
	<b>DIESEL HYDROTREATMENT PROJECT (DHT)</b>	
	<b>DOCUMENT TITLE:</b> WPS for Damper TV-970078	<b>Contract No.:</b> 1032/GC-GN/CON-EP09-00
	<b>DOCUMENT NUMBER:</b> 3607/33-97-4912UD-ME-WPS-0411	<b>POI:</b> FA <b>Rev. No.:</b> A0

# ESFAHAN OIL REFINING COMPANY


## DIESEL HYDROTREATMENT PROJECT (DHT)



### DOCUMENT TITLE

WPS for Damper TV-970078

### DOCUMENT NUMBER

3607/33-97-4912UD-ME-WPS-0411



PURCHASER'S COMMENT/APPROVAL STATUS				Purchaser: NARGAN		
	1. AP: Approved (Released for Manufacturing)			Requisition No.: 3607/33-97-4912UD-ME-DS-4029		
	2. AN: Approved as Noted for Fabrication (Fabrication may Proceed)					
	3. NF: Approved as Noted for Re-Issue (Fabrication not Proceed)			Item No. (Tag No.): TV-970078		
	4. RE: Rejected					
	5. NR: Not Returned			Vendor Doc. No.: Cii97-90004-VD-WPS-01		
Date:	XX.XX.XX	Signature:				
						 Centigrade IND.INC
A0	30.DEC.2008	ISSUED FOR APPROVAL	E.BEYGI	D.DEHGHANI	D.DEHGHANI	
Rev	DATE	DESCRIPTION	PREP'D	CHK'D	APP'D	

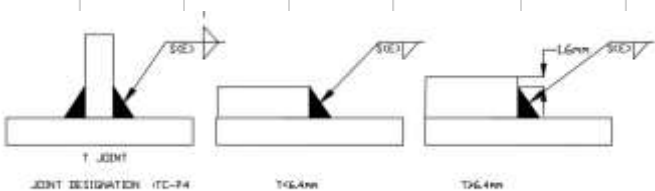
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### TABULATION OF REVISED PAGES

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COMPANY NAME : Centigrade Industries		standard/specification : <b>Aws D.1.1</b>	
SUPPORTING PQR NO. : <b>PREQUALIFIED</b>			
WELDING PROCESS(ES) (D.1.1): <b>SMAW</b>			
TYPE : <b>MANUAL</b>		TYPE OF JOINT : <b>FILLET</b>	
<b>JOINTS (D.1.1- 3.12) :</b>			
JOINT DESIGNATION : <b>TC</b>			
ROOT OPENING: <b>N.A</b>			
ROOT FACE: <b>N.A</b>			
GROOVE ANGLE: <b>NONE</b>			
OTHER : -			
<b>FILLET SIZE (E)</b>			
<b>BASE METALS(D.1.1- 3.3) :</b>			
SPECIFICATION TYPE AND GRADE : <b>S.S 304L</b>			
THICKNESS RANGE			
BASE METAL : <b>6 mm</b>		GROOVE : <b>N.A</b>	
		FILLET : <b>UNLIMITED</b>	
PIPE DIA RANGE : <b>UNLIMITED</b>			
<b>FILLER METALS (D.1.1- 3.3) :</b>		<b>FIRST PASS</b>	<b>OTHER PASS</b>
SPEC. NO.:		<b>SFA-5.4</b>	-
AWS.NO.(CLASS)		<b>E310</b>	-
SIZE OF FILLER METALS		<b>F = 3.25 (mm)</b>	-
FILEER OR ELECTRODE WIRE (CLASS)		-	-
FLUX (CLASS)		<b>N.A</b>	-
OTHER		-	-
<b>NOTE :1 )</b> SMAW FOR TACK WELDS OF THE PIECES SHALL BE DONE WITH FOLLOWING CONDETIONS:			
AWS No. <b>E310</b> / SIZE <b>3.25mm</b> / <b>DC+ /90~120 AMP</b> / <b>22VOLTS</b> / <b>SPEED18-20mm/Min</b> / <b>POSITION ALL</b>			
<b>2)</b> WHEN THE BASE METAL TEMP. IS BELOW <b>0°C</b> , THE BASE METAL SHALL BE <b>PREHEATED</b> TO A MINIMUM OF <b>20°C</b> AND <b>INTERPASS</b> TEMP. SHALL BE MAINTAINED DURING WELDING.			

	<b>DIESEL HYDROTREATMENT PROJECT (DHT)</b>	
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POSITIONING OF GROOVE: <b>N.A</b>				TEMPERATURE RANGE: <b>N.A</b>															
WELDING PROGRESSION UP <input type="checkbox"/> DOWN <input checked="" type="checkbox"/>				HEATING/COOLING RATE: <b>N.A</b>															
POSITIONING OF FILLET: <b>ALL</b>				TIME RANGE: <b>N.A</b>															
<b>PREHEAT: (D.1.1- 3.5)</b>				<b>GAS(D.1.1- 3.6):</b>															
PREHEAT TEMPERATURE: <b>30°C</b>				<table border="1" style="width: 100%;"> <tr> <th></th> <th>GAS(ES)</th> <th>MIXTURE</th> <th>FLOW RATE</th> </tr> <tr> <td>SHIELDING</td> <td>-</td> <td>-</td> <td>-</td> </tr> <tr> <td>BACKING</td> <td>-</td> <td>-</td> <td>-</td> </tr> </table>					GAS(ES)	MIXTURE	FLOW RATE	SHIELDING	-	-	-	BACKING	-	-	-
	GAS(ES)	MIXTURE	FLOW RATE																
SHIELDING	-	-	-																
BACKING	-	-	-																
INTERPASS TEMPERATURE: <b>SAME AS PREHEAT</b> (max) 260																			
(continue or special heating where applicable should be recorded.)																			
<b>ELECTRICAL CHARACTERISTIC:</b>																			
<b>ELECTRICAL CHARACTERISTIC:</b>																			
CURRENT AC OR DC: <b>AC OR DC</b>		POLARITY: <b>DCEN</b>																	
TANGESTIN ELECTROD SIZE & TYPE: <b>NA</b>																			
MODE OF METAL TRANSFER & GMAW <b>NA</b>																			
ELECTROD WIRE FEED SPEED RANGE: <b>NA</b>																			
<b>TECHNIQUE :</b>																			
STRING OF WAVE BEAD:				STRINGER OR WEAWE															
ORIFICE OF GAS CUP SIZE:				NA															
INITIAL & INTERPASS CLEANING (BRUSHING GRINDING ETC.):				BRUSHING AND GRINDING (SLAG REMOVED)															
METHOD OF BACK GOUGING :				NA															
OSCILLATION:				NA															
CONTACT TUBE WORK DISTANCE:				NA															
MULTIPLE OR SINGLE PASS:				SINGEL															
TRAVELSPEED (RANGE):				SEE TABLE															
TRAVELSPEED (RANGE):				SEE TABLE															
OTHER:																			
WELD LAYERS	PROCESS	FILLER METAL CLASS	FILLER METAL DIA. (mm)	CURRENT TYPE OF POLE	CURRENT AMP RANGE	VOLT RANGE	TRAVEL SPEED RANG (cm/min)	OTHERS											
AS REQ'D	SMAW	E 310	3.2	AC OR DC+	90-120	10-16	18-20												