WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS

W2 - METRIC

PROCEDURE SPECIFICATIONS

MATERIAL SPECIFICATION	ASTM A709 GRADES: 250, 345, 345W
WELDING PROCESS	SHIELDED METAL ARC WELDING
MANUAL OR MACHINE	MANUAL
POSITION OF WELDING	ALL (EXCEPT AS NOTED BELOW)
FILLER METAL SPECIFICATION	AWS A5.1 AND A5.5
WELD METAL CLASSIFICATION	E7018/E7028 (TACKING ONLY) AND E8018-C3
WIRE/FLUX	D.N.A.
POLARITY	DC+ OR AC
ROOT TREATMENT	MANUAL CLEANING
PREHEAT AND INTERPASS TEMPERATURE	SEE PREHEAT CHART
ELECTRICAL STICK-OUT	D.N.A.
SHIELDING GAS	D.N.A.

REVISED: 7/27/98

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WELDING PROCEDURE

PASS NO.	WIRE SIZE (mm)	CURRENT RANGE E7018 DC+	CURRENT RANGE E7018 AC	TRAVEL SPEED (mm/min)	JOINT DETAIL
1	3.2	90-150	110-170	152-228	TACK WELDS
1	4.0	120-190	135-225	203-330	GROOVE ROOT PASSES AND TACK WELDS

PASS NO.	WIRE SIZE (mm)	CURRENT RANGE E7028 DC+	CURRENT RANGE E7028 AC	TRAVEL SPEED (mm/min)	JOINT DETAIL (LIMITED TO FLAT AND HORIZONTAL TACK WELDS AND FLAT POSITION GROOVE ROOT PASSES)
1	4.0	170-240	180-270	203-330	GROOVE ROOT PASSES AND TACK WELDS

PASS NO.	WIRE SIZE (mm)	CURRENT RANGE E8018-C3 DC+	CURRENT RANGE E8018-C3 AC	TRAVEL SPEED (mm/min)	JOINT DETAIL
1	4.0	130-190	140-225	203-330	GROOVE ROOT PASSES, REPAIR WELDS AND TACKS
ALL	4.0	130-190	140-225	203-330	FILLET WELDS
ALL	4.8	180-270	210-290	228-381	FILLET WELDS (FLAT AND HORIZONTAL WELDS ONLY)
ALL	4.8	250-330	270-370	228-406	FILLET WELDS (FLAT AND HORIZONTAL WELDS ONLY)

* WELD SIZE DETERMINED BY TRAVEL SPEED

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VTRANS
RECEIVED
JUN 0 3 2005

OK'D BY _____ OK'D BY JWC

RESUBMIT _____ APPROVED ✓

BY _____ DATE 7-6-05

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