NBR Niagara Bridge & Rail

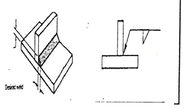
Parts and Service to meet your specific project needs

WELD PROCEDURE SPECIFICATION

Per WPQR # GMAW-01

MATERIAL SPECIFICATION:	A709, A36, A572 Grade 36 & 50
WELDING PROCESS:	GMAW
MANUAL OR MACHINE:	Semi-Automatic
POSITION OF WELDING:	Horizontal
FILLER METAL SPECIFICATION:	A5.18
FILLER METAL CLASSIFICATION:	ER70S-6
FILLER METAL MANUFACTURER:	Hobart
SHIELDING GAS: AR 92% C02 8%	**DEW POINT:** -60°F **FLOW RATE:** 35 CFH
SINGLE OR MULTIPLE PASS:	Single
SINGLE OR MULTIPLE ARC:	Single **ELECTRODE STICKOUT:** 3/4
WELDING CURRENT:	DC+
POLARITY:	Reverse
WELDING PROGRESSION:	Forward (Stringer Bead)
ROOT TREATMENT:	N/A
PREHEAT AND INTERPASS TEMP.	≤ ¾" = 50°F ≤ 1½" = 70°F ≤ 2½" = 150°F (Minimums)
POSTHEAT TREATMENT:	N/A

WELDING PROCEDURE

Weld Size	Electrode Size	Welding Current		Travel Speed "/Min	Joint Detail Fillet
		Amps	Volts		
All	1/16	247 – 302	27 - 31	9 – 11	

THIS PROCEDURE MAY VARY DUE TO THE FABRICATION SEQUENCE. FIT-UP, PASS SIZE, ETC., WITHIN THE LIMITATIONS OF VARIABLES GIVEN IN TABLE 5.3 OF AWS D1.5-2002 BRIDGE WELDING CODE.

PROCEDURE NO: GMAW 01 Fillet **MANUFACTURER:** Niagara Bridge and Rail

REVISION NO: 0 **AUTHORIZED BY:** Thomas F. Wright

VTRANS
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