

AWS D1.8
WELDING PROCEDURE SPECIFICATION

MATERIAL SPECIFICATION: ASTM: A709 GR 250, 345, & 345W (painted); A36, A572; A588 (painted)
(ref. AWS D1.5:2002, sect. 1.2 & 5.4)

WELDING PROCESS: GMAW

MANUAL OR MACHINE: Semi-Automatic

POSITION OF WELDING: Flat, Horizontal

FILLER METAL SPECIFICATION: A5.18

FILLER METAL CLASSIFICATION: BR70S-6

FILLER METAL MANUFACTURER: HOBART BR-6

SHIELDING GAS: Ar - 98%; O₂ - 2%

SINGLE OR MULTIPLE PASS: Single

SINGLE OR MULTIPLE ARC: Single

WELDING CURRENT: DCEP

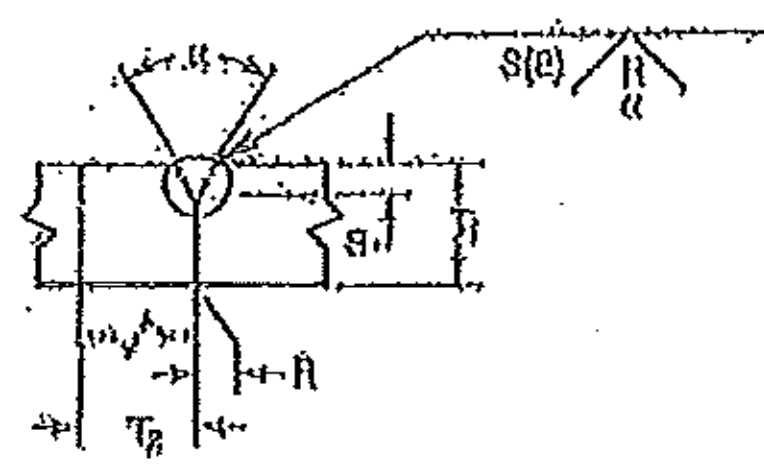
WELDING PROGRESSION: Forward

ROOT TREATMENT: Surfaces shall be smooth and uniform, and free of discontinuities, loose or thick scale, slag, rust, moisture, grease/oil, and other foreign material.
(ref. AWS D1.5:2002, 3.2.1)

PREHEAT AND INTERPASS TEMP: Minimum: $\leq 3/4"$ = 50°F; over 3/4" to 1-1/2" = 70°F;
over 1-1/2" to 2-1/2" = 150°F; over 2-1/2" = 225°F. Maximum: 450°F

POSTHEAT TREATMENT: N/A

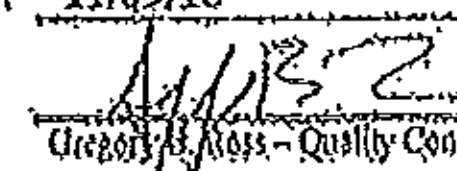
WELDING PROCEDURE

Weld Size (in)	Electrode Size	Welding Current		Travel Speed in/in	Depth of Prep (in)	Joint Detail C-P2-G
		Amps	Volts			
3/16"	.045	265-280	27.5-30	10.0-11.0	265-280	
1/4"	.045	265-280	27.5-30	10.0-11.0	265-280	
5/16"	.045	265-280	27.5-30	10.0-11.0	265-280	
R=0	$\alpha = 60^\circ$	$T_1 = 1/4"$ min	$T_2 =$ Unbeveled	$t = 1/8"$ min, $S = 1/32"$		

*** This procedure may vary within the limitations identified in AWS D1.5:2008 "Bridge Welding Code", ***

PROCEDURE NO: GMAW-06 REVISION NO: 0-2010

QUALIFYING PQR: WPA - GMAW 2010-A PQR REQ'D DATE: 11/09/16

MANUFACTURER: Watson Doyman Acme Corp. AUTHORIZED BY: 
Gregory J. Ross - Quality Control Manager

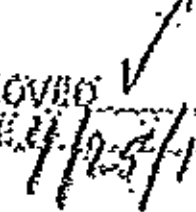
Trans
Received
GWB BY: JWC



CREATED BY: ROSS
CWI 0801/211
QC1 EXP 07/01/11



APR 17 2012

APPROVED BY: 
DATE: 4/25/12