

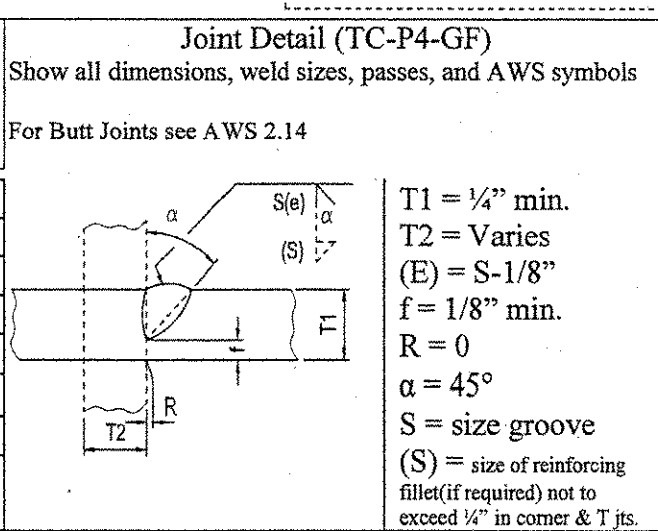
DSBROWN Production Joint Welding Procedure Specification (D1.5-02)

Procedure No: A-GSB-11 Date Issued: 12-21-04 Revision No: 0 Rev. Date: _____
 Contractor (Fabricator) D. S. Brown Company Prepared by: James R. Connor, Quality Assurance Manager
 1. Non-Fracture Critical Fracture Critical WPS Expiration Date: _____
 2. Qualified in accordance with: AWS D1.5:2002 (5.12.1)
 Referenced PQR No(s): PQR-GMAW-01(04)
 Referenced FWST No(s): PQR-GMAW-FWST-01A(03), PQR-GMAW-FWST-01B(03)
 3. Material specification(s) ASTM A709 Gr. 36, 50, 50W, A53 & 500B.C (pipe) For DOT Approval
 4. Material Thickness (es) Unlimited
 5. Welding process GMAW
 6. Manual , machine , or semiautomatic
 7. Position(s) of welding 1G,2G,1F,2F
 8. Filler metal specification AWS A5.18
 9. Filler metal class and brand name ER70S-3 Lincoln SuperArc 50
 10. Flux class & brand N/A, Type N/A
 11. Shielding gas 90% Ar / 10% CO2 Flow rate 45 CFH
 12. Single pass Or multiple pass
 13. Single arc Or multiple arc
 14. Welding Current DCEP
 15. Polarity Reverse
 16. Welding progression stringers
 17. Root treatment Clean to bright sound metal or per AWS D1.5 (3.2.1 & 3.11)
 18. Postheat treatment N/A
 19. Calculated Heat Input (KJ/in) Min 15.3 KJ/in Max 24.9 KJ/in
 20. Electrode extension (electrical stickout) 3/4"

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 APPROVED
 DATE 7-11-06

Weld size (in)	Pass No(s)	Electrode Size (in)	Welding Process Variables		Travel Speed (IPM)	Travel (in)
			AMPS/WFS*	VOLTS		
**1/8"	1	.045"	170-215	24-27	14-16	
**3/16"	1	.045"	170-215	24-27	14-16	
1/4"	1	.045"	170-215	24-27	14-16	
5/16"	1-2	.045"	170-215	24-27	14-16	
3/8"	2-3	.045"	170-215	24-27	14-16	
7/16"	3-5	.045"	170-215	24-27	14-16	
1/2"	4-6	.045"	170-215	24-27	14-16	

** Non-Structural weld



Joint Detail (TC-P4-GF)
 Show all dimensions, weld sizes, passes, and AWS symbols
 For Butt Joints see AWS 2.14
 T1 = 1/4" min.
 T2 = Varies
 (E) = S-1/8"
 f = 1/8" min.
 R = 0
 α = 45°
 S = size groove
 (S) = size of reinforcing fillet (if required) not to exceed 1/2" in corner & T ps.

* Wire feed speed may be used along with amperage (include chart)

Prepared By: James R. Connor DSB QA Manager

Project: _____

DSB Job: 14032-1042

Base Metal Thickness range	Minimum Preheat (°F)	Max Preheat & Interpass (°F)
≤ 3/4"	50°F	450°F
> 3/4" to ≤ 1.5"	70°F	450°F
> 1.5" to ≤ 2.5"	150°F	450°F
> 2.5"	225°F	450°F

Note: When this procedure is used for A709Gr50W materials, it shall be limited to 5/16" single pass or material be coated.

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