



## LARGE CASTINGS



**TYPE:** High integrity welding and fabrication of low and high alloy castings

**APPLICATION:** High pressure, high temperature

**SPEC:** ASME Boiler and pressure vessel codes. PD5500 specification for unfired pressure vessels.  
Customer specific specifications

**DIMENSION:** Ranges from small 50Kg bench top castings to 100,000Kg casting assemblies

**MATERIALS:** All carbon steel grades, P11, P22 CrMoV, P9, P911, P92, austenitic martensitic, duplex, super duplex, and high nickel alloys.

**WELDING PROCEDURES:** TIG, MMA, FCAW & SAW

**TYPES OF WELDING:** Fabrication, butt, overlaying, buttering build-up and upgrading.

**CUTTING PROCESSES:** Arc air gouging, MMA gouging, gas cutting, plasma cutting, machining grinding and saw cutting.

**HEAT TREATMENT:** Local PWHT and furnace PWHT

**NON DESTRUCTIVE TESTING:** Radiography, ultrasonic testing, magnetic particle inspection, dye penetrant inspection, positive metal identification (PMI), hardness testing. Hydro pressure testing and pneumatic pressure testing.



ISO 9001  
ISO 14001  
BS OHSAS 18001



ISO 27001  
BS EN 1090 PT2



REF NUMBER: ES0193