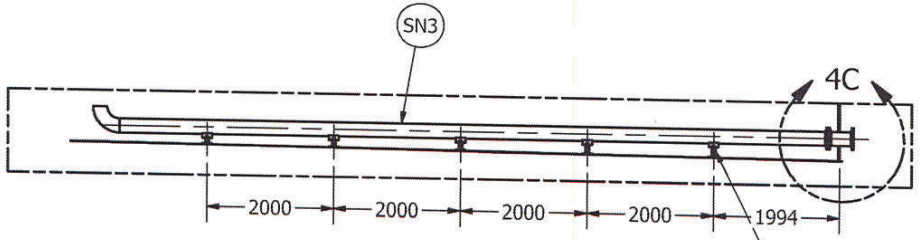
NAME: Lindsay C Bolton
SIGNATURE: LCB
DATE: September 6, 2021

LICENSED PROFESSIONAL ENGINEER
L. C. BROWN
LICENSEE
15-Jun-2021
NTINU

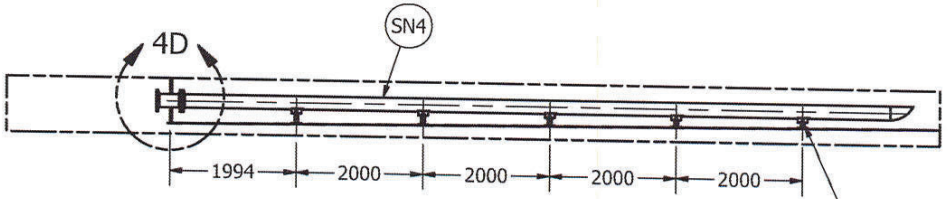
Permit Number: P471

REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUED FOR REVIEW	2/26/2019
1	ISSUED FOR CONSTRUCTION	6/8/2021

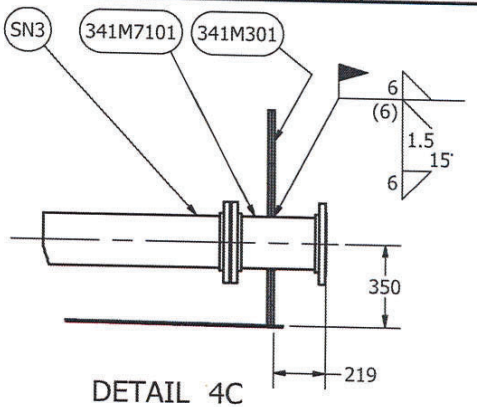
DRAWN MARC LOSIER	5/31/2021	GENERAL ARRANGEMENT AND NOZZLE LAYOUT
CHECKED		
QA		
MFG		TITLE: BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43 33.516M I.D.
APPROVED		
		SIZE A3 · DWG NO 341-M6 · REV 1
		SCALE 1/500 · SHEET 3 OF 6



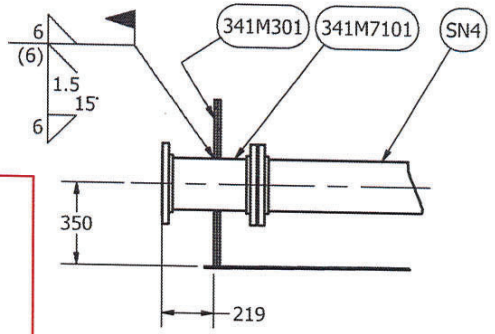
PART SECTION 4A-4A
SCALE 1/75



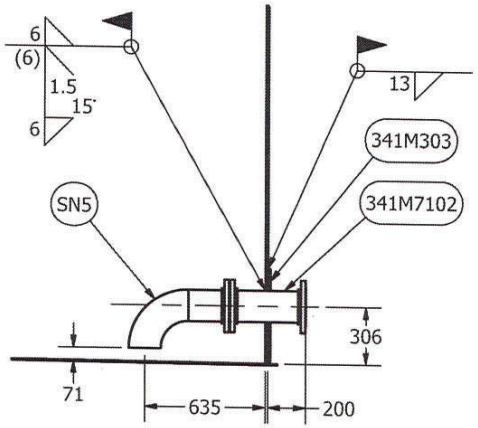
PART SECTION 4B-4B
SCALE 1/75



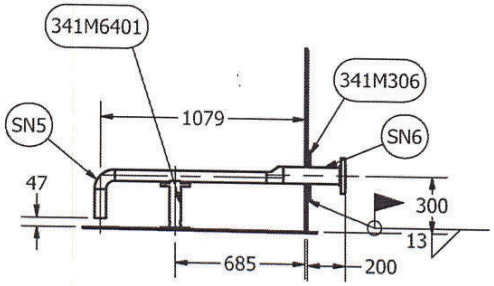
DETAIL 4C
SCALE 1/20



DETAIL 4D
SCALE 1/20



DETAIL 4A
N5 PUMPING LOW SUCTION
SCALE 1/25



DETAIL 4B
N6 WATER DRAWOFF VALVE
SCALE 1/25

STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

☐ CHANGE ☒ NO CHANGE

NAME: Lindsay C Bolton
SIGNATURE: LCB
DATE: September 6, 2021

Permit Number: P471

REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUED FOR REVIEW	6/1/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

DRAWN MARC LOSIER	5/31/2021	GENERAL ARRANGEMENT AND NOZZLE LAYOUT
CHECKED		
QA		TITLE
MFG		BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43 33.516M I.D.
APPROVED		

SIZE	DWG NO	REV
A3	341-M6	1
SCALE 1/500	SHEET 4 OF 6	

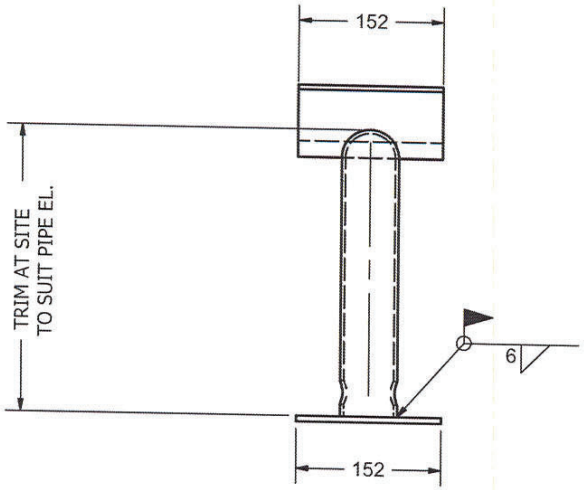
STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

☐ CHANGE ☒ NO CHANGE

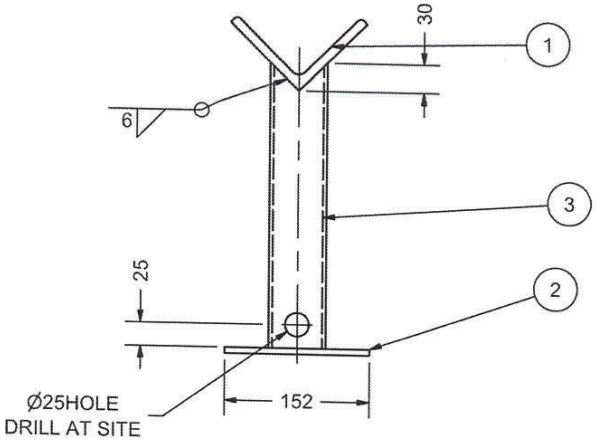
NAME: Lindsay C Bolton
SIGNATURE:
DATE: September 6, 2021

PARTS LIST FOR ONE (1) SHOWN				
ITEM	ITEM QTY	CUT (MM)	DESCRIPTION	MATERIAL
1	1	152	L100X100X10 [4"X4"X3/8"]	G40.21M 350W
2	1	152	FB150X6 [6"X1/4"]	G40.21M 300W
3	1	305	50NS [2"] PIPE SCH. 40	A53 ERW

PIPE SUPPORT TYPE 1
MARK: 315M6401
QTY: 16



PIPE SUPPORT
SCALE 1/5



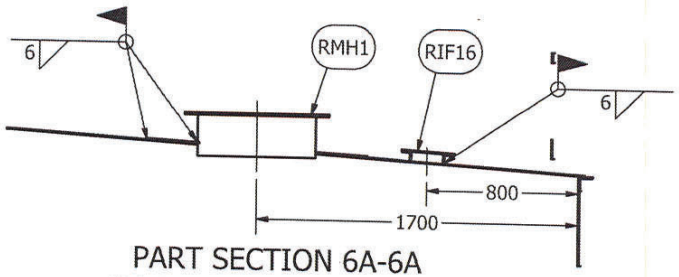
NOTE:
ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE NOTED

PROFESSIONAL ENGINEER
BROWN
LICENSEE
NT/NU
15-Jun-2021

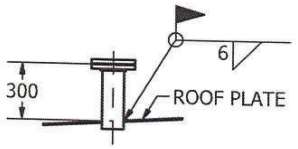
Permit Number: P471

REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUED FOR REVIEW	6/1/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

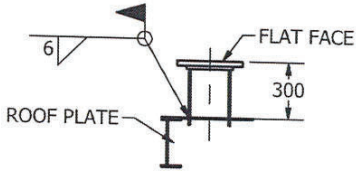
DRAWN MARC LOSIER	5/31/2021	GENERAL ARRANGEMENT AND NOZZLE LAYOUT
CHECKED		
QA		TITLE
MFG		BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43 33.516M I.D.
APPROVED		
		SIZE A3 / DWG NO 341-M6 / REV 1
		SCALE 1/5 / SHEET 5 OF 6



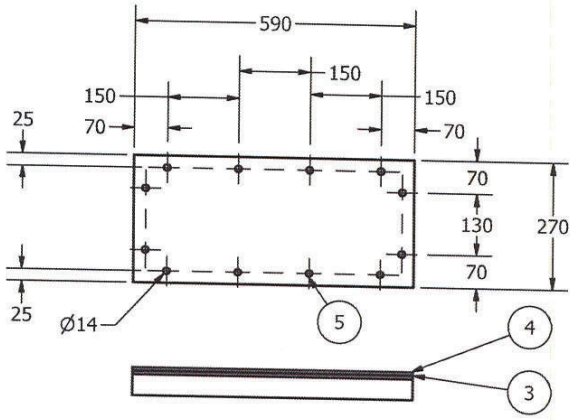
PART SECTION 6A-6A
ROOF MANHOLE (RMH1)
AND ROOF INSPECTION FRAME (RIF16)
SCALE 1/25

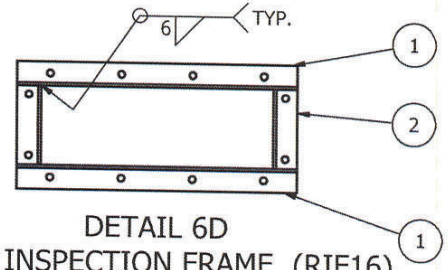


TYPICAL DETAIL 6B
RN8, RN9, RN10, RN11, RN12
SCALE 1 / 25



DETAIL 6C
RN7 - GAUGE HATCH
SCALE 1/25





DETAIL 6D
ROOF INSPECTION FRAME (RIF16)
SCALE 1/10

PARTS LIST					
ITEM	ITEM QTY	CUT (MM)	DESCRIPTION	MATERIAL	MASS
1	2	1180	L50X50X6	300W	2.827 kg
2	2	337	L50X50X6	300W	0.807 kg
3	1		GASKET, 1.5THK X 270 X5 90	Rubber	0.237 kg
4	1		COVER, 6THK X 270 X 590	Steel, Mild	7.951 kg
5	12	1	BOLTS, NUTS, WASHER, 1/2" UNC X 1 1/4" LG,	GR.5	

STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

☐ CHANGE ☒ NO CHANGE

NAME: Lindsay C Bolton
SIGNATURE:
DATE: September 6, 2021

REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUED FOR REVIEW	6/1/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

DRAWN MARC LOSIER	5/31/2021	GENERAL ARRANGEMENT AND NOZZLE LAYOUT
CHECKED		
QA		
MFG		TITLE: BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43 33.516M I.D.
APPROVED		
		SIZE A3 / DWG NO 341-M6 / REV 1
		SCALE 1/500 / SHEET 6 OF 6

APEGGN PROFESSIONAL ENGINEER S. BROWN LICENSEE NT/NU
15-Jun-2021

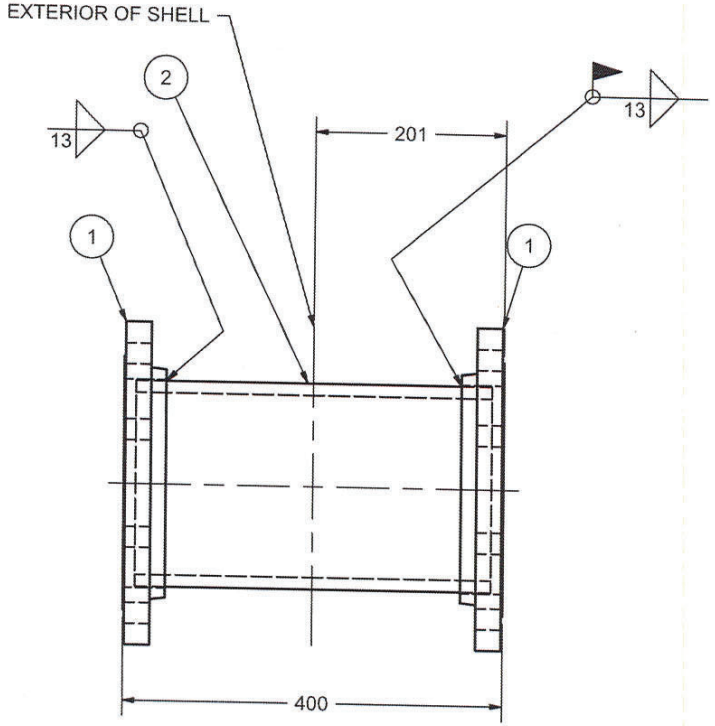
Permit Number: P471

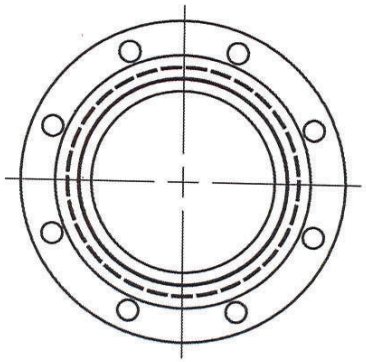
Parts List					
ITEM	ITEM QTY	CUT (MM)	DESCRIPTION	MATERIAL	MASS
1	2		FLANGE, SLIP ON, 150#, 200NS	A350 LF2	12 kg
2	1	375	PIPE, S80, 200NS	A333 GR. 6	24 kg

Ø200 NS DOUBLE FLANGE
USE WITH SN3 & SN4
MARK: 341M7101
QTY: 2

WEIGHT/SPOOL: 48.2KG

NOTES:
1. ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE NOTED
2. FINISH: BARE





STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

☐ CHANGE ☒ NO CHANGE

NAME: Lindsay C Bolton
SIGNATURE:
DATE: September 6, 2021

Permit Number: P471

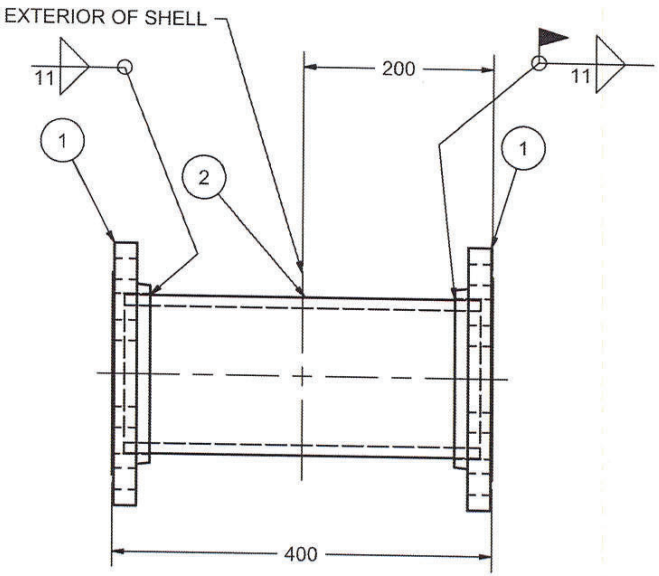
REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUE FOR REVIEW	3/9/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

DRAWN MARC LOSIER	3/9/2021	NOZZLE DETAILS	
CHECKED			
QA		TITLE	
MFG		BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43	
APPROVED			
		SIZE A3	DWG NO 341-M7 / REV 1
		SCALE	SHEET 1 OF 13

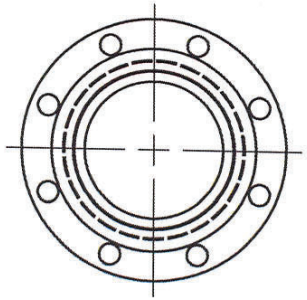
Parts List					
ITEM	ITEM QTY	CUT (MM)	DESCRIPTION	MATERIAL	MASS
1	2		FLANGE, SLIP ON, 150#, 150NS	A350 LF2	7 kg
2	1	375	PIPE, S80, 150NS	A333 GR. 6	16 kg

Ø150 NS DOUBLE FLANGE
USE WITH SN5 LOW PUMPING SUCTION
MARK: 341M7102
QTY: 2

WEIGHT/SPOOL: 30.8KG



NOTES:
1. ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE NOTED
2. FINISH: BARE



STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

☐ CHANGE ☒ NO CHANGE

NAME: Lindsay C Bolton
SIGNATURE: LCB
DATE: September 6, 2021

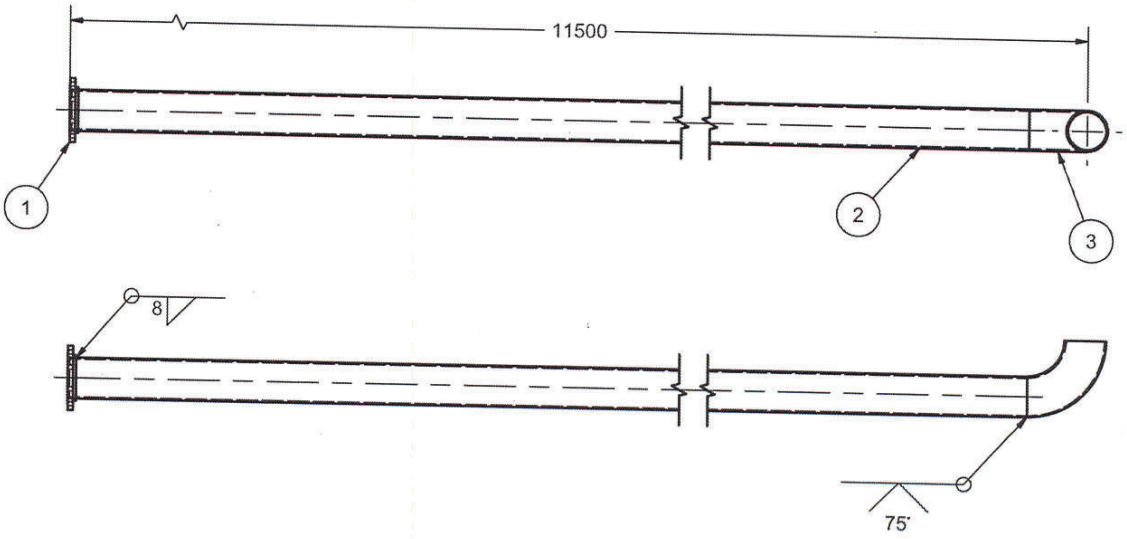
APEGGA PROFESSIONAL ENGINEERS BROWN LICENSEE NT/NU
15-Jun-2021

Permit Number: P471

REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUE FOR REVIEW	3/9/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

DRAWN MARC LOSIER	3/9/2021	NOZZLE DETAILS	
CHECKED			
QA		TITLE	
MFG		BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43	
APPROVED			
		SIZE A3	DWG NO 341-M7 / REV 1
		SCALE	SHEET 2 OF 13

Parts List					
ITEM	ITEM QTY	CUT (MM)	DESCRIPTION	MATERIAL	MASS
1	1		FLANGE, SLIP ON, 150#, 200NS	A350 LF2	12 kg
2	1	11185	PIPE, S40, 200NS	A333 GR. 6	476 kg
3	1		ELBOW, S40, LR, 90DEG, 200NS	A420	20 kg



NOTES:
1. ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE NOTED
2. FINISH: BARE

Ø200 NS FIXED PIPE LOADING
MARK: SN3
QTY: 1
WEIGHT/SPOOL: 508KG

STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

☐ CHANGE ☒ NO CHANGE

NAME: Lindsay C Bolton
SIGNATURE:
DATE: September 6, 2021

PROFESSIONAL ENGINEER BROWN LICENSEE N.T./N.U.
15-Jun-2021

Permit Number: P471

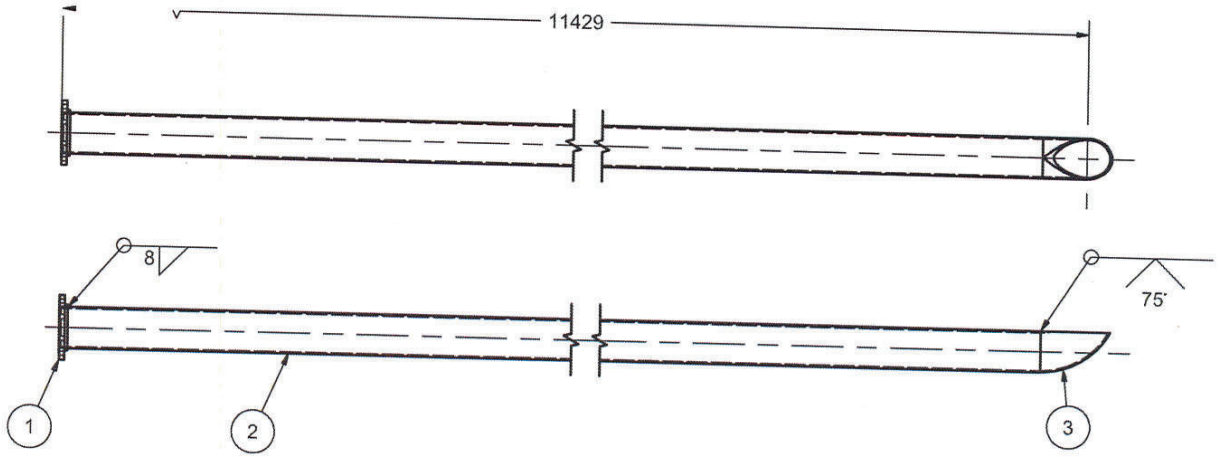
REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUE FOR REVIEW	3/9/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

DRAWN MARC LOSIER	3/9/2021	NOZZLE DETAILS
CHECKED		
QA		
MFG		TITLE: BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43
APPROVED		
		SIZE A3 / DWG NO 341-M7 / REV 1
		SCALE / SHEET 3 OF 13

Parts List					
ITEM	ITEM QTY	CUT (MM)	DESCRIPTION	MATERIAL	MASS
1	1		FLANGE, SLIP ON, 150#, 200NS	A350 LF2	12 kg
2	1	11185	PIPE, S40, 200NS	A333 GR.6	476 kg
3	1		ELBOW, S40, LR, 90DEG, 200NS	A4200	20 kg

Ø200 NS FIXED PIPE UNLOADING
MARK: SN4
QTY: 1
WEIGHT/SPOOL: 499KG

NOTES:
1. ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE NOTED
2. FINISH: BARE



STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

☐ CHANGE ☒ NO CHANGE

NAME: Lindsay C Bolton
SIGNATURE:
DATE: September 6, 2021

PROFESSIONAL ENGINEERS BROWN LICENSEE NT/NU 15-Jun-2021

Permit Number: P471

REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUE FOR REVIEW	3/9/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

DRAWN	MARC LOSIER	3/9/2021
CHECKED		
QA		
MFG		
APPROVED		

NOZZLE DETAILS

TITLE: BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43

SIZE: A3 | DWG NO: 341-M7 | REV: 1

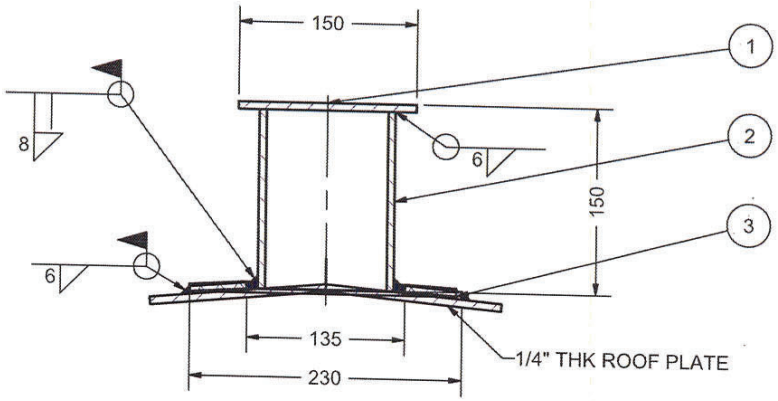
SCALE | SHEET 4 OF 13

Parts List					
ITEM	ITEM QTY	CUT (MM)	DESCRIPTION	MATERIAL	MASS
1	1		PLATE, 6 THK X 150DIA	G40.21M 300W	1 kg
2	1	152	PIPE, S40, 100NS	A53	2 kg
3	1		PLATE, 10THK X 133 I.D. X 229 O.D.	G40.21M 300W	1 kg

Ø100 NS PAINTERS SCAFFOLD CABLE SUPPORT
MARK: RB14
QTY: 1

WEIGHT/SPOOL: 5KG

NOTES:
1. ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE NOTED
2. FINISH: BARE



STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

☐ CHANGE ☒ NO CHANGE

NAME: Lindsay C Bolton
SIGNATURE:
DATE: September 6, 2021

REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUE FOR REVIEW	3/9/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

APPROVED BY PROFESSIONAL ENGINEER S. BROWN LICENSEE NT/NU
15-Jun-2021
Permit Number: P471

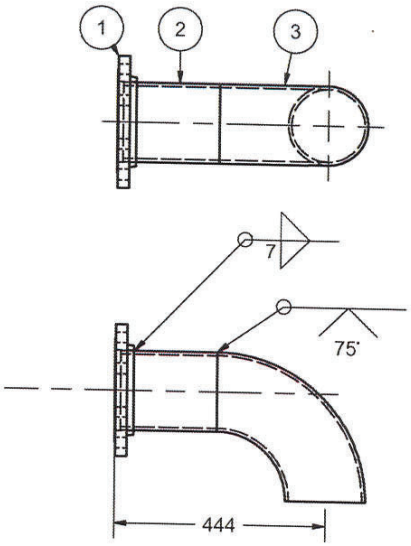
DRAWN MARC LOSIER	3/9/2021	NOZZLE DETAILS
CHECKED		
QA		
MFG		TITLE: BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43
APPROVED		
		SIZE A3 / DWG NO 341-M7 / REV 1
		SCALE / SHEET 5 OF 13

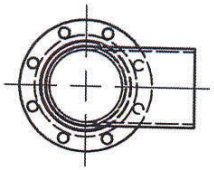
Parts List for one (1), two (2) reqruired					
ITEM	ITEM QTY	CUT (MM)	MATERIAL	DESCRIPTION	MASS
1	1		A350 LF2	FLANGE, SLIP ON, 150#, 150NS	7 kg
2	1	203	A333 GR.6	PIPE, S40, 150NS	6 kg
3	1		A420	ELBOW, LR, S40, 90DEG, 150NS	10 kg

Ø150 NS PIPING LOW LEVEL
MARK: SN5
QTY: 2

WEIGHT/SPOOL: 23.3KG

NOTES:
1. ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE NOTED
2. FINISH: BARE





STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

☐ CHANGE ☒ NO CHANGE

NAME: Lindsay C Bolton
SIGNATURE: LCB
DATE: September 6, 2021

REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUE FOR REVIEW	3/9/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

APPROVED BY PROFESSIONAL ENGINEER
LICENSEE
NT/NU
15-Jun-2021

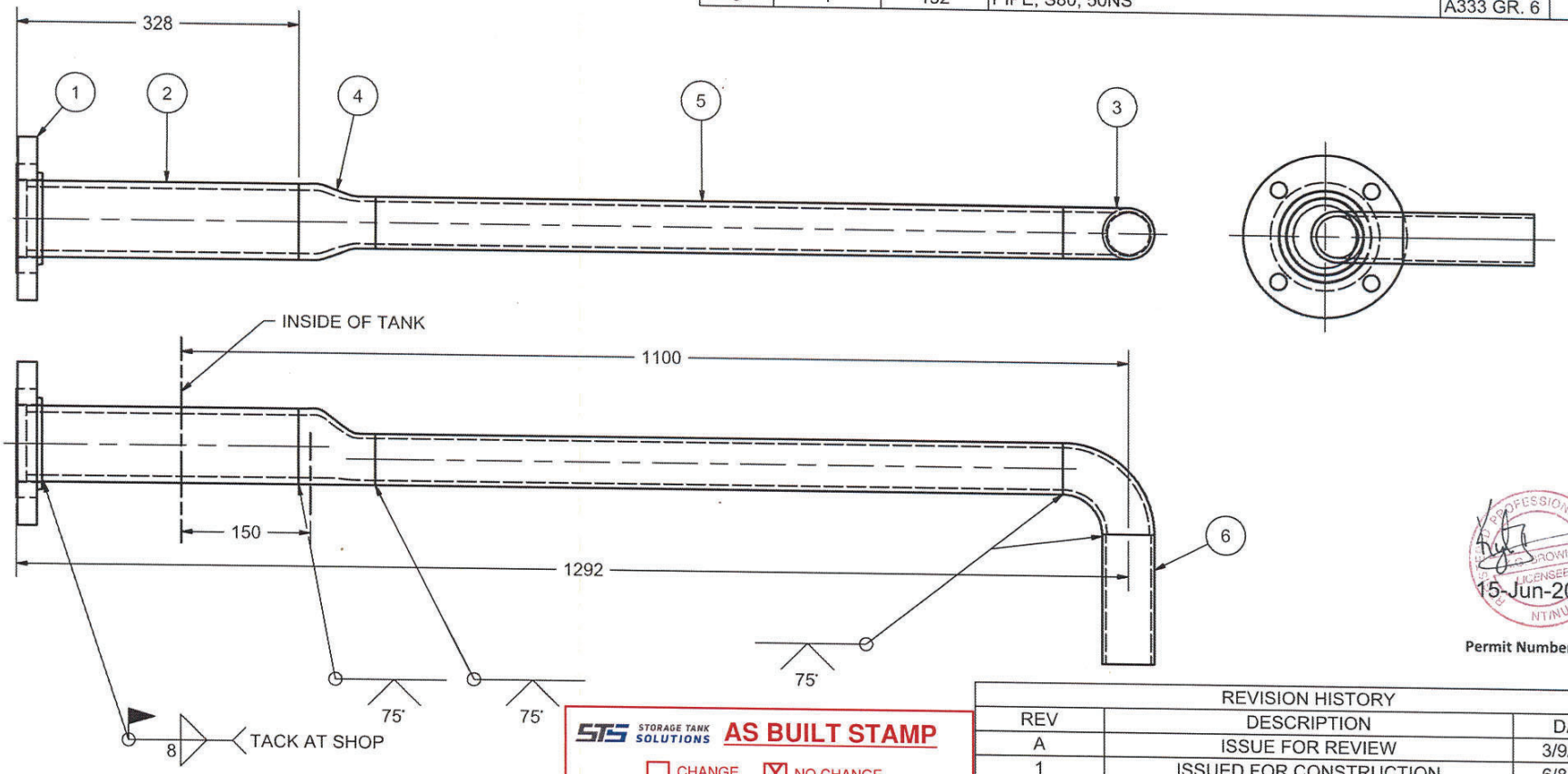
Permit Number: P471

DRAWN MARC LOSIER	3/9/2021	NOZZLE DETAILS
CHECKED		
QA		
MFG		TITLE: BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43
APPROVED		
SIZE A3	DWG NO 341-M7	REV 1
SCALE	SHEET 6 OF 13	

Ø75 NS WATER DRAW OFF
MARK: SN6
QTY: 6
WEIGHT/SPOOL: 16.6KG

Parts List for one (1), six (6) required

ITEM	ITEM QTY	CUT (MM)	DESCRIPTION	MATERIAL	MASS
1	1		FLANGE, SLIP ON, 150#, 75NS	A350 LF2	4 kg
2	1	316	PIPE, S80, 75NS	A333 GR. 6	5 kg
3	1		ELBOW, S80, 90DEG, LR, 50NS	A420	1 kg
4	1		ECCENTRIC REDUCER, BW, S80, 75NS X 50NS	A420	1 kg
5	1	799	PIPE, S80, 50NS	A333 GR. 6	6 kg
6	1	152	PIPE, S80, 50NS	A333 GR. 6	1 kg



NOTES:
1. ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE NOTED
2. FINISH: BARE

STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

☐ CHANGE ☒ NO CHANGE

NAME: Lindsay C Bolton
SIGNATURE: LCB
DATE: September 6, 2021

APEGNT PROFESSIONAL ENGINEER
BROWN
LICENSEE
NT/NU
15-Jun-2021

Permit Number: P471

REVISION HISTORY

REV	DESCRIPTION	DATE
A	ISSUE FOR REVIEW	3/9/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

DRAWN	MARC LOSIER	3/9/2021
CHECKED		
QA		
MFG		
APPROVED		

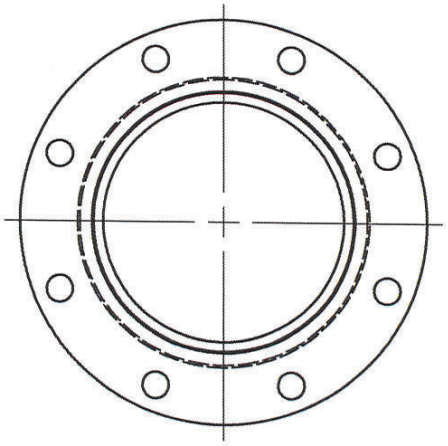
NOZZLE DETAILS

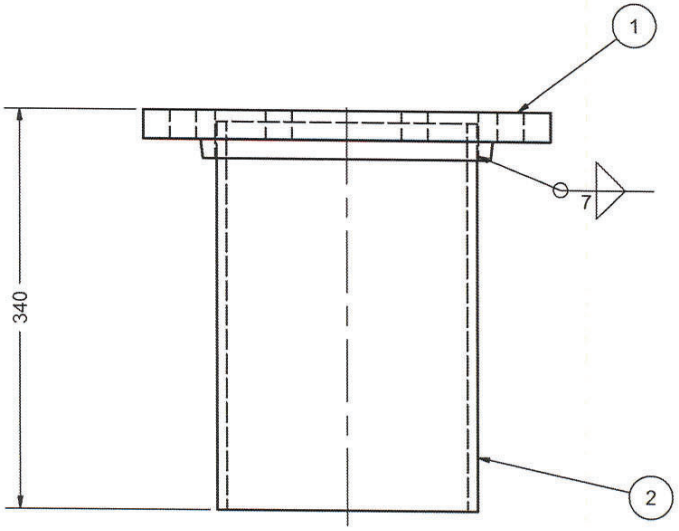
TITLE: BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43

SIZE: A3 | DWG NO: 341-M7 | REV: 1

SCALE | SHEET 7 OF 13

Parts List					
ITEM	ITEM QTY	CUT (MM)	DESCRIPTION	MATERIAL	MASS
1	1		FLANGE, SLIP ON, FLAT FACE, 150#, 2000NS	A350 LF2	11 kg
2	1	330	Pipe	Steel	14 kg





