
	<b>DIESEL HYDROTREATMENT PROJECT (DHT)</b>	
	<b>DOCUMENT TITLE:</b> PQR 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

PQR for Damper TV-970078

### DOCUMENT NUMBER

VD-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:			
A0	13.JAN.2019	ISSUED FOR APPROVAL	H.MOHAJERI	E.BEYGI	D.DEHGHANI
Rev	DATE	DESCRIPTION	PREP'D	CHK'D	APP'D



Centigrade  
IND.INC





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### TABULATION OF REVISED PAGES

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Company Name: CENTIGRADE IND. INC.

Procedure Qualification Record No.: 01

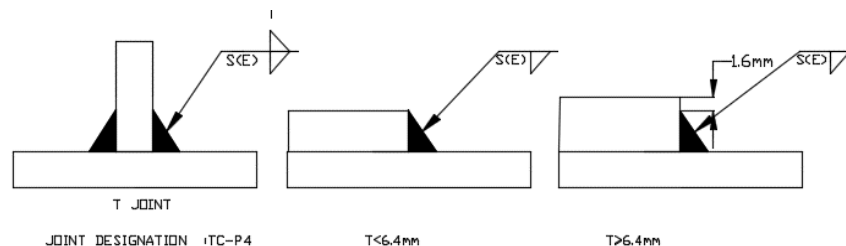
Date: 05/01/2019

WPS No.: WPS-01



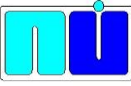
Welding Process(es): SMAW

Types (Manual, Automatic, Semi-Automatic): MANUAL

## JOINTS



<b>BASE METALS</b> Material Spec.: Stainless Steel 304L  Thickness of Test Coupon: 6 mm	<b>POSTWELD HEAT TREATMENT</b> Temperature: NA Time: NA
	<b>GAS</b> Gas(es) (Mixture) Flow Rate  Shielding: NA  Backing: NA
<b>FILLER METALS</b> SFA Specification: A5.4 AWS Classification: E310 Size of Filler Metal: 3.25 mm Weld Metal Thickness: 6mm	<b>ELECTRICAL CHARACTERISTICS</b> Current: AC OR DC+ Polarity: DCEN Amps.: 90-120 Volts: 10-16
<b>POSITION</b> Position of Fillet: ALL Weld Progression (Uphill, Downhill): Flat	<b>TECHNIQUE</b> Travel Speed: 18-20 (cm/min) String or Weave Bead STRINGER OR WEAVE Oscillation: NA Multipass or Single Pass (Per Side): Single Pass
<b>PREHEAT</b> Preheat Temperature 30°C Interpass Temperature NA	

 Esfahan Oil Refining Company  HEIDCO	<b>DIESEL HYDROTREATMENT PROJECT (DHT)</b>	 <b>NARGAN</b> ENGINEERS & CONSTRUCTORS
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### TEST RESULT

**VISUAL TEST RESULTS: OK**

### FRACTURE TEST

SPECIMEN NO.	RESULT	REMARK
1	OK	See attached file

### MACROTCH TEST

SPECIMEN NO.	RESULT	REMARK
1	OK	See attached file