

VT A.O.T.
 # BRF-013-1(B)
 TOWN OF JAMAICA

COSMEC INC.

WELDING PROCEDURE SPECIFICATION

SPECIFICATIONS AND CODE: D1.8 (D1.3)
 MATERIAL SPECIFICATION ASTM A240 TYPE 304 TO ASTM A709 GR 50W
 WELDING PROCESS GTAW
 MANUAL OR MACHINE MANUAL
 POSITION OF WELDING 1F & 2F
 FILLER METAL SPECIFICATION ER309L
 MANUFACTURER HARRIS WELCO
 FLUX INTERNAL
 SHIELDING GAS ARGON
 SINGLE OR MULTIPLE PASSES SINGLE
 SINGLE OR MULTIPLE ARC SINGLE
 WELDING CURRENT DC
 POLARITY REVERSE (EN)
 WELDING PROGRESSION
 ROOT TREATMENT CLEANED & PREPARED BRIGHT METAL
 PREHEAT AND INTERPASS TEMPERATURE SEE BELOW
 POSTHEAT TEMPERATURE N/A
 HEAT INPUT MIN. MAX.

OK'D BY: JWC
 CLASSIFICATION: A5.9
 TRADENAME:
 RESUBMIT APPROVED
 DATE 4-11-05

VT TRANS RECEIVED

APR 08 2005

WELDING PROCEDURE

PASS NO.	ELECTRODE SIZE	WELDING CURRENT AMPERES	TRAVEL SPEED VOLTS	JOINT DETAIL
ALL	3/32"	130-155	23-27	LAP JOINT

PREHEAT TEMPS. ***PREHEAT UNTIL NO POSITURE PRESENT

THICKNESS	TEMP.
UP TO 3/4"	100 DEG.
OVER 3/4" TO 1 1/2"	100 DEG.
OVER 1 1/2" TO 2 1/2"	100 DEG.
OVER 2 1/2"	100 DEG.

THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT-UP, PASS SIZE, ETC.
 WITHIN THE LIMITATION OF VARIABLES GIVEN IN SECTION 5.
 SUPPORTING PQR: GTAW-WF-05
 PROCEDURE NO. GTAW-WF

CONTRACTOR: PA, D.O.T.
 AUTHORIZED BY: DONALD VOSE
 CWI# 01100651

REVISION NO.
 DATE: 2/1/2005

