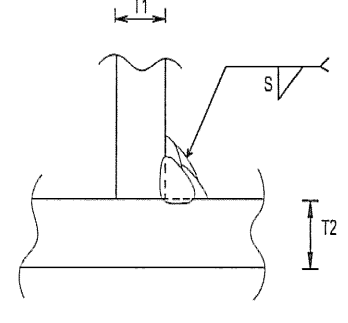


DSBROWN Production Joint Welding Procedure Specification (D1.5-02)

Procedure No: A-(M)GJF-01 Date Issued: 9-28-04 Revision No: 0 Rev. Date: _____
 Contractor (Fabricator) D. S. Brown Company Prepared by: James R. Connor, Quality Assurance Manager

1. Non-Fracture Critical Fracture Critical WPS Expiration Date: _____
2. Qualified in accordance with: AWS D1.5:2002 (5.12.1)
 Referenced PQR No(s): PQR-(MC)GMAW-01(04)
 Referenced FWST No(s): PQR-(MC)GMAW-FWST-01A(04), PQR-(MC)GMAW-FWST-01B(04)
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 30.6 KJ/in Max 51.1 KJ/in
20. Electrode extension (electrical stickout) 3/4"

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Weld size (in)	Weld Pass No(s)	Electrode size (in)	Welding Process Variables		Travel Speed (ft/min)	Joint Detail (Fillet) Show all dimensions, weld sizes, passes, and AWS symbols
			AMPS/WFS*	VOLTS		
1/4"	1	.052"	265-320	31-34.5	13-16	 <p>T1 = Varies T2 = Varies S = Weld Size</p> <p> T1 & T2 equal to or less than 3/4" for 1/4" welds.</p>
5/16"	1	.052"	265-320	31-34.5	13-16	
3/8"	1-3	.052"	265-320	31-34.5	13-16	
7/16"	2-4	.052"	265-320	31-34.5	13-16	
1/2"	4-6	.052"	265-320	31-34.5	13-16	
5/8"	5-7	.052"	265-320	31-34.5	13-16	
3/4"	6-8	.052"	265-320	31-34.5	13-16	

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

Prepared By: James R. Connor DSB QA Manager
 Project: _____

DSB Job: 25217-1104

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

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