

Client :	Inukshuk Construction Ltd,	Date d'intervention :	2018-06-19 to 24
Adresse/Address :	, PO Box 654 Rankin Inlet, Nunavut X0C 0G0	Intervention date :	
Contact :	Marc Losier	Date du rapport :	2018-06-27
Entrepreneur :	tClient	Report date :	
Contractor :		N° dossier :	INS-118016-02
Endroit du travail :	Site Meliadine Gold Mine at	File no :	
Job location :	Rankin Inlet	Commande :	295-1024
		Order :	



List the spots repairs with regulated length and accepted after repair R1

Techniciens :	Etienne Munger	Assistants:	Approuvé par :	Patrick Brodeur
Technicians :			Approved by :	Technical Supervisor
	CGSB 48.9712 MT Level 2 UT/PT niv.1			CSA W178.2 niv.3
		Qualification		

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Client :	Inukshuk Construction Ltd,	Date d'intervention :	2018-06-19 to 24
Adresse/Address :	, PO Box 654 Rankin Inlet, Nunavut X0C 0G0	Intervention date :	
Contact :	Marc Losier	Date du rapport :	2018-06-27
Entrepreneur :	tClient	Report date :	
Contractor :		N° dossier :	INS-118016-02
File no :		Commande :	295-1024
Endroit du travail :	Site Meliadine Gold Mine at Rankin Inlet	Order :	

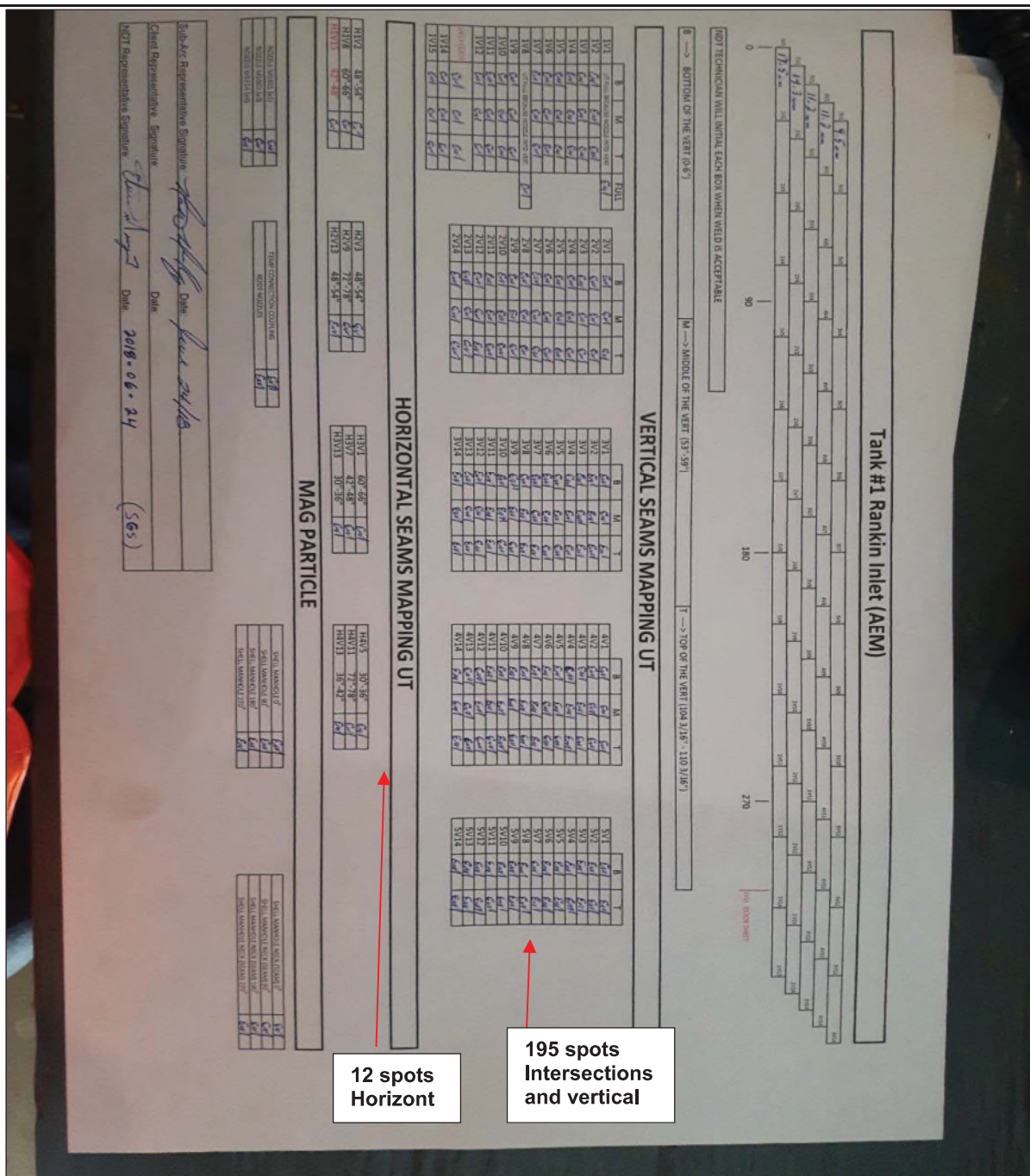


Tank No 1 – Zero degrees

Techniciens :	Etienne Munger	Assistants:		Approuvé par :	Patrick Brodeur
Technicians :				Approved by :	Technical Supervisor
	CGSB 48.9712 MT Level 2 UT/PT niv.1		Qualification		CSA W178.2 niv.3

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Job location :		Commande :	295-1024
		Order :	



Mapping UT

Techniciens : Technicians :	Etienne Munger	Assistants:	Patrick Brodeur Technical Supervisor
CGSB 48.9712 MT Level 2 UT/PT niv.1		Qualification	CSA W178.2 niv.3

