

**GWD DESIGN, INC.**

**Pipeline MAOP Calculation per CFR 195.106 and consistent with ASME B31.4 Sec. 402 & 404**

**Client:** Whiting Petroleum Corporation  
**Project:** Nexen 8" Oil Pipeline  
**Location:** Stanley, ND

**Rev.:** B  
**Rev. Date:** 10/6/2009  
**Print Date:** 10/6/2009

$$P=(2St/D) \times E \times F \quad (\text{See CFR 195.106 for references below})$$

*P* = Internal design pressure in p.s.i. (kPa) gage.

*S* = Yield strength in pounds per square inch (kPa) determined in accordance with paragraph (b) of this section.

*t* = Nominal wall thickness of the pipe in inches (millimeters).  
If this is unknown, it is determined in accordance with paragraph (c) of this section.

*D* = Nominal outside diameter of the pipe in inches (millimeters).

*E* = Seam joint factor determined in accordance with paragraph (e) of this section.

*F* = A design factor of 0.72, except that a design factor of 0.60 is used for pipe, including risers, on a platform located offshore or on a platform in inland navigable waters, and 0.54 is used for pipe that has been subjected to cold expansion to meet the specified minimum yield strength and is subsequently heated, other than by welding or stress relieving as a part of welding, to a temperature higher than 900 °F (482 °C) for any period of time or over 600 °F (316 °C) for more than 1 hour.

**Line Pipe Calculation:**

*S* = 42,000 psi      API 5L B, X42/X52 (transition piece is API 5L B, X42)  
*t* = 0.250 inches  
*D* = 8.625 inches  
*E* = 1      Only ERW pipe will be used (see CFR 195.106 paragraph (e))  
*F* = 0.72  
  
*P* = 1753 psig      From -20 °F to 100 °F

**Above Ground Pipe Calculation:**

*S* = 35,000 psi      A333 Gr 6 (see attached Fig. 17-25 from GPSA 12th Edition Vol. II)  
*t* = 0.500 inches      Sch. 80  
*D* = 8.625 inches  
*E* = 1      Only ERW/Seamless pipe will be used (see CFR 195.106 paragraph (e))  
*F* = 0.72  
  
*P* = 2922 psig      From -20 °F to 100 °F  
(NOTE: 4" STD wall used for valves is rated to 2654 psig)  
(NOTE: Temperatures below -20 °F are excluded from the scope of ASME B31.4-2006)

**Pipeline "Weak Link":**

The weakest point in the pipeline will be the ANSI 600# flanges per ASME B16.5-2003 as shown in the attached Fig. 17-28 from GPSA 12th Edition Vol. II. **MAOP will be 1480 psig from -20 to 100 °F.**

**GWD DESIGN, INC.**

**Hydrotest Calculation per ASME B31.4 Sec. 437.4**

**Client:** Whiting Petroleum Corporation  
**Project:** Nexen 8" Oil Pipeline  
**Location:** Stanley, ND

**Rev.:** B  
**Rev. Date:** 9/21/2009  
**Print Date:** 10/6/2009

per ASME B31.4 the hydrotest must be run at 1.25 times the MAOP for 4 hours and 1.1 times for 4 hours

**MAOP = 1480 psig (see MAOP Calculation)**

**Hydrotest Pressure:**

Hydrotest Pressure = MAOP x 1.25

**Hydrotest Pressure = 1850 psig** (Required at Highest Point in Elevation during 1.25 test)

**Elevation Change Pressure Head:**

Max Elevation Change = Highest Elevation Point - Lowest Elevation Point

Max Elevation Change = 2371 ft - 2157 ft (See Attached Pipeline Profile)

Max Elevation Change = 214 ft

Water Pressure Head = 92.8 psi (Only valid with Water as Test Medium)

**Minimum Pressure at Points During Test:**

Inlet Elevation = 2192.50 ft      Inlet Pressure = 1925 psig

Outlet Elevation = 2204.85 ft      Outlet Pressure = 1920 psig

High Pt Elevation = 2366.59 ft      High Pt Pressure = 1850 psig

Low Pt Elevation = 2158.16 ft      Low Pt Pressure = 1940 psig

Chart Elevation = 2204.85 ft      **Chart Pressure = 1920 psig**

NOTE: Chart was located at the pipeline outlet near Stanley, ND.

