Production Joint Welding Procedure Specification (D1.5)

Procedure No: **B-F-SEALWELD-01** Date Issued: 3-28-08 Revision No: 01 Rev. Date: 4/28/13

Contractor (Fabricator) D. S. Brown Company Prepared by: Brad Streeter, Quality Assurance Manager

1. Non-Fracture Critical [X] Fracture Critical [ ] WPS Expiration Date: 4/12/18
2. Qualified in accordance with: AWS D1.5- 2010 (5.12.1)
   Referenced PQR No(s). PQR-FCAW-01-(13)A __ , __ , ____
   Referenced FWST No(s). FCAW-FWST-01A , FCAW-FWST-01B , __ , ____
3. Material specification(s) ASTM A709 Gr. 36, 50, 50W
4. Material Thickness (es) Unlimited
5. Welding process FCAW
6. Manual [ ] , machine [ ] , or semiautomatic [X]
7. Position(s) of welding 1G,1F, 2F
8. Filler metal specification AWS A5.20
9. Filler metal class and brand name E71T-1CH8 (UltraCore71C)
10. Flux class & brand N/A , Type N/A
11. Shielding gas 100% CO2 Flow rate 50 CFH
12. Single pass [X] Or multiple pass [ ]
13. Single arc [X] Or multiple arc [ ]
14. Welding Current DCEP
15. Polarity Reverse
16. Welding progression stringers
17. Root treatment Clean to bright sound metal and per AWS D1.5 (3.2.1 & 3.11)
18. Postheat treatment N/A
19. Calculated Heat Input (KJ/In) Min 26.7 Kj/in Max 44.3 Kj/in
20. Electrode extension (electrical stickout) 3/4”

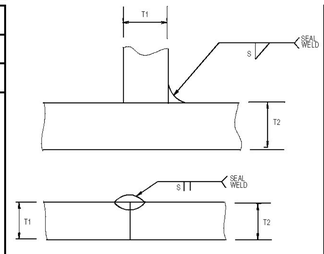
For DOT Approval

Vermont Agency of Transportation
RECEIVED
9-19-17_Strip Seal Welding Procedure_Approved.pdf
CK'D BY RSF OK'D BY CLB
September 19, 2017
RESUBMIT NO Approved
BY C. CARLSON DATE 10/10/17

Weld size (In)	Pass No(s).	Electrode Size (In)	Welding Process Variables AMPS	Welding Process Variables VOLTS	Travel Speed (IPM)
1/8”	1	1/16”	260-305	25-27.6	11.4-14.6
3/16”	1	1/16”	260-305	25-27.6	11.4-14.6

NOTE:
THIS JOINT DETAIL TO BE USED FOR SEALING NON-STRUCTURAL GALVANIZED OR PAINTED APPLICATIONS WHERE FULL SIZED WELDMENTS ARE NOT DESIGNED, DETAILED OR ARE NOT PRACTICAL.

Joint Detail (Fillet)
Show all dimensions, weld sizes, passes, and AWS symbols



T1 = Varies
T2 = Varies
S = Weld Size

Prepared By: _____ DSB QA Manager

Project: VT-15A

DSB Job: 53146-1011

Preheat and Interpass Temperature Chart

Base Metal Thickness range	Minimum Preheat (°F)	Max Preheat & Interpass (°F)
≤ 3/4"	50ºF	450°F
>3/4” to ≤1.5”	70ºF	450°F
>1.5” to ≤2.5”	150ºF	450°F
>2.5”	225ºF	450°F

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