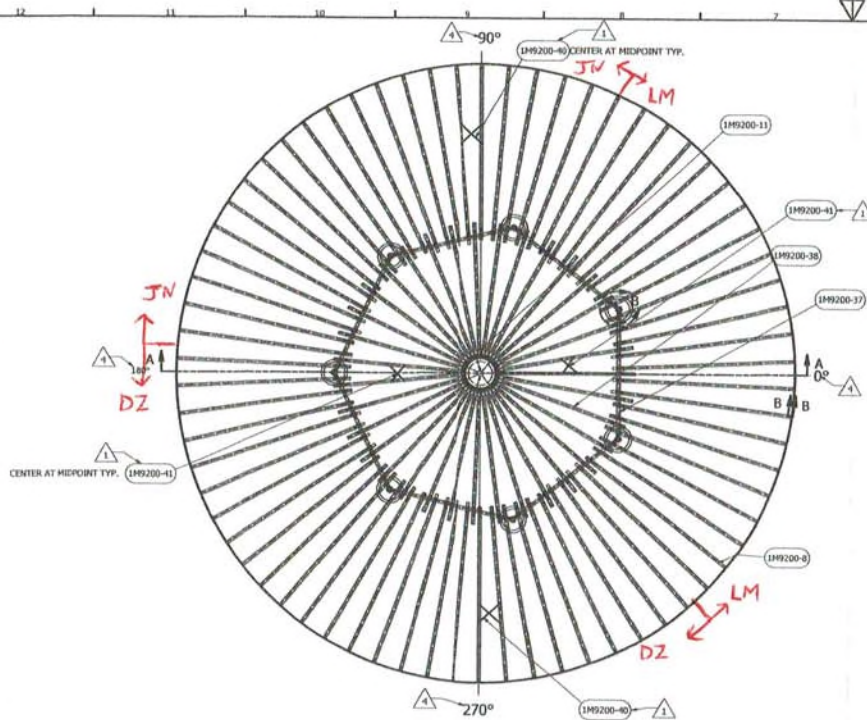
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Field Erected Fuel Storage Tank Handover Package

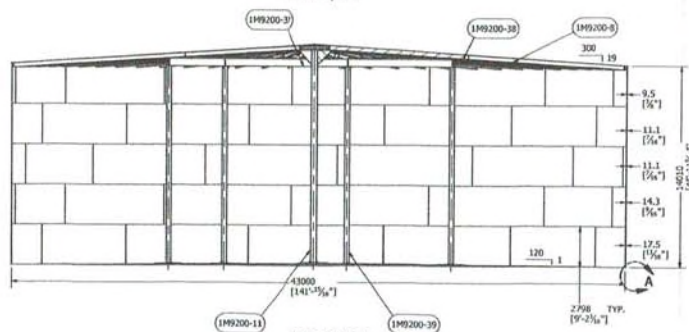
Item 11 – Compression Ring

Contents

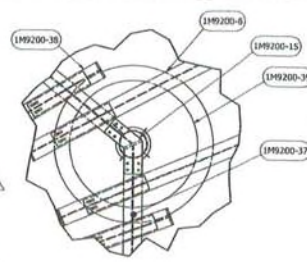
1. Weld Map
2. Visual Report



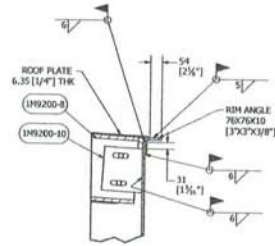
RAFTER LAYOUT
PLAN VIEW
ROOF REMOVED FOR CLARITY
SCALE 1/150



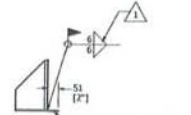
SECTION A-A
SCALE 1/150



DETAIL B
SCALE 1/25

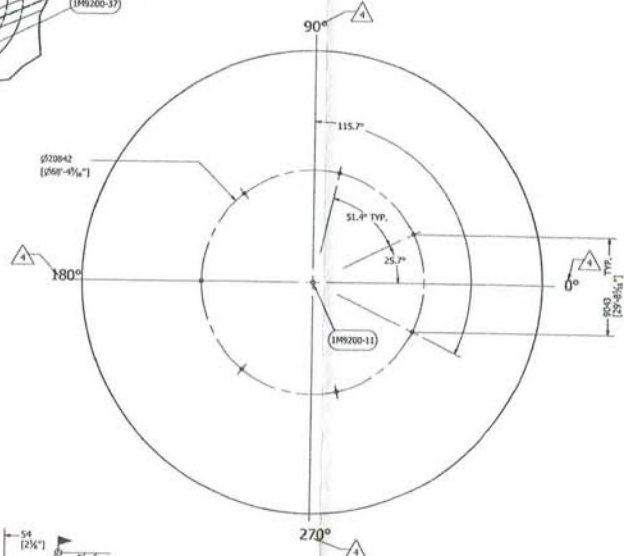


SECTION B-B
SHELL CLIP FITTING DETAIL
SCALE 1/10



DETAIL A
SCALE 1/10

PARTS LIST			
ITEM	ITEM QTY	Description	MATERIAL
1M9200-8	70	OUTER RAFTER - SEE SHT. 2	G40.21M - 350W
1M9200-10	70	SHELL CLIP - SEE SHT. 2	G40.21M - 300W
1M9200-11	1	CENTER COLUMN - SEE SHT. 3	
1M9200-15	7	TOP INTERMEDIATE GIRDOR CONNECTION PLATE - SEE SHT. 2	G40.21M - 300W
1M9200-37	7	INTERMEDIATE GIRDER BEAM ASSY - SEE SHT. 2	
1M9200-38	35	INNER RAFTER - SEE SHT. 2	G40.21M - 350W
1M9200-39	7	INTERMEDIATE COLUMN - SEE SHT. 3	
1M9200-40	4	FB50X6 (F82"x14") - 21.0M [7'-3"] LG	G40.21M - 300W
1M9200-41	4	FB50X6 (F82"x14") - 15.74 [5'-2"] LG	G40.21M - 300W



COLUMNS LAYOUT DETAILS
SCALE 1/200

REVISION HISTORY			
ZONE	REV	DESCRIPTION	DATE
G7, D6, H6, E12, B5	1	RAFTER BRACE ADDED, WELDING DETAIL ADDED IN DETAIL A	3/31/2017
F7, H9, F11, D9, F1, G3, F5, D3	4	REFERENCE ANGLES CHANGED	4/24/2017
DRAWN: MARC LOGHER			
CHECKED: [Signature]			
DATE: 3/17/2017			
PROJECT: 295-M9			
SHEET 1 OF 7			



QUALITY CONTROL MANUAL

Exhibit 15c, Rev 1

VISUAL TEST REPORT

Customer: Agnico Eagle

Location: Rankin Inlet

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.

