



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

Procedure No: A-F-SEALWELD-01 Date Issued: 9-11-03 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 (S.12.1)  
 Referenced PQR No(s): PQR-FCAW-01-03  
 Referenced FWST No(s): PQR-FCAW-FWST-01(03), PQR-FCAW-FWST-01A(03)  
 3. Material specification(s) ASTM A709 Gr. 36, 50, 50W For DOT Approval  
 4. Material Thickness (es) Unlimited  
 5. Welding process FCAW  
 6. Manual , machine , or semiautomatic   
 7. Position(s) of welding 1G, 1F, 2F  
 8. Filler metal specification AWS A5.20  
 9. Filler metal class and brand name E71T-1, E71T-9 (Lincoln Outershield Elite)  
 10. Flux class & brand N/A, Type N/A  
 11. Shielding gas 100% 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 and per AWS D1.5 (3.2.1 & 3.11)  
 18. Postheat treatment N/A  
 19. Calculated Heat Input (KJ/in) Min 31.20 KJ/in Max 50.72 KJ/in  
 20. Electrode extension (electrical stickout) 3/4"

RECEIVED  
 CWD BY: [Signature]  
 DATE: DEC 9 2005  
 RESUBMIT:  APPROVED:

Weld Size (in)	Pass No(s)	Electrode Size (in)	Welding Process Variables		Travel Speed (in/min)	Travel Rate (in/hr)
			AMPS	VOLTS		
**1/8"	1	1/16"	260-310	26-30	11-13	
**3/16"	1	1/16"	260-310	26-30	11-13	

**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.

Joint Detail (Fillet)  
 Show all dimensions, weld sizes, passes, and AWS symbols

T1 = Varies  
 T2 = Varies  
 S = Weld Size

Prepared By: <u>James R. Connor</u> DSB QA Manager	Preheat and Interpass Temperature Chart		
	Base Metal Thickness range	Minimum Preheat (°F)	Max Preheat & Interpass (°F)
Project: <u>U.S. RTE. 5 OVER LULLS BROOK</u>	≤ 3/4"	50°F	450°F
DSB Job: <u>14032-1042</u>	>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.