

AWS 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 & 3.4)

WELDING PROCESS: GMAW

MANUAL OR MACHINE: Semi-Automatic

POSITION OF WELDING: Flat & Horizontal

FILLER METAL SPECIFICATION: A5.18

FILLER METAL CLASSIFICATION: ER70S-6

FILLER METAL MANUFACTURER: HOBART ER-6

SHIELDING GAS: Ar - 98% O₂ - 2%

SINGLE OR MULTIPLE PASS: Single (S₁) or Multiple (S₂)

SINGLE OR MULTIPLE ARC: Single

WELDING CURRENT: DCBP

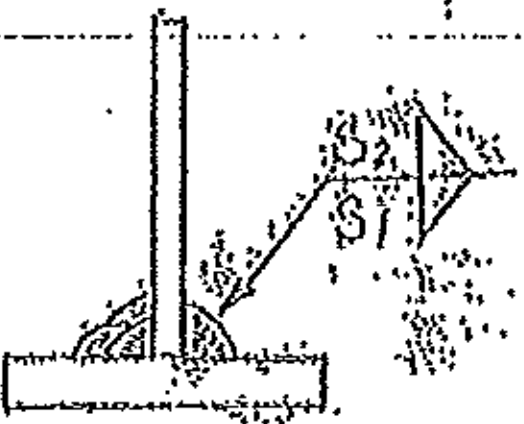
WELDING PROGRESSION: Forward

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

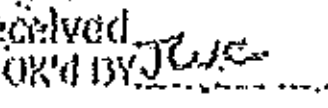
Weld Size	Electrode Size	Welding Current		Travel Speed, in/min	Joint Detail Fillet
		Amps	Volts		
$\leq 5/16$ (S ₁)	.045	265-280	27.5-30	10.0 - 11.0	
$\geq 5/16$ (S ₁)	.045	265-280	27.5-30	10.0 - 11.0	

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

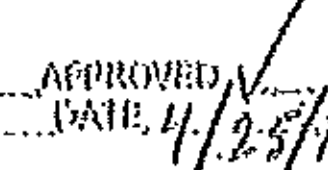
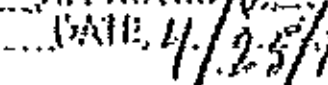
PROCEDURE NO: GMAW-11 REVISION NO: 0-2010

QUALIFYING PQR: WBA-GMAW-2010 & GMAW-CS-2007 Fillet PQR REQUAL DATE: 11/09/15

MANUFACTURER: Watson Bowman Acme Corp. AUTHORIZED BY: 
Gregory V. Ross - Quality Control Manager

Received
OK'd BY: 
APPROVED BY: 
DATE: 08/07/11
EXP: 07/01/11

APR 17 2012

Resubmit: 
BY: 
DATE: 4/25/12

