

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 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"

TRANS RECEIVED

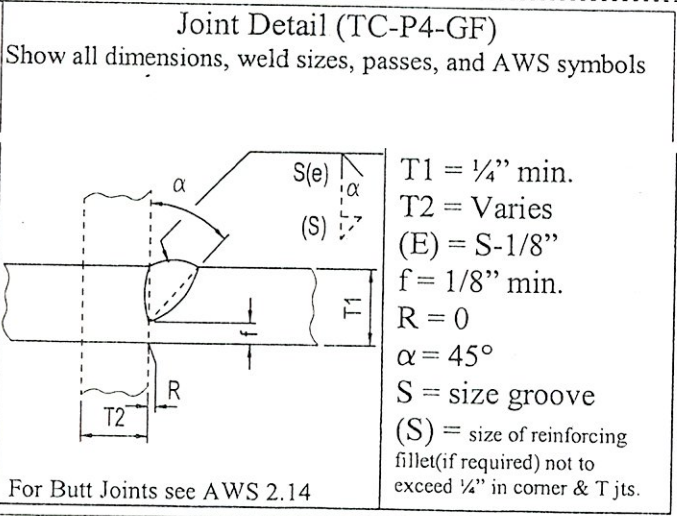
CK'D BY _____ OK'D BY Juc

JUN 05 2008

RESUBMIT _____ APPROVED

BY _____ DATE 6/12/08

(E)&(S)	Weld size (in)	Pass No(s)	Electrod e Size (in)	Welding Process Variables		Travel Speed (IPM)
				AMPS/WFS*	VOLTS	
1/4"	1	1	.052"	265-320	31-34.5	13-16
5/16"	1	1	.052"	265-320	31-34.5	13-16
3/8"	1-2	1-2	.052"	265-320	31-34.5	13-16
1/2"	3-4	3-4	.052"	265-320	31-34.5	13-16
5/8"	4-6	4-6	.052"	265-320	31-34.5	13-16
3/4"	5-7	5-7	.052"	265-320	31-34.5	13-16
7/8"	6-9	6-9	.052"	265-320	31-34.5	13-16
1"	7-10	7-10	.052"	265-320	31-34.5	13-16



T1 = 1/4" min.
 T2 = Varies
 (E) = S-1/8"
 f = 1/8" min.
 R = 0
 alpha = 45°
 S = size groove
 (S) = size of reinforcing fillet (if required) not to exceed 1/4" in corner & T jts.

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

Prepared By: Jessie R. Connor DSB QA Manager

Project: _____

DSB Job: _____

Base Metal Thickness range	Minimum Preheat (°F)	Max Preheat & Interpass (°F)
≤ 3/4"	50°F	450°F
> 3/4" to ≤ .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.