

DSBROWN Production Joint Welding Procedure Specification (D1.5-08)

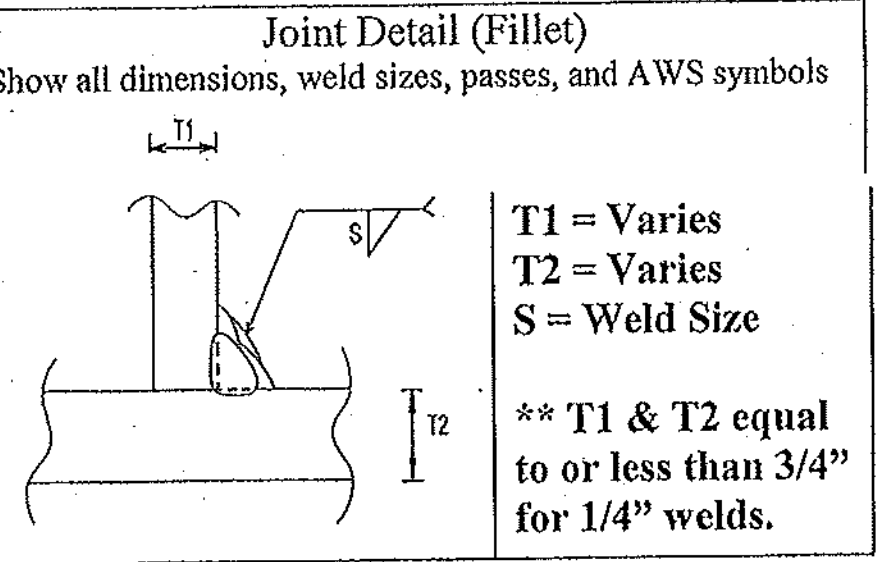
Procedure No: A-(MC)GF-01 Date Issued: 9-28-04 Revision No: 02 Rev. Date: 9-15-09

Contractor (Fabricator) D. S. Brown Company Prepared by: Brad Streeter, Quality Assurance Manager

1. Non-Fracture Critical Fracture Critical WPS Expiration Date: 8-11-14
2. Qualified in accordance with: AWS D1.5-2008 (5.13)
Referenced PQR No(s). PQR-(MC)GMAW-03(09)
Referenced FWST No(s). PQR-(MC)GMAW-FWST-01A(09), PQR-(MC)GMAW-FWST-01B(09)
3. Material specification(s) ASTM A709 Gr. 36, 50, 50W For DOT Approval
4. Material Thickness (es) Unlimited
5. Welding process GMAW
6. Manual , machine , or semiautomatic
7. Position(s) of welding 1F, 2F
8. Filler metal specification AWS A5.18
9. Filler metal class and brand name E70C-6M Corex Metal-Core Maxim
10. Flux class & brand N/A, Type N/A
11. Shielding gas 75% Ar / 25% CO2 Flow rate 45 CFH
12. Single pass Or multiple pass
13. Single arc Or multiple arc
14. Welding Current DCEP
15. Polarity Reverse
16. Welding progression stringers
17. Root treatment Clean to bright sound metal or per AWS D1.5 (3.2.1 & 3.11)
18. Postheat treatment N/A
19. Calculated Heat Input (KJ/in) Min 34.77 KJ/in Max 49.65 KJ/in
20. Electrode extension (electrical stickout) 3/4"

VITENS
 RECEIVED
 FEB 28 2012
 APPROVED
 DATE 2/8/12

Weld size (in)	Pass No(s)	Electrode size (in)	Welding Process Variables		Travel Speed (IPM)
			AMPS/WFS*	VOLTS	
**1/4"	1	.052"	270-307	27.9-31	11.5-13
5/16"	1	.052"	270-307	27.9-31	11.5-13
3/8"	1-3	.052"	270-307	27.9-31	11.5-13
7/16"	2-4	.052"	270-307	27.9-31	11.5-13
1/2"	4-6	.052"	270-307	27.9-31	11.5-13
5/8"	5-7	.052"	270-307	27.9-31	11.5-13
3/4"	6-8	.052"	270-307	27.9-31	11.5-13



* Wire feed speed may be used along with amperage (include chart)

Prepared By: [Signature] DSB QA Manager

Project: _____

DSB Job: 35029-1112

Preheat and Interpass Temperature Chart

Base Metal Thickness range	Minimum Preheat (°F)	Max Preheat & Interpass (°F)
≤ 3/4"	50°F	450°F
> 3/4" to ≤ 1.5"	70°F	450°F
> 1.5" to ≤ 2.5"	150°F	450°F
> 2.5"	225°F	450°F

Note: When this procedure is used for A709Gr50W materials, it shall be limited to 5/16" single pass or material be coated.