FORM R-2 REPORT OF ALTERATION

in accordance with provisions of the National Board Inspection Code

EN	
(Authorized	Rep. Initials)
0.0	

	26	
(Ins	pectors	initials)

54 (Form "R" Registration no.) 1a. DESIGN PERFORMED BY: J. Lowry, LLC 244930 (P.O. no., job no., etc.) (name of "R" organization responsible for design) 2222 Bay Area Blvd Suite 101, Houston, Tx 77058 (address) 1b. CONSTRUCTION PERFORMED BY: Premier Boiler & Combustion, LLC (name of R organization responsible for construction) 788 Old Mill Road Ringgold, Ga 30736 2. OWNER OF PRESSURE RETAINING ITEM: Soffix Corp. 101 Northgate Commercial Center, Chattanooga, Tn 37415 3. LOCATION OF INSTALLATION: Sofix Corp. 2800 Riverfront Road, Chattanooga, Tn 37406 (address) 4. ITEM IDENTIFICATION: Pressure Vessel NAME OF ORIGINAL MANUFACTURER: Alloy Fabricators 1992 1266 5. IDENTIFYING NOS: 1-141 (year built) (National Board no Curisdiction no. 6. NBIC EDITION/ADDENDA: 1989 (edition) 1989 ASME Sect VIII Div 1 Original Code of Construction for Item: (edition / addenda (name / section / division) Construction Code Used for Alteration Performed: ASME Sect VIII Div 1 2023 (edition / addenda) 7a. DESCRIPTION OF DESIGN SCOPE: Form R-4, Report Supplementary Sheet is attached Half pipe jacket was re-rated from a M.A.W.P. of 33 PSI at 335F to 90 PSI at 335F 7b. DESCRIPTION OF CONSTRUCTION SCOPE: Form R-4, Report Supplementary Sheet is attached

Pressure Test, if applied 120

Liquid

54

(Form "R" Registration no.)

244930

(PO no. job no. etc.)

8.	REPLACEMENT PARTS: (Attached are Manufacturer's Partial Data Reports or Form R-3's properly completed for the following items of this report): (name of part, item number, data report type or Certificate of Compliance, mfg's name and identifying stamp)
9.	REMARKS:
	Half pipe jacket re-rated from a M.A.W.P. of 33 PSI at 335F to 90 PSI at 335F
	DESIGN CERTIFICATION
	Leading Change described in this report conforms to the National Board Inspection Code. National Board "R" Certificate of Authorization No. expires on
C	Date 1d23/24 Signed Que 22 (name of design organization) Signed Que 22
	CERTIFICATE OF DESIGN CHANGE REVIEW
1,	STEVE ALEXANDER, holding a valid Commission issued by The National Board of Boiler and Pressure Vessel
1	BUCKAN VELLEN OF LAND OF LAND MA
t	have reviewed the design change as described in this report and state that to the best of my knowledge and belief such change complies with he applicable requirements of the National Board Inspection Code.
E	By signing this certificate, neither the undersigned nor my employer makes any warranty, expressed or implied, concerning the work described in this report. Furthermore, neither the undersigned nor my employer shall be liable in any manner for any personal injury, property damage or
1	oss of any kind arising from or connected with this inspection. Date 6-18-24 Signed Commissions NB - 12488 R
-	(inspector) (National Board and jurisdiction no including encorsement)
	CONSTRUCTION CERTIFICATION
r	Eugene Mitchem, certify that to the best of my knowledge and belief the statements in this report are correct and that all material, construction, and workmanship on this Alteration conforms to the National Board Inspection Code. National Board "R" Certificate of expires on May. 27,2026
1	Date 6/28/24 Preview Boller Signed Eugl Mc (authorized representative)
	CERTIFICATE OF INSPECTION
	I,, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and certificate of competency, where required, issued by the Jurisdiction of and employed by
	Bureau Veritas Insurance and Inspection Co. of Lynn, Massachusetts
	have inspected the work described in this report on and state that to the best of my knowledge and belief, this work complies with the applicable requirements of the National Board Inspection Code. By signing this certificate, neither the undersigned nor my employer makes any warranty, expressed or implied, concerning the work described in this report. Furthermore, neither the undersigned nor my employer shall be liable in any manner for any personal injury, property damage, or loss of any kind arising from or connected with this inspection.
	Date Signed (National Board and jurisdiction no. including endorsement)
1	

