

VT-06215

Contract #BRF 0241 (29)

WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS

W6

PROCEDURE SPECIFICATIONS

MATERIAL SPECIFICATION \_\_\_\_\_ ASTM A709 Gr. 36, 50, 50W  
 WELDING PROCESS \_\_\_\_\_ FLUX CORED ARC WELDING  
 MANUAL OR MACHINE \_\_\_\_\_ SEMIAUTOMATIC OR MACHINE  
 POSITION OF WELDING \_\_\_\_\_ 1F, 2F, 3F, 4F  
 FILLER METAL SPECIFICATION \_\_\_\_\_ AWS A5.20  
 WELD METAL CLASSIFICATION \_\_\_\_\_ E71T-1  
 WIRE/FLUX \_\_\_\_\_ HOBART FORMULA XL 550  
 WIRE DIAMETER \_\_\_\_\_ .052"  
 SINGLE OR MULTIPLE ARC \_\_\_\_\_ SINGLE ARC  
 POLARITY \_\_\_\_\_ DC+  
 ROOT TREATMENT \_\_\_\_\_ REMOVE LOOSE RUST, SCALE, AND CONTAMINANTS  
 PREHEAT AND INTERPASS TEMPERATURE \_\_\_\_\_ SEE PREHEAT CHART  
 ELECTRICAL STICK-OUT \_\_\_\_\_ 3/4"  
 SHIELDING GAS \_\_\_\_\_ 100% CO2

VTRANS  
RECEIVED

OK'D BY \_\_\_\_\_ OK'D BY *Jwc*  
 DEC 13 2006  
 RESUBMIT \_\_\_\_\_ APPROVED ✓  
 BY \_\_\_\_\_ DATE 12-21-06

REVISED:

ORIGINAL ISSUE: 5/3/06

WELDING PROCEDURE

PASS NO.	WELDING CURRENT			TRAVEL SPEED (IPM)	GAS FLOW	JOINT DETAIL
	AMPS	WIRE FEED SPEED	VOLTS			
1	225-250	285-335	25.0-27.0	14.75-16.5	40-50	ALL POSITION TACK WELDS

USED FOR:  
TACK WELDING STIFFENER TO WEB

PREHEAT NOT REQUIRED FOR TACK WELDS REMELTED BY THE SAW PROCESS

PROCEDURE QUALIFICATION RECORD AWS-06-02 (EXPIRES 4/27/11)