

1. Material specification(s) ASTM A709 Gr. 36, 50, 50W
2. Material Thickness (es) Unlimited
3. Welding process FCAW
4. Manual  , machine  , or semiautomatic
5. Position(s) of welding 1G, 2G,(1F,2F)
6. Filler metal specification AWS A5.20
7. Filler metal class and brand name E71T-1CH8 (UltraCore71C)
8. Flux class & brand N/A , Type N/A
9. Shielding gas 100% CO2 , Flow rate 45 CFH
10. Single pass  Or multiple pass
11. Single arc  Or multiple arc
12. Welding Current DCEP
13. Polarity Reverse
14. Welding progression Stringers
15. Root treatment Clean to bright sound metal or per AWS D1.5 (3.2.1 & 3.11)
16. Postheat treatment N/A
17. Calculated Heat Input (KJ/In) Min 31.20 KJ/in Max 50.72 KJ/in
18. Electrode extension (electrical stickout) 3/4"

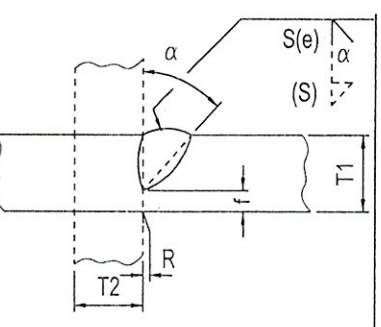
**VT TRANS RECEIVED**

CK'D BY \_\_\_\_\_ OK'D BY JWC

**JUN 05 2008**

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

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

Weld size (E)&(S) (In)	Pass No(s)	Electrode Size (In)	Welding Process Variables		Travel Speed (IPM)	Joint Detail (TC-P4-GF) 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 = 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 &amp; T jts.</p>
5/16"	1	1/16"	260-310	26-30	11-13	
3/8"	2-3	1/16"	260-310	26-30	11-13	
1/2"	3-4	1/16"	260-310	26-30	11-13	
5/8"	4-6	1/16"	260-310	26-30	11-13	
3/4"	5-7	1/16"	260-310	26-30	11-13	
7/8"	6-8	1/16"	260-310	26-30	11-13	
1"	7-9	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: \_\_\_\_\_

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.