



## DALMIA CEMENT (B) LIMITED – ARIYALUR



### MECHANICAL SOP

Issue No. 01	Rev. No: 00	Effective Date: 30.09.2016	SOP/MEC/136
Issued By: M.R		Approved By: HOD Mechanical	
SOP FOR PRIMARY AND SECONDARY CRUHSER TOOTH SEGMENT HARD FACING			

**Scope:** Crusher tooth segment hard facing job

**Responsibility:** Fitter/ Welder/ Supervisor

**Accountability:** Mechanical-Section Engineer / Section Head

**PPE:**

1. Safety helmet.
2. Safety shoe.
3. Nose Mask.
4. Hand Gloves.
5. Goggles.
6. Leather apron.

**TOOLS:**

1. Welding shield
2. Welding machine
3. Chipping hammer
4. Wire Brush

**Hazard Analysis:**

**Risks associated:**

**Mitigating Measures**

Slip of tools

: Use appropriate tools

Electric shock

: Use appropriate gloves & machine Earth system

**SOP FOR PRIMARY AND SECONDARY CRUHSER TOOTH SEGMENT HARD FACING**

1. Use ppe's while working.
2. Take the worn out segments which has to be hard faced.



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3. Check the welding machine and holder condition for welding.
4. Check the height of the tooth's which has to be welded.
5. Cleaning of segment tooth's by wire brush.
6. Electrodes to be preheated by electrode ovens as per recommendations.
7. First Buffer layer welding to be done by buildup electrodes.
8. Buffer layer welding to be done up to 80mm height.
9. Second final layer welding to be done by Final coating electrodes.
10. Final layer welding to be done up to 85mm height (05mm).
11. Check the height of the welding layer with template.
12. Check for any welding cracks
13. Slags to be removed by chipping hammers.

#### Emergency / Emergency Shut OFF:

1. If any injury takes place, provide First aid and inform to the Safety department or Call Emergency number 3108/9865152222

#### Records/Annexure:

1. JSA as enclosed below



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<b>Job Safety Analysis</b>	Job: Crusher tooth segment hard facing job	Date: 02/07/2016	Analysis by: Section Engineer	Reviewed by: Section Head
Title of employee doing job: Crusher tooth segment hard facing job	Supervisor: Section Engineer	Department: Mechanical	Section: RMH Truck tippler	Approved by: HOD Mechanical
Req'd/recommended PPE:				
Sequence of Basic Job Steps	Potential Hazards	Recommended Safe Job Procedure	What Could Go Wrong	Corrective Action
Removing of chips	Body injury	Use appropriate tools	While removing slags, chipping hammer slip.	Use Correct type of tools and hammers.
Using the Welding machine	Hand injury (electric Shock)	Use proper Earth connection	While Welding the job ,secondary earth not connected properly	Check the earth connection before doing the welding