

WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS  
W72X-2 METRIC

PROCEDURE SPECIFICATIONS

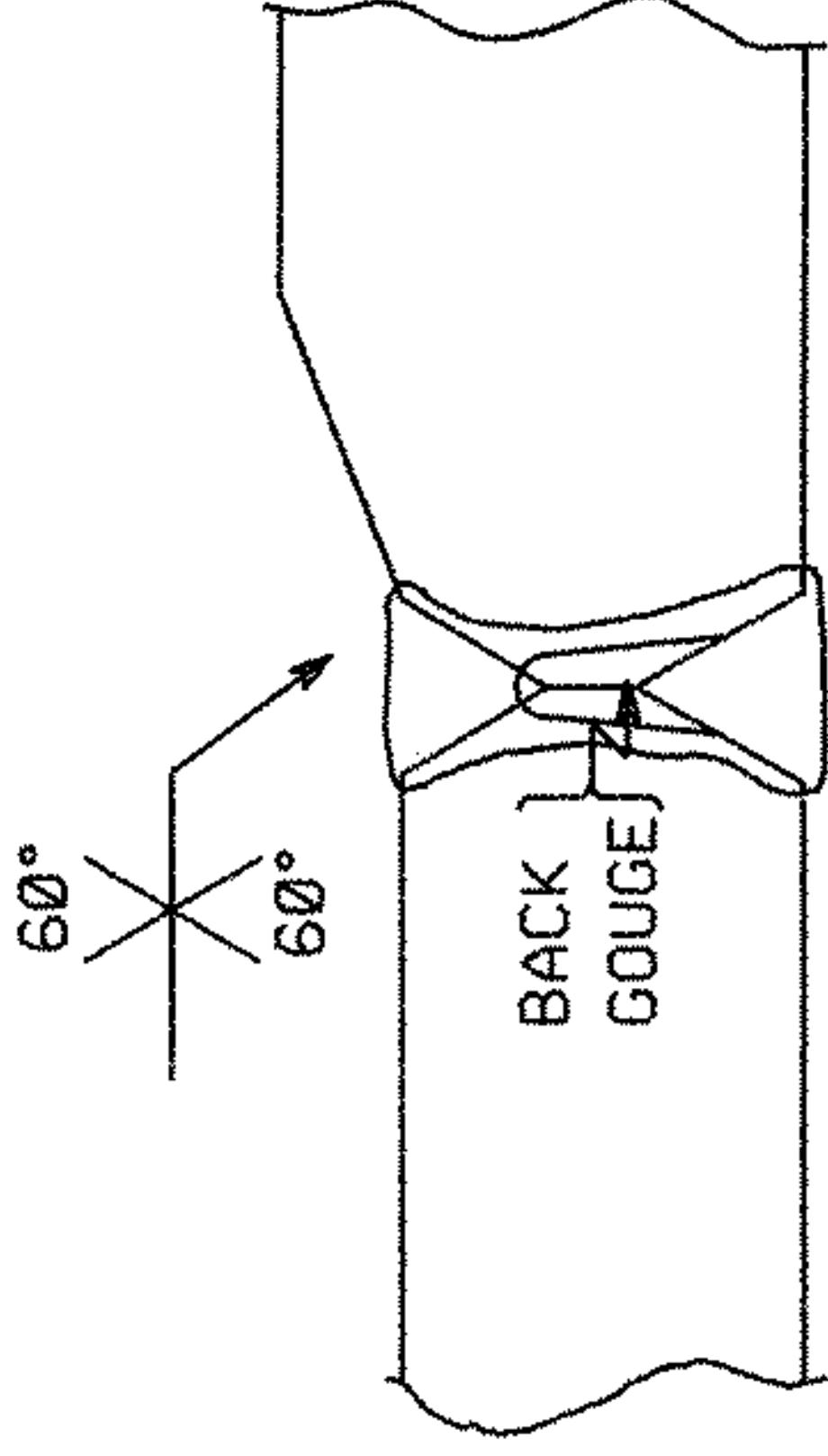
MATERIAL SPECIFICATION \_\_\_\_\_ ASTM A709 GRADES: 250, 345, 345W  
 WELDING PROCESS \_\_\_\_\_ SUBMERGED ARC WELDING  
 MANUAL OR MACHINE \_\_\_\_\_ SEMIAUTOMATIC OR MACHINE  
 POSITION OF WELDING \_\_\_\_\_ 1G  
 FILLER METAL SPECIFICATION \_\_\_\_\_ AWS A5.23  
 WELD METAL CLASSIFICATION \_\_\_\_\_ F8A2-ENIK-NII-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.

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-U3c-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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REVISED:

ORIGINAL ISSUE: 3/10/03

VTRASS  
RECEIVED

OK'D BY Jac

JUN 03 2005

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RESUBMIT \_\_\_\_\_ APPROVED

BY \_\_\_\_\_ DATE 7-6-05