Section 12 Exhibit

	TR	AVELER						
Landson Market Control of the Contro			NBIC Edition: _20			1992		
ASME "S" Original Mfg.:	Alloy Fab	pricator	S S/N: 1-141		_ NB#:	1266		
CUSTOMER: SOFTX CORP. CI	nattangog	a,Th		JOB NO.	2440	30		
DESCRIPTION: Re-rate half	DIDP Jac	Ket Fro	m 33 psi to	90 001				
DRAWING NO.:		PMENT NO.	- L		ATE:	-1-11		
DRAWING NO.: EQUIPMENT NO. DATE: 425/								
SCOPE	QUALITY CONTROL	DATE	AUTHORIZED INSPECTOR	DATE	HOLD	NCR#		
DESIGN REVIEW:								
DRAWINGS								
CALCULATIONS	EM	6/25/24	SX5 BY XLO	6-78-24				
SPECIAL INSTRUCTION								
TRAVELER REVIEW								
MATERIAL INSPECTION:								
MAT'L LIST COMPLETE								
MTR'S CHECKED	-							
OTHER								
FABRICATION INSPECTION:		-						
NOZZLE FITUP	-							
GIRTH SEAM FITUP								
LONG SEAM FITUP					or her concerns of the American Address of the			
INTERNAL PRIOR TO CLOSING								
WELDER QUALIFICATION								
PREHEAT REQUIREMENTS								
PWHT REQUIREMENTS								
PWHT RECEIVING INSPECTION								
PWHT CHARTS REVIEWED								
WELD SYMBOLS								
VISUAL INSPECTION								
OTHER								
RT: FULL() SPOT()%			_					
MT() PT() UT() VT()			. 22					
HYDROTEST @ 120 PSI	EM	4-28-24	1. apal	6-28-25				
GAUGE NO. PBC-005	EM	6-28-24						
GAUGE CAL. DATE 8-31-23	EM	6-28-24						
OTHER						and the same and t		
FINAL						and the second s		
FINAL INSPECTION								
NCR's CLOSED			0.00					
DATA REPORT	EM	4/29/24	8.Clarac	6.78.74				
STAMPING	EN	6/20/24	& allyon	6-78-24				
NAME PLATE ATTACHED	EN	6/24/24	8. alba	6-78-24				

Volunteer NDT Corporation

Chattanooga, Tennessee

Providing Inspection & Scaffolding Services

Tank Inspection C5112



Premier Boiler

VNDT Job # 24131

Procedure: TST-VT-001

TST-UT-001

External Visual: Performed

Internal Visual: Not Available

Thickness: Various

Retirement: No retirement or predictions are given because there is no historical data on the vessel. No Ul Manufacturers Data Sheet was found to have a comparison.

Only a baseline was given at this time.

Volunteer Review By:

Heath Water

Date: 5/29/2024

Volunteer NDT Level III

Volunteer NDT Corporation

Chattanooga, Tennessee

Providing Inspection & Scaffolding Services

ofix

TST-UT-001 SS-Wedge-SN 2298-19

GE- FH2E S/N: 23A015W5 Krautkramer DMS-2

>100 Ft Candles-Streamlight

Premier Boiler @ Sofix Chattanooga, TN 5/24/2024 Tech: Horth Writen

Summary:

C-5112

This was a stainless steel tank with a stainless jacket of coils. The orientation of the readings of this tank were inspection ports at the following locations. The top head had 2 inspection ports. The shell had 4 shell readings with 4 jacket readings taken. The bottom head had 2 inpection ports.

