

WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS

W44 - METRIC

PROCEDURE SPECIFICATIONS

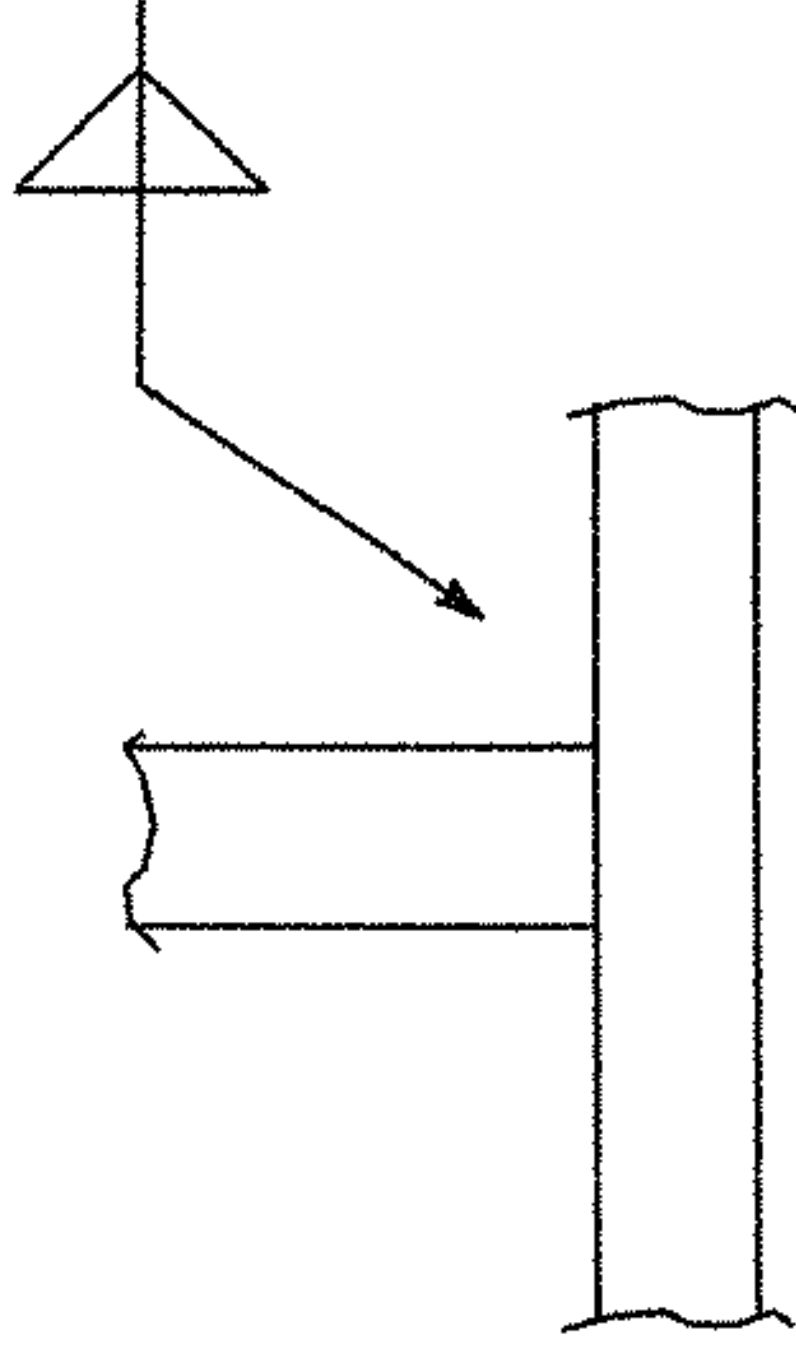
MATERIAL SPECIFICATION _____ ASTM A709 GRADES: 250, 345, 345W
 WELDING PROCESS _____ SUBMERGED ARC WELDING
 MANUAL OR MACHINE _____ SEMIAUTOMATIC OR MACHINE
 POSITION OF WELDING _____ 2F
 FILLER METAL SPECIFICATION _____ AWS A5.17
 WELD METAL CLASSIFICATION _____ F7A2-EM12K
 WIRE/FLUX _____ LINCOLN L61/76I
 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	VOLTS		
1	360-440	29.0-36.0	279-685	8mm FILLET WELD

PRIMARY USE:
 STIFFENER TO FLANGE
 (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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RECEIVED
 OK'D BY Jaw

JUN 03 2005
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RESUBMIT _____ APPROVED ✓
 BY _____ DATE 7-6-05