**GWD DESIGN, INC.**  
*Hydrotest Calculation per ASME B31.4 Sec. 437.4*

**Client:** Whiting Petroleum Corporation  
**Project:** Nexen 8" Oil Pipeline  
**Location:** Stanley, ND

**Rev.:** C  
**Rev. Date:** 10/6/2009  
**Print Date:** 10/6/2009

per ASME B31.4 Sec. 437.4.1: When lines are tested at pressures that develop a hoop stress, based on nominal wall thickness, in excess of 90% of the specified minimum yield strength of the pipe, special care shall be used to prevent overstrain of the pipe.

$$\text{Hoop Stress} = P \times ID / 2t < 90\% S$$

- P = Internal Pressure in psig
- ID = Internal Diameter in inches
- t = Wall Thickness in inches
- S = Yield Strength in psi

***Line Pipe Hoop Stress Calculation:***

To prevent overstrain of pipe Max Hydrotest pressure should be at a hoop stress less than 90% of SMYS

ID = 8.125 in  
t = 0.250 in  
S = 52,000 psi

Max Hoop Stress = 46,800 psi

P = 2880 psig (Max Pressure that can be applied at lowest point)

***Above Ground Pipe Hoop Stress Calculation:***

To prevent overstrain of pipe Max Hydrotest pressure should be at a hoop stress less than 90% of SMYS

ID = 7.625 in	<b>Transition Piece</b>
t = 0.500 in	8.125 in
S = 35,000 psi	0.250 in (min)
	42,000 psi

Max Hoop Stress = 31,500 psi	37,800 psi
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P = 4131 psig	2326 psig
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***Maximum Allowable Pressure at Points During Test:***

Inlet Elevation = 2192.50 ft	Inlet Pressure = 2865 psig
Outlet Elevation = 2204.85 ft	Outlet Pressure = 2860 psig
High Pt Elevation = 2368.59 ft	High Pt Pressure = 2790 psig
Low Pt Elevation = 2158.16 ft	Low Pt Pressure = 2880 psig
Chart Elevation = 2204.85 ft	Chart Pressure = 2860 psig

NOTE: Chart was located at the pipeline outlet near Stanley, ND.

**GWD DESIGN, INC.**  
*Fill Volume Calculation*

Client: Whiting Petroleum Corporation  
Project: Noxen 8" Oil Pipeline  
Location: Stanley, ND