Ø200 NS ROOF NOZZLE FOR GAUGE HATCH
MARK: RN7
QTY: 1

WEIGHT/SPOOL: 16KG

NOTES:
1. ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE NOTED
2. FINISH: BARE

STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

☐ CHANGE ☒ NO CHANGE

NAME: Lindsay C Bolton
SIGNATURE:
DATE: September 6, 2021

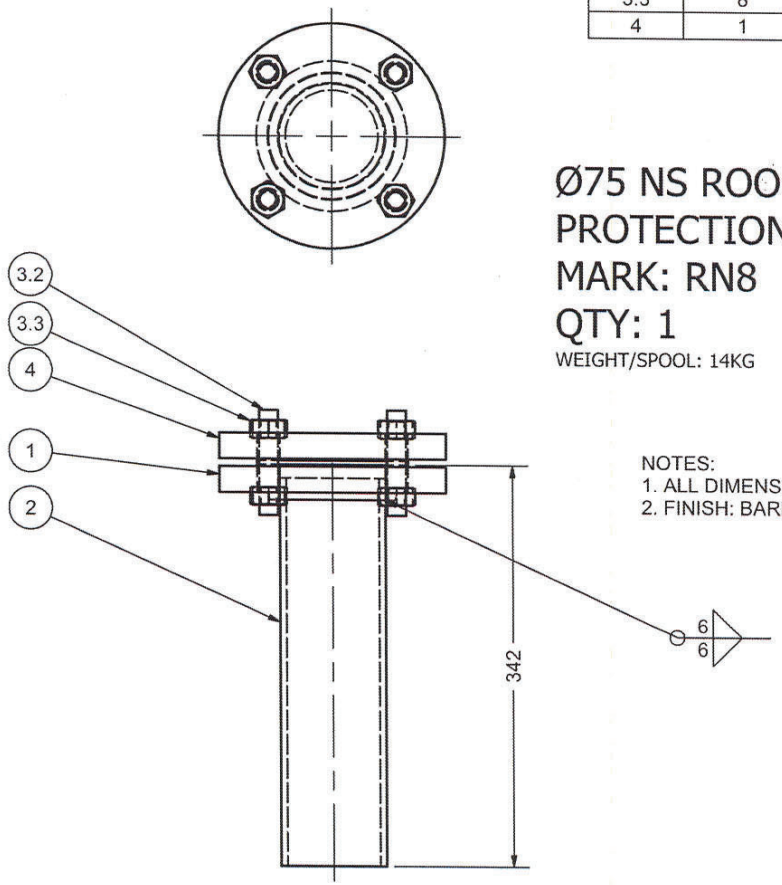
REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUE FOR REVIEW	3/9/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

PROFESSIONAL ENGINEER — S. BROWN — LICENSEE — NT/NU
15-Jun-2021

Permit Number: P471

DRAWN MARC LOSIER	3/9/2021	NOZZLE DETAILS
CHECKED		
QA		TITLE
MFG		BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43
APPROVED		
		SIZE A3 / DWG NO 341-M7 / REV 1
		SCALE / SHEET 8 OF 13

Parts List					
ITEM	ITEM QTY	CUT (MM)	DESCRIPTION	MATERIAL	MASS
1	1		FLANGE, SLIP ON, 150#, 75NS	A350 LF2	4 kg
2	1	330	PIPE, S40, 75NS	A53	4 kg
3.1	1		GASKET, RING, 150#, 1/16"THK X 75NS	DURLON 8500	0 kg
3.2	4		STUD, L7, 5/8" X 3.5" LG	L7	0 kg
3.3	8		HEAVY HEX NUT, GR4, 5/8" NC	GR4	0 kg
4	1	25	BLIND FLANGE, 150#, 75NS	A350 LF2	5 kg



Ø75 NS ROOF NOZZLE FOR OVERFILL PROTECTION

MARK: RN8

QTY: 1

WEIGHT/SPOOL: 14KG

NOTES:
1. ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE NOTED
2. FINISH: BARE

STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

☐ CHANGE ☒ NO CHANGE

NAME: Lindsay C Bolton
SIGNATURE:
DATE: September 6, 2021

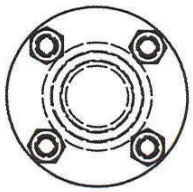
REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUE FOR REVIEW	3/9/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

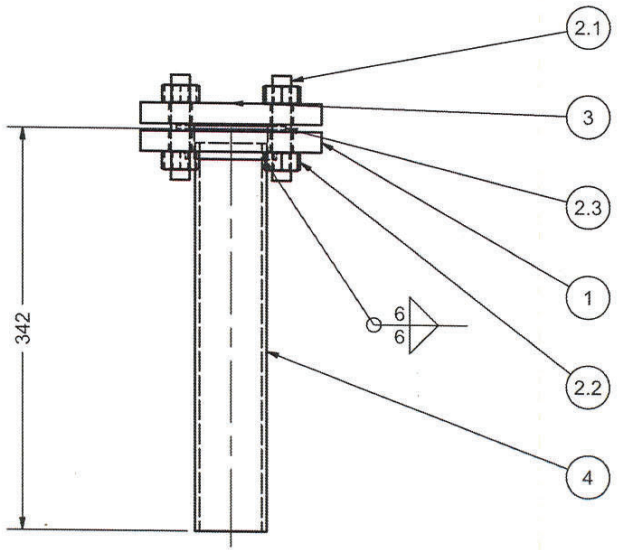
DRAWN MARC LOSIER	3/9/2021	NOZZLE DETAILS
CHECKED		
QA		
MFG		TITLE: BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43
APPROVED		
SIZE A3	DWG NO 341-M7	REV 1
SCALE	SHEET 9 OF 13	

APEGGA PROFESSIONAL ENGINEER BROWN LICENSEE 15-Jun-2021 NT/NU

Permit Number: P471

Parts List for One, Three (3) Required					
ITEM	ITEM QTY	CUT (MM)	DESCRIPTION	MATERIAL	MASS
1	1		FLANGE, SLIP ON, RF, 150#, 50NS	A350 LF2	2 kg
2.1	4		STUD, 5/8" X 3.5" LG	L7	0 kg
2.2	8		NUT, 5/8" UNC	GR4	0 kg
2.3	1		GASKET, RING, 150#, 1/16" THK X 50NS	DURLON 8500	0 kg
3	1		BLIND FLANGE, RF, 150#, 50NS	A350 LF2	2 kg
4	1	330	PIPE, S40, 50NS	A53	2 kg





Ø50 NS ROOF NOZZLE FOR TEMPERATURE & WATER DETECTION PROBE
MARK: RN9 (1X), RN11 (2X)
QTY: 3

WEIGHT/SPOOL: 7KG

NOTES:
1. ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE NOTED
2. FINISH: BARE

STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

☐ CHANGE ☒ NO CHANGE

NAME: Lindsay C Bolton
SIGNATURE:
DATE: September 6, 2021

Permit Number: P471

REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUE FOR REVIEW	3/9/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

DRAWN	MARC LOSIER	3/9/2021	NOZZLE DETAILS
CHECKED			
QA			TITLE: BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43
MFG			
APPROVED			
SIZE: A3	DWG NO: 341-M7	REV: 1	
SCALE		SHEET 10 OF 13	

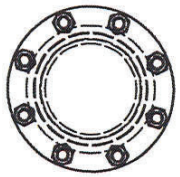
Parts List					
ITEM	ITEM QTY	CUT (MM)	DESCRIPTION	MATERIAL	MASS
1	1		FLANGE, SLIP ON, RF, 150#, 150NS	A350 LF2	7 kg
2	1	330	PIPE, S40, 150NS	A53	9 kg
3.1	1		GASKET, 1/16"THK, RING, 150 NS	DURLON 8500	0 kg
3.2	8		STUD, 3/4" X 4" LG	L7	0 kg
3.3	16		HEAVY HEX NUT, 3/4"	GR.4	0 kg
4	1		BLIND FLANGE, 150#, 150NS	A350 LF2	11 kg

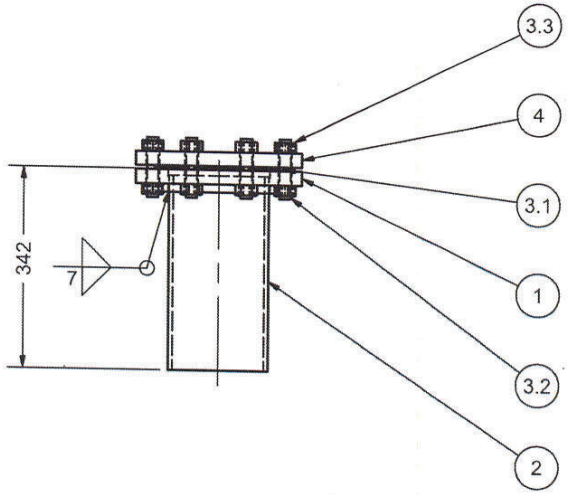
Ø150 NS ROOF NOZZLE RADAR - LEVEL DETECTION

MARK: RN10

QTY: 1

WEIGHT/SPOOL: 32 KG





NOTES:
1. ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE NOTED
2. FINISH: BARE

STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

☐ CHANGE ☒ NO CHANGE

NAME: Lindsay C Bolton
SIGNATURE:
DATE: September 6, 2021

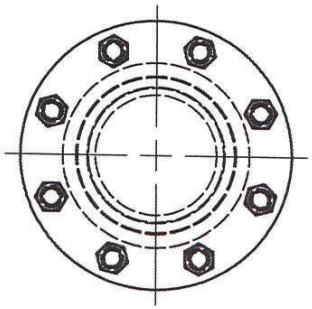
REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUE FOR REVIEW	3/9/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

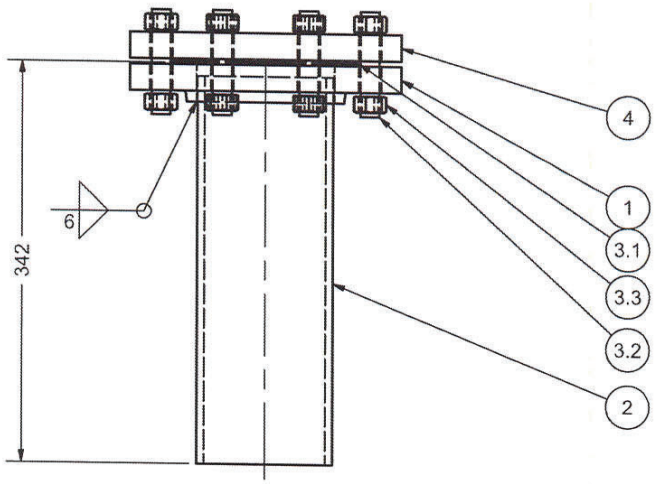
PROFESSIONAL ENGINEER J.C. BROWN LICENSEE NT/NU
15-Jun-2021

Permit Number: P471

DRAWN MARC LOSIER	3/9/2021	NOZZLE DETAILS
CHECKED		
QA		TITLE
MFG		BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43
APPROVED		
		SIZE A3 / DWG NO 341-M7 / REV 1
		SCALE / SHEET 11 OF 13

Parts List					
ITEM	ITEM QTY	CUT (MM)	DESCRIPTION	MATERIAL	MASS
1	1		FLANGE, SLIP ON, RF, 150#, 100NS	A350 LF2	5 kg
2	1	330	PIPE, S40, 100NS	A53	5 kg
3.1	1		GASKET, RING, 150#, 1/16"THK, 100NS	DURLON 8500	0 kg
3.2	8		STUD, 5/8" X 3.5" LG	L7	0 kg
3.3	16		HEAVY HEX NUT, 5/8" UNC	GR.4	0 kg
4	1		BLIND FLANGE, 150#, 100NS	A350 LF2	7 kg





Ø100 NS ROOF NOZZLE SPARE
MARK: RN12
QTY: 2
WEIGHT/SPOOL: 19 KG

NOTES:
1. ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE NOTED
2. FINISH: BARE

STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

☐ CHANGE ☒ NO CHANGE

NAME: Lindsay C Bolton
SIGNATURE: LCB
DATE: September 6, 2021

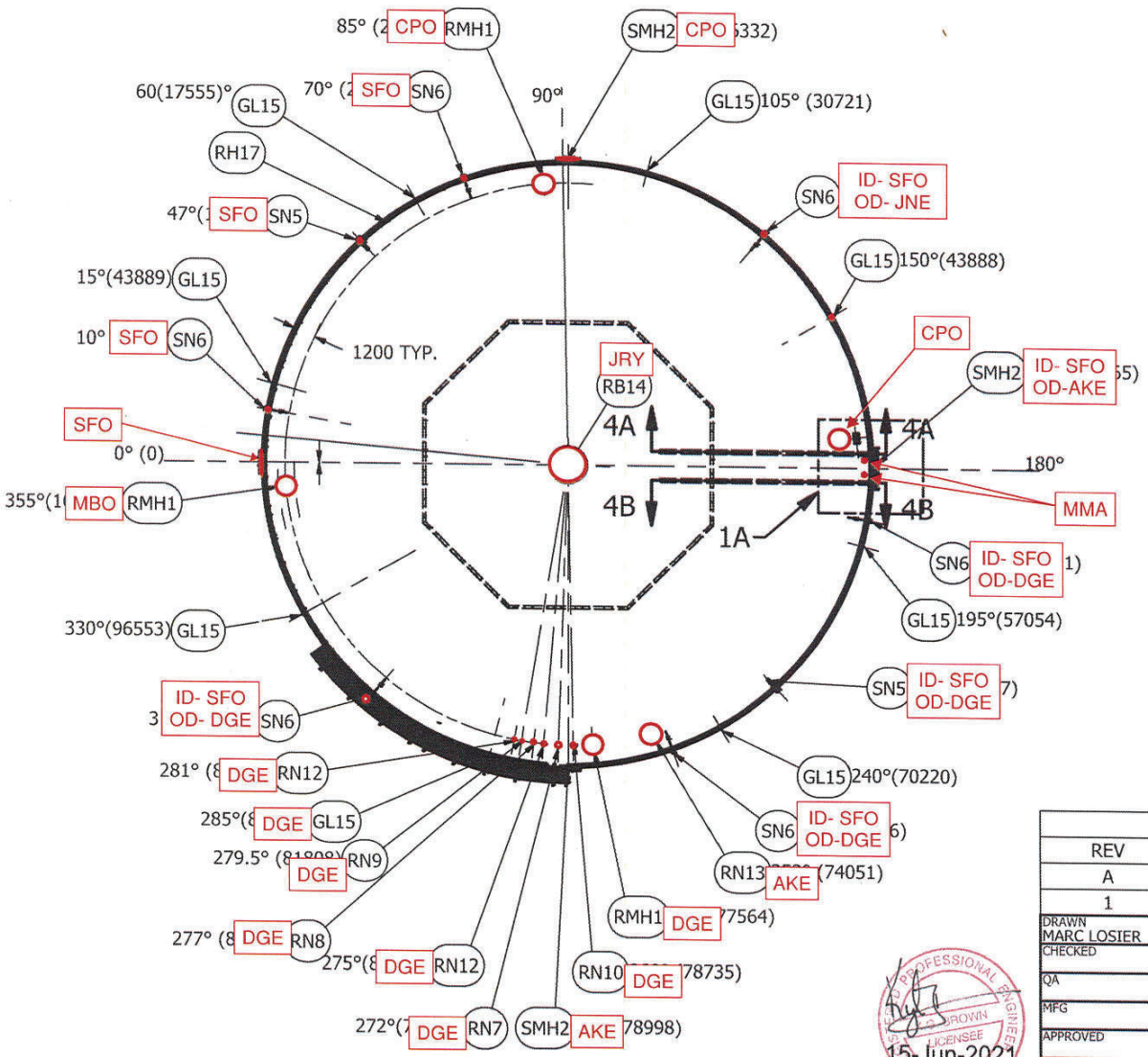
REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUE FOR REVIEW	3/9/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

DRAWN MARC LOSIER	3/9/2021	NOZZLE DETAILS
CHECKED		
QA		
MFG		TITLE: BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43
APPROVED		

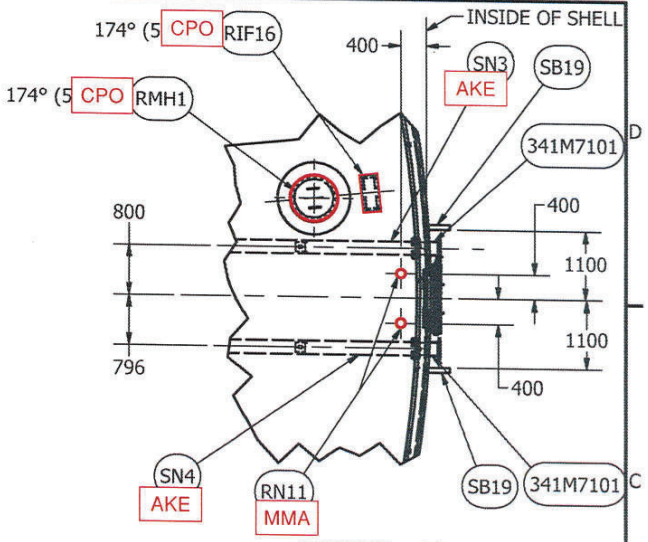
SIZE A3 | DWG NO 341-M7 | REV 1
SCALE | SHEET 12 OF 13

LICENSED PROFESSIONAL ENGINEER — BROWN — LICENSEE — NT/NU
15-Jun-2021

Permit Number: P471



PLAN VIEW



DETAIL 1A
SCALE 1/75

DIMENSION IN () DENOTES
ARC LENGTH ON THE EXTERIOR OF
THE SHELL FROM 0° IN MILLIMETRES
MEASURED ON COURSE ONE (1) FOR SHELL NOZZLES
AND ON COURSE FIVE (5) FOR ROOF NOZZLES

15-Jun-2021
Permit Number: P471

REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUE FOR REVIEW	6/1/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

DRAWN MARC LOSIER	5/31/2021	GENERAL ARRANGEMENT AND NOZZLE LAYOUT
CHECKED		
QA		
MFG		TITLE: BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43 33.516M I.D.
APPROVED		

SIZE	DWG NO	REV
A3	341-M6	1
SCALE 1/250	SHEET 1 OF 6	

QUALITY CONTROL MANUAL

VISUAL TEST REPORT

Customer: AGNICO EAGLE

Location: BAKER LAKE

Code Requiring Test: API 650 (section 8.5.2) Reason for Test: New Construction

A weld shall be acceptable by visual examination if the inspection shows the following.

a) There are no crater cracks, other surface cracks or arc strikes in or adjacent to the welded joints.
b) Maximum permissible undercut is 0.4 mm (1/64 in.) in depth for vertical butt joints, vertically oriented permanent attachments, attachment welds for nozzles, manholes, flush-type openings, and the inside shell-to-bottom welds. For horizontal butt joints, horizontally oriented permanent attachments, and annular-ring butt joints, the maximum permissible undercut is 0.8 mm (1/32 in.) in depth.
c) The frequency of surface porosity in the weld does not exceed one cluster (one or more pores) in any 100 mm (4 in.) of length, and the diameter of each cluster does not exceed 2.5 mm (3/32 in.).
d) The reinforcement of the welds on all thicknesses:

Plate Thickness mm (in.)	Maximum Reinforcement Thickness mm (in.)	
	Vertical Joints	Horizontal Joints
≤ 13 (1/2)	2.5 (3/32)	3 (1/8)
> 13 (1/2) to 25 (1)	3 (1/8)	5 (3/16)
> 25 (1)	5 (3/16)	6 (1/4)

Surface Condition (As Welded)

Test Solution: N/A Test Date(s): 2021-09-01

Tested by: Matthew MacKenzie Ambient Conditions: 10 Degrees Celsius

Items Tested:

All nozzle welds.

