

WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS
W71X-2 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 _____ IC
 FILLER METAL SPECIFICATION _____ AWS A5.23
 WELD METAL CLASSIFICATION _____ F8A2-ENI1K-NI1-H8
 WIRE/FLUX _____ LINCOLN LA-75/960
 WIRE DIAMETER _____ 2.4 mm
 SINGLE OR MULTIPLE ARC _____ SINGLE ARC
 POLARITY _____ DC+
 ROOT TREATMENT _____ MANUAL CLEANING
 PREHEAT AND INTERPASS TEMPERATURE _____ SEE PREHEAT CHART
 ELECTRICAL STICK-OUT _____ 25.4 mm
 SHIELDING GAS _____ D.N.A.

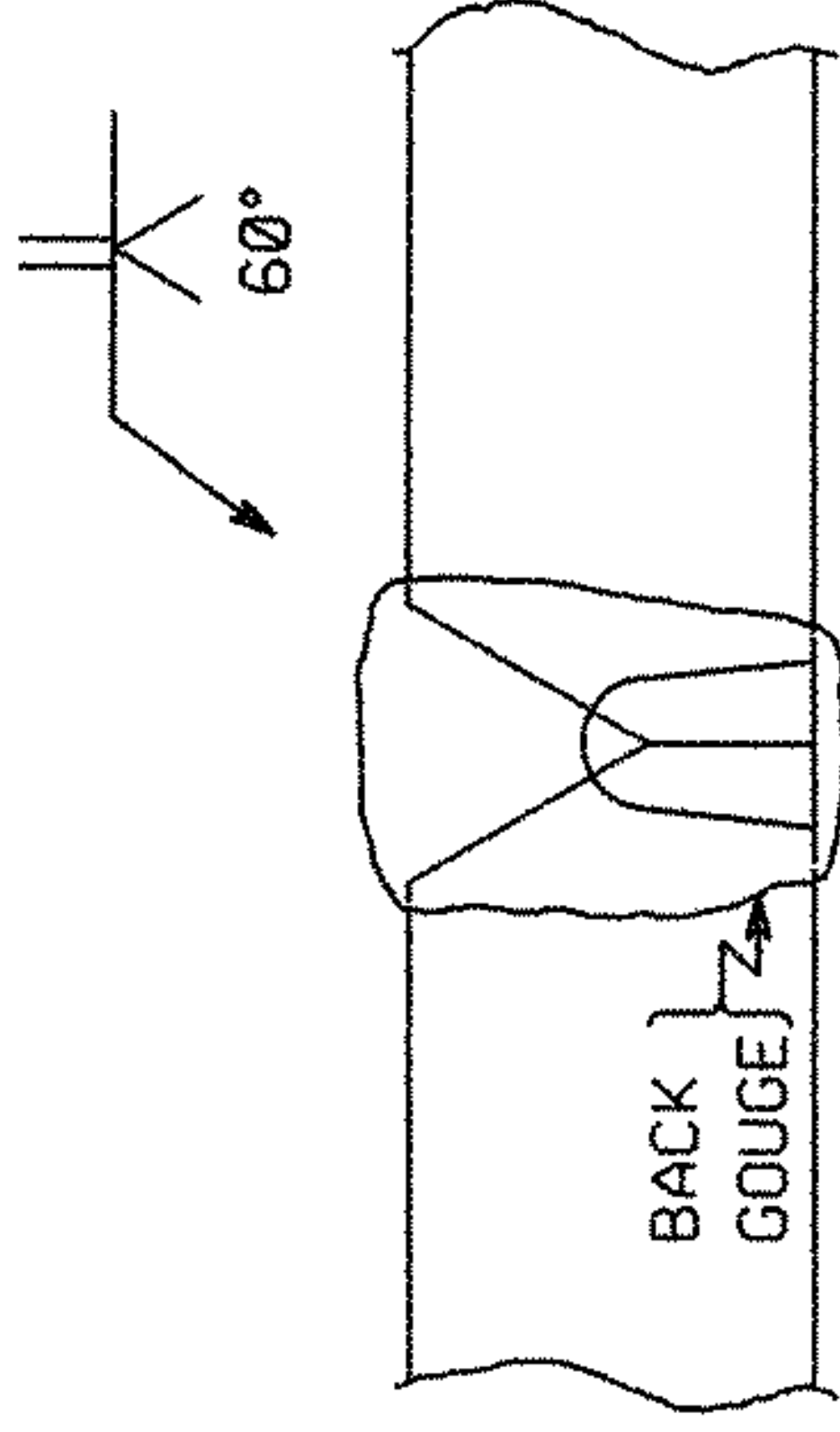
REVISED: _____
 ORIGINAL ISSUE: 3/10/03

WELDING PROCEDURE

PASS NO.	AMPS	WIRE FEED SPEED (m/MIN.)	VOLTS	TRAVEL SPEED (mm/MIN.)
ALL	448-550	2.3-3.2	31.0-38.0	381-635

B-L2c-S

JOINT DETAIL



PROCEDURE QUALIFICATION RECORD AWS-04-1 (EXPIRES 4/29/09)
 PROCEDURE QUALIFICATION RECORD AWS-04-2 (EXPIRES 2/2/09)

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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