

WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS

W72X - AC - METRIC

PROCEDURE SPECIFICATIONS

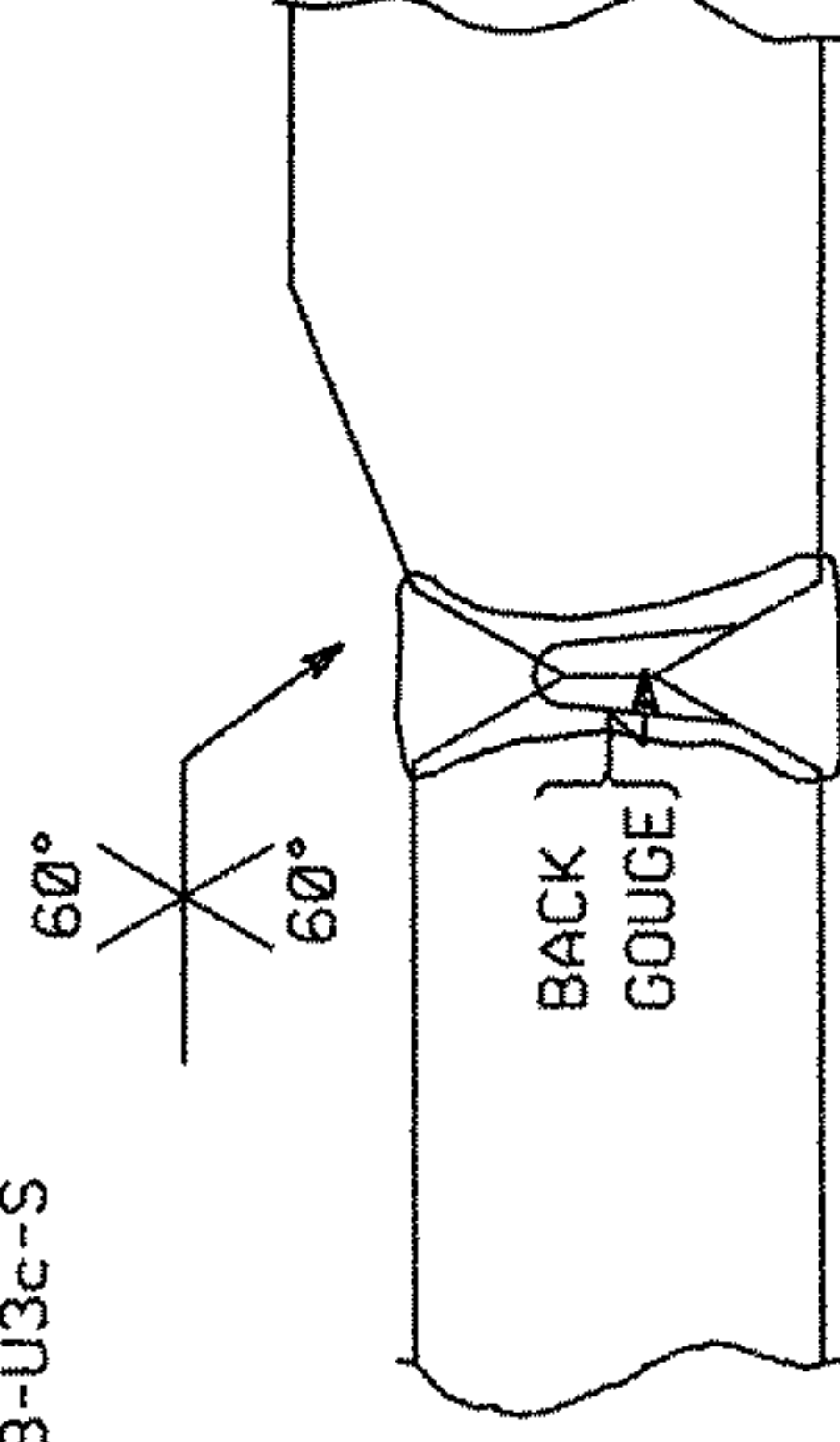
MATERIAL SPECIFICATION _____ ASTM A709 GRADES: 250, 345, 345W
 WELDING PROCESS _____ SUBMERGED ARC WELDING
 MANUAL OR MACHINE _____ SEMIAUTOMATIC OR MACHINE
 POSITION OF WELDING _____ 1G
 FILLER METAL SPECIFICATION _____ AWS A5.23
 WELD METAL CLASSIFICATION _____ F8A2-ENI1K-N11-H8
 WIRE/FLUX _____ LINCOLN LA-75/S60
 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.)	JOINT DETAIL
ALL	462-670	108-205	34.0-36.0	381-508	B-U3c-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 JWC

JUN 03 2005

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APPROVED

DATE 7-6-05