Rev.: B  
Rev. Date: 9/21/2009  
Print Date: 10/6/2009

$$\text{Volume} = \pi R^2 L$$

$$R = ID/2$$

$$ID = 8.125 \text{ in} = 0.67708 \text{ ft}$$

$$R = 0.33854 \text{ ft}$$

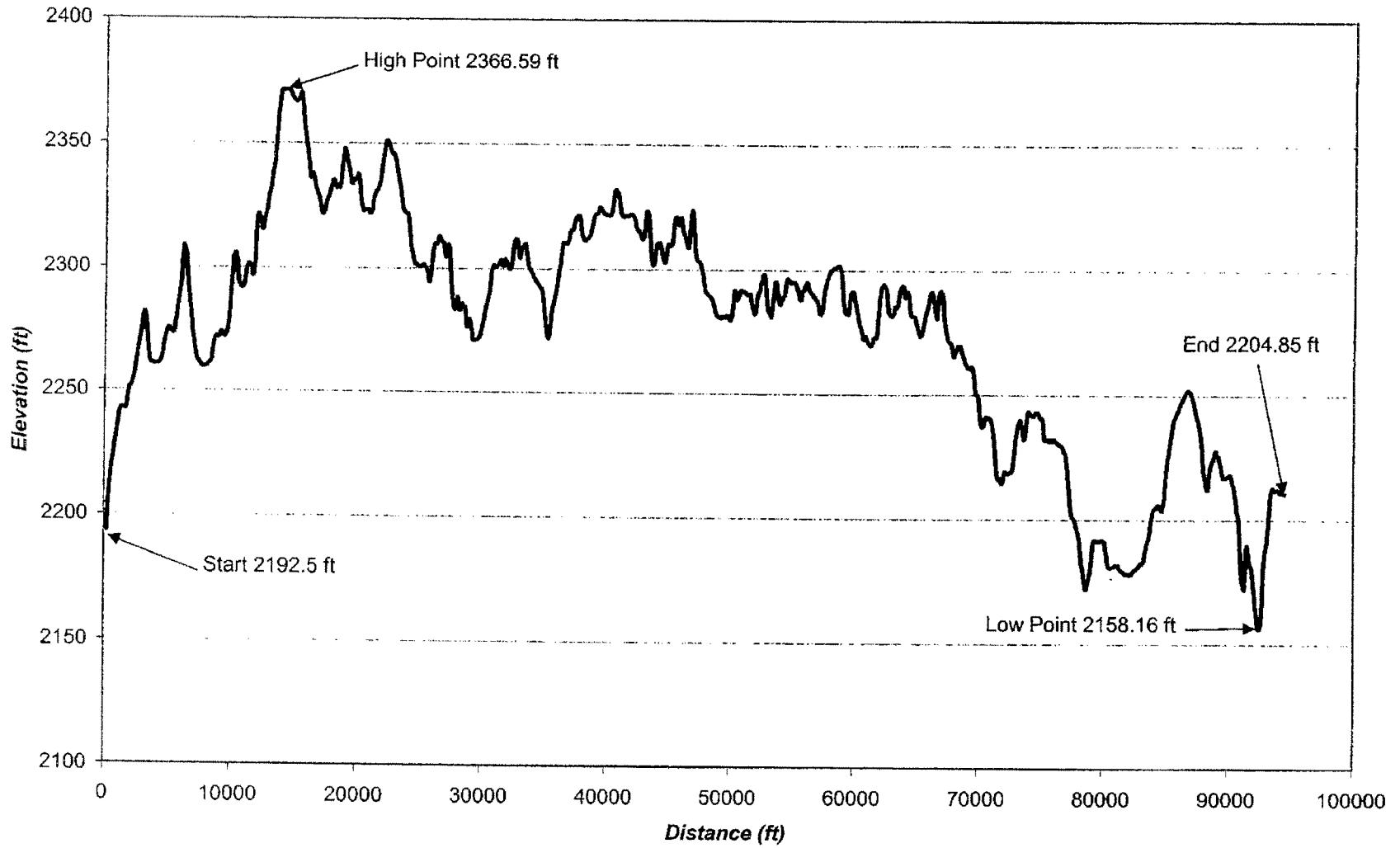
$$L = 94,500 \text{ ft}$$

$$\text{Volume} = 34,026 \text{ ft}^3$$

$$\text{Volume} = 254,529 \text{ gallons}$$

$$\text{Volume} = 6,060 \text{ bbls}$$

### 8" Nexen Oil Pipeline Profile



Material	Specification	Grade	Class	Factor (E)	Tensile Strength min. psi	Yield Strength min. psi	BASIC ALLOWABLE STRESSES IN TENSION, psi (1)																		
							Metal Temperature, °F (7)																		
							(C) Min. Temp.	Min. Temp. to 100	200	300	400	500	600	650	700	750	800	850	900	950	1000	1050	1100		
CARBON STEEL																									
Seamless Pipe																									
	ASTM A53	A	Type S		48000	30000	-20	16000	16000	16000	16000	16000	18900	17300	17000	16500	13000	10800	8700	6500	4500	2500	1600	1000	
	ASTM A53	B	Type S		60000	35000	-20	20000	20000	20000	20000	20000	18900	17300	17000	16500	13000	10800	8700	6500	4500	2500	1600	1000	
	ASTM A106	A			48000	30000	-20	16000	16000	16000	16000	16000	18900	17300	17000	16500	13000	10800	8700	6500	4500	2500	1600	1000	
	ASTM A106	B			60000	35000	-20	20000	20000	20000	20000	20000	18900	17300	17000	16500	13000	10800	8700	6500	4500	2500	1600	1000	
	ASTM A106	C			70000	40000	-20	23300	23300	23300	22300	21600	19700	19400	19200	14800	12000								
	ASTM A120						-20	112000	11400																
	ASTM A120	1			55000	30000	-50	18300	18300	17700	17200	16200	14800	14500	14400	12000	10200	8300	6500	4500	2500	1600	1000		
	ASTM A334	1			55000	30000	-50	18300	18300	17700	17200	16200	14800	14500	14400	12000	10200	8300	6500	4300	2600	1600	1000		
	ASTM A334	6			60000	35000	-50	20000	20000	20000	20000	18900	17300	17000	16500	13000	10800	8700	6500	4500	2500	1600	1000		
	ASTM A334	6			60000	35000	-50	20000	20000	20000	20000	18900	17300	17000	16500	13000	10800	8700	6500	4500	2500	1600	1000		
	API 5L	A			48000	30000	-20	16000	16000	16000	16000	18900	14800	14500	14400	10700	9300	7900	6500	4500	2500	1600	1000		
	API 5L	B			60000	35000	-20	20000	20000	20000	20000	18900	17300	17000	16500	13000	10800	8700	6500	4500	2500	1600	1000		
	API 5LX	X42			60000	42000	-20	20000	20000	20000	20000	18900	17300	17000	16500	13000	10800	8700	6500	4500	2500	1600	1000		