Results:

Acceptable to code at the time of Inspection.

STS Representative Signature: _____ Date: 2021-09-01

Client Representative Signature: _____ Date: 21st Sept 21

Exhibit 31, Rev 1

DIMENSIONAL CHECK REPORT- NOZZLES

Customer: AGNICO EAGLE

Location: BAKER LAKE

Equipment Tag No.: TK 8

Equipment Type: Above Ground Storage Tank

Equipment Description: Diesel Storage Tank

Code Requiring Test: API 650 Reason for Test: New Construction

(Nozzles (excluding manholes) shall be installed within the following tolerances:
a) specified projection from outside of tank shell to extreme face of flange: ±5 mm (3/16 in.);
b) elevation of shell nozzle or radial location of a roof nozzle: ±6 mm (1/4 in.);
c) flange tilt in any plane, measured on the flange face:
±1/2 degree for nozzles greater than NPS 12 in. nominal diameter,
±3 mm (1/8 in.) at the outside flange diameter for nozzles NPS 12 and smaller;
d) flange bolt hole orientation: ±3 mm (1/8 in.).)

Test Date(s): 2021-09-01

Tested by: Matthew MacKenzie

Test Results:

All nozzles within tolerance at the time of inspection; acceptable to code.

STS Representative Signature: _____ Date: 2021-09-01

Client Representative Signature: _____ Date: 21st Sept 21

Exhibit 12, Rev 1

AIR TEST REPORT – NOZZLE REINFORCEMENT PLATE WELDS

Customer: AGNICO EAGLE

Location: BAKER LAKE

Equipment Tag No.: TANK 8

Equipment Type: Above Ground Storage Tank

Equipment Description: Diesel Storage Tank

Code Requiring Test: API 650 Reason for Test: New Construction

(An air pressure/soap solution test for nozzle reinforcement plate weld seams is required for new construction or major alterations, no visible leaks should be observed)

Test Pressure: 100 kPa (15 psi) Surface Condition (As Welded, Painted, Blasted)

Test Solution: Water / Snoop: Test Date(s): 2021-09-

Tested by: Matthew MacKenzie Pressure Gauge: Ambient Conditions: 10 Degrees Celsius

Items Tested:

All Shell Nozzles.

Results:

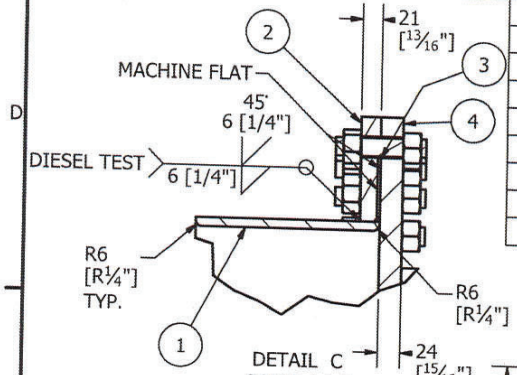
No leaks detected at the time of inspection; acceptable to code.

STS Representative Signature: _____ Date: 2021-09-04

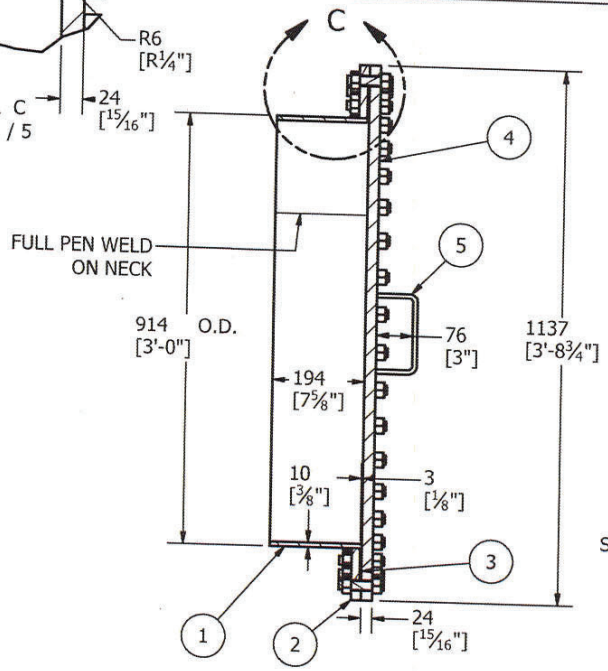
Client Representative Signature: _____ Date: 4th Sept 21

SECTION 15.0

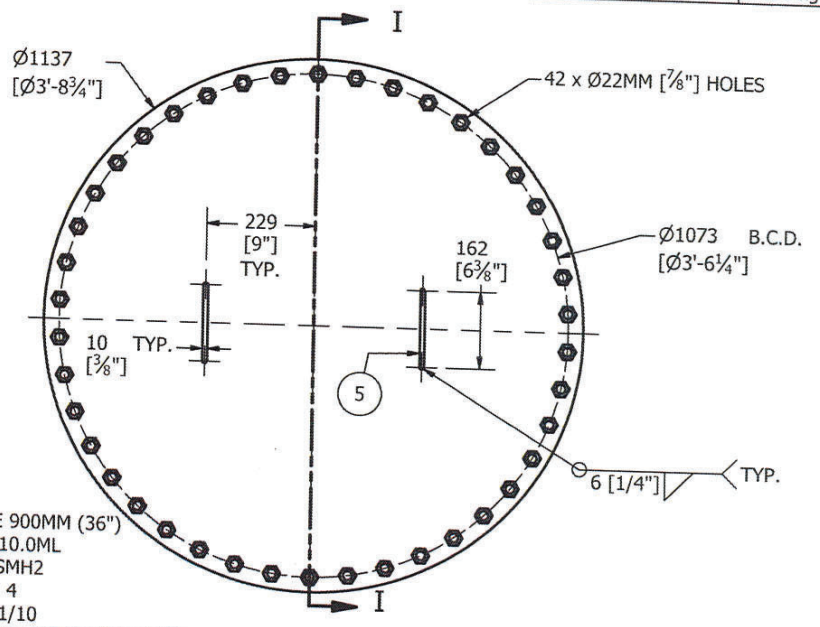
Manways



PARTS LIST					
ITEM	ITEM QTY	PART NUMBER	DESCRIPTION	MATERIAL	MASS
1	1	T1-2-4 SHELL NECK	10 [3/8"] THK X 194 [7 5/8"] WD. X 2842 [9'-3 7/8"] LONG	G40.21M - 350WT CAT. 4	40.783 kg
2	1	T1-2-4 SHELL BOLTING FLANGE	22 [7/8"] THK X 1137 [3'-8 3/4"] O.D. X 914 [3'-0"] I.D.	G40.21M - 350WT CAT. 4	54.904 kg
3	1	T1-2-4 SHELL GASKET	3 [1/8"] THK X 1051 [3'-5 3/8"] O.D. X 914 [3'-0"] I.D.	DURLON 8500	0.622 kg
4	1	T1-2-4 SHELL COVER PLATE	25 [1"] THK X 1137 [3'-8 3/4"] O.D.	G40.21M - 350WT CAT. 4	186.633 kg
5	2	T1-2-4 SHELL HANDLE ROD	10 [3/8"] THK X 314 [12 3/8"] LONG	MILD STEEL	0.175 kg
6	42	STUDS	STUD, 3/4" X 95 [3 3/4"] LG. NC	A320 L7	0.213 kg
7	84	NUTS	NUT, HEX HEAVY, 3/4" NC	A194A GR4	0.096 kg



SECTION I-I
SCALE 1/10



SHELL MANHOLE 900MM (36")
TANK 7 - 10.0ML
MARK: SMH2
QTY: 4
SCALE 1/10

REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUED FOR REVIEW	2/18/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

☐ CHANGE ☒ NO CHANGE

NAME: Lindsay C Bolton
SIGNATURE: LCB
DATE: September 6, 2021

Permit Number: P471

DRAWN	MARC LOSIER	2/18/2021	
CHECKED			
QA			
MFG			
APPROVED			

SHELL MANHOLE

TITLE

BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43

SIZE	DWG NO	REV
A3	341-M4	1

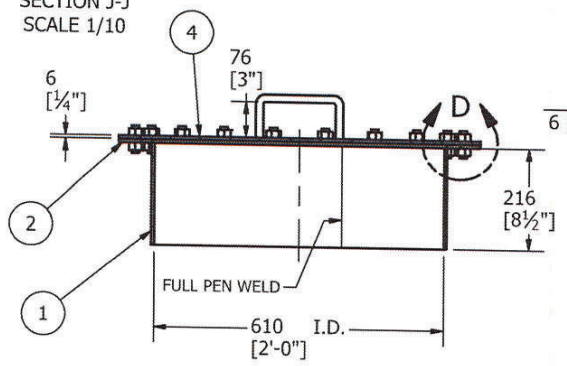
SCALE

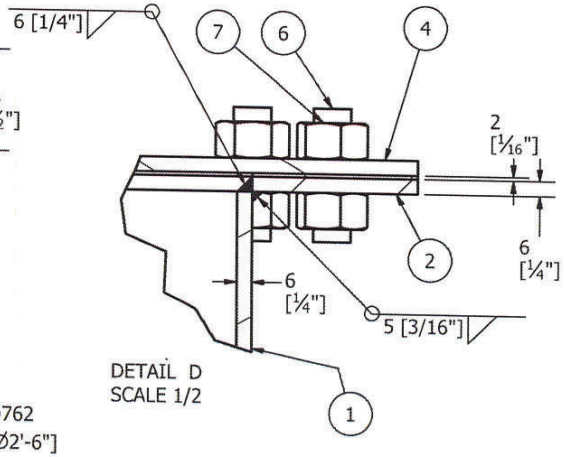
SHEET 1 OF 2

PARTS LIST

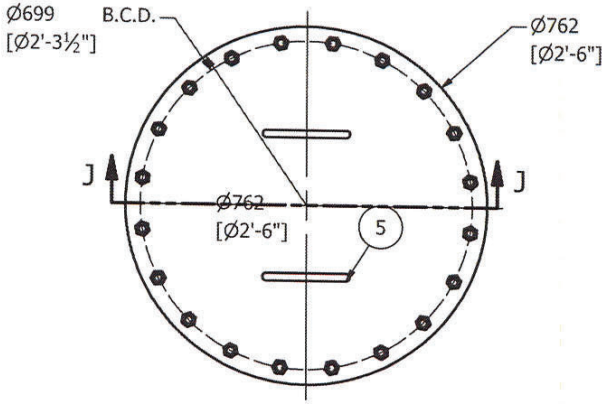
ITEM	ITEM QTY	PART NUMBER	DESCRIPTION	MATERIAL	MASS
1	1	ROOF NECK	6 [1/4""] THK X 216 [8 1/2"] WD X 1935 [6' - 4 3/16"] LG	G40.21M 300W	20.825 kg
2	1	ROOF BOLTING FLANGE	6 [1/4"] THK X 762 [2'-6"] O.D. X 622 [2'-1/2"] I.D.	G40.21M 300W	7.287 kg
4	1	ROOF COVER PLATE	6 [1/4"] THK X 762 [2'-6"] DIA	G40.21M 300W	22.448 kg
5	2	ROOF HANDLE ROD	16 [5/8"] DIA X 314 [12 3/8"] LG.	Steel, MILD	0.506 kg
6	20	STUDS	STUD, 5/8" X 57 [2 1/4"] LG. NC	A320 L7	0.089 kg
7	40	NUTS	NUT, HEX HEAVY, 5/8"	A194A GR4	0.059 kg
8	1	295-P1 Gasket 24in (600mm)		Rubber	0.216 kg

SECTION J-J
SCALE 1/10





DETAIL D
SCALE 1/2



ROOF MANHOLE 600MM (24")
TANK 7 - 10.0ML
MARK: RMH1
QTY: 4
SCALE 1/10

Permit Number: P471

STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

☐ CHANGE ☒ NO CHANGE

NAME: Lindsay C Bolton
SIGNATURE: LCB
DATE: September 6, 2021

ALTERNATE MATERIAL: ALL 350W STEEL MAY BE SUBSTITUTED WITH 260W IF EASIER TO SOURCE

REVISION HISTORY

REV	DESCRIPTION	DATE
A	ISSUED FOR REVIEW	2/18/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

DRAWN	MARC LOSIER	2/18/2021
CHECKED		
QA		
MFG		
APPROVED		

ROOF MANHOLE

TITLE

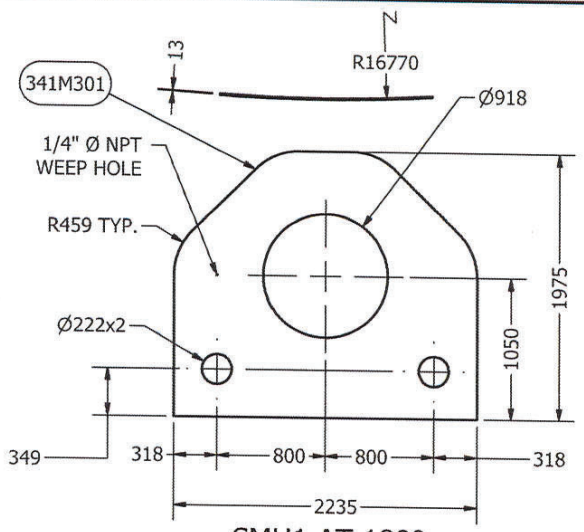
BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43

SIZE	DWG NO	REV
A3	341-M4	1

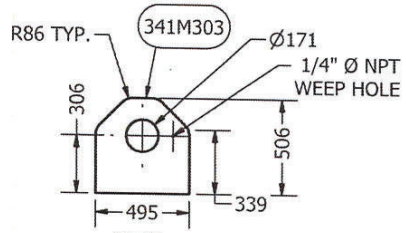
SCALE

SHEET 2 OF 2

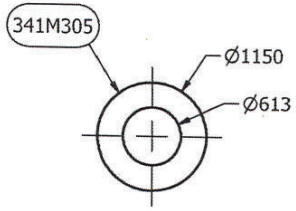
TABLE					
MARK	QTY	DESCRIPTION	MATERIAL	MTR	WT #'S
341M301	1	1/2"THK SEE DETAIL	ASME SA 516 GRADE 70 KILLED FINE GRAIN, NORMALIZED	YES	684
341M302	3	1/2"THK SEE DETAIL	ASME SA 516 GRADE 70 KILLED FINE GRAIN, NORMALIZED	YES	700
341M303	2	1/2"THK SEE DETAIL	ASME SA 516 GRADE 70 KILLED FINE GRAIN, NORMALIZED	YES	35
341M304	4	1/4"THK SEE DETAIL	ASME SA 516 GRADE 70 KILLED FINE GRAIN, NORMALIZED	NO	80
341M305	1	1/4"THK SEE DETAIL	ASME SA 516 GRADE 70 KILLED FINE GRAIN, NORMALIZED	NO	81
341M306	6	1/2"THK SEE DETAIL	ASME SA 516 GRADE 70 KILLED FINE GRAIN, NORMALIZED	YES	11



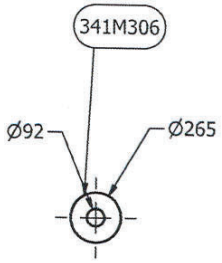
SMH1 AT 180°
900NS SHELL MANHOLE
200NS LOADING AND UNLOADING
QTY: 1
SCALE 1/35



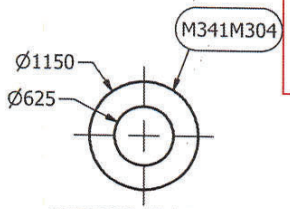
SN5
150NS PUMPING LOW LEVEL
QTY:2
SCALE 1/25



REPAD RN13
600NS VENT
QTY: 1
SCALE 1/50

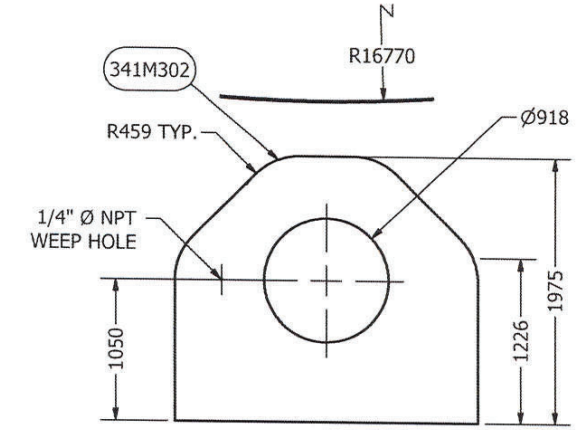


REPAD SN6
80NS WATER DRAWOFF
QTY: 6
SCALE 1/25



REPAD RMH1
600NS ROOF MANHOLE
QTY: 4
SCALE 1/50

STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**
☐ CHANGE ☒ NO CHANGE
NAME: Lindsay C Bolton
SIGNATURE:
DATE: September 6, 2021



SMH2 AT 0°, 90°, 270°
900NS SHELL MANHOLE
QTY: 3
SCALE 1/35

USE THE DROP FROM SHELL COURSE C5S TO CUT REPADS FOR RMH1 AND RN13.
CUT REPADS FOR SMH1, SN5, AND SN6 FROM ONE 1/2" X 96" X 480" PLATE.

REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUED FOR REVIEW	2/18/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

DRAWN	MARC LOSIER	2/18/2021
CHECKED		
QA		
MFG		
APPROVED		

NOZZLE REPAD DETAILS

TITLE

BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43

SIZE	DWG NO	REV
A3	341-M3	1

SCALE

SHEET 1 OF 1

PROFESSIONAL ENGINEERS PROVINCE OF NUNAVUT
S. BROWN
LICENSEE
NT/NU
15-Jun-2021

Permit Number: P471

PARTS LIST FOR ONE (1) ASSY, FOUR (4) PER TANK

ITEM	ITEM QTY	CUT (MM)	DESCRIPTION	MATERIAL
341M1101	1	341	5/8"THK X 66 WIDE PLATE, SEE DETAIL	G40.21M 300W
341M1102	1	373	2 1/2" STD PIPE	A53
341M1103	1		DAVIT ARM, SEE DETAIL	
341M1104	1	198	16 [5/8"] DIA LG SEE DETAIL	Steel
341M1105	1		EYE-BOLT 5/8"DIA X 12" LG CROSBY G291	FORGED STEEL
341M1106	2		5/8"-11UNC Hex Nuts (Inch Series) Heavy Hex Nut	A194 GR4

PARTS LIST FOR ONE (1) DAVIT ARM, FOUR (4) PER TANK

ITEM	ITEM QTY	CUT (MM)	DESCRIPTION	MATERIAL
341M1108	1	645	2"NS XH PIPE	A53
341M1109	1	25	2 1/2"NS STD PIPE	A53
341M11010	1		2"NS HX ELBOW BW 90DEG L.R.	A234
341M11011	1	890	2"NS XH PIPE	A53
341M11012	1	520	FB10X50 [3/8"X2"]	G40.21M 300W

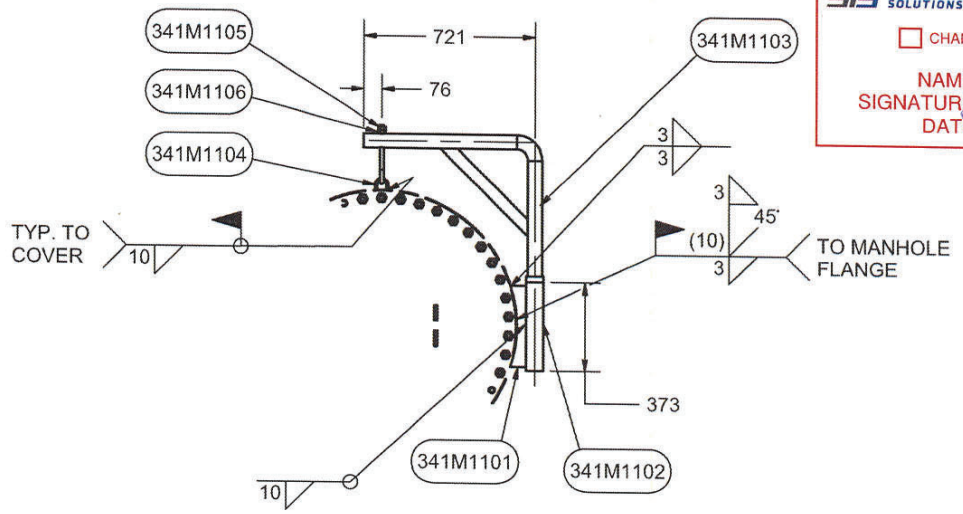
STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

☐ CHANGE ☒ NO CHANGE

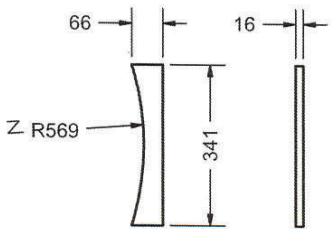
NAME: Lindsay C Bolton

SIGNATURE:

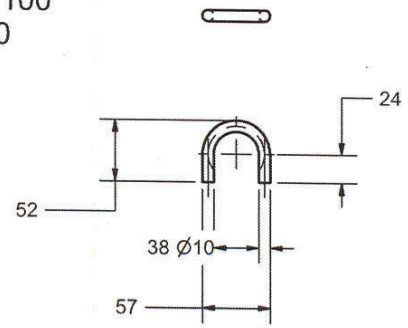
DATE: September 6, 2021



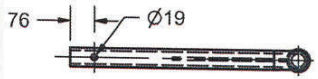
DAVIT ASSEMBLY
QTY: 4
MARK: 341M1100
SCALE 1/20

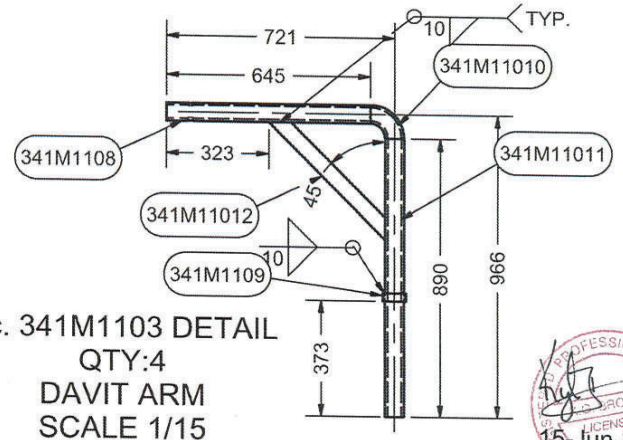


Pc M1101 DETAIL
SCALE 1/10



Pc M1104 DETAIL
SCALE 1/4





Pc. 341M1103 DETAIL
QTY:4
DAVIT ARM
SCALE 1/15

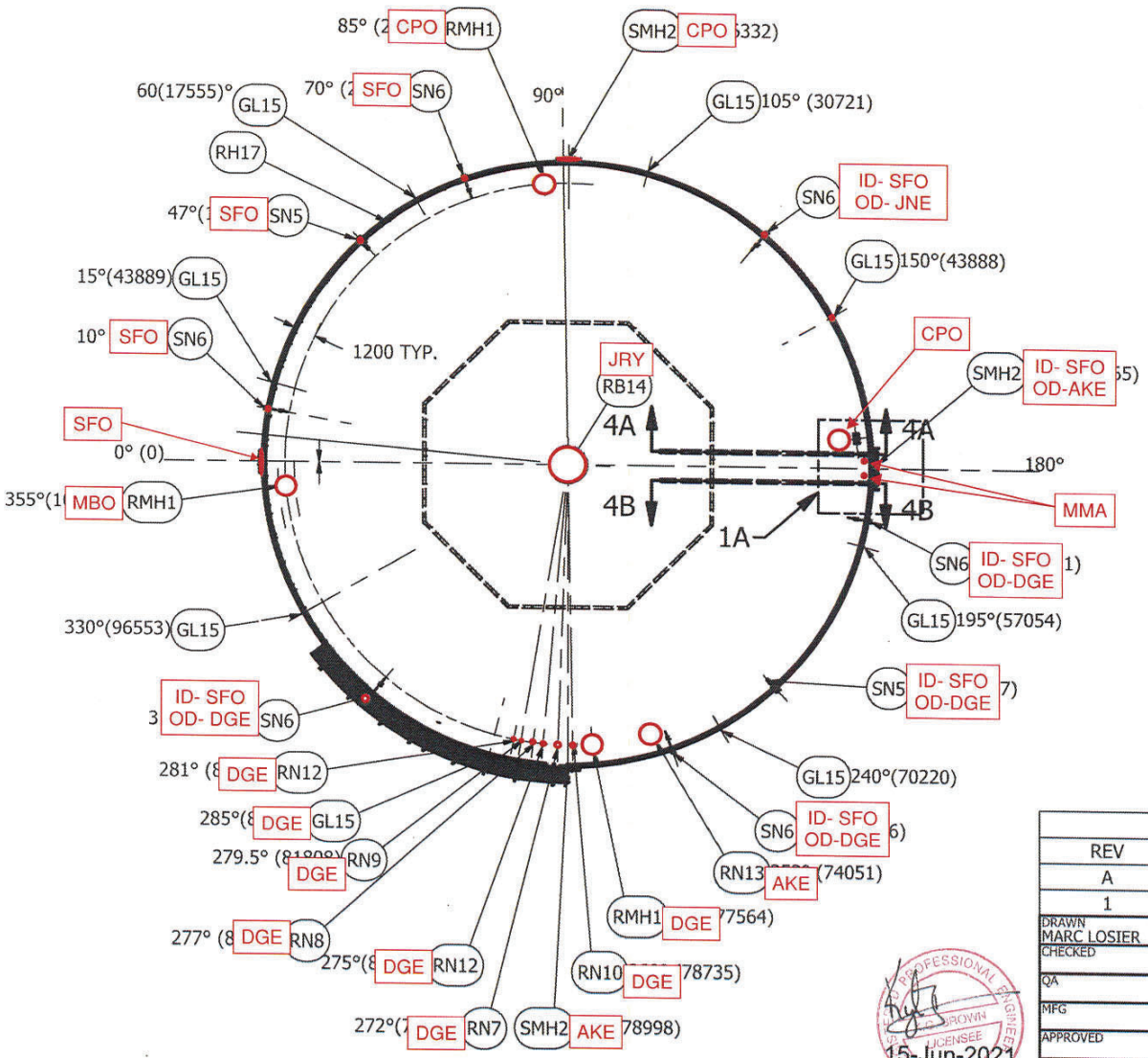
REGISTERED PROFESSIONAL ENGINEER
BROWN
LICENSEE
NT/NU
15-Jun-2021

Permit Number: P471

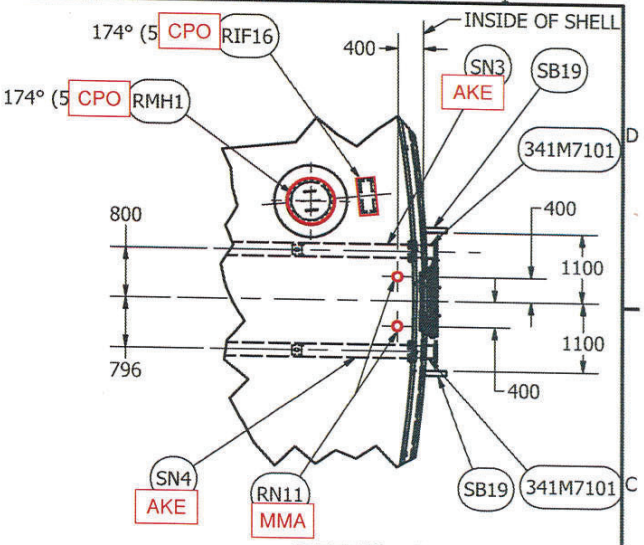
REVISION HISTORY

REV	DESCRIPTION	DATE
A	ISSUED FOR REVIEW	3/10/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

DRAWN MARC LOSIER	3/10/2021	FOR 900MM [36"] NS SHELL MANHOLE
CHECKED		
QA		
MFG		TITLE: MANHOLE COVER DAVIT
APPROVED		
SIZE A3	DWG NO 341-M11	REV 1
SCALE	SHEET 1 OF 1	



PLAN VIEW



DETAIL 1A
SCALE 1/75

DIMENSION IN () DENOTES
ARC LENGTH ON THE EXTERIOR OF
THE SHELL FROM 0° IN MILLIMETRES
MEASURED ON COURSE ONE (1) FOR SHELL NOZZLES
AND ON COURSE FIVE (5) FOR ROOF NOZZLES

REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUE FOR REVIEW	6/1/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

DRAWN MARC LOSIER	5/31/2021	GENERAL ARRANGEMENT AND NOZZLE LAYOUT
CHECKED		
QA		TITLE
MFG		BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43 33.516M I.D.
APPROVED		

SIZE	DWG NO	REV
A3	341-M6	1

SCALE 1/250 SHEET 1 OF 6

PROFESSIONAL ENGINEERS BROWN LICENSEE NT/NU 15-Jun-2021

Permit Number: P471

QUALITY CONTROL MANUAL

VISUAL TEST REPORT

Customer: AGNICO EAGLE

Location: BAKER LAKE

Code Requiring Test: API 650 (section 8.5.2) Reason for Test: New Construction

A weld shall be acceptable by visual examination if the inspection shows the following.

a) There are no crater cracks, other surface cracks or arc strikes in or adjacent to the welded joints.
b) Maximum permissible undercut is 0.4 mm (1/64 in.) in depth for vertical butt joints, vertically oriented permanent attachments, attachment welds for nozzles, manholes, flush-type openings, and the inside shell-to-bottom welds. For horizontal butt joints, horizontally oriented permanent attachments, and annular-ring butt joints, the maximum permissible undercut is 0.8 mm (1/32 in.) in depth.
c) The frequency of surface porosity in the weld does not exceed one cluster (one or more pores) in any 100 mm (4 in.) of length, and the diameter of each cluster does not exceed 2.5 mm (3/32 in.).
d) The reinforcement of the welds on all thicknesses:

Plate Thickness mm (in.)	Maximum Reinforcement Thickness mm (in.)	
	Vertical Joints	Horizontal Joints
≤ 13 (1/2)	2.5 (3/32)	3 (1/8)
> 13 (1/2) to 25 (1)	3 (1/8)	5 (5/16)
> 25 (1)	5 (5/16)	6 (1/4)

Surface Condition (As Welded)

Test Solution: N/A Test Date(s): 2021-09-01

Tested by: Matthew MacKenzie Ambient Conditions: 10 Degrees Celsius

Items Tested:

All Shell Manways.

Results:

Acceptable at time of Inspection.

STS Representative Signature: _____ Date: 2021-09-01

Client Representative Signature _____ Date: 4th Sept 21

Exhibit 32, Rev 1

DIMENSIONAL CHECK REPORT- MANWAYS

Customer: AGNICO EAGLE

Location: BAKER LAKE

Equipment Tag No.: TK 8

Equipment Type: DIESEL STORAGE TANK

Equipment Description:

Code Requiring Test: API 650 Reason for Test: New Construction

(Manholes shall be installed within the following tolerances:
a) specified projection from outside of shell to extreme face of flange, ±13 mm (1/2 in.)
b) elevation and angular location, ±13 mm (1/2 in.)
c) flange tilt in any plane, measured across the flange diameter, ±13 mm (1/2 in.))

Test Date(s): 2021-09-01

Tested by: Matthew MacKenzie

Test Results:

All manways are within tolerance at the time of inspection; acceptable to code.

STS Representative Signature: _____ Date: 2021-09-01

Client Representative Signature: _____ Date: 4th SEPT 21

Exhibit 12, Rev 1

AIR TEST REPORT – NOZZLE REINFORCEMENT PLATE WELDS

Customer: AGNICO EAGLE

Location: BAKER LAKE

Equipment Tag No.: TANK 8

Equipment Type: Above Ground Storage Tank

Equipment Description: Diesel Storage Tank

Code Requiring Test: API 650 Reason for Test: New Construction

(An air pressure/soap solution test for nozzle reinforcement plate weld seams is required for new construction or major alterations, no visible leaks should be observed)

Test Pressure: 100 kPa (15 psi) Surface Condition (As Welded, Painted, Blasted)

Test Solution: Water / Snoop: Test Date(s): 2021-09-

Tested by: Matthew MacKenzie Pressure Gauge: Ambient Conditions: 10 Degrees Celsius

Items Tested:

All Shell Manways.

Results:

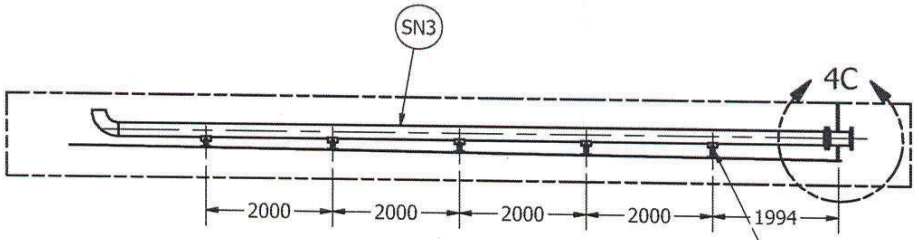
No leaks detected at the time of inspection; acceptable to code.

