

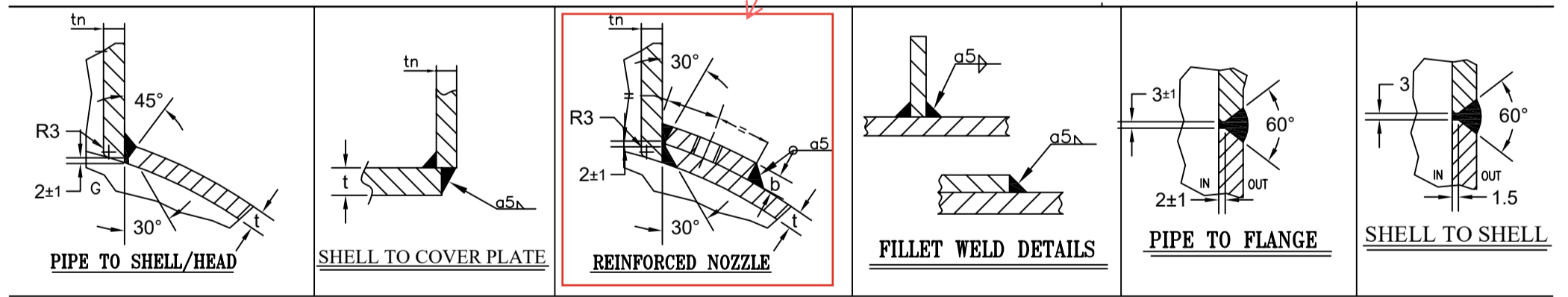
To be corrected as per final WPS/PQR

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JOINT NO.	JOINT SPEC.	VESSEL JOINTS	Process weld line	BASE METALS		THICKNESS RANGE (mm)	WPS	PQR	VT	RT	PT	UT
1	CWL-1 TO CWL-3	SHELL TO SHELL	SMAW/GTAW	SA516 Gr70N	SA516 Gr70N	5-20	WPS 01	PQR-01	100%	10%	100%	-
2	LW-1 TO LW-2	SHELL TO SHELL	SMAW/GTAW	SA516 Gr70N	SA516 Gr70N	5-20	WPS 01	PQR-01	100%	10%	100%	-
3	WL4	PAD TO SHELL	SMAW/GTAW	SA516 Gr70N	SA516 Gr70N	5-20	WPS 01	PQR-01	100%	-	30%	-
4	WL5	NOZZLE NECK TO FLANGE	SMAW/GTAW	SA 350 Gr.LF2	SA 333 Gr.6	5-20	WPS 03	PQR-01	100%	10%	100%	-
5	WL6	NOZZLE NECK TO SHELL OR HEAD	SMAW	SA 333 Gr.6	SA516 Gr70N	5-20	WPS 02	PQR-01	100%	-	100%	10%
6	WL-7	FILLET WELD	SMAW	SA283 Gr.C	SA283 Gr.C	5-20	WPS 01	PQR-01	100%	-	10%	-

This detail does not exist. please delete

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PROJECT:
STYRENE PARK OFFSITE

NO.	DATE	DESCRIPTION	PREPARED	CHECKED	APPROVED BY
00	06-April-2025	IFA	M.Y	S.D	S.D



DWG. TITLE:
NDT & WELDING MAP FOR RECEIVER HEADER(RU0001A/B-D-02)

PHASE:	DOCUMENT NUMBER:	SIZE :	A4	REV.	00	SCALE:	-
	E1027-HSE-VD-ME-DWG-018			SHT.	1 of 1		