	API 5LX	X46			63000	46000	-20	21000	21000	21000	21000														
	API 5LX	X52			66000	52000	-20	22000	22000	22000	22000														
	API 5LX	X52			72000	52000	-20	24000	24000	24000	24000														
Electric Resistance Welded Pipe																									
	ASTM A53	A	Type E	0.85	48000	30000	-20	13600	13600	13800	13600	13500	12800	12300	12250	9100	7900	6700	5500	3800	2150	1350	850		
	ASTM A53	B	Type E	0.85	60000	35000	-20	17000	17000	17000	17000	16100	14700	14500	14000	11000	9200	7350	5500	3800	2150	1350	850		
	ASTM A120			0.85			-20	10200	9800																
LOW AND INTERMEDIATE ALLOY STEEL & STAINLESS STEEL (4.40) - Seamless Pipe																									
3 1/2 Ni	ASTM A333	3			65000	35000	-150	21700	19600	19600	18700	17800	16800	16300	15500	13900	11400	9000	6500	4500	2500	1600	1000		
3 1/2 Ni	ASTM A334	3			65000	35000	-150	21700	19600	19600	18700	17800	16800	16300	15500	13900	11400	9000	6500	4500	2500	1600	1000		
Ni-Cr-Co-Al	ASTM A333	4			60000	35000	-150	20000	19100	18200	17300	16400	15500	15000											
2 1/4 Ni	ASTM A333	7			65000	35000	-100	21700	19600	19600	18700	17600	16800	16300	15500	13900	11400	9000	6500	4500	2500	1600	1000		
2 1/4 Ni	ASTM A334	7			65000	35000	-100	21700	19600	19600	18700	17600	16800	16300	15500	13900	11400	9000	6500	4500	2500	1600	1000		
9 Ni	ASTM A333	8			100000	75000	-320	31700	31700																
9 Ni	ASTM A334	8			100000	75000	-320	31700	31700																
18Cr-8Ni Pipe	ASTM A376	TP304			75000	30000	-425	20000	20000	20000	18700	17500	16400	16200	16000	15600	15200	14900	14600	14400	13800	12300	9700		
18Cr-8Ni Pipe	ASTM A376	TP304L			75000	30000	-325	20000	20000	20000	18700	17500	16400	16200	16000	15600	15200	14900	14600	14400	13800	12200	9700		

Note: ASME 31.3 Appendix A includes notes which may additionally limit allowable stress values or application of the above materials due to temperature limitations, wall thickness, heat treating, material composition, etc. Refer to ASME 31.3 Appendix A notes for these limitations or special requirements applicable to particular materials.

Representative Allowable Stresses in Tension for Materials  
(Developed from ASME B31.3, 2002, Tables A-1, A-1B)

FIG. 17-25



FIG. 17-28

Pressure-Temperature Ratings for Pipe Flanges and Flanged Fittings from ANSI B16.5-1996