- There are no crater cracks, other surface cracks or arc strikes in or adjacent to the welded joints.
- 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.
- 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.).
- 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 (1/2)

Surface Condition (As Welded)

Test Solution: N/A

Test Date(s): JUNE 10/18

Tested by: MATT MACKENZIE

Ambient Conditions: 4°

Items Tested:

COMPRESSION RING - TOP + BOTTOM SIDE.

Results:

NO DEFECTS WERE FOUND. ALL WELDING ACCEPTABLE.Sub-Arc Representative Signature: [Signature] Date: JUNE 10/18Client Representative Signature: [Signature] Date: JUNE 24/18

Client Signature: _____ Date: _____

Field Erected Fuel Storage Tank Handover Package

Item 12 - Roof

Contents

1. Visual Report

QUALITY CONTROL MANUAL

Exhibit 15c, Rev 1

VISUAL TEST REPORT

Customer: Agnico Eagle

Location: Rankin Inlet

Code Requiring Test: API 650 (section 8.5.2)

Reason for Test: New Construction

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- 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.).
- 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 (7/16)
> 25 (1)	5 (3/16)	6 (1/2)

Surface Condition (As Welded)

Test Solution: N/A

Test Date(s): JUNE 23/18

Tested by: NATI MARKERZIE

Ambient Conditions: 10°

Items Tested:

TK-1 ROOF

Results:

NO DEFECTS WERE FOUND. ALL WELDING ACCEPTABLE.

Sub-Arc Representative Signature: Matt Markerzie Date: June 25/18Client Representative Signature: Clara Bonner Date: June 25/18

Client Signature: _____ Date: _____

Field Erected Fuel Storage Tank Handover Package

Item 13 – Roof Structure

Contents

1. Column Plumbness Dimension Report
2. Welding Visual Report

QUALITY CONTROL MANUAL

Exhibit 19, Rev A

DIMENSIONAL CHECK REPORT – PLUMBNESS

Customer: AEM.

Location: RANKIN INLET. TK. 1

Equipment Tag No.:

Equipment Type:

Equipment Description:

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): JUNE 9/18

Tested by: MATT MACKENZIE.

Seam Test Results:

ALL STRUCTURE COLUMNS ARE PLUMB.

Sub-Arc Representative Signature: Matt Mackenzie Date: June 9/18

Client Representative Signature: Clm Bonner Date: June 25/18

Client Signature: _____ Date: _____

QUALITY CONTROL MANUAL

Exhibit 15c, Rev 1

VISUAL TEST REPORT

Customer: Agnico Eagle

Location: Rankin Inlet

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.

- There are no crater cracks, other surface cracks or arc strikes in or adjacent to the welded joints.
- 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.
- 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.).
- 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 (3/8)	5 (3/16)
> 25 (1)	5 (3/16)	6 (1/4)

Surface Condition (As Welded)

Test Solution: N/A

Test Date(s): JUNE 9/18

Tested by: MATT MACKENZIE

Ambient Conditions: 3°

Items Tested:

COLUMN REPAIRS.

Results:

NO DEFECTS WERE FOUND. ALL WELDING ACCEPTABLE.

Sub-Arc Representative Signature: Matt Mackenzie Date: June 9/18Client Representative Signature: Clm Borne Date: June 25/18

Client Signature: _____ Date: _____

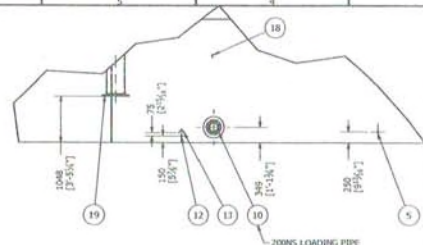
Field Erected Fuel Storage Tank Handover Package

Item 14 – Nozzles

Contents

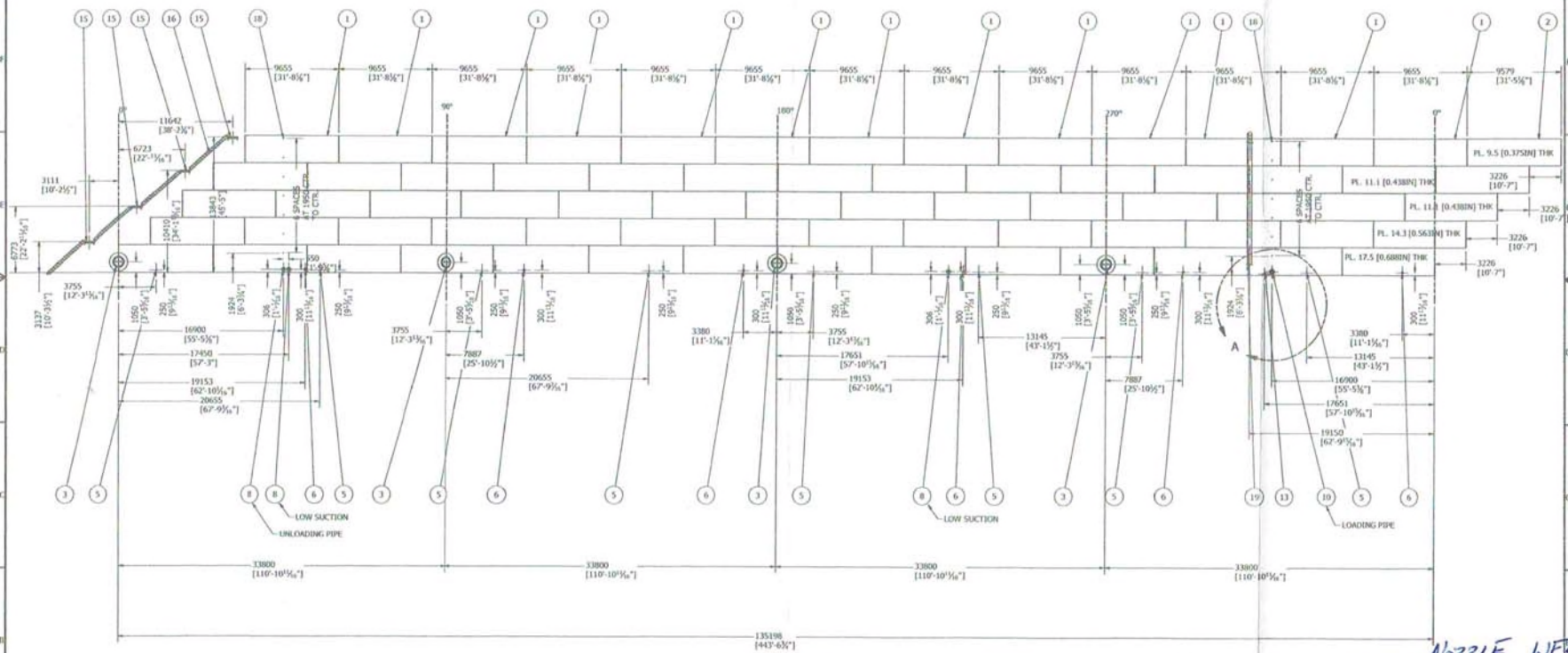
1. Weld Map
2. Visual Report
3. Leak Test Report – Shell Nozzle Repad Air Test
4. MPI Report

