

VI. A.C.1
PROJ NO IM 089-2 (35)

CHITTENDEN COUNTY COSMEC INC
WELDING PROCEDURE SPECIFICATION

SPECIFICATIONS AND CODE D16 (D13)
MATERIAL SPECIFICATION ASTM A240 TYPE 304 TO ASTM A709 GR 50W
WELDING PROCESS GTAW
MANUAL OR MACHINE MANUAL
POSITION OF WELDING 1F & 2F
FILLER METAL SPECIFICATION ER309L CLASSIFICATION AS 9
MANUFACTURER HARRIS WELCO TRADENAME
FLUX INTERNAL
SHIELDING GAS ARGON FLOW RATE 45 CFH
SINGLE OR MULTIPLE PASSES SINGLE
SINGLE OR MULTIPLE ARC SINGLE
WELDING CURRENT DC
POLARITY REVERSE (EN)
WELDING PROGRESSION
ROOT TREATMENT CLEANED & PREPARED BRIGHT METAL
PREHEAT AND INTERPASS TEMPERATURE SEE BELOW
POSTHEAT TEMPERATURE N/A
HEAT INPUT MIN MAX

VTRANS RECEIVED
JUL 2, 2006
DATE 8-1-06

WELDING PROCEDURE

PASS NO	ELECTRODE SIZE	WELDING CURRENT AMPERES	TRAVEL SPEED VOLTS	JOINT DETAIL
ALL	3/32"	130-155	14-17	LAP JOINT

PREHEAT TEMPS. ***PREHEAT UNTIL NO MOISTURE PRESENT
THICKNESS 1 TEMP
UP TO 3/4" 100 DEG
OVER 3/4" TO 1 1/2" 100 DEG
OVER 1 1/2" TO 2 1/2" 100 DEG
OVER 2 1/2" 100 DEG

THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT-UP, PASS SIZE ETC
WITHIN THE LIMITATION OF VARIABLES GIVEN IN SECTION 5
SUPPORTING PQR GTAW-WF-05
PROCEDURE NO GTAW-WF
CONTRACTOR COSMEC INC
AUTHORIZED BY DONALD VOSE
CWI# 01100651

REVISION NO 1
DATE 2/1/2005