STS Representative Signature: _____ Date: 2021-09-04

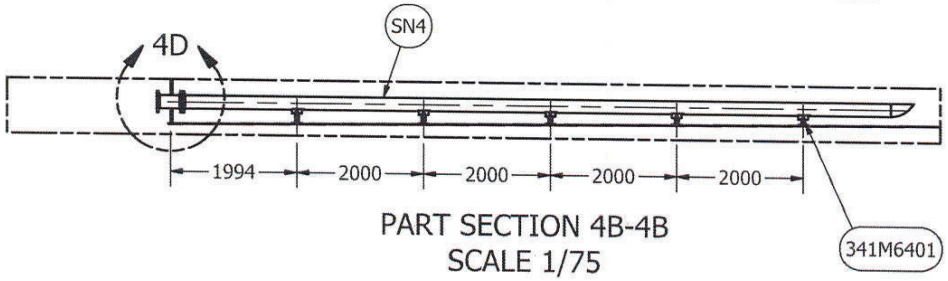
Client Representative Signature: _____ Date: 4th Sept 21

SECTION 16.0

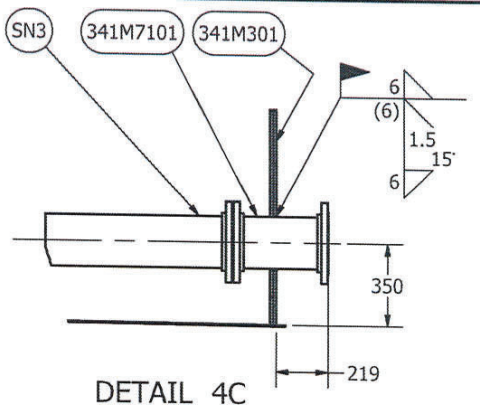
Internals



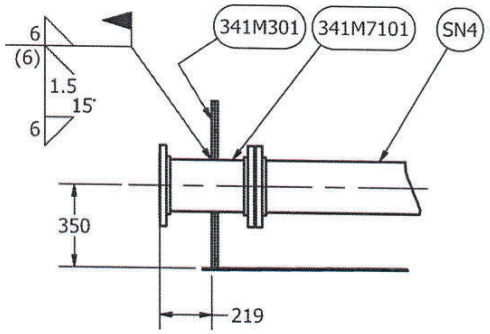
PART SECTION 4A-4A
SCALE 1/75



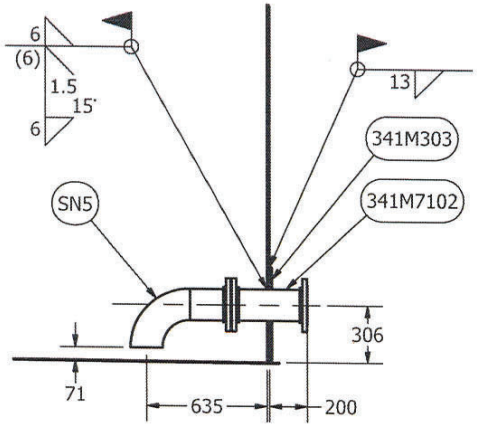
PART SECTION 4B-4B
SCALE 1/75



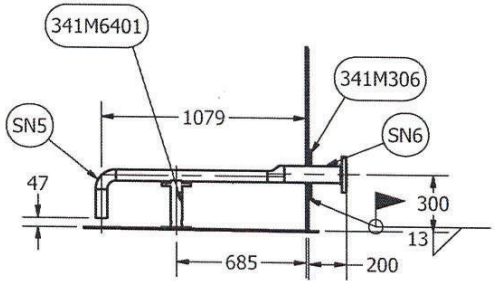
DETAIL 4C
SCALE 1/20



DETAIL 4D
SCALE 1/20



DETAIL 4A
N5 PUMPING LOW SUCTION
SCALE 1/25



DETAIL 4B
N6 WATER DRAWOFF VALVE
SCALE 1/25

STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

☐ CHANGE ☒ NO CHANGE

NAME: Lindsay C Bolton
SIGNATURE:
DATE: September 6, 2021

PROFESSIONAL ENGINEERS — BROWN — LICENSEE — NT/NU
15-Jun-2021

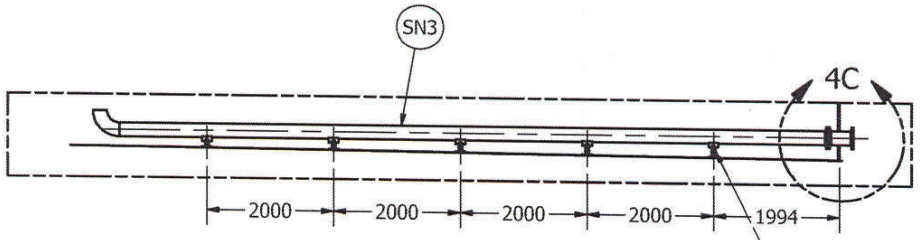
Permit Number: P471

REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUED FOR REVIEW	6/1/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

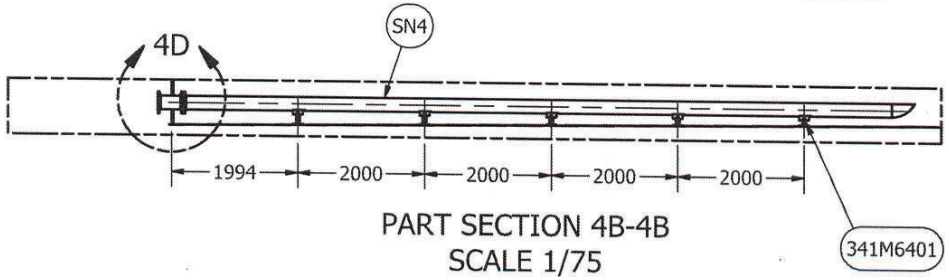
DRAWN MARC LOSIER	5/31/2021	GENERAL ARRANGEMENT AND NOZZLE LAYOUT
CHECKED		
QA		TITLE
MFG		BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43 33.516M I.D.
APPROVED		

SIZE	DWG NO	REV
A3	341-M6	1

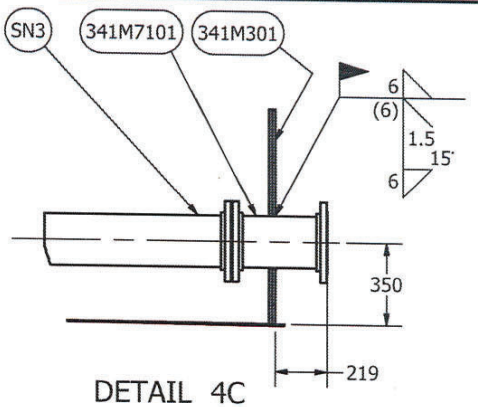
SCALE 1/500 SHEET 4 OF 6



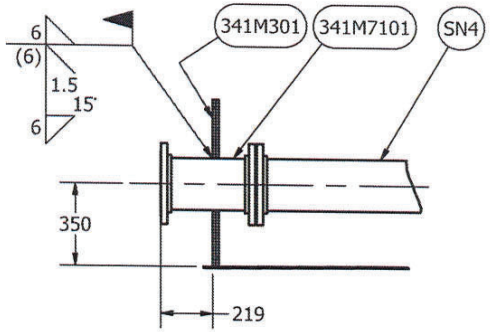
PART SECTION 4A-4A
SCALE 1/75



PART SECTION 4B-4B
SCALE 1/75

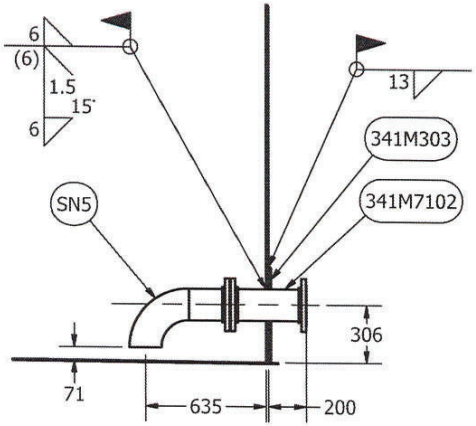


DETAIL 4C
SCALE 1/20

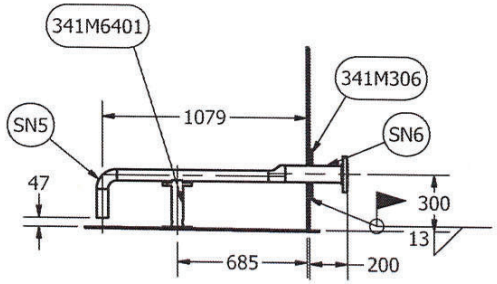


DETAIL 4D
SCALE 1/20

Internal Pipe Supports all welded by: SFO



DETAIL 4A
N5 PUMPING LOW SUCTION
SCALE 1/25



DETAIL 4B
N6 WATER DRAWOFF VALVE
SCALE 1/25

Permit Number: P471

REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUED FOR REVIEW	6/1/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

DRAWN MARC LOSIER	5/31/2021	GENERAL ARRANGEMENT AND NOZZLE LAYOUT
CHECKED		
QA		TITLE
MFG		BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43 33.516M I.D.
APPROVED		

SIZE	DWG NO	REV
A3	341-M6	1

SCALE 1/500 SHEET 4 OF 6

QUALITY CONTROL MANUAL

VISUAL TEST REPORT

Customer: AGNICO EAGLE

Location: BAKER LAKE

Code Requiring Test: API 650 (section 8.5.2) Reason for Test: New Construction

A weld shall be acceptable by visual examination if the inspection shows the following.

a) There are no crater cracks, other surface cracks or arc strikes in or adjacent to the welded joints.
b) Maximum permissible undercut is 0.4 mm (1/64 in.) in depth for vertical butt joints, vertically oriented permanent attachments, attachment welds for nozzles, manholes, flush-type openings, and the inside shell-to-bottom welds. For horizontal butt joints, horizontally oriented permanent attachments, and annular-ring butt joints, the maximum permissible undercut is 0.8 mm (1/32 in.) in depth.
c) The frequency of surface porosity in the weld does not exceed one cluster (one or more pores) in any 100 mm (4 in.) of length, and the diameter of each cluster does not exceed 2.5 mm (3/32 in.).
d) The reinforcement of the welds on all thicknesses:

Plate Thickness mm (in.)	Maximum Reinforcement Thickness mm (in.)	
	Vertical Joints	Horizontal Joints
≤ 13 (1/2)	2.5 (3/32)	3 (1/8)
> 13 (1/2) to 25 (1)	3 (1/8)	5 (3/16)
> 25 (1)	5 (3/16)	6 (1/4)

Surface Condition (As Welded)

Test Solution: N/A Test Date(s): 2021-08- 31

Tested by: Matthew MacKenzie Ambient Conditions: 10 Degrees Celcius

Items Tested:

INTERNAL PIPE SUPPORTS / BASE PLATES.

Results:

ALL WELDING ACCEPTABLE AT TIME OF INSPECTION.

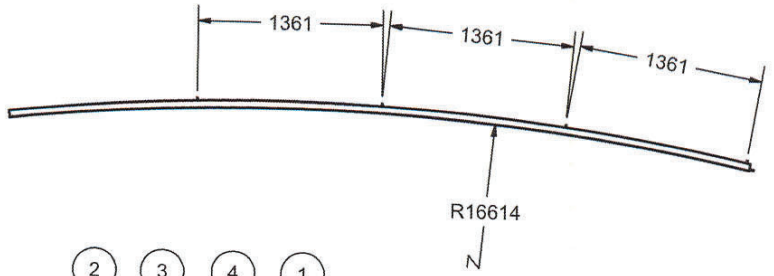
STS Representative Signature: Matthew MacKenzie Date: 2021-08- 31

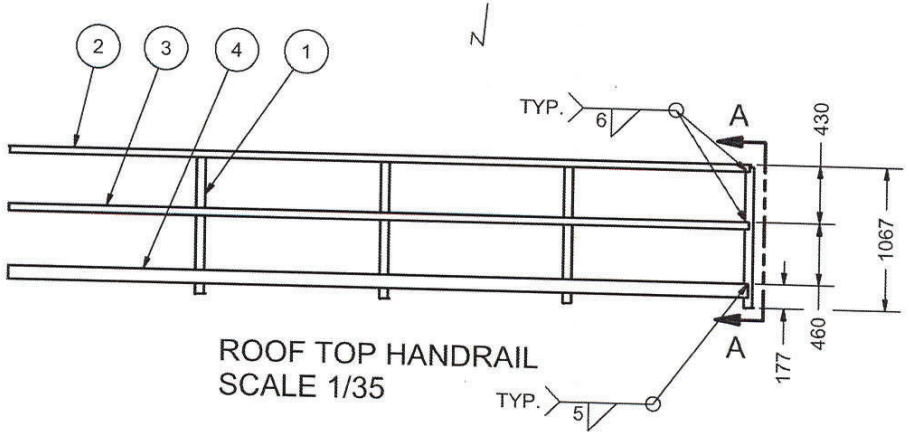
Client Representative Signature: [signature] Date: 4th Sept 21

SECTION 17.0

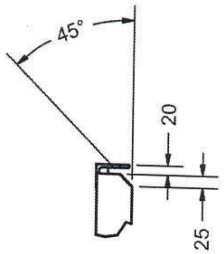
Externals

PARTS LIST FOR ONE (1) ASSY, TWENTY (20) REQUIRED					
ITEM	ITEM QTY	CUT (MM)	DESCRIPTION	MATERIAL	MASS
1	4	1051	L65X65X6	G40.21 300W	6 kg
2	1	5486	L50X50X6	G40.21 300W	26 kg
3	1	5486	FB50X6	G40.21 300W	14 kg
4	1	5486	FB100X5	G40.21 300W	21 kg

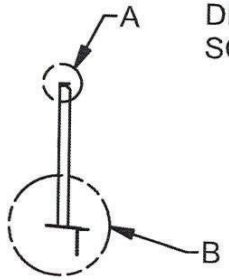




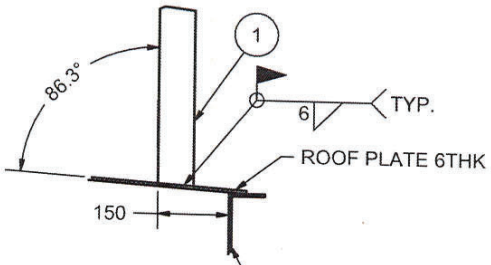
ROOF TOP HANDRAIL
SCALE 1/35



DETAIL A
SCALE 1/10



VIEW A-A
SCALE 1/35



DETAIL B
SCALE 1/10

Professional Engineer
Ryan Brown
Licensee
NT/NU
15-Jun-2021

Permit Number: P471

REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUED FOR REVIEW	3/12/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

DRAWN	MARC LOSIER	3/12/2021
CHECKED		
QA		
MFG		
APPROVED		

ROOF TOP HANDRAIL

TITLE: BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - #8: A6170TNK43

SIZE	DWG NO	REV
A3	341-M8	1

SCALE

SHEET 1 OF 1

STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

☐ CHANGE ☒ NO CHANGE

NAME: Lindsay C Bolton
SIGNATURE: LCB
DATE: September 6, 2021

QUALITY CONTROL MANUAL

VISUAL TEST REPORT

Customer: AGNICO EAGLE

Location: BAKER LAKE

Code Requiring Test: API 650 (section 8.5.2) Reason for Test: New Construction

A weld shall be acceptable by visual examination if the inspection shows the following.

a) There are no crater cracks, other surface cracks or arc strikes in or adjacent to the welded joints.
b) Maximum permissible undercut is 0.4 mm (1/64 in.) in depth for vertical butt joints, vertically oriented permanent attachments, attachment welds for nozzles, manholes, flush-type openings, and the inside shell-to-bottom welds. For horizontal butt joints, horizontally oriented permanent attachments, and annular-ring butt joints, the maximum permissible undercut is 0.8 mm (1/32 in.) in depth.
c) The frequency of surface porosity in the weld does not exceed one cluster (one or more pores) in any 100 mm (4 in.) of length, and the diameter of each cluster does not exceed 2.5 mm (3/32 in.).
d) The reinforcement of the welds on all thicknesses:

Plate Thickness mm (in.)	Maximum Reinforcement Thickness mm (in.)	
	Vertical Joints	Horizontal Joints
≤ 13 (1/2)	2.5 (3/32)	3 (1/8)
> 13 (1/2) to 25 (1)	3 (1/8)	5 (3/16)
> 25 (1)	5 (3/16)	6 (1/4)

Surface Condition (As Welded)

Test Solution: N/A Test Date(s): 2021-08-31

Tested by: Matthew MacKenzie Ambient Conditions: 10 Degrees Celcius

Items Tested:

EXTERNAL BRACKETS + SUPPORTS.

Results:

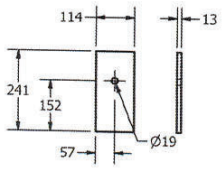
ALL WELDING ACCEPTABLE AT TIME OF INSPECTION.