ITEM	ITEM QTY	PARTS LIST	PART NUMBER
1	65	SHELL PLATE 2798 X 9055	
2	5	LAST SHELL PLATE PER COURSE 2798 X 9579 (TRIMMED AT SITE)	
3	4	2000S SHELL MANHOLE	
5	8	GROUNDING LUG	
6	6	750S WATER DRAWOFF VALVE	
8	3	1500S SHELL NOZZLE	
10	1	2000S SHELL NOZZLE	
12	1	200S TEMPERATURE SENSOR CONNECTION	
13	1	AISC - L 4 x 4 x 1/4 - 15,748031 TEMPERATURE SENSOR PROTECTION	
15	4	PLATFORM	
16	68	STEPS	
18	14	AISC - L 3 x 3 x 1/4 - 15,748031 PPV PIPE SUPPORTS	
19	1	4000S VENT	



*ALL NOZZLES
- D.Z*

DETAIL A
SCALE 1/50



SHELL DEVELOP VIEW
SCALE 1/200

NOTES:
ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE NOTED.
ALL DIMENSIONS ARE TAKEN FROM THE OUTER SIDE OF THE SHELL.



REVISION HISTORY			
REV	DESCRIPTION	DATE	
6	THIS SHEET ADDED	7/15/2017	
DESIGN	MARK JOSIER	3/17/2017	
DRWG			
APPROVED			
Permit Number: P471		TITLE	
		AGNICO EAGLE - MELIADINE GOLD MINE -	
		TK #1 - 20,000CUM TANK 43M DIA X 14M H	
SIZE	SCALE	DRWG NO	REV
A1	295-M9		6
SHEET 7 OF 7			

NOZZLE WELD MAP

QUALITY CONTROL MANUAL

Exhibit 15c, Rev 1

VISUAL TEST REPORT

Customer: Agnico Eagle

Location: Rankin Inlet

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.

- There are no crater cracks, other surface cracks or arc strikes in or adjacent to the welded joints.
- 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.
- 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.).
- 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)	8 (5/16)

Surface Condition (As Welded)

Test Solution: N/A

Test Date(s): June 20/18

Tested by: MATT MACKENZIE Ambient Conditions: 7°

Items Tested:

SHELL NOZZLES.

Results:

NO DEFECTS WERE FOUND. ALL WELDING
ACCEPTABLE.Sub-Arc Representative Signature: [Signature] Date: June 20/18Client Representative Signature: [Signature] Date: June 20/18

Client Signature: _____ Date: _____

QUALITY CONTROL MANUAL

Exhibit 19, Rev A

DIMENSIONAL CHECK REPORT - PLUMBNESS

Customer: AGNICO EAGLE

Location: RANKIN INLET

Equipment Tag No.:

Equipment Type:

Equipment Description:

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): JUNE 20

Tested by: MATT MACKENZIE

Seam Test Results:

Nozzles checked for plumbness. All

Nozzles acceptable.

Sub-Arc Representative Signature: [Signature] Date: June 20/18

Client Representative Signature: [Signature] Date: June 20/18

Client Signature: _____ Date: _____

QUALITY CONTROL MANUAL

Exhibit 12, Rev 1

AIR TEST REPORT – NOZZLE REINFORCEMENT PLATE WELDS

Customer: AGNICO EAGLELocation: RANKIN INLET TK-1

Equipment Tag No.:

Equipment Type:

Equipment Description:

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): JUNE 24/18Tested by: MAT MACKENZIE

Pressure Gauge:

Ambient Conditions: 5°149985

Items Tested:

SHELL NOZZLES

Results:

NO LEAKS WERE FOUNDSub-Arc Representative Signature: Matthew KellyDate: June 24/18Client Representative Signature: Adam BonarDate: June 24/18

Client Signature: _____

Date: _____

M1614

291°



ST. OK

MM C

NE 24/18

M1601

315°

AIR TEST OK MM

JUNE 24/18



M1614

351°

TEST OK MMCB

E 24/18



M1602
45°
M1603 AIR TEST OK
JUNE 24/18



611-109133-19 (DWA)

10X

M1602

AIR TEST

JUNE 24/18





M1614

51°

AIR TEST OK MMCA

JUNE 24/18



M1614

111°

AIR TEST OK MM CB

JUNE 24/18

M1614

171°

AIR TEST OK MM CB

JUNE 24/18



M1602

227°

AIR TEST OK MM

JUNE 24/18

CB





M1614
231"

AIR TEST OK MM CB
JUNE 24/18



Client :	Inukshuk Construction Ltd,	Date d'intervention :	2018-06-19 to 24
Adresse/Address :	, PO Box 654 Rankin Inlet, Nunavut X0C 0G0	Intervention date :	
Contact :	Marc Losier	Date du rapport :	2018-06-27
Entrepreneur :	tClient	Report date :	
Contractor :		N° dossier :	INS-118016-02
Endroit du travail :	Meliadine Gold Mine Nunavut	File no :	
Job location :		Commande :	295-1024
		Order :	