CLASS	150	300	400	600	900	1500	2500
Material Group 1.1 (Carbon Steel)						A105 (1), A216-WCB (1), A515-70 (1) A516-70 (1) (2) A350-LF2 (1), A537-C1.1 (3)	
°F	Pressures are in pounds per square inch, gauge (psig)						
-20 to 100	285	740	990	1480	2220	3705	6170
200	260	675	900	1350	2025	3375	5625
300	230	685	875	1315	1970	3280	5470
400	200	635	845	1270	1900	3170	5280
500	170	600	800	1200	1795	2995	4990
600	140	550	730	1095	1640	2735	4560
650	125	535	715	1075	1610	2685	4475
700	110	535	710	1065	1600	2665	4440
750	95	505	670	1010	1510	2520	4200
800	80	410	550	825	1235	2060	3430
850	65	270	355	535	805	1340	2230
900	50	170	230	345	515	860	1430
950	35	105	140	205	310	515	860
1000	20	50	70	105	155	260	430
Material Group 2.1 (Type 304)						A182-F304 (5), A182-F304H A240-304 (5), A351-CF8 (5) A351-CF3 (4)	
-20 to 100	275	720	960	1440	2160	3600	6000
200	230	600	800	1200	1800	3000	5000
300	205	540	720	1080	1620	2700	4500
400	190	495	660	995	1490	2485	4140
500	170	465	620	930	1395	2330	3880
600	140	435	580	875	1310	2185	3640
650	125	430	575	860	1290	2150	3580
700	110	425	565	850	1275	2125	3540
750	95	415	555	830	1245	2075	3460
800	80	405	540	805	1210	2015	3360
850	65	395	530	790	1190	1980	3300
900	50	390	520	780	1165	1945	3240
950	35	380	510	765	1145	1910	3180
1000	20	320	430	640	965	1605	2675
1050		310	410	615	925	1545	2570
1100		255	345	515	770	1285	2145
1150		200	265	400	595	995	1655
1200		155	205	310	465	770	1285
1250		115	150	225	340	565	945
1300		85	115	170	255	430	715
1350		60	80	125	185	310	515
1400		50	65	90	145	240	400
1450		35	45	70	105	170	285
1500		25	35	55	80	135	230

- Notes:
- (1) Upon prolonged exposure to temperatures above about 800°F (425°C), the carbide phase of carbon steel may be converted to graphite; permissible but not recommended for prolonged use above 800°F
  - (2) Not to be used over 850°F
  - (3) Not to be used over 700°F
  - (4) Not to be used over 800°F
  - (5) At temperatures over 1000°F (540°C), use only when the carbon content is 0.04 percent or higher
  - (6) For temperatures above 1000°F (540°C), use only if the material is heat treated by heating it to a temperature of at least 1900°F (1040°C) and quenching in water or rapidly cooling by other means

### 6.3. HAZOP Recommendations: Whiting Oil & Gas

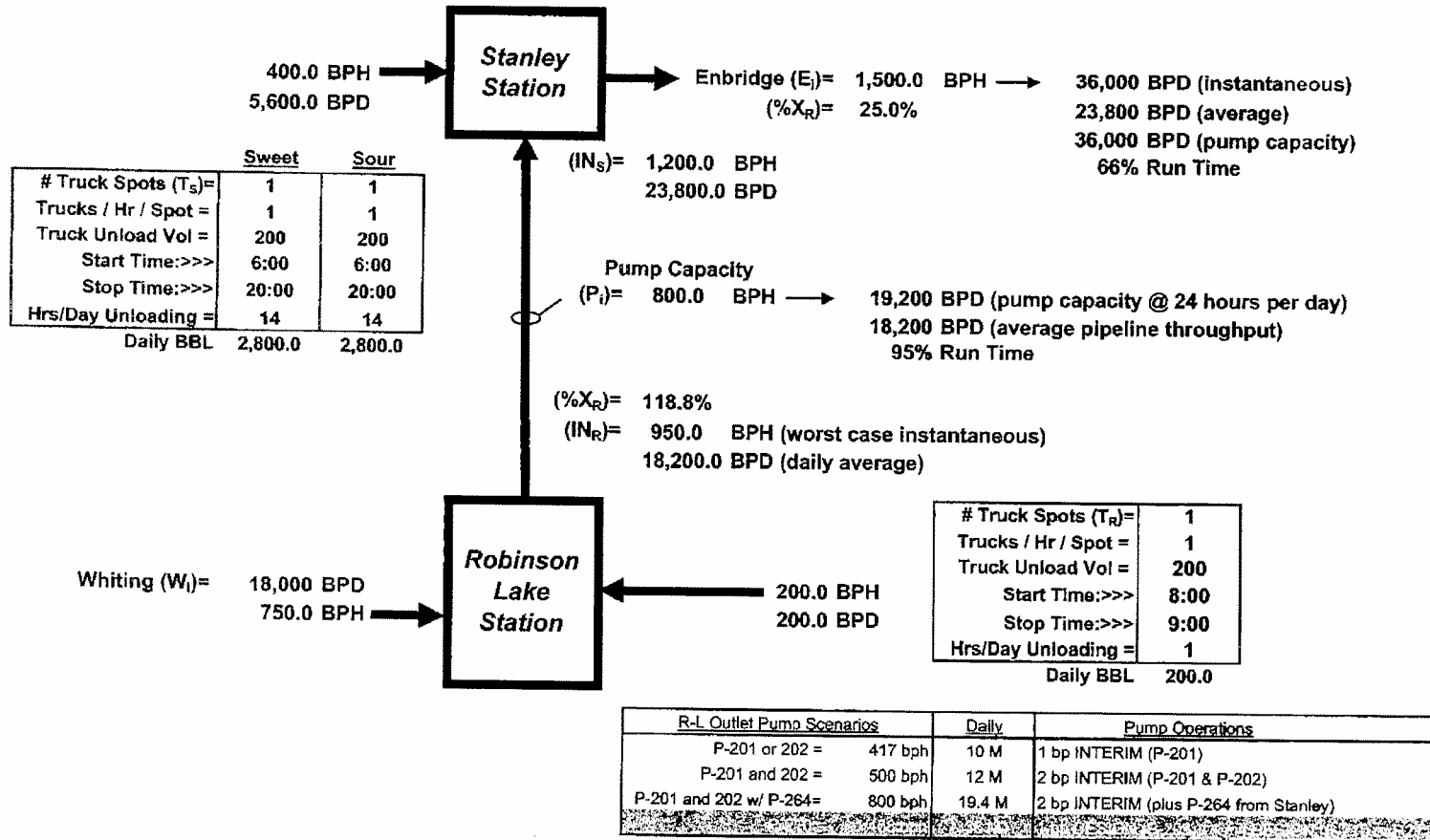
During discussion of node 1 (Robinson Lake inlet from the Whiting Oil and Gas Co. crude pipeline), a representative from Whiting was available to provide information to the PHA team related to the pipeline and nearby operations.

