

VT-05124

Contract # Duxbury STP 013-4(24)

WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS
W34X - METRIC

PROCEDURE SPECIFICATIONS

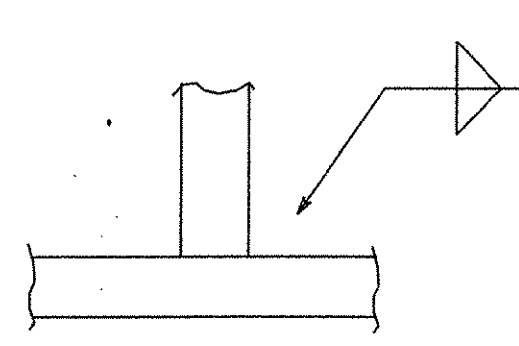
MATERIAL SPECIFICATION _____ ASTM A709 GRADES: 250, 345, 345W
WELDING PROCESS _____ SUBMERGED ARC WELDING
MANUAL OR MACHINE _____ SEMIAUTOMATIC OR MACHINE
POSITION OF WELDING _____ 2F
FILLER METAL SPECIFICATION _____ AWS A5.17
WELD METAL CLASSIFICATION _____ F7A2-EM12K
WIRE/FLUX _____ LINCOLN L61/761
WIRE DIAMETER _____ 2.4mm
SINGLE OR MULTIPLE ARC _____ SINGLE ARC
POLARITY _____ DC-
ROOT TREATMENT _____ MANUAL CLEANING
PREHEAT AND INTERPASS TEMPERATURE _____ SEE PREHEAT CHART
ELECTRICAL STICK-OUT _____ 25.4mm
SHIELDING GAS _____ D.N.A.

TRANS RECEIVED
 OK'D BY _____ OK'D BY *JWC*
 MAR 09 2006
 RESUBMIT _____ APPROVED _____
 DATE 3/10/06

REVISED: 5/5/03
 ORIGINAL ISSUE: 3/4/96

PASS NO.	WELDING CURRENT			TRAVEL SPEED (mm/m)	JOINT DETAIL
	AMPS	WIRE FEED SPEED	VOLTS		
1	360-440	2.9-3.7	29.0-36.0	279-686	8mm FILLET WELD

PRIMARY USE:
 STIFFENER TO WEB
 (AND OTHER APPLICATIONS AS NEEDED)



AWS D1.5 FWST T-TEST-10
 PROCEDURE QUALIFICATION RECORD AWS-FCM-02-4 (EXPIRES 6/27/07)
 PROCEDURE QUALIFICATION RECORD AWS-FCM-02-5A (EXPIRES 7/16/07)