

VT-06215

Contract #BRF 0241 (29)

WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS
W13

PROCEDURE SPECIFICATIONS

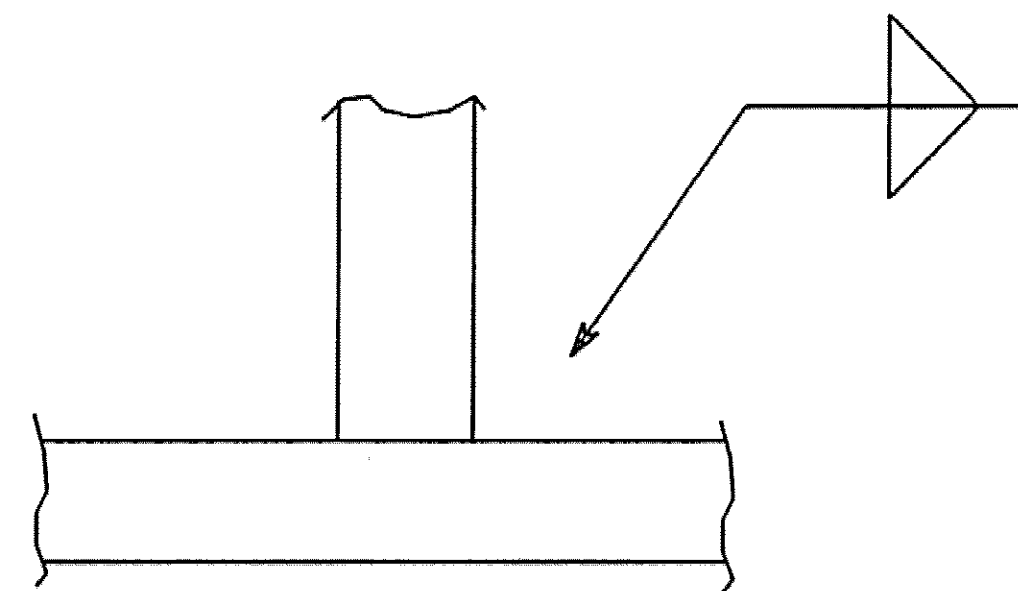
MATERIAL SPECIFICATION _____ ASTM A709 Gr. 36, 50, 50W
 WELDING PROCESS _____ SUBMERGED ARC WELDING
 MANUAL OR MACHINE _____ SEMIAUTOMATIC OR MACHINE **VTRAWS**
 POSITION OF WELDING _____ 2F **RECEIVED**
 FILLER METAL SPECIFICATION _____ AWS A5.17 **OK'D BY JWC**
 WELD METAL CLASSIFICATION _____ F7A2-EM12K **DEC 18 2006**
 WIRE/FLUX _____ LINCOLN L61/960 **RESUBMIT APPROVED**
 WIRE DIAMETER _____ 3/32" **DATE 12-21-06**
 SINGLE OR MULTIPLE ARC _____ SINGLE ARC
 POLARITY _____ DC-
 ROOT TREATMENT _____ REMOVE ALL MILL SCALE
 PREHEAT AND INTERPASS TEMPERATURE _____ SEE PREHEAT CHART
 ELECTRICAL STICK-OUT _____ 1 INCH
 SHIELDING GAS _____ D.N.A.

REVISED: 3/24/06
 ORIGINAL ISSUE: 2/1/00

WELDING PROCEDURE

PASS NO.	WELDING CURRENT			TRAVEL SPEED (IPM)	JOINT DETAIL
	AMPS	WIRE FEED SPEED	VOLTS		
1	405-550	131-195	34.5-39.5	15.5-25.0	5/16" FILLET WELDS

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



PROCEDURE QUALIFICATION RECORD AWS-03-7 (EXPIRES 2/4/08)
 PROCEDURE QUALIFICATION RECORD 06-01B (EXPIRES 3/24/11)