As a result of the review of this node, six (6) recommendations were made for which input or follow-up from Whiting would be required. Two (2) of these six recommendations were ranked as "H" high risk. These recommendations were as follows:

Recommendations	Max RR	Responsibility
32. Review means to divert overland water from the Whiting facility away from the diked area at the Nexen Robinson Lake facility, as this water could reduce the capacity of the Nexen dikes. (Causes: 1.15.2)		Travis Mecham and Bill Herrmann
35. Review the location of the truck unloading facility, as Whiting trucks will require access via the truck unloading area to other areas of the Robinson Lake site. (Causes: 1.15.4)		Bill Herrmann, Barry Garvin, Travis Mecham
1. Consider having Whiting add a bladder valve upstream of AOV-1001 (line 8-CO-AGA-1010), in order to protect and maintain backpressure in the Whiting oil pipeline. (Causes: 1.1.1, 1.1.2)	M	Bill Herrmann and Barry Garvin
3. Consider the addition of a low pressure alarm to PIT-1001, on the Whiting pipeline, as a potential means to identify leaks on the Whiting pipeline and at the inlet to the Robinson Lake station. (Causes: 1.1.1, 1.1.2)	M	Bill Herrmann and Barry Garvin
4. Verify with Whiting that their pipeline pumps will shut down on high discharge pressure, and/or verify that PSVs are included on the Whiting pipeline, to reduce the likelihood of potential pipeline ruptures that could occur should AOV-1001 at Robinson Lake malfunction closed. Also determine if the response time of the shutdowns on the Whiting pipeline are quick enough to reduce the likelihood of a spill in the event AOV-1001 malfunctions closed. (Causes: 1.1.3)	M	Bill Herrmann and Barry Garvin
33. Consider removing the drain line from the Whiting plant (the contents of which are currently unknown). (Causes: 1.15.3)		Travis Mecham and Bill Herrmann

Stanley Outlet Pump Scenarios	Daily	Pump Operations
P-262 = 500 bph	12 M	1 bp INTERIM (P-262)
P-263 = 1000 bph	24 M	1 bp INTERIM (P-263)
P-262/263 = 1500 bph	36 M	2 bp INTERIM (P-262 & P-263 in parallel)

