

AWD D1.5
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-C

FILLER METAL MANUFACTURER: HOBART BR-C

SHIELDING GAS: Ar - 98%, O₂ - 2%

SINGLE OR MULTIPLE PASS: Multiple

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 - # of Passes	Electrode Size	Welding Current		Travel Speed "/Min	Joint Detail D.P.3-Q
		Amps	Volts		
All	.045	265-280	27.5-30	10.0-11.0	
				$T_1 = 1/2"$ min $T = 1/8"$ min $\alpha = 60^\circ$ $R = 0$ $S_1 + S_2 = 1/3 T$	

*** This procedure may vary within the limitations identified in AWS D1.5:2005 "Bridge Welding Code" ***

PROCEDURE NO: GMAW-07 REVISION NO: 0-2010

QUALIFYING PQRI: WBA - GMAW 2010 -A FOR REQUAL DATE: 11/09/15

MANUFACTURER: Watson Boylston Acme Corp. AUTHORIZED BY: *[Signature]*
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ORFORD ROSS
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BY: _____ DATE: 4/25/12