Page 1 de/of 6

INSP. VISUELLE VISUAL INSP.	☐	MAGNÉTOSCOPIE MAGNETIC PARTICLES	☒	RESSUAGE LIQUID PENETRANT	☐	ULTRASONS ULTRASONIC	☐												
DESCRIPTION :																			
Project: Meliadine Gold Mine (Agnico Eagle).																			
Magnetic particles inspection on tank no 1 at Rankin Inlet Installation (Nozzles only)																			
Remark: Visual inspection was performed by client																			
INSP. VISUELLE / VISUAL INSP.		NORME : SPECIFICATION :		N° équip. : Equip. no :															
MAGNÉTOSCOPIE MAGNETIC PARTICLES		NORME : SPECIFICATION : API 650		N° équip. : Equip. no : MP-Q-22															
Ampérage : Amperage : Longitudinale Longitudinal	Culasse/Yoke ☒	Continue Continuous Circulaire Circular	☒ ☐	Résiduelle Residual C.A. A.C.	☐ ☒	Humide Wet C.C. D.C.	☐ ☐												
RESSUAGE LIQUID PENETRANT		NORME : SPECIFICATION :		N° équip. : Equip. no :															
Pénétrant/Penetrant :		Émulsifiant/Emulsifier :		Révélateur/Developer :															
Temps/Time :		Temps/Time :		Temps/Time :															
ULTRASONS / ULTRASONIC		NORME : SPECIFICATION :		N° équip. : Equip. no :															
ÉTALONNAGE/CALIBRATION :		Trou/Hole :		C.A.D. /D.A.C. :		☐													
Bloc/Block :																			
APPAREIL/EQUIPMENT :		Couplant :		Échelle/Sweep length :															
Instrument :		Palpeur/Transducer :																	
N° équip./Equip. no :																			
RÉSULTATS/RESULTS :																			
TANK No. 1																			
<table><thead><tr><th>Item inspected</th><th>MPI 100% of Weld outside</th><th>MPI 100% of Weld inside</th></tr></thead><tbody><tr><td>15 nozzles on shell (Including 4 manholes)</td><td>14 Pads / shell - Accepted 14 Nozzles / Pads - Accepted 1 nozzle / shell - Accepted</td><td>15 nozzles on shell Accepted</td></tr><tr><td>Seam on each manhole (4)</td><td>Accepted</td><td>Accepted</td></tr><tr><td>11 Nozzles on top tanks</td><td>11 Pads on top Shell - Accepted 11 Nozzles / Pads – Accepted 2 nozzles no pad</td><td>N/A</td></tr></tbody></table>								Item inspected	MPI 100% of Weld outside	MPI 100% of Weld inside	15 nozzles on shell (Including 4 manholes)	14 Pads / shell - Accepted 14 Nozzles / Pads - Accepted 1 nozzle / shell - Accepted	15 nozzles on shell Accepted	Seam on each manhole (4)	Accepted	Accepted	11 Nozzles on top tanks	11 Pads on top Shell - Accepted 11 Nozzles / Pads – Accepted 2 nozzles no pad	N/A
Item inspected	MPI 100% of Weld outside	MPI 100% of Weld inside																	
15 nozzles on shell (Including 4 manholes)	14 Pads / shell - Accepted 14 Nozzles / Pads - Accepted 1 nozzle / shell - Accepted	15 nozzles on shell Accepted																	
Seam on each manhole (4)	Accepted	Accepted																	
11 Nozzles on top tanks	11 Pads on top Shell - Accepted 11 Nozzles / Pads – Accepted 2 nozzles no pad	N/A																	
Note: Accepted after two repairs on manhole 270° interior weld																			
Techniciens : Technicians :		Assistants:		Approuvé par : Approved by :		Patrick Brodeur Superviseur technique													
Etienne Munger ASNT-TC-1A Level 2 CAN/CGSB 48.9712 MT Level 2		Qualification				CSA W178.2 niv.3													

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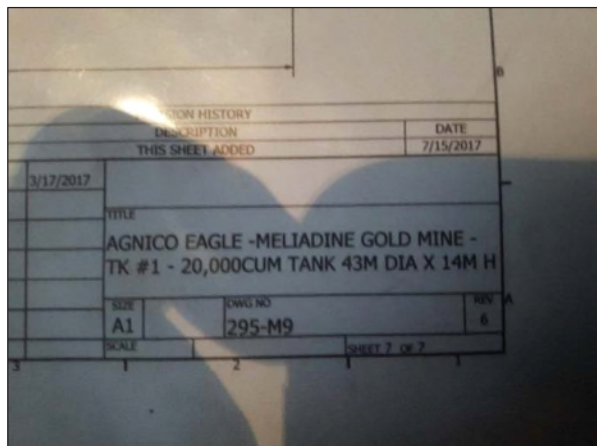
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Membre du groupe SGS (SGS SA)

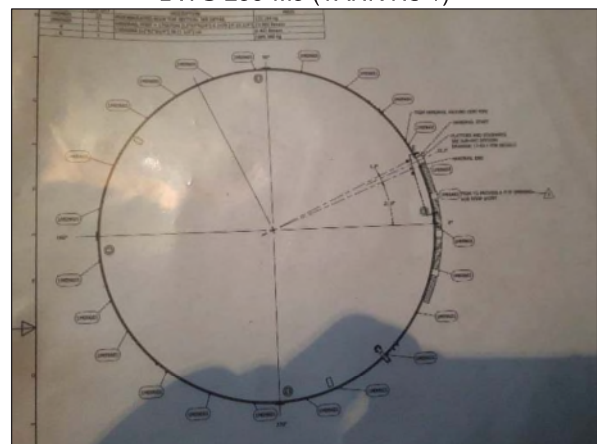
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Contact :	Marc Losier	Date du rapport :	2018-06-27
Entrepreneur :	tClient	Report date :	
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Job location :		Commande :	295-1024
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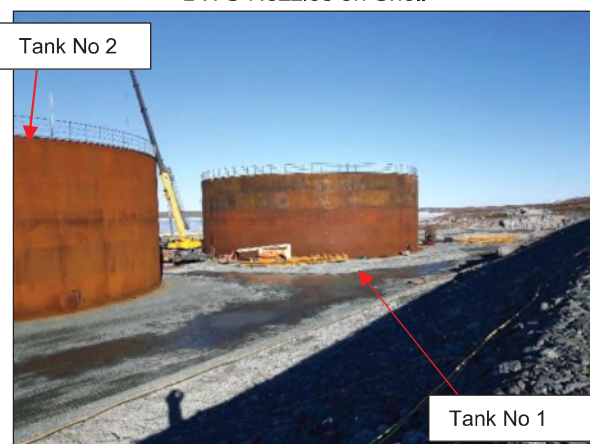
DWG 295-M9 (TANK No 1)



