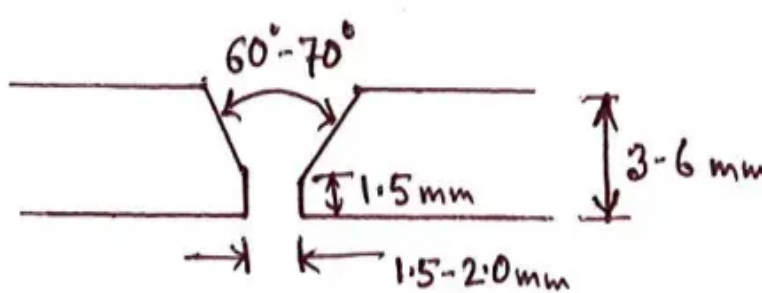


EASTERN REFINERY LIMITED
CHATTOGRAM
INSPECTION DEPARTMENT
WELDING PROCEDURE SPECIFICATION

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"																																						
JOINT DESIGN		DEPOSITED WELD METAL DETAILS																																					
		Not mentioned																																					
<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th colspan="4">FILLER METALS</th> <th>SHIELDING GAS</th> <th>YES</th> </tr> <tr> <th>TYPE</th> <th>ROOT</th> <th>FILLING</th> <th>CAPPING</th> <th>COMPOSITION</th> <th>N/A</th> </tr> <tr> <td>W. PROCESS</td> <td>GTAW</td> <td>SMAW</td> <td>-</td> <td>PURITY</td> <td>N/A</td> </tr> <tr> <td>Ø ELECT.</td> <td>-</td> <td>2.5</td> <td>-</td> <td>FLOW RATE</td> <td>N/A</td> </tr> <tr> <td>Ø FILLER</td> <td>2.4 mm</td> <td>-</td> <td>-</td> <td>POSITION (S)</td> <td>N/A</td> </tr> <tr> <td>AWS NO.</td> <td>ER 347 (SFA 5.4)</td> <td>ER 347 (SFA 5.9)</td> <td>-</td> <td>PROGRESSION</td> <td>N/A</td> </tr> </table>				FILLER METALS				SHIELDING GAS	YES	TYPE	ROOT	FILLING	CAPPING	COMPOSITION	N/A	W. PROCESS	GTAW	SMAW	-	PURITY	N/A	Ø ELECT.	-	2.5	-	FLOW RATE	N/A	Ø FILLER	2.4 mm	-	-	POSITION (S)	N/A	AWS NO.	ER 347 (SFA 5.4)	ER 347 (SFA 5.9)	-	PROGRESSION	N/A
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AWS NO.	ER 347 (SFA 5.4)	ER 347 (SFA 5.9)	-	PROGRESSION	N/A																																		
PREHEAT TEMPERATURE																																							
BASE METAL:		N/A		ELECTRODE:	N/A																																		
INTERPASS TEMPERATURE:				N/A																																			
POST HEAT:				NO																																			
HEATING RATE:				N/s																																			
HOLDING TIME:				N/s																																			
COOLING RATE:				N/s																																			
NDT				REMARKS																																			
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																																		