LOCATION	N	5	E	W	Average	Lou
Top Head	.261	.305	.251	.268	.271	.251
Shell Course	.259	.261	.257	.258	.259	.257
Bottom Head	.258	.264	.263	.258	.261	.258







Premier Boiler & Combustion, LLC

PRESSURE TEST REPORT									
Repair Alteration No. R-54 Date: 6/28/24 Job Number: 244930									
10 miles									
Routine Repair Piping Install / Replacement									
NBIC Edition: 2023 Addenda: N/A Other: Original MFG: Alloy Foor Codors Year Build: 1992 Serial No.: 1-141 Nat'l. BD. No.: 12/6/6 Description of Work: For make healthing Tooket From 33 no. to 90 193)									
Serial No.: 1-14 Nat'l. BD. No.: 12(e)									
	- 1 le () le () le ()								
Description of Work: Re-rate halfpipe Tocket from 33 psi to 90 psi Location of Work: Sofix Corp. Chattanaga									
AIA Inspector Approval & Acceptance Req'd	YES NO								
Verified by:	Date: 6-28-24								
AND THE RESIDENCE OF THE PROPERTY OF THE PROPE	Requirements Water Clycol Air Other								
Test Medium	Yes No N/A								
Conforms to Drawings, Codes & Specifications?	Yes No N/A								
System Cleared by Quality Control?	Name of the second seco								
Valves Opened and/or Closed as Required?	Manager Landschaft Control of the Co								
Valve Orientation Correct & Verified?	Name of Section 2 Section								
Blinds Installed or removed as Required?	Yes No N/A Yes No N/A								
In Line Instruments Removed or Bypassed?	Yes No N/A								
Pre	essure Test Data								
Gauge Number PBC - COD	Design MAWP 90 PSI								
	Ambient Temperature 85 °F								
Gauge Make Gauge Range 0 - 300 PSI	Required Test Pressure 120 PSI								
Gauge Calibrated Date 8-30-23	Actual Test Pressure 120 PSI								
	Hold Time Required 10 Min								
De by Marie Control	Actual Hold Time 24 hrs -Min-								
	st Pressure Test								
Blinds removed and accounted for?	Yes No N/A								
Spring hanger stops removed?	Yes No N/A								
Guides Installed?	Yes No N/A								
Correct bolts and gaskets reinstalled?	Yes No N/A								
High point and Low point plugs installed?	Yes No N/A								
Control Valves Installed?	Yes No N/A								
Check Valve internals installed?	Yes No N/A								
System blown free of test medium?	Yes No N/A								
NINGEL MANTEL AND OF COMPTION OF THE PARTY O	Amend hand								
Acceptance of Repair / Alteration Pressure T	Cest:								
Premier Boiler Supervisor	Date:								
Ovality Control Manager 6-24									
Repair Inspector	Date: 6.20-24								

FORM U-1 MANUFACTURER'S DATA REPORT FOR PRESSURE VESSELS As Required by the Provisions of the ASME Code Rules, Section VIII, Division 1

