

VT-06215

Contract #BRF 0241 (29)

VTRANS
RECEIVED

Juc

WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS

W2

PROCEDURE SPECIFICATIONS

DEC 13 2006

RESUBMIT _____ APPROVED

DATE 12-21-06

MATERIAL SPECIFICATION _____ ASTM A709 Gr. 36, 50, 50W
 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 _____ REMOVE LOOSE RUST, SCALE AND CONTAMINANTS
 PREHEAT AND INTERPASS TEMPERATURE _____ SEE PREHEAT CHART
 ELECTRICAL STICK-OUT _____ D.N.A.
 SHIELDING GAS _____ D.N.A.

REVISED: 11/12/02

WELDING PROCEDURE

ORIGINAL ISSUE: 01/01/92

PASS NO.	WIRE SIZE	CURRENT RANGE E7018		TRAVEL IPM	JOINT DETAIL
		DC+	AC		
1	1/8	90-150	110-170	6-9	TACK WELDS
1	5/32	120-190	135-225	8-13	GROOVE ROOT PASSES AND TACK WELDS
PASS NO.	WIRE SIZE	CURRENT RANGE E7028		TRAVEL IPM	JOINT DETAIL (LIMITED TO FLAT AND HORIZONTAL TACK WELDS AND FLAT POSITION GROOVE ROOT PASSES)
		DC+	AC		
1	5/32	170-240	180-270	8-13	GROOVE ROOT PASSES AND TACK WELDS
PASS NO.	WIRE SIZE	CURRENT RANGE E8018-C3		TRAVEL IPM	JOINT DETAIL
		DC+	AC		
1	5/32	130-190	140-225	8-13	GROOVE ROOT PASSES, REPAIR WELDS AND TACKS
ALL	5/32	130-190	140-225	8-13	FILLET WELDS
ALL	3/16	180-270	210-290	9-15	FILLET WELDS (FLAT AND HORIZONTAL WELDS ONLY)
ALL	7/32	250-330	270-370	9-16	FILLET WELDS (FLAT AND HORIZONTAL WELDS ONLY)

* WELD SIZE DETERMINED BY TRAVEL SPEED