

WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS W45S													
<p>PROCEDURE SPECIFICATIONS</p> <p>MATERIAL SPECIFICATION: ASTM A-36, A-572, A-588, A-240 TYPE 304</p> <p>WELDING PROCESS: SHIELDED METAL ARC WELDING</p> <p>MANUAL OR MACHINE: MANUAL</p> <p>POSITION OF WELDING: 1F AND 2F</p> <p>FILLER METAL SPECIFICATION: AWS A5.4</p> <p>WELD METAL CLASSIFICATION: E308-16</p> <p>WIRE/FLOW: D.N.A.</p> <p>POLARITY: DC- OR AC</p> <p>ROOT TREATMENT: MANUAL CLEANING</p> <p>PREHEAT AND INTERPASS TEMPERATURE: SEE PREHEAT CHART</p> <p>ELECTRICAL STICK-OUT: 1/4 INCH</p> <p>SHIELDING GAS: D.N.A.</p>													
<p>MINIMUM PREHEAT AND INTERPASS TEMPERATURE</p> <p>SHIELDED METAL-ARC WELDING WITH LOW HYDROGEN ELECTRODES, OR SUBMERGED ARC WELDING OR FLOW CORDED ARC WELDING</p>													
<p>THICKNESS OF THICKEST PART AT POINT OF WELDING - INCHES</p> <p>ASTM A-36, A-572, AND A-588: 1/8", 1/2", AND 1/2"</p> <p>ASTM A-240 TYPE 304: 1/8", 1/2", AND 1/2"</p> <p>ASTM A-572 GRADE 50: 1/8", 1/2", AND 1/2"</p> <p>ASTM A-588 GRADE 80: 1/8", 1/2", AND 1/2"</p>													
<p>TO 3/16 INCL. 100°F</p> <p>OVER 3/16 TO 1/2 INCL. 200°F</p> <p>OVER 1/2 TO 2 1/2 INCL. 300°F</p> <p>OVER 2 1/2: 350°F</p>													
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<p>PRIMARY USE: STAINLESS STEEL (AND OTHER APPLICATIONS AS NEEDED)</p> <p>REVISOR: 02/08/93</p> <p>ORIGINAL ISSUE: 01/01/92</p>													

WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS W33X													
<p>PROCEDURE SPECIFICATIONS</p> <p>MATERIAL SPECIFICATION: ASTM A-36, A-572, A-588</p> <p>WELDING PROCESS: SUBMERGED ARC WELDING</p> <p>MANUAL OR MACHINE: SEMIAUTOMATIC OR MACHINE</p> <p>POSITION OF WELDING: 2F</p> <p>FILLER METAL SPECIFICATION: AWS A5.17</p> <p>WELD METAL CLASSIFICATION: F7A2-D2EX</p> <p>WIRE/FLOW: LINCOLN L61/761</p> <p>WIRE DIAMETER: 3/16"</p> <p>SINGLE OR MULTIPLE ARC: SINGLE ARC</p> <p>POLARITY: DC-</p> <p>ROOT TREATMENT: MANUAL CLEANING</p> <p>PREHEAT AND INTERPASS TEMPERATURE: SEE PREHEAT CHART</p> <p>ELECTRICAL STICK-OUT: 1 INCH</p> <p>SHIELDING GAS: D.N.A.</p>													
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<p>PRIMARY USE: STIFFENER TO WEB (AND OTHER APPLICATIONS AS NEEDED)</p> <p>REVISOR: 11/21/94</p> <p>REVISOR: 18/26/93</p> <p>REVISOR: 11/6/92</p> <p>ORIGINAL ISSUE: 01/01/92</p>													

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<p>PROCEDURE SPECIFICATIONS</p> <p>MATERIAL SPECIFICATION: ASTM A-36, A-572, A-588, A240 TYPE 304</p> <p>WELDING PROCESS: GAS TUNGSTEN ARC WELDING</p> <p>MANUAL OR MACHINE: MANUAL</p> <p>POSITION OF WELDING: 2F</p> <p>ELECTRODE CLASSIFICATION: AWS A5.12</p> <p>FILLER METAL: EWT-2 (2% THORATED)</p> <p>FILLER METAL: AUTOMATIC WELD</p> <p>ELECTRODE SIZE: 3/16"</p> <p>NOZZLE SIZE: 3/16" (1")</p> <p>POLARITY: DC-</p> <p>ELECTRICAL STICK-OUT (INCHES): 3/4"</p> <p>ROOT TREATMENT: MANUAL CLEANING</p> <p>PREHEAT AND INTERPASS TEMPERATURE: NONE</p> <p>SHIELDING GAS: 100% ARGON</p>													
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<p>PRIMARY USE: MACHINE SHOP - STAINLESS STEEL OVERLAY (AND OTHER APPLICATIONS AS NEEDED)</p> <p>REVISOR: 02/08/93</p> <p>ORIGINAL ISSUE: 01/01/92</p>													

WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS W2																			
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WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS W71X																									
<p>PROCEDURE SPECIFICATIONS</p> <p>MATERIAL SPECIFICATION: ASTM A-36, A-572, A-588</p> <p>WELDING PROCESS: SUBMERGED ARC WELDING</p> <p>MANUAL OR MACHINE: SEMIAUTOMATIC OR MACHINE</p> <p>POSITION OF WELDING: 1F</p> <p>FILLER METAL SPECIFICATION: AWS A5.23</p> <p>WELD METAL CLASSIFICATION: F7A4-D2EX-N3</p> <p>WIRE/FLOW: LINCOLN L61/XXX08</p> <p>WIRE DIAMETER: 3/16"</p> <p>SINGLE OR MULTIPLE ARC: SINGLE ARC OR PARALLEL ARC</p> <p>POLARITY: DC-</p> <p>ROOT TREATMENT: MANUAL CLEANING</p> <p>PREHEAT AND INTERPASS TEMPERATURE: SEE PREHEAT CHART</p> <p>ELECTRICAL STICK-OUT: 1 INCH</p> <p>SHIELDING GAS: D.N.A.</p>																									
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<p>PARAMETERS FOR PASS 1 (SINGLE ARC) MAY BE USED FOR CWP PASSES.</p> <p>(****) THE JOINT MAY BE COMPLETED USING SINGLE ARC WELDING EQUIPMENT AND THE PARAMETERS OF PASS 2-3.</p> <p>PROCEDURE QUALIFICATION RECORD 93-7 (EXPIRES 18/5/96)</p> <p>PROCEDURE QUALIFICATION RECORD 94-8 (EXPIRES 3/2/98)</p> <p>PROCEDURE QUALIFICATION RECORD FCM-94-11 (EXPIRES 9/28/97)</p> <p>PROCEDURE QUALIFICATION RECORD FCM-94-18 (EXPIRES 9/28/97)</p> <p>REVISOR: 12/14/95</p> <p>ORIGINAL ISSUE: 12/14/95</p>																									

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<p>PRIMARY USE: WEB TO FLANGE (AND OTHER APPLICATIONS AS NEEDED)</p> <p>REVISOR: 7/27/95</p> <p>ORIGINAL ISSUE: 01/01/92</p>													

WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS W43X													
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