
	DIESEL HYDROTREATMENT PROJECT (DHT)	
	DOCUMENT TITLE: WPS for Damper TV-970078	Contract No.: 1032/GC-GN/CON-EP09-00
	DOCUMENT NUMBER: 3607/33-97-4912UD-ME-WPS-0411	POI: FA Rev. No.: A1

ESFAHAN OIL REFINING COMPANY


DIESEL HYDROTREATMENT PROJECT (DHT)



DOCUMENT TITLE

WPS 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:				
						 Centigrade IND.INC
A1	12.SEP.2018	ISSUED FOR APPROVAL	E.BEYGI	D.DEHGHANI	D.DEHGHANI	
A0	30.DEC.2018	ISSUED FOR APPROVAL	E.BEYGI	D.DEHGHANI	D.DEHGHANI	
Rev	DATE	DESCRIPTION	PREP'D	CHK'D	APP'D	

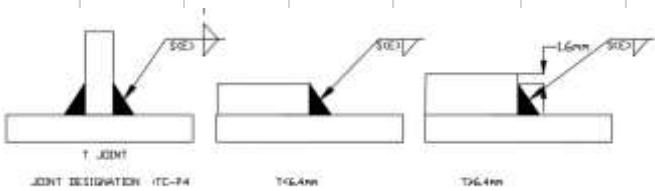
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COMPANY NAME : Centigrade Industries		standard/specification : Aws D.1.1	
SUPPORTING PQR NO. : PREQUALIFIED			
WELDING PROCESS(ES) (D.1.1): SMAW			
TYPE : MANUAL		TYPE OF JOINT : FILLET	
JOINTS (D.1.1- 3.12) :			
JOINT DESIGNATION : TC			
ROOT OPENING: 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 CONDEITIONS:			
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				<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: SAME AS PREHEAT (max) 260 (continue 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												