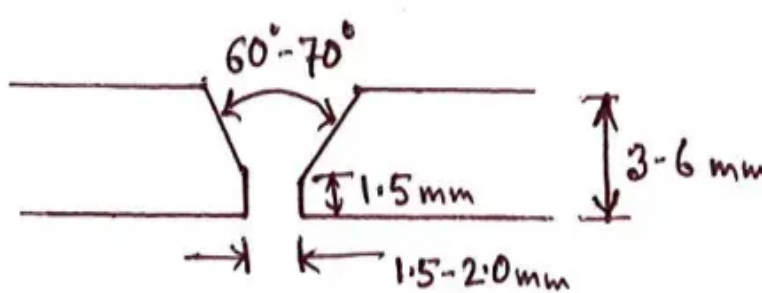


**EASTERN REFINERY LIMITED**  
**CHATTOGRAM**  
**INSPECTION DEPARTMENT**  
**WELDING PROCEDURE SPECIFICATION**

|  |                        |                                     |                |
|--|------------------------|-------------------------------------|----------------|
| UNIT :   | Reforming              | SL. NO.                             | 1234           |
| ITEM :   | 4" dia pipe line       | WELDING PROCESS :                   | GTAW + SMAW    |
| LOCATION/MARK :  | B1206 A/B - KM 1202/3  | CODE REF                            | Not mentioned  |
| P-NO:  | 8                      | GR:                                 | 1              |
| BASE METAL :   | ASTM A312 TP321        | BACKING :                           | NO             |
| THICKNESS RANGE :  | 3-6 mm                 | BACKING MATERIAL                    |                |
| PIPE DIAMETER :  | 4"                     |                                     |                |
| <b>JOINT DESIGN</b>  |                        | <b>DEPOSITED WELD METAL DETAILS</b> |                |
|  |                        | Not mentioned                       |                |
| <b>FILLER METALS</b>   |                        |                                     |                |
| <b>TYPE</b>  | <b>ROOT</b>            | <b>FILLING</b>                      | <b>CAPPING</b> |
| <b>W. PROCESS</b>  | GTAW                   | SMAW                                | -              |
| <b>Ø ELECT.</b>  | -                      | 2.5                                 | -              |
| <b>Ø FILLER</b>  | 2.4 mm                 | -                                   | -              |
| <b>AWS NO.</b>   | ER 347 (SFA 5.4)       | ER 347 (SFA 5.9)                    | -              |
| <b>SHIELDING GAS</b>   |                        | <b>YES</b>                          |                |
| <b>COMPOSITION</b>   |                        | <b>N/A</b>                          |                |
| <b>PURITY</b>  |                        | <b>N/A</b>                          |                |
| <b>FLOW RATE</b>   |                        | <b>N/A</b>                          |                |
| <b>POSITION (S)</b>  |                        | <b>N/A</b>                          |                |
| <b>PROGRESSION</b>   |                        | <b>N/A</b>                          |                |
| <b>PREHEAT TEMPERATURE</b>   |                        |                                     |                |
| BASE METAL:  | N/A                    | ELECTRODE:                          | N/A            |
| INTERPASS TEMPERATURE:   |                        | N/A                                 |                |
| <b>POST HEAT:</b>  |                        | NO                                  |                |
| HEATING RATE:  |                        | N/s                                 |                |
| HOLDING TIME:  |                        | N/s                                 |                |
| COOLING RATE:  |                        | N/s                                 |                |
| <b>NDT</b>   |                        | <b>REMARKS</b>                      |                |
| VISUAL :   | Yes                    | Nothing special                     |                |
| DYE PENETRANT TEST :   | Yes, (After root pass) |                                     |                |
| RADIOGRAPHY :  | Yes                    |                                     |                |
| HARDNESS :   | Yes                    |                                     |                |
| HYDRO TEST PRESSURE :  | Yes                    |                                     |                |
| ISSUED BY :  | Someone                | APPROVED BY :                       | Somebody       |