

VT-05124

Contract # Duxbury STP 013-4(24)

WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS					
W2 - METRIC					
PROCEDURE SPECIFICATIONS					
MATERIAL SPECIFICATION	ASTM A709 GRADES: 250, 345, 345W				
WELDING PROCESS	SHIELDED METAL ARC WELDING				
MANUAL OR MACHINE	MANUAL				
POSITION OF WELDING	ALL (EXCEPT AS NOTED BELOW)				
FILLER METAL SPECIFICATION	AWS A5.1 AND A5.5				
WELD METAL CLASSIFICATION	E7018/E7028 (TACKING ONLY) AND E8018-C3				
WIRE/FLUX	D.N.A.				
POLARITY	DC+ OR AC				
ROOT TREATMENT	MANUAL CLEANING				
PREHEAT AND INTERPASS TEMPERATURE	SEE PREHEAT CHART				
ELECTRICAL STICK-OUT	D.N.A.				
SHIELDING GAS	D.N.A.				
				REVISED: 7/27/98	
				ORIGINAL ISSUE: 4/9/96	
WELDING PROCEDURE					
PASS NO.	WIRE SIZE (mm)	CURRENT RANGE		TRAVEL SPEED (mm/min)	JOINT DETAIL
		E7018			
		DC+	AC		
1	3.2	90-150	110-170	152-228	TACK WELDS
1	4.0	120-190	135-225	203-330	GROOVE ROOT PASSES AND TACK WELDS
PASS NO.	WIRE SIZE (mm)	CURRENT RANGE		TRAVEL SPEED (mm/min)	JOINT DETAIL
		E7028			(LIMITED TO FLAT AND HORIZONTAL TACK WELDS AND FLAT POSITION GROOVE ROOT PASSES)
		DC+	AC		
1	4.0	170-240	180-270	203-330	GROOVE ROOT PASSES AND TACK WELDS
PASS NO.	WIRE SIZE (mm)	CURRENT RANGE		TRAVEL SPEED (mm/min)	JOINT DETAIL
		E8018-C3			
		DC+	AC		
1	4.0	130-190	140-225	203-330	GROOVE ROOT PASSES, REPAIR WELDS AND TACKS
ALL	4.0	130-190	140-225	203-330	FILLET WELDS
ALL	4.8	180-270	210-290	228-381	FILLET WELDS (FLAT AND HORIZONTAL WELDS ONLY)
ALL	4.8	250-330	270-370	228-406	FILLET WELDS (FLAT AND HORIZONTAL WELDS ONLY)

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TRANS RECEIVED
 OK'D BY Juc 065 ss
 MAR 09 2006
 RESUBMIT APPROVED
 BY DATE 3/10/06