

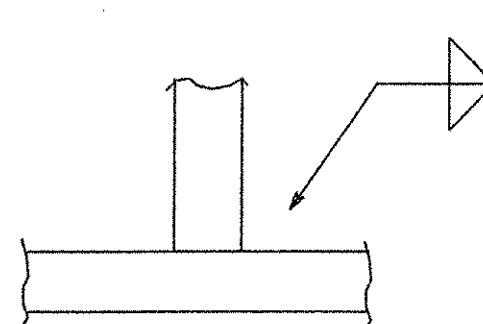
VT-05124

Contract # Duxbury STP 013-4(24)

| WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS | | | | |
|---|----------------------------------|--|--|------------------------|
| W44X - METRIC | | | | |
| PROCEDURE SPECIFICATIONS | | | | |
| MATERIAL SPECIFICATION | ASTM A709 GRADES: 250, 345, 345W | | | |
| WELDING PROCESS | SUBMERGED ARC WELDING | | | |
| MANUAL OR MACHINE | SEMI-AUTOMATIC OR MACHINE | | | |
| POSITION OF WELDING | 2F | | | |
| FILLER METAL SPECIFICATION | AWS A5.17 | | | |
| WELD METAL CLASSIFICATION | F702-EM12K | | | |
| WIRE/FLUX | LINCOLN L61/761 | | | |
| WIRE DIAMETER | 2.4mm | | | |
| SINGLE OR MULTIPLE ARC | SINGLE ARC | | | |
| POLARITY | DC- | | | |
| ROOT TREATMENT | MANUAL CLEANING BY | | | |
| PREHEAT AND INTERPASS TEMPERATURE | SEE PREHEAT CHART | | | |
| ELECTRICAL STICK-OUT | 25.4mm | | | |
| SHIELDING GAS | D.N.A. | | | |
| | | | | REVISD: 5/5/03 |
| WELDING PROCEDURE | | | | 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 FLANGE
(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)