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mutertured an	d certified by	いいせいし	LWOKIC		11011				
			ť	Name end address o	i manutactureri		CHATT	AMOOCA	TN
	SOFIX	CORP.,	101 NOR	THGATE C	OMMERCI	AL CIR.	, CHALL	HNOUGA,	T 14
INDIRECTOR OF TO	***************************************			(Name and address	of purchaser)			7m > 1	
	501	IX CORF	., 2800	RIVERPO	RT RD.,	CHATTA	NOOGA,	TN	
				• .					
UPDT	TCAT	1 - 1	41	Ŋ	I/A	1-141	12	66 <u> </u>	1992
pe VERA	1 (12) 14		Migr (period No)		ICANI	(Organing)		(Net'l, Ed. No.)	(Yage built)
17700	tar vers, estate		•					Dunanian Mass	al Code The design
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nstruction, an	d workmanship	conform to AS	ME Rules, Sec	tion VIII, Divis	kan 1		Year		
							N / A		
1	989								· · · · · · · · · · · · · · · · · · ·
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·11 incl. to be c	napialed for sing	iis maii sassais is	. 250	NONI	P.	3 3 1/	2"		5 13/16"
eli: SA-Z	Mett Hose No. Gu	Jel -	Ham The Im!					1	Length (Overallitt & m.)
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s/ma:	SVBW						EH (%)		H T. Tomp. (-F)
	Lor	-		•		817	X X 1 22		1
	N/A		SVBW		-				No of Courses
	1/ years		Gre	(DM, Snet)					
	SA-24	0-T304			(b) Mati.	SA-24			
22CTS: (8) WIGHT.		(Spec	No . Gradel				(Spec	No . Grade)	
			(2001)	* C	Educates!	Constal	Hamispherical	Flat	Side to Pressure
		Allowance	Radius	Redius	Ratio	Ages Angle	Radius	Diameter	(Convex or Conceve)
							40.00		CONCAVE
								w	CONCAVE
removable, b	olts used (descr	ibe other festen	ings) ,		N		Gr. Sup No.1		
of tooket		N/A			Proof Test				
				t hat, vivo dime	Proof Tost	para i para tria cam	N/A	If bolts	ed, describe or sketch.
ype of Jacket acket Closure,		e e	r ata l	f bar, givo dime	nsions	980-36 - 980-36 VIII C 2000 884-884	N/A		
ocket Clasure,	(Describe	e e	r ata l	f bar, givo dime	nsions	980-36 - 980-36 VIII C 2000 884-884	N/A		
ecket Closure,	(Describe	as ages & weld. ba	r, etc) ex. temp.	t har, give dime	nsions of. I	980-36 - 980-36 VIII C 2000 884-884	N/A		od, describe or sketch.
ecket Closure,	(Describe	as ages & weld. ba	r, etc) ex. temp.	f bar, givo dime	nsions of. I	980-36 - 980-36 VIII C 2000 884-884	N/A		
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AAWP	(Describe 3 3 r coint), test pre- completed for the N/A Stationary Mail (Sp Mail (Spe No.)) Time the Minimum Thekross	psi of mics. 57 be sections pec No. Gr.) ec. No. Gr.) inner chambers of linder Long (DM, Sngl.) (Spec. No. Gr.) (Spec. No. Gr.)	Diam (in) (Subject Diam (in) (Subject Diam Diam Diam One Redus	3 3 5 If to pressure) O D (m) is ar channels of Con Knuckte Redus	Nom This (iii) Nom Th	This (in or Gauge	Curr Atlaw (in Carr Atlaw (in Carr Atlaw (in Eff is) Spot, Partial, or Fulfi (Spec No. C Hemispherical Rodius	Flat Drametes	Attach (Welded, Bolted) Attach Type (Straight of U') Length (Oversit & in 1 M.7 Yemp, (F) No of Courter Side to Pressure (Concave)
AAWP	(Describe 3 3 r coint), test pre- completed for the N/A Stationary Mail (Sp Mail (Spe No.)) Time the Minimum Thekross	psi of mice. psi of mice. psi of mice. 5.7 poc No. Gr.) sc. No. Gr.) spec No. Gr.) inner chambers of mice. Long (DM, Smil) (Spec. No. Gr.) Corrosiun Allowance	Diam (in) (Subject Diam (in) (Subject Diam Diam Diam One Redus	3 3 5 If to pressure) O D (m) is ar channels of Con Knuckte Redus	Nom This (ii) Nom This (iii) Nom Thi	This (in or Gauge	Corr Atlaw (in Corr Atlaw (in Corr Atlaw (in 10 If 6 in 1 Etrin) Spot, Partial, or Futth (Spec No. C Hemispherical Redus	Flat Drametes	Attach (Welded, Bolted) Attach Type (Straight or 'U') Length (Oversilliff & in 1 M.7 Temp. (1*F) No of Courter Side to Pressure (Concave)
