WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS

W71X - AC - 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	1G
FILLER METAL SPECIFICATION	AWS A5.23
WELD METAL CLASSIFICATION	F8A2-EN1K-N1-H8
WIRE/FLUX	LINCOLN LA-75/960
WIRE DIAMETER	2.4 mm
SINGLE OR MULTIPLE ARC	SINGLE ARC
POLARITY	AC (SEE RESTRICTIONS BELOW)
ROOT TREATMENT	MANUAL CLEANING
PREHEAT AND INTERPASS TEMPERATURE	SEE PREHEAT CHART
ELECTRICAL STICK-OUT	25.4 mm
SHIELDING GAS	D.N.A.

REVISED: 2/18/03

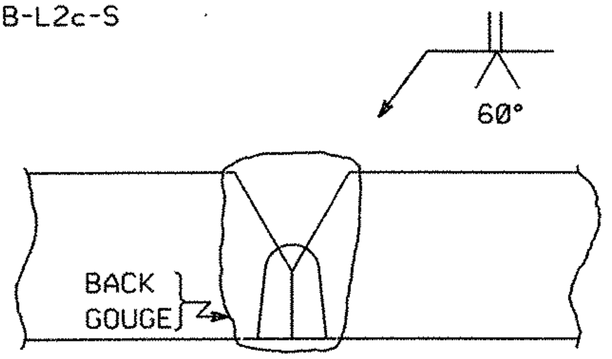
ORIGINAL ISSUE: 5/10/02

WELDING PROCEDURE

PASS NO.	AMPS	WIRE FEED SPEED (IN/MIN.)	VOLTS	TRAVEL SPEED (mm/MIN.)
ALL	462-670	108-205	34.0-36.0	381-508

JOINT DETAIL

B-L2c-S



NOTE: THIS PROCEDURE SHALL ONLY BE USED WITH A MILLER SUMMIT ARC 1000 POWER SOURCE WITH A FREQUENCY OF 60HZ AND A 66/34 (DC+/DC-) POLARITY BALANCE PLUG.

THE MAXIMUM WELDING CURRENT TO BE USED IN MAKING A GROOVE WELD FOR ANY PASS THAT HAS FUSION TO BOTH FACES OF THE GROOVE SHALL BE 600 AMPS / 171 WIRE FEED SPEED.

PROCEDURE QUALIFICATION RECORD AWS-03-1 (EXPIRES 1/8/08)
PROCEDURE QUALIFICATION RECORD AWS-03-2 (EXPIRES 1/9/08)

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OK'D BY _____ OK'D BY JWC

RESUBMIT _____ APPROVED ✓

BY _____ DATE 7-6-05

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