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WELDING PROCEDURE SPECIFICATION (WPS)

April 7, 2017

AWS D1.5 Bridge Welding Code

RESUBMIT No Approved
BY Kristin Higgins DATE 4/11/2017

WPS No.: CPM-SM-Fillet/ Bridge Deck Forming

Joint Details (refer to section 2.8 Details of Fillet Welds)

JOINT DESIGN

Type: Fillet Weld

Minimum Fillet Weld Size

Table 2.1

Base Metal Thickness of Thicker Part Joined (T) Minimum Size of Fillet Weld

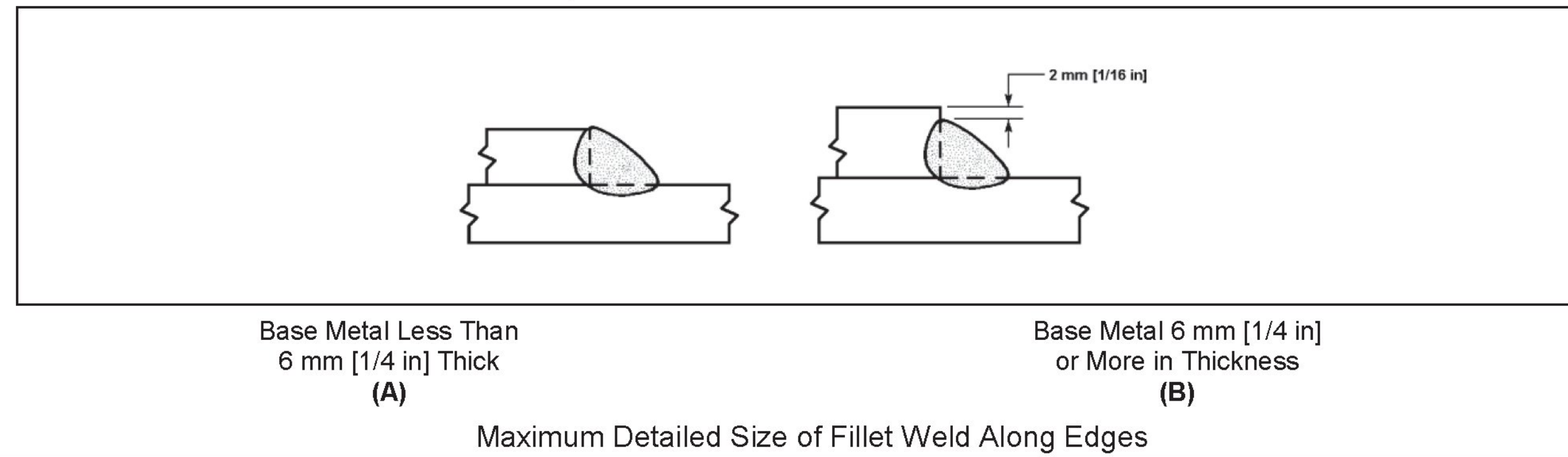
$T \leq 20$ mm [3/4 in]	6 mm [1/4 in]	Single-pass welds shall be used
$T > 20$ mm [3/4 in]	8 mm [5/16 in]	

Note: * Smaller fillet sizes may be approved by the Engineer based upon applied stress and the use of appropriate preheat

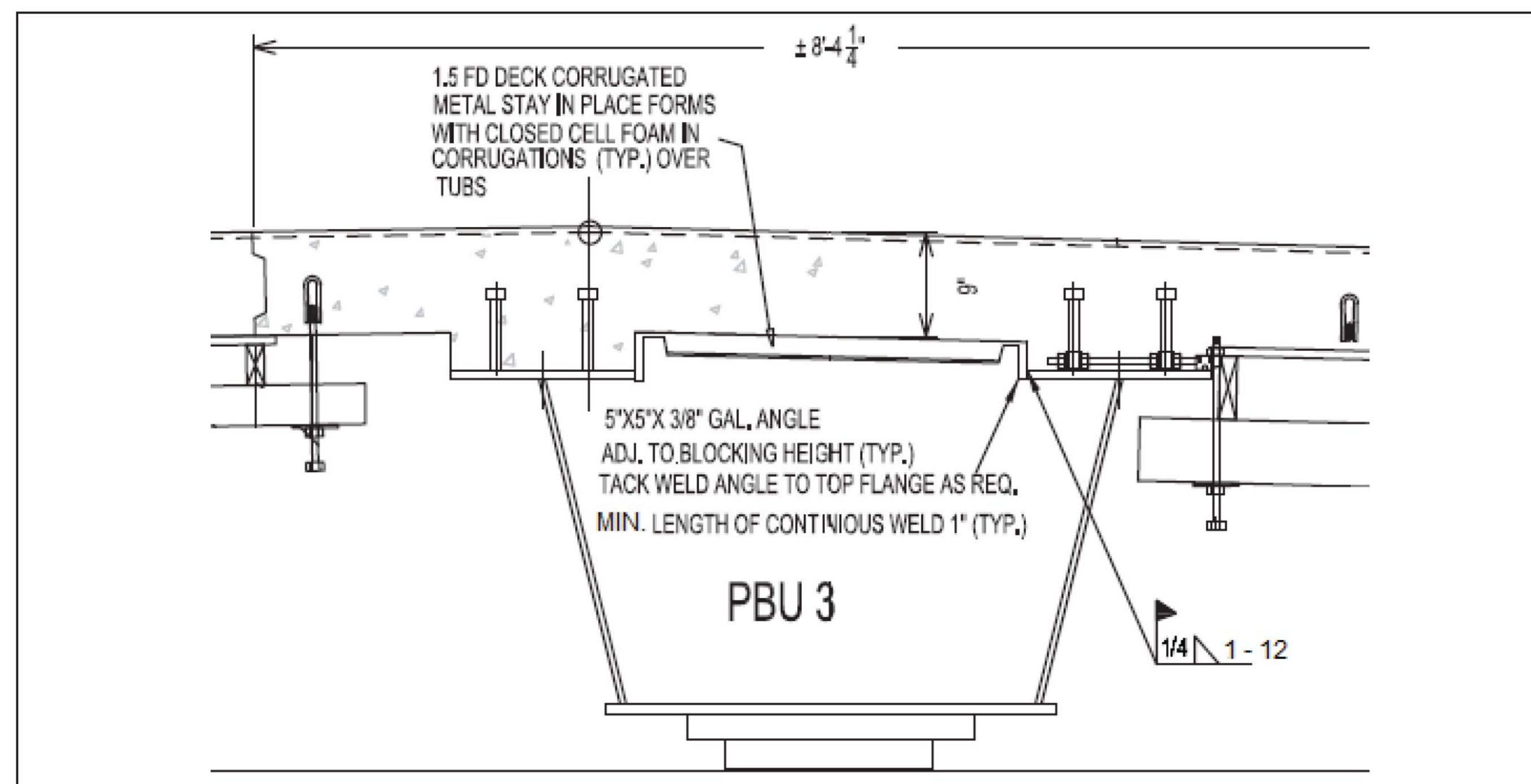
** Except that the weld size need not exceed the thickness of the thinner part joined. For this exception, particular care should be taken to provide sufficient preheat to ensure weld soundness.

Maximum Fillet Size

Figure 2.3 Details for Fillet Welds



Project Weld Details



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 REVISE AND RESUBMIT
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JOSH OLUND REVIEWER April 11, 2017 DATE