

3. Material specification(s) ASTM A709 Gr. 36, 50, 50W
4. Material Thickness (es) Unlimited
5. Welding process GMAW
6. Manual , machine , or semiautomatic
7. Position(s) of welding 1F, 2F
8. Filler metal specification AWS A5.18
9. Filler metal class and brand name E70C-6M Corex Metal-Core Maxim
10. Flux class & brand N/A, Type N/A
11. Shielding gas 75% Ar / 25% 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 30.6 Kj/in Max 51.1 Kj/in
20. Electrode extension (electrical stickout) 3/4"

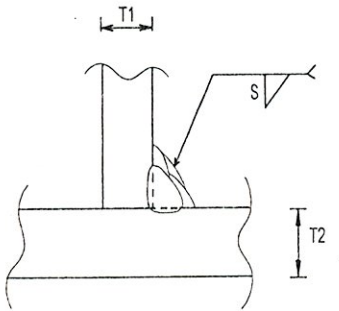
**VT TRANS RECEIVED**

OK'D BY \_\_\_\_\_ OK'D BY JUC

**JUN 05 2008**

RESUBMIT \_\_\_\_\_ APPROVED

BY \_\_\_\_\_ DATE 6/12/08

Weld size (In)	Pass No(s)	Electrode Size (In)	Welding Process Variables		Travel Speed (IPM)	Joint Detail (Fillet)
			AMPS/WFS*	VOLTS		
**1/4"	1	.052"	265-320	31-34.5	13-16	<p>Show all dimensions, weld sizes, passes, and AWS symbols</p>  <p>T1 = Varies T2 = Varies S = Weld Size</p> <p>** T1 &amp; T2 equal to or less than 3/4" for 1/4" welds.</p>
5/16"	1	.052"	265-320	31-34.5	13-16	
3/8"	1-3	.052"	265-320	31-34.5	13-16	
7/16"	2-4	.052"	265-320	31-34.5	13-16	
1/2"	4-6	.052"	265-320	31-34.5	13-16	
5/8"	5-7	.052"	265-320	31-34.5	13-16	
3/4"	6-8	.052"	265-320	31-34.5	13-16	

<p>* Wire feed speed may be used along with amperage (include chart)</p> <p>Prepared By: <u>James R. Connor</u> DSB QA Manager</p> <p>Project: _____</p> <p>DSB Job: _____</p>	<p><b>Preheat and Interpass Temperature Chart</b></p> <table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th>Base Metal Thickness range</th> <th>Minimum Preheat (°F)</th> <th>Max Preheat &amp; Interpass (°F)</th> </tr> </thead> <tbody> <tr> <td>≤3/4"</td> <td>50°F</td> <td>450 °F</td> </tr> <tr> <td>&gt;3/4" to ≤1.5"</td> <td>70°F</td> <td>450 °F</td> </tr> <tr> <td>&gt;1.5" to ≤2.5"</td> <td>150°F</td> <td>450 °F</td> </tr> <tr> <td>&gt;2.5"</td> <td>225°F</td> <td>450 °F</td> </tr> </tbody> </table>	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
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.