	WELDING & ND														
WELDING & NDT				JOB DESCRIPTION: STATIC PRESSURE VESSEL				PROJECT NO.: ABC		CUSTOMER: XYZ COMPANY		INSP. AGENCY: WE&NDT + TPI	MFG. CODE: ASME SEC VIII DIV.1	SHEET 1 OF 1	
	SHOP WELD P	LAN												ED - 2017	
SR. PART No 1	Part No.2	BASE	BASE METAL		WELDING		WPS NO(Rev		PREHEAT			SUPPORTING PQR No./	NOTES:		
		P NO.	P NO.	(mm)	PROCESS(es)		1113110(11	°C MIN.		°C MAX.	POSITION	Consumable	1. SURFACES TO BE WELDED SHALL BE CLEAN & FREE OF SCALE, RUST, OIL,		
101	101,102	1	1	14 max	SMAW	ALL	ALL S-001(F		25	275	ALL	001/E 7018	GREESE, SLAG, OXIDES & OTHER DETRIMENTAL MATERIALS. 2. SLAG & SPATTERS OF PREVIOUSLY DEPOSITED BEADS SHALL BE REMOVED		
104	104	1	1	10 max	SMAW	ALL	ALL S-001(R1)		25	275	ALL	001/E7018			
101	103	1	1	14 max	GTAW +	ROOT + 1 GS-001(I		(R1)	25	275	ALL	001/E7018 + ER70S-2	PRIOR TO DEPOSITING NEXT PASS. 3. ONLY QUALIFIED WELDERS/WELDING OPERATORS AS PER WELDER		PER WEI DER
101	104	1	1		SMAW	-		R1)	25	275	ALL	001/F7018	LIST SHALL BE USED.		
105	106	1	1	12.7 max	GTAW	ALL	G-001((R1)	25	275	ALL	002/ER70S-2	4. FOR THERMAL CUTTING PREHEAT SHALL BE CARRIED AS PER WPS BEFORE CUTTING.		
108	107,109	1	1	5.48 max	GTAW	ALL G-001(R1)	25	275	ALL	002/ER70S-2	S. 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		
110	111	1	1	12.7 max	SMAW	ALL S-001		R1)	25	275	ALL	001/E7018			
106	102	1	1	18 max	SMAW	ALL S-001(R1)	25	275	ALL	001/E7018			
108	103	1	1	18 max	SMAW	ALL	ALL S-001(25	275	ALL	001/E7018			
111	101	1	1	1 14 max SMAW ALL		S-001(R1) 25		25	275	ALL	001/E7018	AFTER GETTING PERMISSION FROM CONCERNED WELDING ENGINEER.			
													8. FOLLOWING MATER	IALS ARE CLASSIFIED AS,	
													P1: SA516 GR.70, SA36	, SA105, IS 2062 GR.B, SA 105, SA	A 106GrB, SA234WPB
EV. REVISIONS		DATE		REV. BY	APPRVD. BY							_			
0.		14/00	14/09/2010				<u>· </u>					-			
	·	1-700	, 1 015		WE		NA.				^				ASME STAMP IREQD.
			REVIEWED BY:					APPROVED BY:					APPROVED BY:		REV
VELDING ENGINEER IAME: ABC DATE: 14.08.2019		NAME: SA	WELDING MANAGER NAME: SANDEP SINGH						NAME: PQR				NAME: XYZ	ſ	0
3	104 101 105 108 110 106 108 111 111 RE RE	PART No 1 Part No.2 101 101,102 104 104 101 103 101 104 105 106 108 107,109 110 111 106 102 108 103 111 101 REVISIONS 0 IV: ENGINEER	PART No 1 Part No.2 P NO. 101 101,102 1 104 104 1 101 103 1 101 103 1 101 103 1 101 104 1 101 103 1 101 104 1 105 106 1 108 107,109 1 110 111 1 106 102 1 108 103 1 111 101 1 REVISIONS 0 14/0 WELDIN WELDIN NAME: SA	PART No 1 Part No.2 P NO. P NO. 101 101,102 1 1 104 104 1 1 101 101,102 1 1 101 103 1 1 101 103 1 1 101 103 1 1 101 104 1 1 101 103 1 1 105 106 1 1 108 107,109 1 1 106 102 1 1 108 103 1 1 108 103 1 1 111 101 1 1 111 101 1 1 REVISIONS DATE 0 14/08/2019 IV: REVIEWED BY: ENGINEER WELDING MANA	PART No 1 Part No.2 BASE METAL THK. 101 101,102 1 1 4 max 104 104 1 1 1 4 max 101 101,102 1 1 1 4 max 101 103 1 1 1 4 max 105 106 1 1 1 2.7 max 108 107,109 1 1 5.48 max 106 102 1 1 18 max 111 101 1 1 14 max 108 103 1 1 14 max 111 101 1 1 1 max 111 101 1 1 4 max 0 0 <	PART No 1 Part No.2 BASE METAL THK. 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