STS Representative Signature: Matthew MacKenzie Date: 2021-08-31

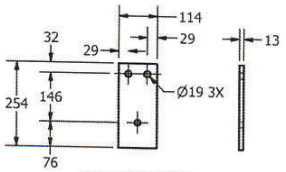
Client Representative Signature: [signature] Date: 4th Sept 21

SECTION 18.0

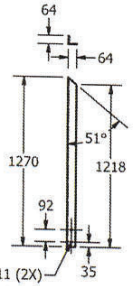
Stairs and Platforms



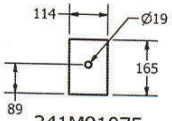
341M91071
QTY: 4
SCALE 1/10



341M91074
QTY: 2
SCALE 1/10



341M91100
QTY: 9
SCALE 1/25



341M91075
QTY:14
SCALE 1/10

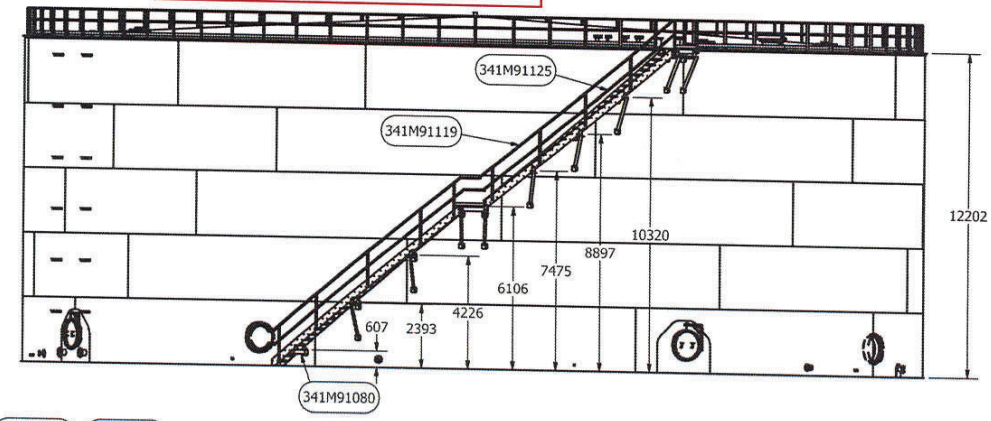
STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

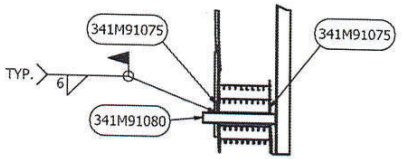
☐ CHANGE ☒ NO CHANGE

NAME: Lindsay C Bolton
SIGNATURE:
DATE: September 6, 2021

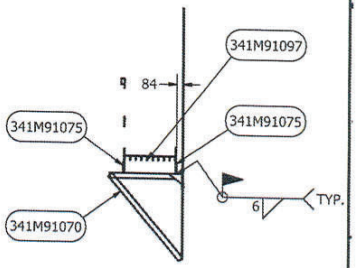
PARTS LIST					
ITEM	QTY	CUT (MM)	DESCRIPTION	MATERIAL	MASS (KG)
341M91011	1	782	L50X50X6	G40.21 300W	3
341M91070	9		SUPPORT BRACKET SEE SHT 3		26
341M91071	4	241	FB114X13 SEE DETAIL	G40.21 300W	3
341M91074	2	254	FB114X13 SEE DETAIL	G40.21 300W	3
341M91075	14	165	FB114X13 SEE DETAIL	G40.21 300W	2
341M91080	1		BOTTOM STAIRWAY BRACKET SEE SHT 3		35
341M91081	2	1254	L65X65X6	G40.21 300W	8
341M91084	1	972	L50X50X6	G40.21 300W	5
341M91085	1	981	FB50X6	G40.21 300W	2
341M91097	2		STAIRWAY ASSEMBLY SEE SHT 4		453
341M91098	2		PLATFORM SEE SHEET 2		102
341M91100	9	1270	L65X65X6 SEE DETAIL	G40.21 300W	8
341M91112	1	701	FB50X6	G40.21 300W	2
341M91115	1	981	FB100X5	G40.21 300W	4
341M91116	1	1005	FB100X5	G40.21 300W	4
341M91117	1	1225	FB100X5	G40.21 300W	5
341M91119	1	9412	L50X50X6 - TOP RAIL	G40.21 300W	29
341M91120	1	1079	L50X50X6	G40.21 300W	5
341M91121	1	1077	FB50X6	G40.21 300W	3
341M91125	1	9412	FB50X6 - MID RAIL	G40.21 300W	8
341M91201	32		5/8" x 2" LG HEX HD BOLT C/W (1) NUT & LOCK WASHER AND (2) FLAT WASHER	A325	
341M91202	20		3/8" X 1 1/2" LG HEX HD BOLT C/W (1) NUT & LOCK WASHER AND (2) FLAT WASHER	A325	
126	1	1		Steel	1923
127	1	1		Steel	1443
128	2	1		Steel	1202
129	1	1		Steel	962

* CHECK CUT LENGTH AT SITE

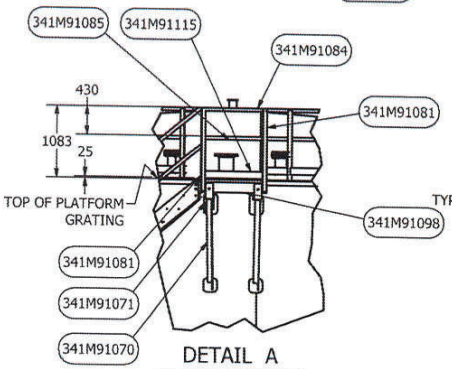




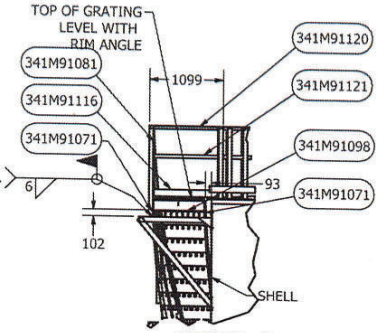
DETAIL D
BOTTOM STAIRWAY BRACKET
SCALE 1/50



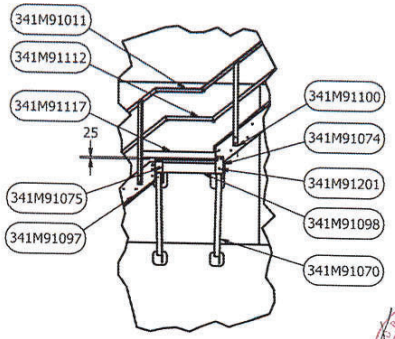
DETAIL E
TYPICAL STAIRWAY BRACKET
SCALE 1 / 50



DETAIL A
TOP PLATFORM
FRONT VIEW
SCALE 1 / 50



DETAIL B
TOP PLATFORM
SIDE VIEW
SCALE 1 / 50



DETAIL C
MID PLATFORM
SCALE 1 / 50

PROFESSIONAL ENGINEERS BROWN JESSEF NT/NU
15-Jun-2021
Permit Number: P471

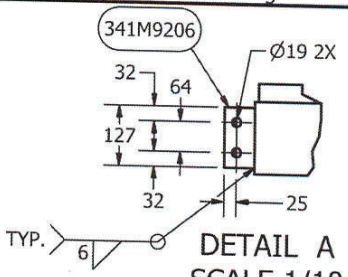
REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUED FOR REVIEW	4/05/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

DRAWN: MARC LOSIER 4/5/2021
CHECKED
QA
MFG
APPROVED

STAIRWAY AND PLATFORMS

TITLE
BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43 STAIRWAY AND PLATFORM

SIZE A2 | DWG NO 341-M9 | REV 1
SCALE 1 / 100 | SHEET 1 OF 4



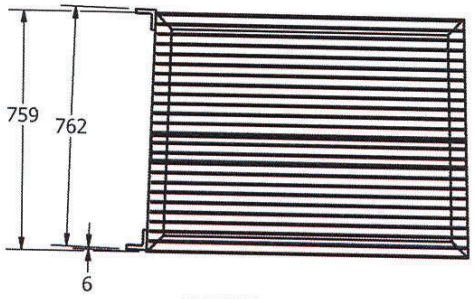
DETAIL A
SCALE 1/10

PARTS LIST FOR ONE TANK TWO (2) REQUIRED					
ITEM	ITEM QTY	CUT (MM)	DESCRIPTION	MATERIAL	MASS
341M9201	1	1016	C150X16	G40.21 350W	15 kg
341M9202	1	972	C150X16	G40.21 350W	15 kg
341M9203	1	995	L76X76X10	G40.21 300W	11 kg
341M9204	2	760	C150X16	G40.21 350W	11 kg
341M9205	1		Welded steel grating type 30-102, 25mm x 4.8mm serrated bearing bars @ 32mm c/c, cross rods @ 102mm c/c, galvanized	Steel, Galvanized	35 kg
341M9206	2	127	L65X65X14	G40.21 300W	1 kg

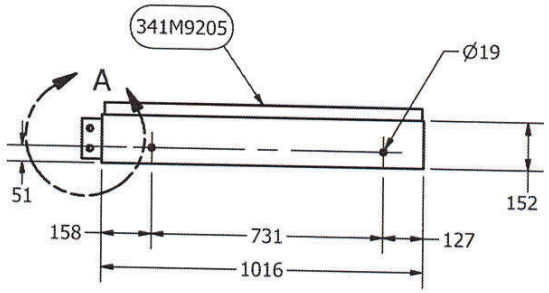
STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

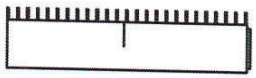
☐ CHANGE ☒ NO CHANGE

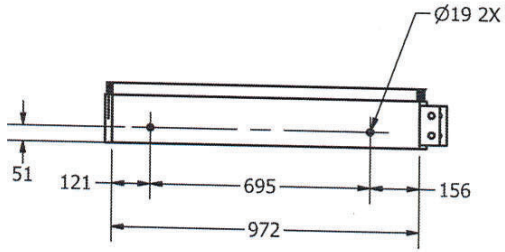
NAME: Lindsay C Bolton
SIGNATURE:
DATE: September 6, 2021

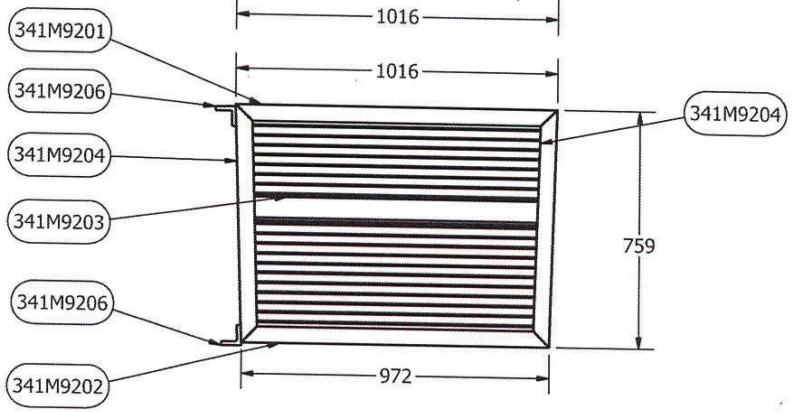


MARK: 341M91098
QTY: 2









Permit Number: P471

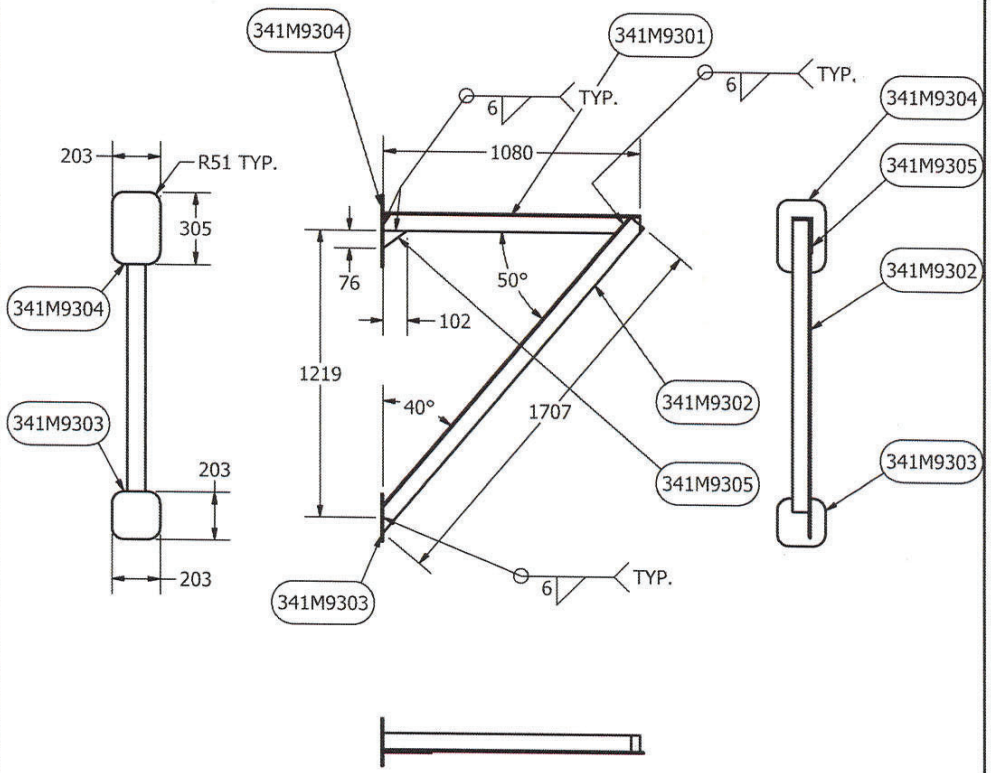
REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUED FOR REVIEW	4/05/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

DRAWN MARC LOSIER	4/5/2021	TOP PLATFORM
CHECKED		
QA		
MFG		TITLE: BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43 STAIRWAY AND PLATFORM
APPROVED		

SIZE	DWG NO	REV
A3	341-M9	1

SCALE 1/15 SHEET 2 OF 4

PARTS LIST FOR ONE TANK 9 REQUIRED					
ITEM	ITEM QTY	CUT (MM)	DESCRIPTION	MATERIAL	MASS (KG)
341M9301	1	1080	L76X76X6	G40.21 300W	8
341M9302	1	1707	L76X76X6	G40.21 300W	12
341M9303	1	203	FB203X6	G40.21 300W	2
341M9304	1	305	FB203X6	G40.21 300W	3
341M9305	1	152	FB102X6	G40.21 300W	1



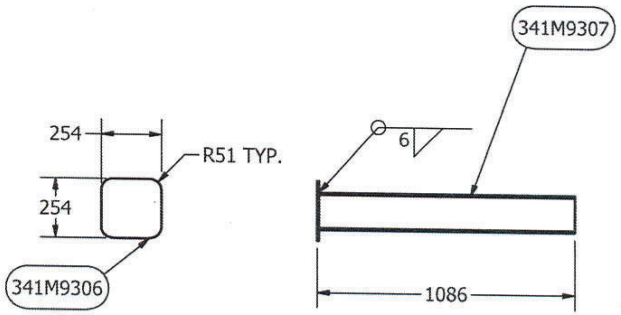
MARK: 341M91070
QTY: 9

PARTS LIST FOR ONE TANK ONE REQUIRED					
ITEM	QTY	CUT (MM)	DESCRIPTION	MATERIAL	MASS (KG)
341M9306	1		PL254X254X6	G40.21 300W	3
341M9307	1	1080	W150X30	G40.21 350W	32

STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**

☐ CHANGE ☒ NO CHANGE

NAME: Lindsay C Bolton
SIGNATURE: LCB
DATE: September 6, 2021



MARK: 341M91080
QTY: 1

Permit Number: P471

REVISION HISTORY		
REV	DESCRIPTION	DATE
A	ISSUED FOR REVIEW	4/05/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

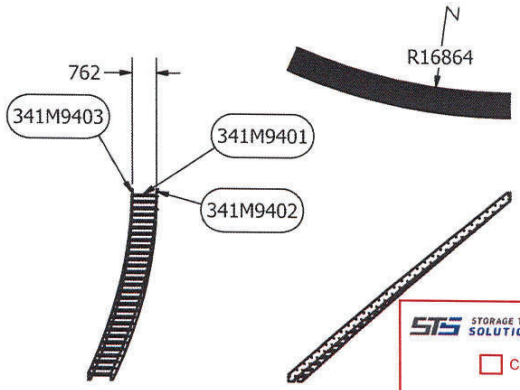
DRAWN MARC LOSIER	4/5/2021	SUPPORT BRACKETS
CHECKED		
QA		TITLE
MFG		BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43 STAIRWAY AND PLATFORM
APPROVED		

SIZE	DWG NO	REV
A3	341-M9	1

SCALE 1/20 SHEET 3 OF 4

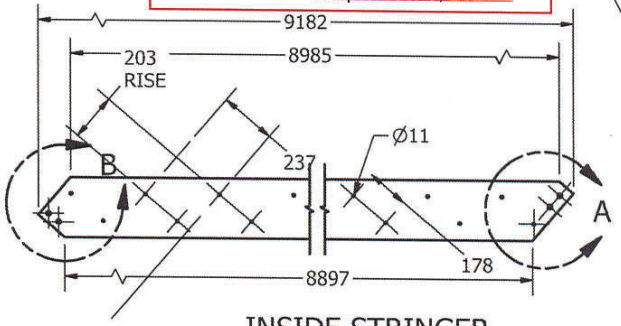
PARTS LIST FOR ONE TANK, TWO (2) REQ'D

ITEM	QTY	DESCRIPTION	MATERIAL	MASS (KG)
341M9401	29	WELDED STEEL TREADS TYPE 19-4 1-1/2" X 3/16" SERRATED, STANDARD END PLATES, CH. PL. NOSING, 9-3/4" X 30"	Steel, Galvanized	8
341M9402	1	OUTER STRINGER 6THK X 254 X 9412	G40.21 300W	117
341M9403	1	INSIDE STRINGERTHK X 254 X 9182	G40.21 300W	114
341M9404	116	3/8" X 1 1/2" LG HEX HD BOLT C/W (1) NUT & LOCK WASHER AND (2) FLAT WASHER	A325 GALV	

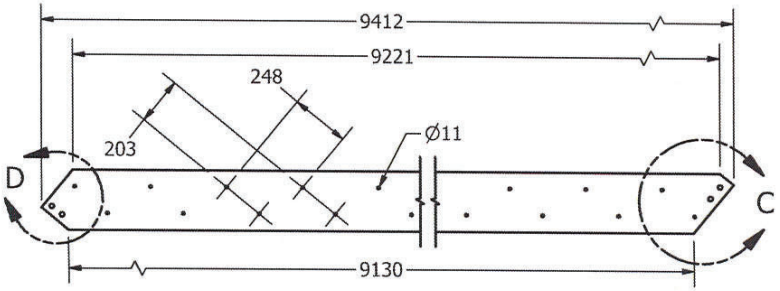


MARK 315M9106
STAIRWAY ASSY
SCALE 1/150

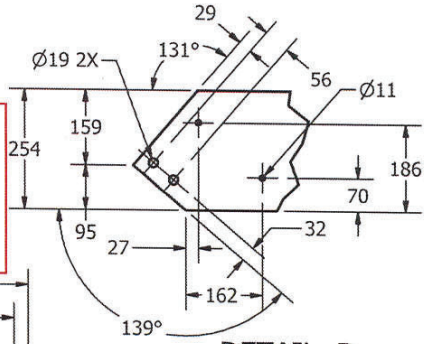
STS STORAGE TANK SOLUTIONS **AS BUILT STAMP**
☐ CHANGE ☒ NO CHANGE
NAME: Lindsay C Bolton
SIGNATURE:
DATE: September 6, 2021



