

DISCLAIMER: These Standard Operating Procedures (SOP's) are for the exclusive use of Navy Public Works Center (PWC) Norfolk. They are promulgated as guidance for their NAVFAC Commands. If intended to be used by other activities, they must be tailored to each activity's particular requirements and must be reviewed/approved by the activity's safety professionals prior to use.

**NAVY PUBLIC WORKS CENTER
NORFOLK, VIRGINIA
(utilities, transportation,etc)**

STANDARD OPERATING PROCEDURE / JOB HAZARD ANALYSIS

TITLE

Large Steam Component Replacement

PROCEDURE NUMBER

621.2 STM 2

SIGNED: _____ **(DATE)**

APPROVED: _____ **(DATE)**

SAFETY PROFESSIONAL: _____ **(DATE)**

MANAGEMENT OFFICIAL: _____ **(DATE)**

REVISION

Standard Operating Procedure
Large Component Replacement
(Flanged)

Safety Equipment Required:

- Hard hat
- Gloves
- Safety Belt
- Safety glasses
- Safety shoes

Equipment required:

- Bucket truck, boom truck or platform lift
- Hand tools

PROCEDURE

1. Operate lifting equipment in accordance with its SOP, support the component to be removed.
2. Remove nuts and bolts or studs.
3. Remove gaskets. If gasket is fiber, or not clearly marked as non asbestos, see SOP 629STM28 Asbestos Gasket Handling.
4. Lift and lower component to the ground.
5. Clean flange faces.
6. Inspect flanges for cuts or other damage. Repair as needed.
7. Lift replacement or repaired component and set in place.
8. Install bottom bolts, put gaskets in place, install remaining bolts and nuts.
9. Tighten all bolts to proper tightness using proper tightening pattern.
10. If component has base, attach to support or foundation.
11. Clean up area, remove all debris from site.
12. After steam pressure is restored, return to component and retighten nuts to proper tightness.