AAWP	(Describe 3 3 r coint), test pre- completed for the N/A Stationary Mail (S Floating Mail (S) Mail (S) e completed for high (Spec No. () Time the completed for Time the completed fo	psi of mics. 5.7 be sections pec No. Gr) ec. No. Gr) spec No. Gr) inner chambers of the control of the	Diam (in) (Subject Diam (in) (Subject Diam Diam Diam One Crown Redius	(in) OD (in) Con Con Knuckte Redus	Nom This (iii) Nom Th	This (in or Gauge Conicel Apex Anglo Misti, Spec No. 6	Curr Atlaw (in Curr Atlaw (in Curr Atlaw (in Erris) Number Spot Perist of Full (Spec No. C Nemispherical Redius	isade) Flat Drameter	Attach (Welded, Bolted) Attach Type (Straight or 'U') Length (Oversilliff & in 1 M.7 Temp. (1*F) No of Courter Side to Pressure (Concave)
AAWP	(Describe 3 3 r coint), test pre- completed for the N/A Stationary Mail (Sp Mail (Spe No.)) Time the Minimum Thekross	psi ot miss. 5.7 be sections pec No. Gr.) ec. No. Gr.) spec No. Gr.) inner chambers of prodes Long (DM, Sngl.) (Spec. No. Gr.) Corresion Allowance	Diam (in) (Subject Diam (in) (Subject Diam Diam Diam One Crown Redius	(in) OD (in) Con Con Knuckte Redus	Nom This (ii) Nom This (iii) Nom Thi	Min design met This (in or Gouge RT (Conicel Apex Angle Matt. Spec No. G	Curr Atlaw (in Curr Atlaw (in Curr Atlaw (in Erris) Number Spot Perist of Full (Spec No. C Nemispherical Redius	isade) Flat Drameter	of at 33 psi. Itach (Welded, Bolted) Attach Type (Straight or U') H.7 Temp. I'F) No of Courses Side to Pressura (Convex or Cancave)
	productured for cation of instance in the chomical and instruction, and instruction, and instruction, and instruction is a chomical and instruction in the control of the c	vestion of installation SOFIX in the chornical and physical proprint propriate and physical proprint propriate and workmanship 1989 Addenda Manil SA-240-T304 Maril Illow No. Gr. SVBW Lon N/A Lines Eastion (Top. SIA-24 Leastion (Top. Minimum Thockness TOP .250 BOTTOM .250	position of installation SOFIX CORP., position of installation SOFIX CORP. Position of installation	position of installistion SOFIX CORP., 101 NOR's position of installistion SOFIX CORP., 2800 Pose VERTICAL 1-141 Proper or even, tenshi (Maler i serial No.) Rechardles and physicial properties of all parts majest the requirestruction, and workmanship conform to ASME Rules, Section 1989 N/A Addends Main) Code Cess No. 1989 N/A Code Cess No. 1980 N/A Code Cess No. SV BW Long (Dot. Singl.) N/A SV BW Core (Spec. No. Grade) Lession (Rop. Milmmum Corrosion Grown Redius TOP 250 NONE BOTTOM 250 NONE BOTTOM 250 NONE	SOFIX CORP., 101 NORTHGATE CORP., 101 NORTHGATE CORP., 101 NORTHGATE CORP., 102 NORTHGATE COR	inufactured for SOFIX CORP., 101 NORTHGATE COMMERCI (Name and address of purchaser) cettor of installation SOFIX CORF., 2800 RIVERPORT RD., (Name and address) (NAME) (Interview or ven., tenh) (Interview or ve	Instituted for SOFIX CORP., 101 NORTHGATE COMMERCIAL CTR. Name and address of purchaser) SOFIX CORF., 2800 RIVERPORT RD., CHATTA (Name and address) (Name and address) (Name and address) (Name and address) (Name and address) (Name and address) (NAME (Inverse) (NAME (Inver	SOFIX CORP., 101 NORTHGATE COMMERCIAL CTR., CHATTA. (Name and address of purchaser) (Name and address of purchaser) (Name and address) (Name and address and	SOFIX CORP., 101 NORTHGATE COMMERCIAL CTR., CHATTANOOGA, (Name and address of purchaser) (Name and address of purchaser) (Name and address) SOFIX CORF., 2800 RIVERPORT RD., CHATTANOOGA, TN (Name and address) VERTICAL 1-141 N/A 1-141 12:56 (Name and address) (NAME (CORP) (NAME (CORP) (NAME (CORP) (CORP) N/A 1-141 12:56 (CORP) (CO

