

3. Material specification(s) ASTM A709 Gr. 36, 50, 50W
4. Material Thickness (es) Unlimited
5. Welding process FCAW
6. Manual , machine , or semiautomatic
7. Position(s) of welding 1F, 2F
8. Filler metal specification AWS A5.20
9. Filler metal class and brand name E71T-1CH8 (UltraCore71C)
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 or 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"

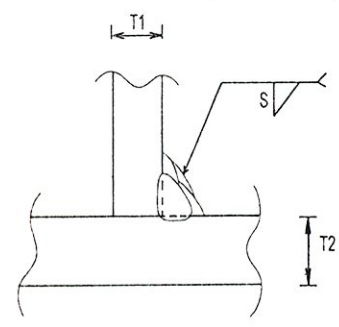
VTRANS RECEIVED

CK'D BY _____ OK'D BY JWC

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) Show all dimensions, weld sizes, passes, and AWS symbols
			AMPS/WFS*	VOLTS		
1/4"	1	1/16"	260-310	26-30	11-13	 <p>T1 = Varies T2 = Varies S = Weld Size</p> <p> T1 & T2 equal to or less than 3/4" for 1/4" welds.</p>
5/16"	1	1/16"	260-310	26-30	11-13	
3/8"	2-3	1/16"	260-310	26-30	11-13	
7/16"	3-5	1/16"	260-310	26-30	11-13	
1/2"	4-6	1/16"	260-310	26-30	11-13	
5/8"	5-7	1/16"	260-310	26-30	11-13	
3/4"	6-8	1/16"	260-310	26-30	11-13	

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

Prepared By: [Signature] DSB QA Manager

Project: _____

DSB Job: _____

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 ≤.5"	70°F	450 °F
>1.5" to ≤.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.