DWG Nozzles on Shell



DWG Nozzles on Top Shell



Site of Tank No 1 & No 2 at Rankin Inlet



Techniciens :	Etienne Munger	Assistants:		Approuvé par :	Patrick Brodeur
Technicians :	ASNT-TC-1A Level 2 CAN/CSB 48,9712 MT Level 2			Approved by :	Superviseur technique
			Qualification		CSA W178.2 niv.3

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Client :	Inukshuk Construction Ltd,	Date d'intervention :	2018-06-19 to 24
Adresse/Address :	, PO Box 654 Rankin Inlet, Nunavut X0C 0G0	Intervention date :	
Contact :	Marc Losier	Date du rapport :	2018-06-27
Entrepreneur :	tClient	Report date :	
Contractor :		N° dossier :	INS-118016-02
Endroit du travail :	Meliadine Gold Mine Nunavut	File no :	
Job location :		Commande :	295-1024
		Order :	

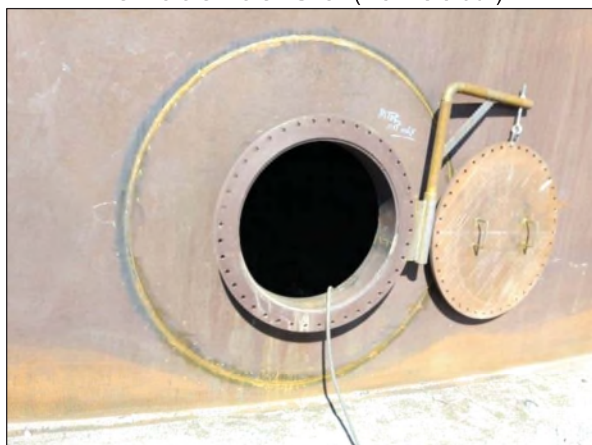
Nozzles 1 and 2 of 15 on Shell



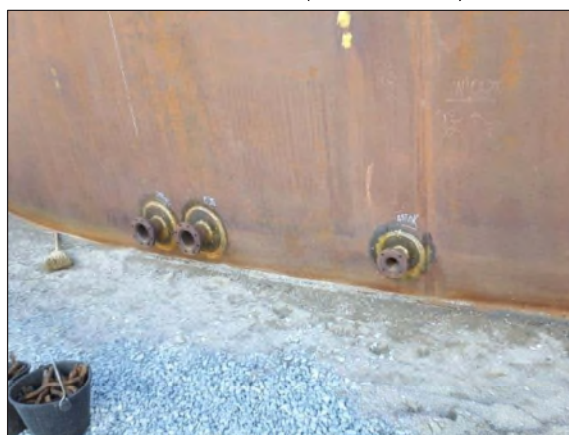
Nozzles 3 and 4 of 15 on Shell



Nozzle 5 of 15 on Shell (Manhole 90°)



Nozzles 6 and 7 (Manhole 180°)



Nozzle 8 of 15 (Manhole 270°)



Nozzles 9, 10 and 11 of 15



Nozzles 12 and 13 of 15

Nozzle 14 of 15

Techniciens :	Etienne Munger	Assistants:		Approuvé par :	Patrick Brodeur
Technicians :				Approved by :	Superviseur technique
	ASNT-TC-1A Level 2				
	CAN/CGSB 48.9712 MT Level 2		Qualification		CSA W178.2 niv.3

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Contractor :		N° dossier :	INS-118016-02
Endroit du travail :	Meliadine Gold Mine Nunavut	File no :	
Job location :		Commande :	295-1024
		Order :	



Nozzle 15 of 15 on Shell



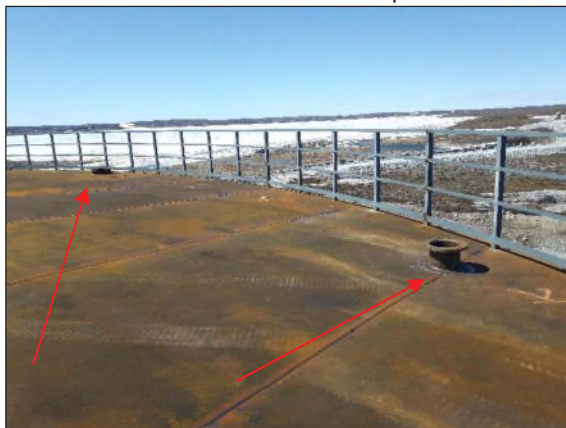
Nozzles 1, 2, of 13 on top tank



Nozzles 3 to 6 of 13 on top tank



Nozzles 7 o of 13 on top tank



Nozzles 8, 9 of 13 on top tankl

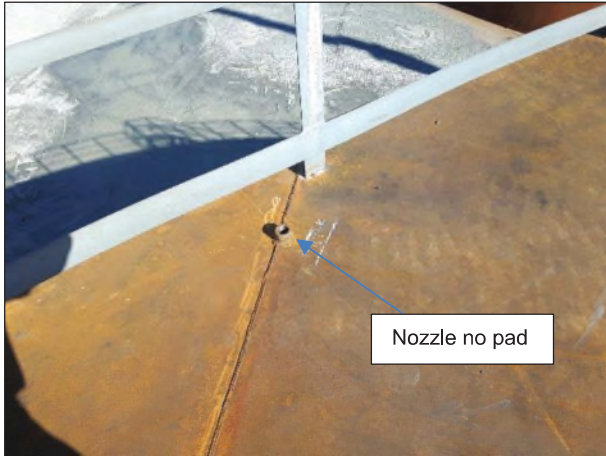


Nozzles 10, 11 of 13 on top tank

Techniciens :	Etienne Munger	Assistants:		Approuvé par :	Patrick Brodeur
Technicians :	ASNT-TC-1A Level 2 CAN/CGSB 48.9712 MT Level 2		Qualification	Approved by :	Superviseur technique
					CSA W178.2 niv.3

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Entrepreneur :	tClient	Report date :	
Contractor :		N° dossier :	INS-118016-02
Endroit du travail :	Meliadine Gold Mine Nunavut	File no :	
Job location :		Commande :	295-1024
		Order :	



