



**DALMIA CEMENT (B) LIMITED – CEMENT PLANT
ARIYALUR
INSTRUMENTATION DEPARTMENT**

Issue No. 02	Rev. No: 00	Effective Date: 01.11.2019	WI-9 (SP-8; AM-7)
Issued By: M.R		Approved By: HOD-INSTRUMENTATION	
CALIBRATION PROCEDURE OF OXYGEN ANALYSER			

The Instrument engineer takes action as follows, for calibration:

- 1.1 Calibration of Oxygen analyzer consists of establishing zero calibration and span calibration using Nitrogen and Oxygen standard gases respectively.
 - 1.1.1 Ensure that power is ON at least for one hour before calibration. This helps the instrument to acquire the temperature stability and to avoid condensation.
- 1.2 ZERO CALIBRATION:
 - 1.2.1 Select manual and zero calibration from analyzer panel.
 - 1.2.2 Pass N₂ gas (zero gas) through the analyzer at the rate of 50 to 60 lpm for three minutes.
 - 1.2.3 Clear the value which is displaying and then enter 0.000 then press enter.
 - 1.2.4 Check the o/p reading with the help of multimeter it should be 4 mA.
- 1.3 SPAN CALIBRATION:
 - 1.3.1 Select manual and span calibration from analyzer panel.
 - 1.3.2 Pass standard O₂ gas through the analyzer at the rate of 50 to 60 lpm for three minutes.
 - 1.3.3 Observe the displayed value and to be match with standard gas value by entering it.
 - 1.3.4 The output mA reading on multimeter should be corresponding to the amount of O₂ gas present in the cylinder.
- 1.4 Repeat the procedure to get consistent readings and record the same in the Instrument calibration format F-1/WI-9(SP-8; AM-7)
- 2.0 CONNECTED DOCUMENT:



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F-1/WI-9(SP-8; AM-7)

Calibration of Oxygen Analyser.

CALIBRATION OF KILN INLET O2 ANALYSER
CALIBRATION OF PC OUTLET O2 ANALYSER
CALIBRATION OF PH OUTLET O2 ANALYSER
CALIBRATION OF COAL MILL BH O2 ANALYSER

KILN INLET O2 ANALYSER

RATE 50 to 60 lph

Applied Gas.
As per standard gas

Calculated value
As per standard gas value

PC OUTLET O2 ANALYSER

RATE 50 to 60 lph

Applied Gas.
As per standard gas

Calculated value
As per standard gas value

PH OUTLET O2 ANALYSER

RATE 50 to 60 lph

Applied Gas.
As per standard gas

Calculated value
As per standard gas value

COAL MILL BH O2 ANALYSER

RATE 50 to 60 lph

Applied Gas.
As per standard gas

Calculated value
As per standard gas value