

<b>REPAIR PROCEDURE</b>		<b>RP Number:</b>
<b>Repair procedure to be carried out in accordance with document:</b> <b>Repair and Minor Alterations to Existing Pressure Equipment, Piping and Tanks (DP-05-095-06)</b>		
<b>PLANT:</b> AN2	<b>EQUIPMENT No. :</b> R 1001	
<b>DESCRIPTION OF REPAIR:</b> (attach sketch if applicable) R1001 has arrived on site with weld cracks on the Compensating Ring. AGC intend as per Field Instruction RFQ 114 to lightly grind into the root of the welds and weld over using OSCHATZ WPS BW-43-141-001		
<b>APPLICABLE CODES, STANDARDS &amp; PIPE SPEC.:</b> AS4458-1997, AS1228, AS1210, AS3992 & AS4037		
<b>MATERIALS TO BE WELDED:</b> Nicrofer 6023H		
<b>HEAT TREATMENT PRIOR TO REPAIRS:</b> (e.g. normalising) N/A		
How applied: N/A	How monitored: N/A	
Temperature: N/A	Time: N/A	
<b>HOW IS FAILED COMPONENT REMOVED:</b> Light grinding will be applied to the root side of the welds.		
<b>WELD PREPARATION</b>		
<b>CLEANING:</b> Grind and wire brush as required using iron free discs & stainless steel wire brushes.		
<b>JOINT PREPARATION:</b> Lightly grind at a slight angle to open the weld preparation up to allow good fusion.		
<b>NDT TO CLEAR PREPARATION:</b> DPI existing material that is to be reused to a minimum of 50mm from new weld preparation.		
<b>WELDING METHOD &amp; RUN SEQUENCE:</b> As per the approved WPS & supporting WPQR		

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<b>SPECIAL CONDITIONS APPLYING TO WELDING PROCEDURE:</b> Only if recommended by the CSBP Senior Plant Inspector.		
<b>PRE-HEAT REQUIREMENTS:</b> As stipulated on the approved WPS & supporting WPQR.		
How applied:	Propane torch (If Applicable)	How monitored: Temp stick / Digital Thermometer.
Temperature:	As stipulated on the approved WPS & supporting WPQR.	Time: As stipulated on the approved WPS & supporting WPQR.
<b>WELD COMPLETION</b>		
<b>BACK GOUGING/GRINDING BETWEEN RUNS:</b> Grinding & wire brush as required using iron free discs & stainless steel wire brush.		
<b>NDT DURING WELDING:</b> N/A		
<b>COMPLETED WELD SURFACE FINISH:</b> As welded & cleaned with a stainless steel wire brush.		
<b>POST WELD HEAT TREATMENT:</b> NO		
How applied:	N/A	How monitored: N/A
Temperature:	N/A	Time: N/A
<b>FINAL NDT:</b> YES		
Visual:	100%	MT / PT: 100% PT
Radiography (RT):		Acceptance Criteria: AS4037
<b>FINAL CLEANING / PASSIVATION / PAINTING:</b> As welded.		
<b>PRESSURE TEST REQUIREMENTS (NO)</b>		
<b>PRESSURE:</b> In Service Test. Plant Engineer to provide Hydrostatic waiver and sign.  <b>COMMENT:</b> Hydro test is not possible.   <b>SIGN:</b>		

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<b>FABRICATION INSPECTOR:</b> (approved by CSBP Senior Plant Inspector) PTAS-ITS	<b>APPROVAL STAMP:</b>	
<b>NDT CO-ORDINATOR:</b> (Responsible Officer / Contractor) Richard Ward		
<b>CSBP RESPONSIBLE OFFICER:</b> Neil St John		