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| **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) | | |
|  | 2. AN: Approved as Noted for Fabrication (Fabrication may Proceed) | | | Requisition No.: 3607/33-97-4912UD-ME-DS-4029 | | |
|  | 3. NF: Approved as Noted for Re-Issue (Fabrication not Proceed) | | |
|  | 4. RE: Rejected | | | Item No. (Tag No.): TV-970078 | | |
|  | 5. NR: Not Returned | | |
| Date: XX.XX.XX Signature: | | | | Vendor Doc. No.: Cii97-90004-VD-WPS-01 | | |
|  |  |  |  |  |  | E:\sentigrade arm.jpg  Centigrade IND.INC |
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| A0 | 13.Jan.2019 | ISSUED FOR APPROVAL | H.Mohajeri | E.Beygi | D.Dehghani |
| Rev | DATE | DESCRIPTION | PREP'D | CHK'D | APP'D |

**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

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

**Test Result**

**Visual test Results: ok**

**FRACTURE Test**

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| specimen no. | result | remark |
| 1 | ok | See attached file |

**MACROtch TEST**

|  |  |  |
| --- | --- | --- |
| specimen no. | result | remark |
| 1 | ok | See attached file |