

WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS  
**W34 - METRIC**

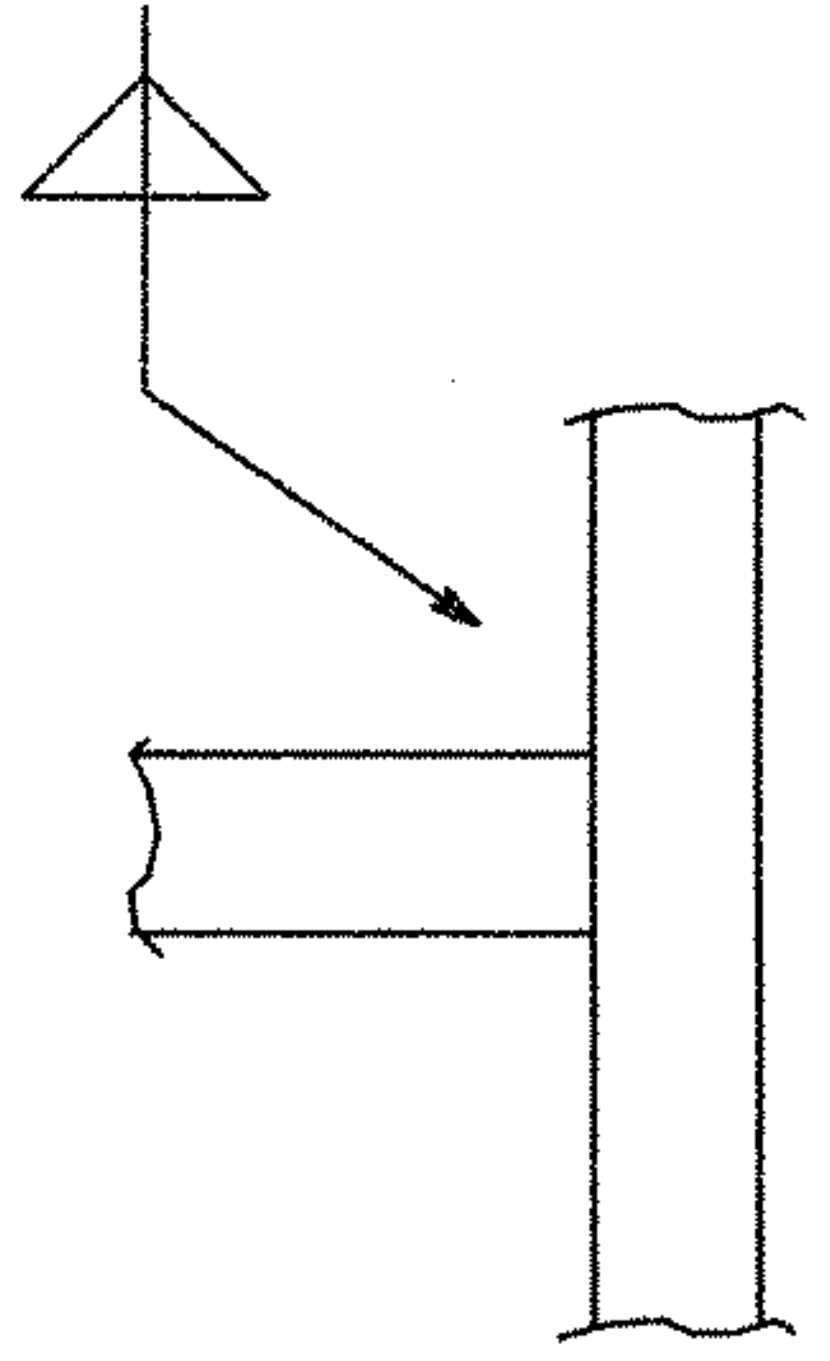
PROCEDURE SPECIFICATIONS

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 L61/761  
 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: 5/5/03  
 ORIGINAL ISSUE: 3/4/96

WELDING PROCEDURE

PASS NO.	WELDING CURRENT		TRAVEL SPEED (mm/m)	JOINT DETAIL
	AMPS	WIRE FEED SPEED		
1	360-440	2.9-3.7	29.0-36.0	279-686 8mm FILLET WELD



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

PROCEDURE QUALIFICATION RECORD AWS-FCM-02-4 (EXPIRES 6/27/07)  
 PROCEDURE QUALIFICATION RECORD AWS-FCM-02-5A (EXPIRES 7/16/07)

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**TRANS RECEIVED**  
 OK'D BY Jaw  
 JUN 03 2005  
 RESUBMIT \_\_\_\_\_ APPROVED   
 BY \_\_\_\_\_ DATE 7-6-05 **09755**