

WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS
 W14 - METRIC

PROCEDURE SPECIFICATIONS

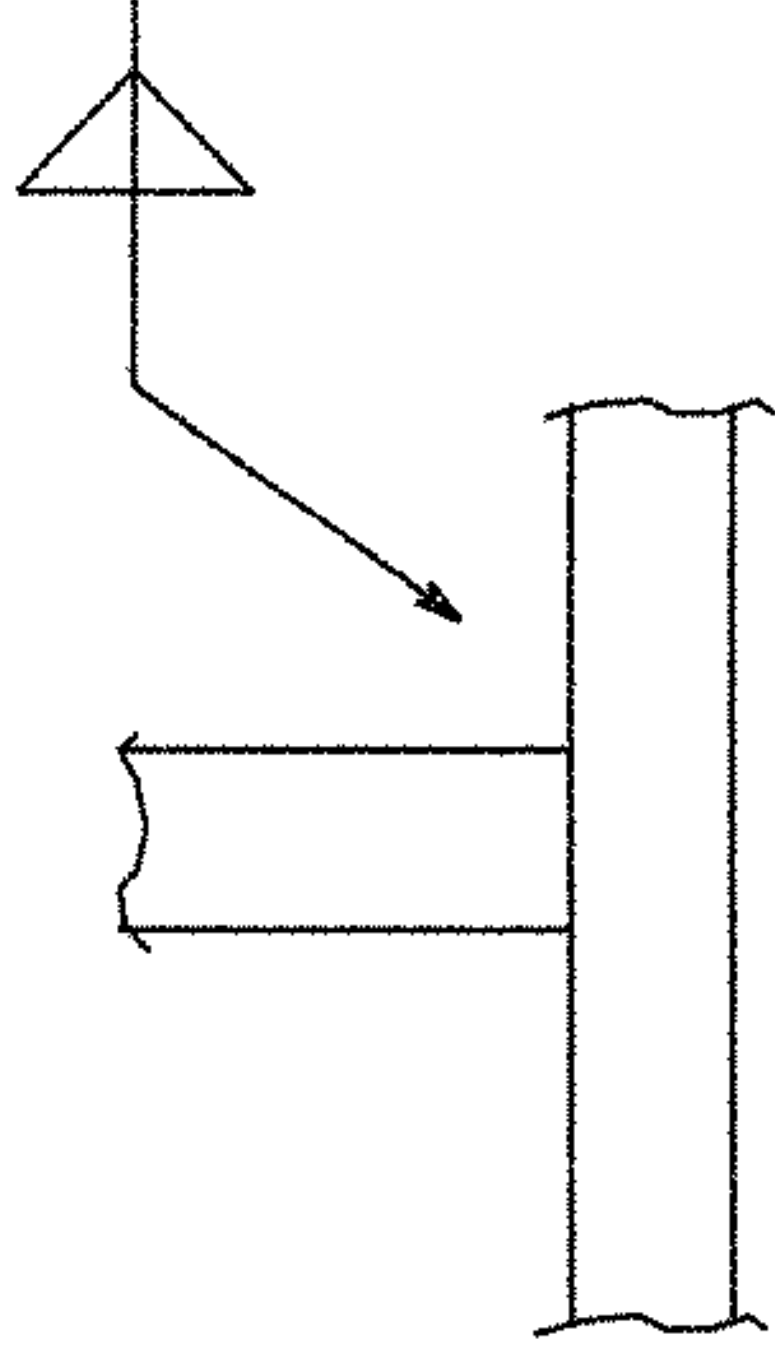
MATERIAL SPECIFICATION _____ ASTM A709 GRADES: 250, 345, 345W
 WELDING PROCESS _____ SUBMERGED ARC WELDING
 MANUAL OR MACHINE _____ SEMIAUTOMATIC OR MACHINE
 POSITION OF WELDING _____ 2F
 FILLER METAL SPECIFICATION _____ AWS A5.17
 WELD METAL CLASSIFICATION _____ F7A2-EM12K
 WIRE/FLUX _____ LINCOLN L61/960
 WIRE DIAMETER _____ 2.4mm
 SINGLE OR MULTIPLE ARC _____ SINGLE ARC
 POLARITY _____ DC-
 ROOT TREATMENT _____ MANUAL CLEANING
 PREHEAT AND INTERPASS TEMPERATURE _____ SEE PREHEAT CHART
 ELECTRICAL STICK-OUT _____ 25.4mm
 SHIELDING GAS _____ D.N.A.

REVISED: 3/3/03

ORIGINAL ISSUE: 3/4/96

WELDING PROCEDURE

PASS NO.	WELDING CURRENT		TRAVEL SPEED (mm/m)	JOINT DETAIL
	AMPS	VOLTS		
1	405-550	34.5-39.5	394-635	8mm FILLET WELD



PRIMARY USE:
 WEB TO FLANGE
 (AND OTHER APPLICATIONS AS NEEDED)

PROCEDURE QUALIFICATION RECORD 01-1 (EXPIRES 3/19/06)
 PROCEDURE QUALIFICATION RECORD AWS-03-7 (EXPIRES 2/4/08)

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VT TRANS
 RECEIVED

OK'D BY JWC

JUN 03 2005

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RESUBMIT _____ APPROVED

BY

DATE 7-6-05