

WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS
W54 - 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 _____ SEE BELOW
 SINGLE OR MULTIPLE ARC _____ SINGLE ARC
 POLARITY _____ SEE BELOW
 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

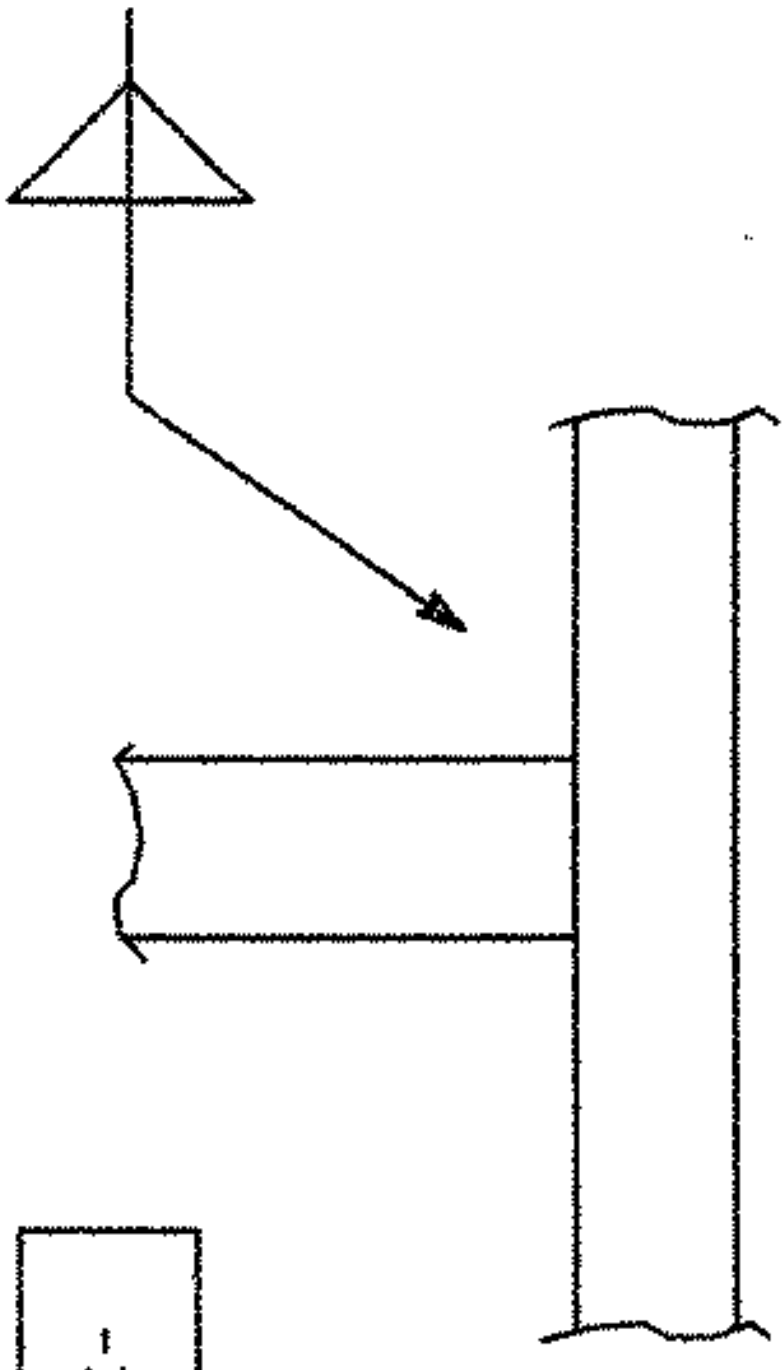
ORIGINAL ISSUE: 10/25/00

WELDING PROCEDURE

PASS NO.	WELDING CURRENT		TRAVEL SPEED (mm/m)	WIRE DIA.	POL.
	AMPS	VOLTS			
1	400-550	32.5-39.5	431-584	2.0mm	DC+

8mm FILLET WELDS

1	400-550	3.3-5.0	32.5-39.5	431-584	2.4mm	DC-
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PRIMARY USE:
CROSS FRAMES AND DIAPHRAGMS
(AND OTHER APPLICATIONS AS NEEDED)

- PROCEDURE QUALIFICATION RECORD AWS-03-7 (EXPIRES 2/4/08)
- PROCEDURE QUALIFICATION RECORD 01-1 (EXPIRES 3/19/06)
- PROCEDURE QUALIFICATION RECORD AWS-03-5 (EXPIRES 1/28/08)
- PROCEDURE QUALIFICATION RECORD AWS-03-6 (EXPIRES 1/31/08)

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VTRANS
RECEIVED

CK'D BY _____ OK'D BY JWC

JUN 03 2005

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RESUBMIT _____ APPROVED

BY _____ DATE 7-6-05