


WELDING & NDT		JOB DESCRIPTION:		PROJECT NO.:		CUSTOMER:		INSP. AGENCY:		MFG. CODE:		SHEET 1 OF 1									
 SHOP WELD PLAN		STATIC PRESSURE VESSEL		ABC		XYZ COMPANY		WE&NDT + TPI		ASME SEC VIII DIV.1 ED - 2017											
		SR. NO.	PART No 1	Part No.2	BASE METAL		THK. (mm)	WELDING PROCESS(es)	LAYER(s)	WPS NO(Rev No).	PREHEAT TEMP. °C MIN.	INTERPASS TEMP. °C MAX.	POSITION	SUPPORTING PQR No./ Consumable	NOTES: 1. SURFACES TO BE WELDED SHALL BE CLEAN & FREE OF SCALE, RUST, OIL, GREASE, SLAG, OXIDES & OTHER DETRIMENTAL MATERIALS. 2. SLAG & SPATTERS OF PREVIOUSLY DEPOSITED BEADS SHALL BE REMOVED PRIOR TO DEPOSITING NEXT PASS. 3. ONLY QUALIFIED WELDERS/WELDING OPERATORS AS PER WELDER LIST SHALL BE USED. 4. FOR THERMAL CUTTING PREHEAT SHALL BE CARRIED AS PER WPS BEFORE CUTTING. 5. WELDING SHALL BE CARRIED OUT AS PER WPS ISSUED ALONG WITH THE SHOP WELD PLAN. 6. FOR JOINT DETAILS REFER APPLICABLE MANUFACTURING DRAWINGS. 7. ANY REPAIRS IN WELD METAL AS WELL AS BASE METAL SHALL BE ATTAINED AFTER GETTING PERMISSION FROM CONCERNED WELDING ENGINEER. 8. FOLLOWING MATERIALS ARE CLASSIFIED AS, P1: SA516 GR.70, SA36, SA105, IS 2062 GR.B, SA 105, SA 106GrB, SA234WPB						
1	101	101,102	1	1	14 max	SMAW	ALL	S-001(R1)	25	275	ALL	001 / E 7018	REV. NO.	REVISIONS		DATE	REV. BY	APPRVD. BY	POST WELD HEAT TREATMENT		
2	104	104	1	1	10 max	SMAW	ALL	S-001(R1)	25	275	ALL	001/E7018	0			14/08/2019	0	WE	SEAM NOS.	TEMPERATURE	TIME
3	101	103	1	1	14 max	GTAW + SMAW	ROOT + 1 REMAINING	GS-001(R1)	25	275	ALL	001/E7018 + ER70S-2							NA	NA	NA
4	101	104	1	1	----	SMAW	ALL	S-001(R1)	25	275	ALL	001/E7018									
5	105	106	1	1	12.7 max	GTAW	ALL	G-001(R1)	25	275	ALL	002/ER70S-2									
6	108	107,109	1	1	5.48 max	GTAW	ALL	G-001(R1)	25	275	ALL	002/ER70S-2									
7	110	111	1	1	12.7 max	SMAW	ALL	S-001(R1)	25	275	ALL	001/E7018									
8	106	102	1	1	18 max	SMAW	ALL	S-001(R1)	25	275	ALL	001/E7018									
9	108	103	1	1	18 max	SMAW	ALL	S-001(R1)	25	275	ALL	001/E7018									
10	111	101	1	1	14 max	SMAW	ALL	S-001(R1)	25	275	ALL	001/E7018									
PREPARED BY:		REVIEWED BY:		APPROVED BY:		APPROVED BY:		APPROVED BY:		REV.											
WELDING ENGINEER NAME: ABC DATE: 14.08.2019		WELDING MANAGER NAME: SANDEP SINGH DATE: 14.08.2019		GM NAME: PQR DATE: 14.08.2019		CUSTOMER/CLIENT NAME: XYZ DATE: 31.08.2019				0											

ASME
STAMP
REQD.
NOT REQD.