



**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%; O ₂ - 2%	DEW POINT: -40°F min. FLOW RATE: 37 - 49 CFH
SINGLE OR MULTIPLE PASS:	Single
SINGLE OR MULTIPLE ARC:	Single ELECTRODE STICKOUT: 3/4" ± 1/4"
WELDING CURRENT:	DCMP
WELDING PROGRESSION:	Forward
ROOT TREATMENT:	Surfaces shall be smooth and uniform, and free of discontiguities, 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: ≤ 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 (E)	Electrode Size	Welding Current		Travel Speed ⁱⁿ /Min	Depth of Prep. (S)	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	α = 60°	T ₁ = 1/4" min	T ₂ = Unbeveled	t = 1/8" min, S = 1/3" min		

*** 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: WBA - GMAW 2010-A PQR REQUAL DATE: 11/09/16
 MANUFACTURER: Watson Doyman Acme Corp. AUTHORIZED BY: [Signature]
Gregory D. Ross - Quality Control Manager

Trans Received
 CRD BY: JWC

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 CWI 0801/211
 QC1 EXP 07/01/11



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Approved by: [Signature]
 DATE: 4/25/12