

WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS
GMAW - TACK

PROCEDURE SPECIFICATIONS

MATERIAL SPECIFICATION _____ ASTM A709 GRADES: 250, 345, 345W
 WELDING PROCESS _____ GAS METAL ARC WELDING
 MANUAL OR MACHINE _____ SEMIAUTOMATIC
 POSITION OF WELDING _____ IF OR 2F
 FILLER METAL SPECIFICATION _____ AWS A5.18
 WELD METAL CLASSIFICATION _____ ER70S-6
 WIRE/FLUX _____ NATIONAL STANDARD NS-115
 WIRE DIAMETER _____ 1.6 mm
 SINGLE OR MULTIPLE ARC _____ SINGLE ARC
 POLARITY _____ DC+
 ROOT TREATMENT _____ MANUAL CLEANING
 PREHEAT AND INTERPASS TEMPERATURE _____ SEE PREHEAT CHART*
 ELECTRICAL STICK-OUT _____ 19.1 mm
 SHIELDING GAS _____ 92% AR + 8% CO2

REVISED:
ORIGINAL ISSUE: 1/21/03

WELDING PROCEDURE

PASS NO.	AMPS	VOLTS	TRAVEL SPEED (mm/MIN.)	GAS FLOW (L/MIN.)	JOINT DETAIL
1	283-325	25.2-28.7	394-432	15-20	TACK WELDS REMELTED BY THE SAW PROCESS

* PREHEAT NOT REQUIRED FOR TACKING.

THIS PROCEUDRE IS ONLY TO BE USED FOR TACKING
CROSS- FRAMES / DIAPHRAGMS.

PROCEDURE QUALIFICATION RECORD NS-01-02 (EXPIRES 9/10/06)

Z:\HS\JOBS\05017\wp1.dgn 04/27/05 10:24:26 AM

VTTRANS
RECEIVED

OK'D BY JJWC

095SS

JUN 03 2005

RESUBMIT _____ APPROVED [Signature]

BY _____ DATE 7-6-05