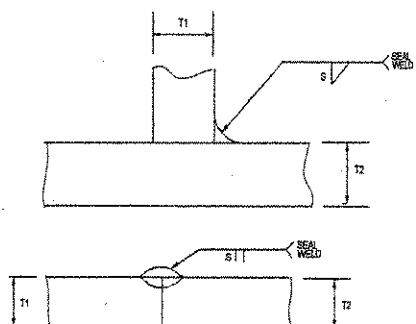


DSBROWN Production Joint Welding Procedure Specification (D1.5-02)

Procedure No: A-G-SEALWELD-01 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, A500B, A53 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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Weld Size (in)	Pass No(s)	Electrode Size (in)	Welding Process Variables		Travel Speed (in/min)	Joint Detail (Sealweld) Show all dimensions, weld sizes, passes, and AWS symbols
			AMPS	VOLTS		
**1/8"	1	.045"	170-215	24-27	14-16	 <p>T1 = Varies T2 = Varies S = Weld Size</p>
**3/16"	1	.045"	170-215	24-27	14-16	

NOTE:
 THIS JOINT DETAIL TO BE USED FOR SEALING NON-STRUCTURAL GALVANIZED OR PAINTED APPLICATIONS WHERE FULL SIZED WELDMENTS ARE NOT DESIGNED, DETAILED OR ARE NOT PRACTICAL.

Preheat and Interpass Temperature Chart		
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

Prepared By: James R. Connor DSB QA Manager

Project: _____

DSB Job: 14032-1042

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