

VT-05124

Contract # Duxbury STP 013-4(24)

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

MINIMUM PREHEAT AND INTERPASS TEMPERATURE

SHIELDED METAL-ARC WELDING WITH LOW  
HYDROGEN ELECTRODES, OR SUBMERGED ARC  
WELDING, OR FLUX CORED ARC WELDING

THICKNESS OF THICKEST PART AT POINT OF WELDING - (mm)	ASTM A-36, A-572, AND A-588 M103, M223, AND M222 ASTM A709, GRADE 36 (250) ASTM A709, GRADE 50 (345) ASTM A709, GRADE 50W (345W)
TO 19.1, INCL.	10°C
OVER 19.1 TO 38.1, INCL.	20°C
OVER 38.1 TO 63.5, INCL.	65°C
OVER 63.5	110°C

THE MAXIMUM PREHEAT TEMPERATURE SHALL NOT EXCEED 232°C.  
THE MAXIMUM INTERPASS TEMPERATURE SHALL NOT EXCEED 288°C.

REFER TO THE FOLLOWING CHART FOR EQUIVALENT STEEL TYPES.  
ASTM A-36 AND A-709 GRADE 36 AND AASHTO M103  
ASTM A-572 AND A-709 GRADE 50 AND AASHTO M223  
ASTM A-588 AND A-709 GRADE 50W AND AASHTO M222

CONTACT QUALITY CONTROL FOR PREHEAT REQUIREMENTS ON ANY STEEL  
NOT SPECIFICALLY NOTED ABOVE

REVISED:  
ORIGINAL ISSUE: 3/4/96