Nozzle 12 of 13 on top tank

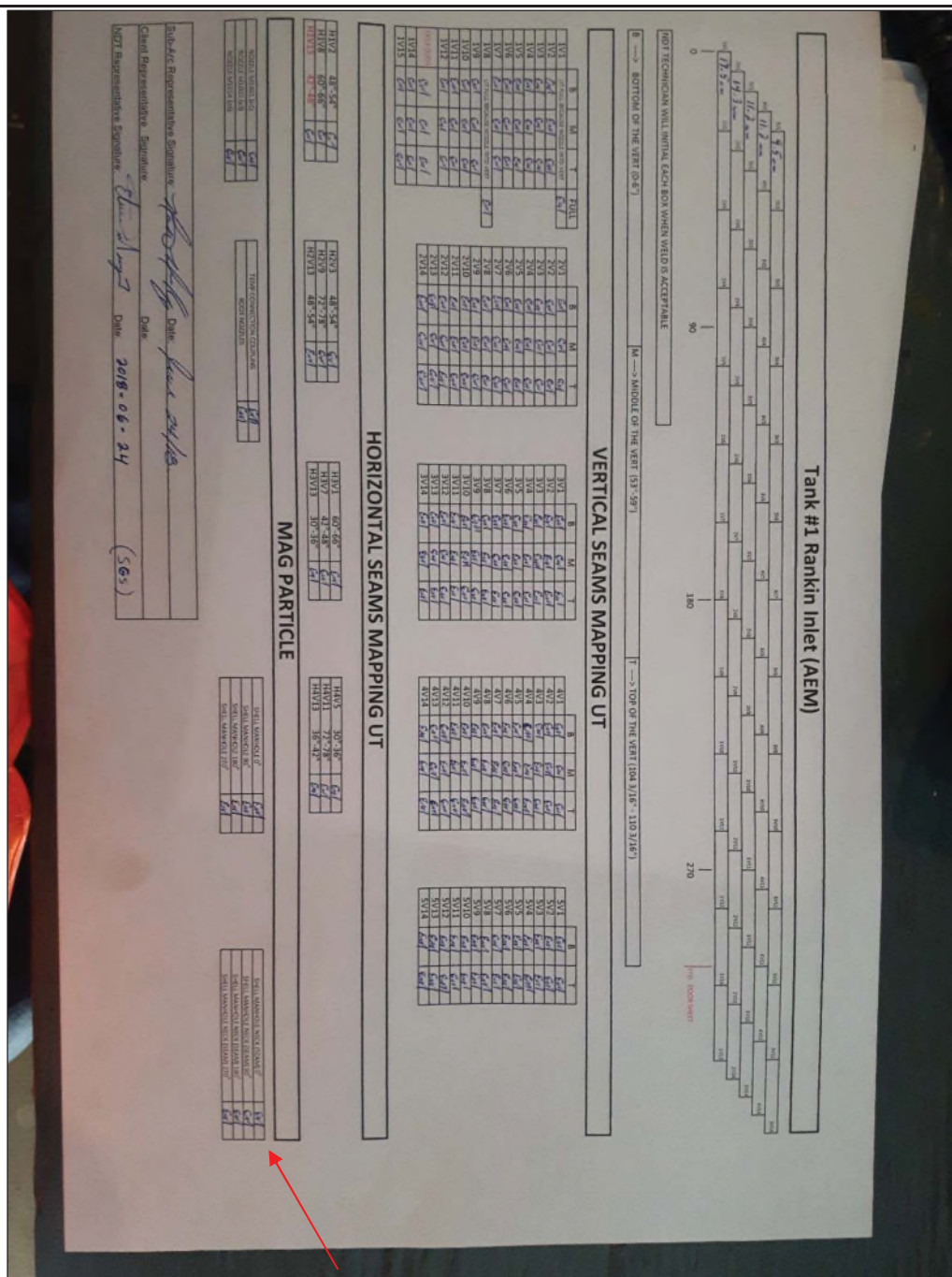


Nozzles 13 of 13 on top tank

Techniciens :	Etienne Munger	Assistants:		Approuvé par :	Patrick Brodeur
Technicians :				Approved by :	Superviseur technique
	ASNT-TC-1A Level 2		Qualification		CSA W178.2 niv.3
	CAN/CGSB 48.9712 MT Level 2				

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Client : Adresse/Address : Contact :	Inukshuk Construction Ltd, , PO Box 654 Rankin Inlet, Nunavut X0C 0G0 Marc Losier	Date d'intervention : Intervention date :	2018-06-19 to 24
		Date du rapport : Report date :	2018-06-27
Entrepreneur : Contractor :	tClient	N° dossier : File no :	INS-118016-02
Endroit du travail : Job location :	Meliadine Gold Mine Nunavut	Commande : Order :	295-1024



Magnetic particles mapping

Techniciens : Technicians :	Etienne Munger ASNT-TC-1A Level 2 CAN/CSB 48.9712 MT Level 2	Assistants: Qualification	Approuvé par : Approved by : Patrick Brodeur Superviseur technique CSA W178.2 niv.3
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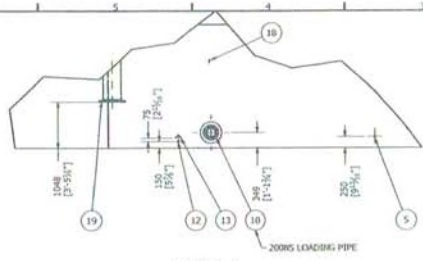
Field Erected Fuel Storage Tank Handover Package

