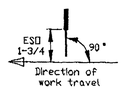
VT WP101

Submission Date: 2/7/96 NATIONAL EASTERN CORPORATION Sht 1 of 3
Revision No: 0 WELDING PROCEDURE SPECIFICATION - 101 Page 1 of 1
Issue Date: 2/7/96 Project: RANDOLF, VT BRS 0147 (14) Job No: 15644
Welding Process: Submerged Arc AWS Joint No: Fillet Manual — Machine X
Code Requirements: AASHTO/AWS D1.5-95 Base Metal: BELOW Position: 2F
Filler Metal Specs: A5.17 Filler Metal Classification: EM12K(L61) Flux: F7A2(860)
Shielding Gas: N/A Flow Rate: N/A S or M Pass M S or M Arc M
Minimum Preheat and Interpass Temperature To Be Maintained During Welding:

Thickness of Thickest Part at Point of Welding	A709-36, 50, 50W
t ≤ 3/4	50
3/4 < t ≤ 1-1/2	70
1-1/2 < t ≤ 2-1/2	150
t > 2-1/2	225



Direction of work travel

Electrode angle normal to travel is 55°±5°

Base Metal (cont): A709-36, 50, 50W

Note: Two fillet welds may be welded at the same time with welding heads directly opposite each other.

Fillet Size	Electrode	Electrode Size	Amps optimum (range)	Volts optimum (range)	Current	Travel IPM optimum (range)	Notes
5/16	1	3/16	650	34	DCSP	25	1 Pass
		Limitation of Variables					
	lead	3/16	585-715	32-36	DCSP	21-29	

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Too small

This procedure may vary due to fabrication sequence, fit-up, pass size, etc. within the limitations of variables given in 4B, 4C, or 4D of AWS D1.5 Bridge Welding Code

WPQ6
(5304K)

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