

Lehigh Valley Steel Structures, Inc.
WELDING PROCEDURE SPECIFICATION

Material specification ASTM A 572 Gr 50-50W
 Welding process Submerged Arc Welding
 Manual or machine Machine
 Position of welding Flat
 Filler metal specification AWS A 5-23
 Filler metal classification E 8018-RTK-NI-H8
 Flux Lincoln 760 with LA-75 Elec
 Shielding gas NA
 Single or multiple pass MULTIPLE Flow rate NA
 Single or multiple arc SINGLE
 Welding current DC
 Polarity DCRP
 Welding progression See Detail
 Root treatment Wire brush, area to be free of loose scale, slag, rust, dirt
 Preheat and interpass temperature See Table
 Postheat temperature NA
 Heat Input Min 39.76 kJ/in Max 42.5 kJ/in P.Q.R FCM #14-02.8 KOTW

Minimum Preheat and Interpass Temperature, °C [°F]

Thickness of Thicker Part at Point of Welding, mm [in]	Over 20 mm [3/4 in]	Over 40 mm [1-1/2 in]	Over 65 mm [2-1/2 in]
Preheat	100 [200]	150 [300]	175 [345]
Interpass	100 [200]	150 [300]	175 [345]

Welding Process (Base Metal)

SAW (A 709) Cr. 100 (20)	SAW (A 709) Cr. 150 (30)	SAW (A 709) Cr. 200 (40)	SAW (A 709) Cr. 250 (50)
100 [200]	150 [300]	200 [400]	250 [500]

WELDING PROCEDURE

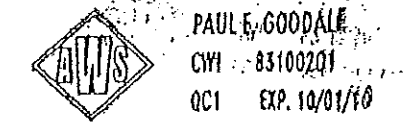
Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
AS REQ	5/32	600	30	19
		567	28	17
		70	31	21

Sec. 5-13
 AWS D1-5 Joint detail B-U3c-s
 MAX INTERPASS Temp. 450°F

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in applicable A. W. S. codes or contract specifications.

Procedure no. 206-5T of VT
 Revision no. 1-8-3-10

Contractor Lehigh Valley Steel
 Authorized By Paul E. Goodale
 Date 4-13-09



PAUL E. GOODALE
 CMI - 8310001
 OCT EXP. 10/31/10

RESUBMIT _____ APPROVED _____
 BY _____ DATE 9/10/10

For B-U3c-s only

Over	to	S ₁
2	2-1/2	1-3/8
2-1/2	3	1-3/4
3	3-5/8	2-1/8
3-5/8	4	2-1/2
4	4-3/4	2-3/4
4-3/4	5-1/2	3
5-1/2	6-1/4	3-3/4

For T₁ > 8-1/4 or T₁ ≤ 2
 S₁ = 20 (T₁ - 14)

OK'D BY _____
 SEP 02 2010

VTRANS RECEIVED