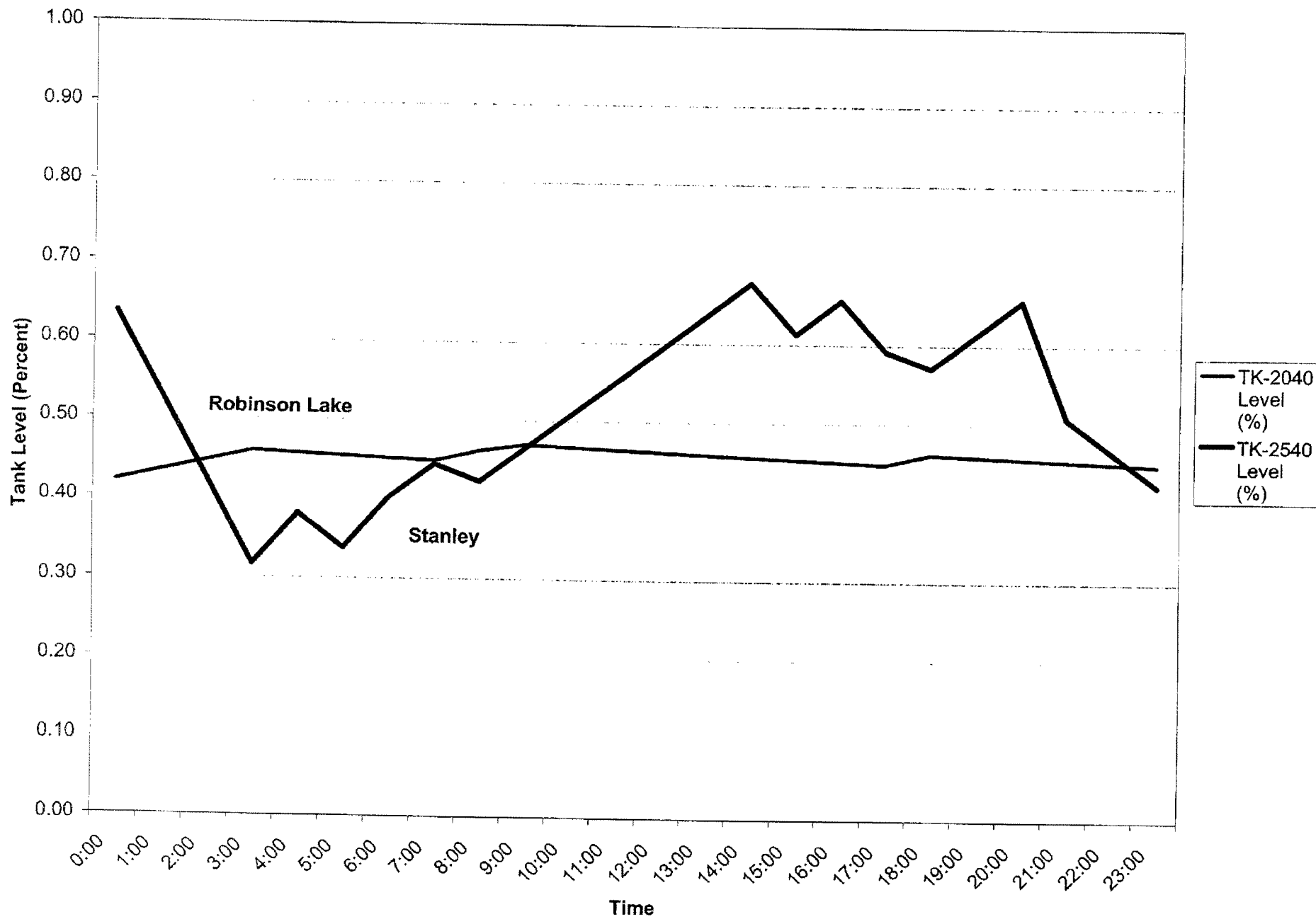
Future  
Future



R-L Outlet Pump Scenarios	Daily	Pump Operations
P-201 or 202 = 417 bph	10 M	1 bp INTERIM (P-201)
P-201 and 202 = 500 bph	12 M	2 bp INTERIM (P-201 & P-202)
P-201 and 202 w/ P-264 = 800 bph	19.4 M	2 bp INTERIM (plus P-264 from Stanley)

Future

Tank Levels, Day 1



# Monthly Tank Levels

