




 Esfahan Oil Refining Company	 HEIDCO	 NARGAN	CON. NO.: 1032/GC-GN/CON-EP09-00			REF. NO. : 3607/33-PRC-9559				
			DOCUMENT NUMBER							
DIESEL HYDROTREATMENT PROJECT (DHT)			PLAN /PRJ.	UNIT	PHASE	DISC.	DOC. TYPE	SER NO.	REV.	PAGE
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WPS for Damper TV-970078

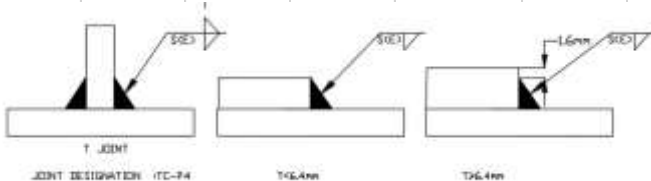
A0	30.DEC.2008	ISSUED FOR APPROVAL	E.BEYGI	D.DEHGHANI		
REV.	DATE	DESCRIPTION	PREPARED BY	CHECKED BY	CONTRACTOR	EMPLOYER
					APPROVED	




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			DIESEL HYDROTREATMENT PROJECT (DHT)	

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

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POSITIONING OF GROOVE: N.A				TEMPERATURE RANGE: N.A				
WELDING PROGRESSION UP <input type="checkbox"/> DOWN <input checked="" type="checkbox"/>				HEATING/COOLING RATE: N.A				
POSITIONING OF FILLET: ALL				TIME RANGE: N.A				
PREHEAT: (D.1.1- 3.5)				GAS(D.1.1- 3.6):				
PREHEAT TEMPERATURE: 30°C				GAS(ES) MIXTURE FLOW RATE				
				SHILDING - - -				
INTERPASS TEMPERATURE: SAME AS PREHEAT (max) 260				BACKING - - -				
(continuse or special heating where applicable should be recorded.)								
ELECTRICAL CHARACTERISTIC:								
ELECTRICAL CHARACTERISTIC:								
CURRENT AC OR DC: AC OR DC				POLARITY: DCEN				
TANGESTIN ELECTROD SIZE & TYPE: NA								
MODE OF METAL TRANSFER & GMAW NA								
ELECTROD WIRE FEED SPEED RANGE: NA								
TECHNIQUE :								
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		CURRENT		VOLT RANGE	TRAVEL SPEED RANG (cm/min)	OTHERS
		CLASS	DIA. (mm)	TYPE OF POLE	AMP RANGE			
AS REQ'D	SMAW	E 310	3.2	AC OR DC+	90-120	10-16	18-20	