(12/87)

Form U-1 (Back)

18. Nozzles, In	spection (and Salary Va	tve Openings:					
Purpose (Inies, Outlet, Orein, etc.)	No	Gigen on Bila	Type	Metl	Marin. Jish.	ésointuraimens Mail	Hop Atlantad	Lorginge
LIO IN	N1	21'	150#KFSO	SA182 F304	SCH 40	g an kaj - aur - g an way i réi réginay uny distriment débadapén (seri er Agarèthe	WELDED	TOP IFAU
LIQ OUT	N2	1 1/2"	PAD FLG	5A276 T304	•=-	na justos a jūra pa prominentam saudinies. Takas	WELLED)	BIM HEAD
30PA INLET	N3	10	150#RFS0	SA182 F304	SC11 40	a basan ingeritar i sian inga na diseberah di teleberahan Mendebah	WELLIEI)	TUP HEAD
VENT	N4	1 1/2"	150#RFS0	SA182 F304	SC11 40	ngada ng pangangan ini diangga piningan proproposat pangangan pangangan Managan	WELDED)	TOP IEAD
TG	N5	111	150#KFSO	SA182 F304	SCH 40	u – 1941 ir ir varas ir	WELDED)	SHELL
SPARE	N6	211	150#RFS0	SA182 F304	SC11 40	ggrap cana yakeyi mpampaya errge Asque eryindi. Heft ggrap	WELLDED	TOP HEAD
SGT GLASS	N7	2 1/2 X 1		SA240 T304		स्वयुक्तासम्बद्धाः क्षेत्रकः सुरः स्वयुक्तासम्बद्धाः स्वरूपाः कर्माः स्वरूपाः स्वरूपाः स्वयुक्तिः	WELDED	SHELL
LGT GLASS	N8	411	150#RFSO	SA240 T304	man man man a m Man a man a ma	gyrige i.	WELDED	TUP HEAD
406 INLET	N9	1 1/2"	150# RFS0	SA182 F304	SC11 40	, a sis ga parag a v rau asanakiriyê diki didhe. 🔑 de 19 de alê dilîre	MELDED	SHELL/TOP HE
40SC OUTLET	N10	1 1/2"	150# 13	SA182 F304	1 scii 40 1	and the second s	WELLED	SIGLL/TOP HE
RELIEF	N11	2"	150# RFS0	SA182 F304	SCH 40	/	WELLED)	TUP HEAD
itoms of the	fanufactu report:	uror's Partist N12 - HAN	Data Reports DKOLE, 6".		i signed by Comm F304, EKH 40, In tem tumbel, migra su	nlesioned Inspectors ha <u>WELDED TO TOP</u> HE ns and identifying Liampit	Wirers and how we been furnished AD, PARKICATE	od for the following
		PE JACKET:	CONSTRUC	DED OF 2" SCH 10	SA 312 PLPE T	יאאנין	en primary and a primary dispersion and the second	
		AT 335 F	سبله ويبدونهم وخدومونوني فيد	-20° F AT 44 PSI	به مدونها خواهد به دوستان به مناهد به دوستان به به	the state of the second		
BIM HE	AD HALF	PIPE JACK	ET: SAME	SPECIFICATIONS AS	LISTED FOR S	HELL HALF PIPE JA	CKET	
				CERTIFICATE OF	MOR COMPLIAN			
				re correct and that all		- -	, and workmansh	ip of this versel can-
			7,251	Vitt, Division 1.	04/28	0	a .	
"U" Certificate			A1.1.()V	FABRICATORS.	INC.		7900	
Date /5 /5	<u> </u>	Co. nen	us	(Manufacturer)		Signed	(Papretentative)	
/essel construct	ed by	ALLOY FAR	BRICATORS	CERTIFICATE OF	SHOP INSPECTION	SO. INDUSTRI	AL DR., TR	entou, ga
i, the undersign	ed, holdi GA	ing a velid co	utel noissimm	ed by the National Bo played by KEMPER	ard of Builer and NATIONAL I	Pressure Vessel Inspect NSURANCE COMP	tors and/or the :	State or Province of
LONG	GROVE,	, ILLINO	LS		have lastness	ad the presents vessell	described in this	Menufecturer's Deta
	TAN	. 10	19 9	ac, and state that, t	o the best of my	nowledge and belief, t	he Manufecturer	has constructed this
	n accorda	ence with ASA	AE Code, Secti	an VIII, Division 1. By	signing this cortif	cate neither the insec	tar nor his emple	over makes eny war-
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ployer shall be il	able in ar			njury or property dame	age or a loss of any	kind erising from er	onnscted with th	nis inspection.
			CEA		ASSEMBLY CON		Witt Milleren 4	of the ASSE Solice
We certify that and Pressure Ve			ISTRUCTION Of S	il parts of this vessel co	mitarina vyjen tria f	adenement di Sacilei	, m 171) M(T(3)M(T &	A. IIIA WAME BAUEL
"U" Cartificate				expires .			•	
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i, the undersign	ed, hold		ommission issu	ed by the National Bo	ard of Boller and	Pressure Vessel Inspec		
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