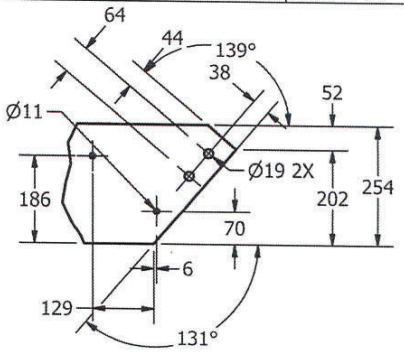
INSIDE STRINGER
MARK: 315M9403
SCALE 1/20



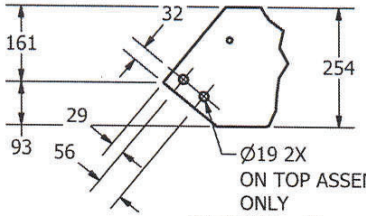
OUTER STRINGER
315-M9402
SCALE 1/20



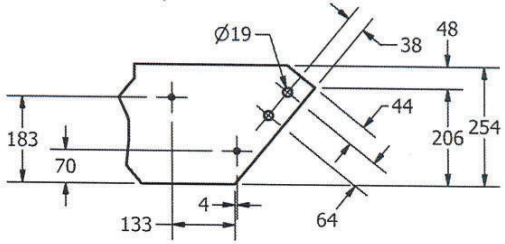
DETAIL B
SCALE 1 / 10



DETAIL A
SCALE 1 / 10



DETAIL D
SCALE 1 / 10



DETAIL C
SCALE 1 / 10

REVISION HISTORY

REV	DESCRIPTION	DATE
A	ISSUED FOR REVIEW	4/05/2021
1	ISSUED FOR CONSTRUCTION	6/8/2021

DRAWN MARC LOSIER	4/5/2021	STAIRWAY STEPS AND STRINGER ASSEMBLY
CHECKED		
QA		TITLE
MFG		BAKER LAKE WHALE TAIL PROJECT - 10M LITERS - TANK #8: 6170TNK43 STAIRWAY AND PLATFORM
APPROVED		

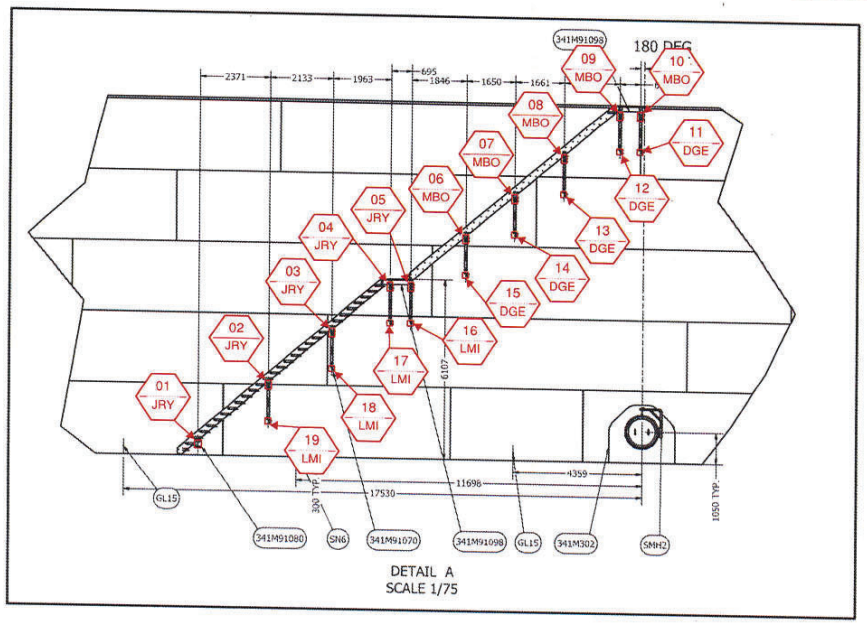
SIZE	DWG NO	REV
A3	341-M9	1

SCALE 1/150 SHEET 4 OF 4

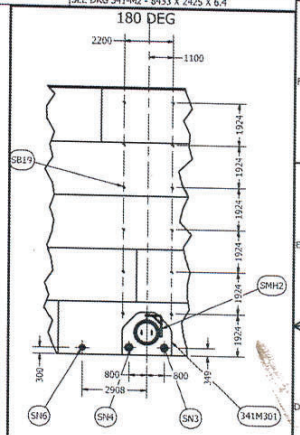
APEGGA PROFESSIONAL ENGINEERS S. G. BROWN LICENSEE NT/NU
15-Jun-2021
Permit Number: P471

Stair Bracket Weld Mapping

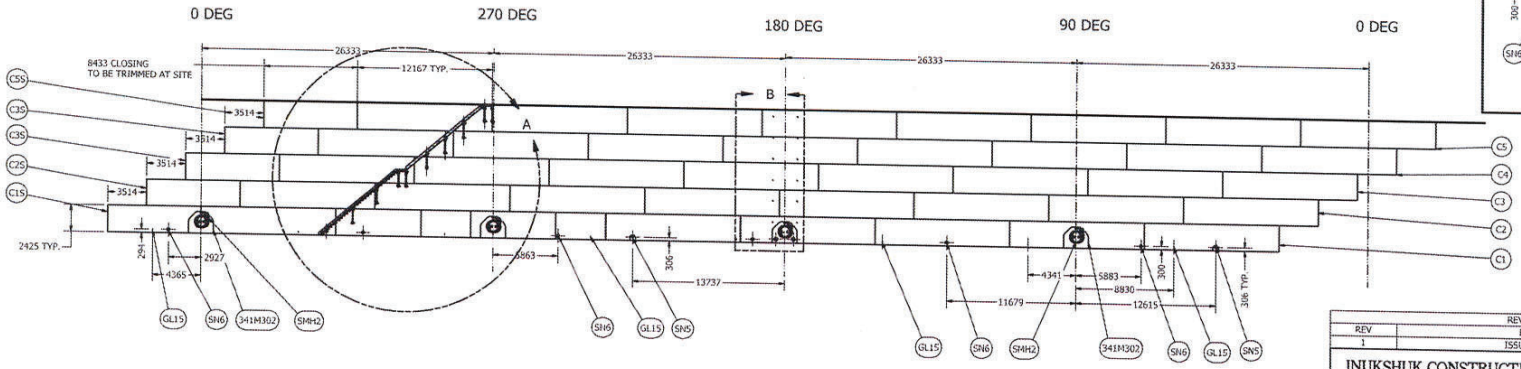
PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
SN3	1	200NS - FITTED PIPE TANK LOADING	SEE DRG 341-M7 - SHT 1 & 3
SN4	1	200NS - FITTED PIPE TANK UNLOADING	SEE DRG 341-M7 - SHT 1 & 4
SN5	2	150NS - PUMPING LOW SUCTION	SEE DRG 341-M7 - SHT 6
SN6	6	75 NS WATER DRAW OFF	SEE DRG 341-M7 - SHT 7
GL15	8	GROUNDING LUG	SEE DRG 341-M6 - SHT 2
SB19	12	AISC - L 3 x 3 x 1/4 - 15.75" - BRACKET FOR PRV PIPING	SEE DRG 341-M6 - SHT 3
341M301	1	900NS SHELL MANWAY REPAD 200NS LOADING AND UNLOADING AT 180 DEG	SEE DRG 341-M3
341M302	3	900 NS SHELL MANWAY REPAD AT 0, 90 & 270 DEG	SEE DRG 341-M3
C1	8	C1 - SHELL PLATE COURSE 1	SEE DRG 341-M2 - 12167 X 2425 X 12.7
C2	8	C2 - SHELL PLATE COURSE 2	SEE DRG 341-M2 - 12167 X 2425 X 9.5
C3 & C4	16	C3 & C4 - SHELL PLATE COURSE 3 & 4	SEE DRG 341-M2 -12167 X 2425 X 7.9
C5	8	C5 - SHELL PLATE COURSE 5	SEE DRG 341-M2 - 12167 X 2425 X 6.5
341M9401	58	STAIR THREAD	SEE DRG 341-M9 SHT 4
341M91070	9	STAIRWAY SUPPORT BRACKET	SEE DRG 341-M9 - SHT 3
341M91080	1	BOTTOM STAIRWAY BRACKET	SEE DRG 341-M9 R1 SHT 3
341M91098	2	PLATFORM	SEE DRG 341-M9 R1 - SHT 2
C1S	1	SHELL PLATE COURSE 1 CLOSURE (TRIM AT SITE)	SEE DRG 341-M2 - 8433 X 2425 X 12.7
C2S	1	SHELL PLATE COURSE 2 CLOSURE (TRIM AT SITE)	SEE DRG 341-M2 - 8433 X 2425 X 9.5
C3S	1	SHELL PLATE COURSE 3 CLOSURE (TRIM AT SITE)	SEE DRG 341-M2 - 8433 X 2425 X 7.9
C4S	1	SHELL PLATE COURSE 4 CLOSURE (TRIM AT SITE)	SEE DRG 341-M2 - 8433 X 2425 X 7.9
C5S	1	SHELL PLATE COURSE 5 CLOSURE (TRIM AT SITE)	SEE DRG 341-M2 - 8433 X 2425 X 6.4



DETAIL A
SCALE 1/75



DETAIL B
SCALE 1 / 100



TANK DEVELOPPED VIEW
SCALE 1 / 200

NOTE:
- GUARDRAILS NOT SHOWN FOR INCLUDED FOR CLARITY.

REVISION HISTORY		
REV	DESCRIPTION	DATE
1	ISSUED FOR CONSTRUCTION	6/7/2021

INUKSHUK CONSTRUCTION LIMITED
-GRAVEL CRUSHING
-EARTHWORK
-PROCESS PIPE WELDING
-INDUSTRIAL CONTRACTING

PO BOX 654
RANKIN INLET, NU
X0C1G0
PH: (867) 645-4030
FAX: (902) 429-7762

15-Jun-2021
Permit Number: P471

ALL DIMENSIONS IN MM

DRAWN	MARC LOSIER	6/7/2021
CHECKED		
QA		
MFG		
APPROVED		

TANK DEVELOPED VIEW

TITLE: BAKER LAKE WHALE TAIL PROJECT FLOOR AND ROOF LAYOUT FOR 10,000CUM TANK

SIZE: A1 | DWG NO: 341-M10 | REV: A
SCALE: 1 / 200 | SHEET 1 OF 1

QUALITY CONTROL MANUAL

VISUAL TEST REPORT

Customer: AGNICO EAGLE

Location: BAKER LAKE

Code Requiring Test: API 650 (section 8.5.2) Reason for Test: New Construction

A weld shall be acceptable by visual examination if the inspection shows the following.

a) There are no crater cracks, other surface cracks or arc strikes in or adjacent to the welded joints.
b) Maximum permissible undercut is 0.4 mm (1/64 in.) in depth for vertical butt joints, vertically oriented permanent attachments, attachment welds for nozzles, manholes, flush-type openings, and the inside shell-to-bottom welds. For horizontal butt joints, horizontally oriented permanent attachments, and annular-ring butt joints, the maximum permissible undercut is 0.8 mm (1/32 in.) in depth.
c) The frequency of surface porosity in the weld does not exceed one cluster (one or more pores) in any 100 mm (4 in.) of length, and the diameter of each cluster does not exceed 2.5 mm (3/32 in.).
d) The reinforcement of the welds on all thicknesses:

Plate Thickness mm (in.)	Maximum Reinforcement Thickness mm (in.)	
	Vertical Joints	Horizontal Joints
≤ 13 (1/2)	2.5 (3/32)	3 (1/8)
> 13 (1/2) to 25 (1)	3 (1/8)	5 (3/16)
> 25 (1)	5 (3/16)	6 (1/4)

Surface Condition (As Welded)

Test Solution: N/A Test Date(s): 2021-08-31

Tested by: Matthew MacKenzie Ambient Conditions: 10 Degrees Celcius

Items Tested:

STAIRS & PLATFORMS.

Results:

ALL WELDING ACCEPTABLE AT TIME OF INSPECTION.

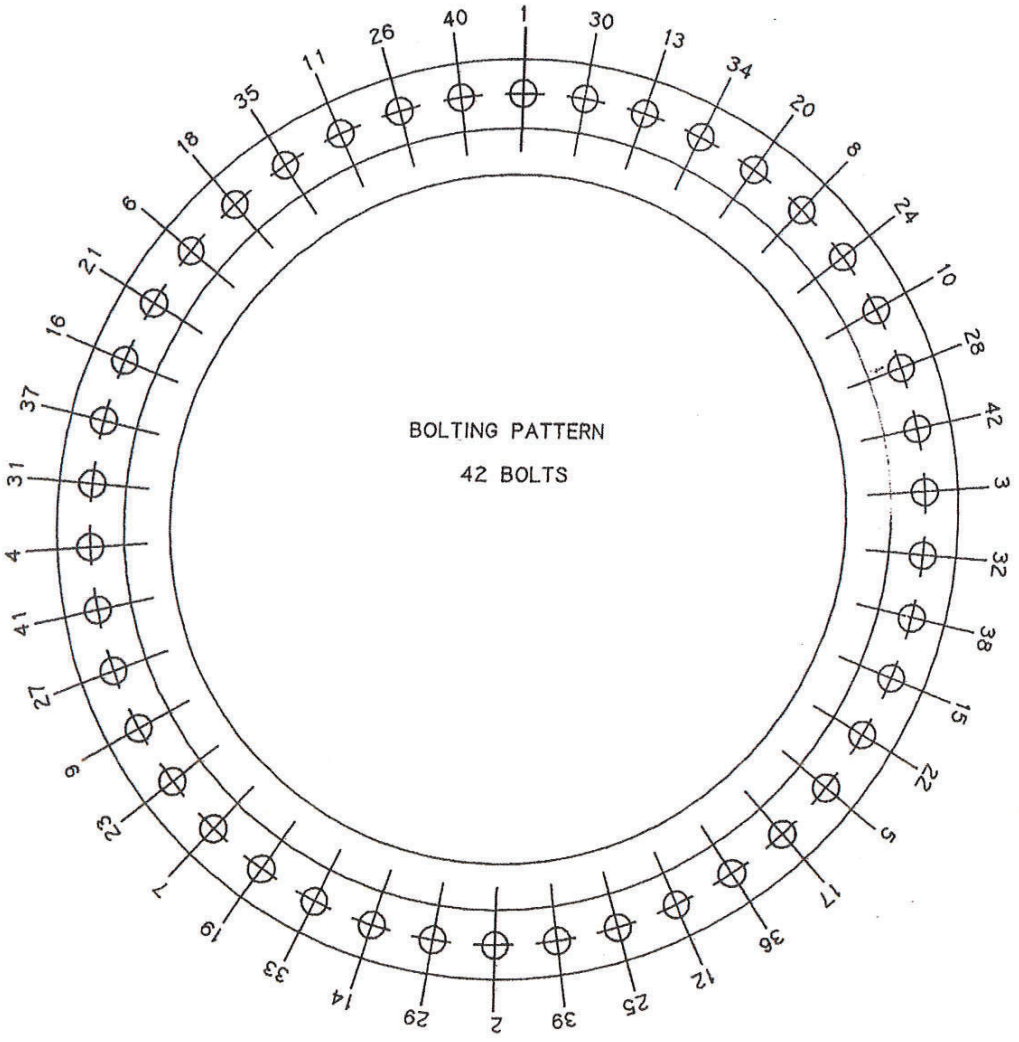
STS Representative Signature: Matthew MacKenzie Date: 2021-08-31

Client Representative Signature: [signature] Date: 1st Sept 21

SECTION 19.0

Bolts and Nuts

Garlock
SEALING TECHNOLOGIES



Garlock Sealing Technologies
Garlock Inc
1666 Division Street
Palmyra, New York 14522-9350
800-448-6688
315-597-4811
Fax: 800-543-0598
http://www.garlock.net

Factors Affecting Gasket Performance

A gasket has one basic function: to create a positive seal between two relatively stationary parts. The gasket must do a number of different jobs well to function properly - first, create an initial seal; second, maintain the seal over a desired length of time; third, be easily removed and replaced. Varying degrees of success are dependent on how well the gasket does the following:

1. Seals system fluid.
2. Chemically resists the system fluid to prevent serious impairment of its physical properties.
3. Deforms enough to flow into the imperfections on the gasket seating surfaces to provide intimate contact between the gasket and the sealing surfaces.
4. Withstands system temperatures without serious impairments of its performance properties.
5. Is resilient and creep resistant enough to maintain an adequate portion of the applied load.
6. Has sufficient strength to resist crushing under the applied load, and maintain its integrity when being handled and installed.
7. Does not contaminate the system fluid.
8. Does not promote corrosion of the gasket seating surfaces.
9. Is easily and cleanly removable at the time of replacement.

During the gasket product selection process that follows, we recommend that these nine (9) factors be used as a checklist from the viewpoint of the user's degree of need for each factor and the manufacturer's degree of compliance.

Garlock Sealing Technologies
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1666 Division Street
Palmyra, New York 14522-9350
800-448-6688
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Fax: 800-543-0598
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Installation

A few simple precautionary measures must be observed during installation to ensure the most satisfactory joint.

- Center the gasket on the flange. This is extremely vital where raised faces are involved.
- Be sure surface finish and flatness are satisfactory.
- Tighten the bolts to compress the gasket uniformly. This means going from side to side around the joint. See Figure 1.
- Use a torque wrench, well-lubricated fasteners, and hardened flat washers to ensure correct initial loading.
- All bolts should be tightened in one-third increments, according to proper bolting patterns.
- Make a final check pass at the target torque value moving consecutively from bolt to bolt.
- Retorque 12 to 24 hours after initial installation, whenever possible. All applicable safety standards including lockout/tagout procedures should be observed.
- Never use liquid or metallic based anti-stick or lubricating compounds on the gaskets. Premature failure could occur as a result.

Correct Bolting Patterns

Figure 1