Item 15 – Manways

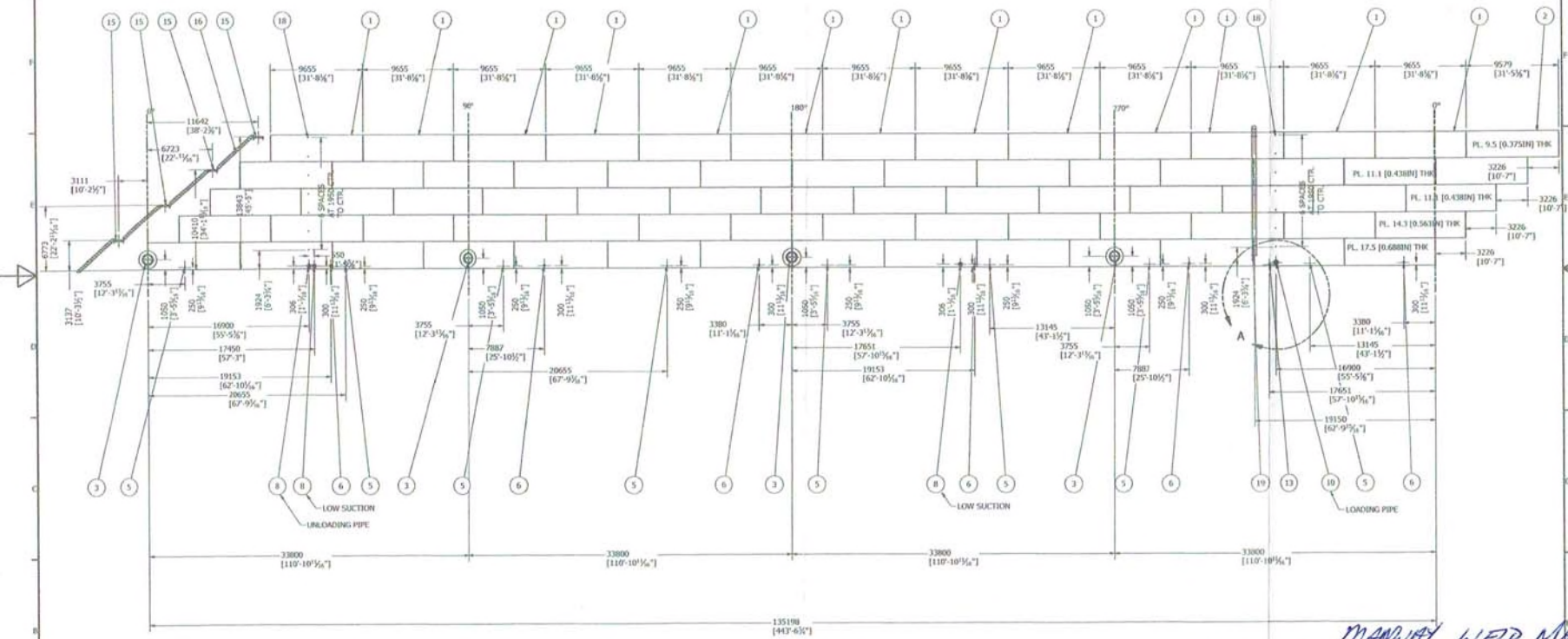
Contents

1. Weld Map
2. Visual Report
3. Leak Test Report – Shell Manway Repad Air Test
4. Manway Torque Specs
5. MPI Report

PARTS LIST		
ITEM	ITEM QTY	PART NUMBER
1	65	SHELL PLATE 2700 X 9055
2	5	LAST SHELL PLATE PER COURSE 2700 X 9579 (TRIMMED AT SITE)
3	4	9000S SHELL MANHOLE
4	8	GRACKENDING LUG
5	6	750S WATER DRAWWOFF VALVE
6	3	1500S SHELL NOZZLE
7	1	2000S SHELL NOZZLE
8	1	200S TEMPERATURE SENSOR CONNECTION
9	1	ASC - L 4 x 4 x 1/4 - 15.740031 TEMPERATURE SENSOR PROTECTION
10	1	PLATFORM
11	68	STEPS
12	14	ASC - L 3 x 3 x 1/4 - 15.740031 FRV PIPE SUPPORTS
13	1	4000S VENT



ALL MANWAYS
- D.Z



SHELL DEVELOP VIEW
SCALE 1/200

NOTES:
ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE TAKEN FROM THE OUTER SIDE OF THE SHELL



REVISION HISTORY		
REV	DESCRIPTION	DATE
6	THIS SHEET ADDED	7/15/2017
5	MANWAY LOSER	3/17/2017
4	CHECKED	
3	DRN	
2	APPROVED	
1		
AGNICO EAGLE - MELIADINE GOLD MINE - TK #1 - 20,000CUM TANK 43M DIA X 14M H		
REV	DATE	REV
A1	295-M9	6
SCALE		

MANWAY WED MAP

Exhibit 15c, Rev 1

QUALITY CONTROL MANUAL

VISUAL TEST REPORT

Customer: Agnico Eagle

Location: Rankin Inlet

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.

- There are no crater cracks, other surface cracks or arc strikes in or adjacent to the welded joints.
- 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.
- 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.).
- 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): JUNE 20 / 18

Tested by: MAT MACKENZIE

Ambient Conditions: 7°

Items Tested:

SHELL MANWAYS.

NO DEFECTS WERE FOUND. ALL WELDING ACCEPTABLE.

Results:

Sub-Arc Representative Signature: Math Mackenzie Date: June 20/18Client Representative Signature: Clara Bomer Date: June 20/18

Client Signature: _____ Date: _____

QUALITY CONTROL MANUAL

Exhibit 19, Rev A

DIMENSIONAL CHECK REPORT – PLUMBNESS

Customer: AGNICO EAGLE

Location: RANKIN INLET

Equipment Tag No.:

Equipment Type:

Equipment Description:

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): June 20/18

Tested by: MAST MACKENZIE

Seam Test Results:

ALL MEASUREMENTS ARE ACCEPTABLE.

Sub-Arc Representative Signature: [Signature] Date: June 20/18

Client Representative Signature: [Signature] Date: June 20/18

Client Signature: _____ Date: _____

QUALITY CONTROL MANUAL

Exhibit 12, Rev 1

AIR TEST REPORT - NOZZLE REINFORCEMENT PLATE WELDS

Customer: AGNICO EAGLE

Location: RANKIN INLET TK 1

Equipment Tag No.:

Equipment Type:

Equipment Description:

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): JUNE 24/18

Tested by: MATT MARKERIE

Pressure Gauge:

Ambient Conditions: 5°

149985

Items Tested:

SHELL MANNAK.

Results:

NO LEAKS WERE FOUND.

Sub-Arc Representative Signature: [Signature]

Date: June 24/18

Client Representative Signature: Clem Bonner

Date: June 24/18

Client Signature: _____

Date: _____

MAN HOLE
270'

AIR TEST OK
JUNE 24/18 MM. CB



MAN HOLE
0°

AIRTEST OK MM C

JUNE 24/18





MAN H
90°
AIR TES
JUNE 2

MAN HOLE

180°

AIR TEST OK MM CB

JUNE 24/18

