



DALMIA CEMENT (B) LIMITED – ARIYALUR

MECHANICAL SOP

Issue No. 02	Rev. No: 00	Effective Date: 18.11.2022	SOP/MEC/208
Issued By: M.R		Approved By: HOD Mechanical	
SOP FOR IMPORTED SHREDDER BLADE COMB & SHAFT HARD FACING			

Scope: Imported shredder blade, comb & shaft 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 IMPORTED SHREDDER BLADE, COMB & SHAFTS HARD FACING

1. Take hot work permit with all necessary precautions.
2. Use PPE's while working.
3. Check the welding machine, cables and holder condition before welding.



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4. Take the blade thickness and height for the required level.
5. Electrodes used for buffer layers welding to be preheated in oven up to 250 ° C for duration of one hour.
6. Clean the blade,comb and shafts by wire brush.
7. Do buffer layers welding up to required height.
8. Remove the slag after welding each layer.
9. Don't require to preheat the hard facing electrode which is moisture proof flux coating electrode.
10. Do hard facing the blade height of required level.
11. Check the height and profile of welding layers with template.
12. Check for any visual welding cracks.
13. Clean the burrs by chipping hammers.
14. Close the hot work permit.

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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Job Safety Analysis	Job: Imported shredder blade,comb shaft hard facing job	Date: 02/07/2022	Analysis by: Section Engineer	Reviewed by: Section Head
Title of employee doing job: Imported shredder blade,comb shaft hard facing job	Supervisor: Section Engineer	Department: Mechanical	Section: AFR	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