

VT-06215

Contract #BRF 0241 (29)

WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS

W43

PROCEDURE SPECIFICATIONS

MATERIAL SPECIFICATION \_\_\_\_\_ ASTM A709 Gr. 36, 50, 50W  
 WELDING PROCESS \_\_\_\_\_ SUBMERGED ARC WELDING  
 MANUAL OR MACHINE \_\_\_\_\_ SEMIAUTOMATIC OR MACHINE  
 POSITION OF WELDING \_\_\_\_\_ 2F  
 FILLER METAL SPECIFICATION \_\_\_\_\_ AWS A5.17  
 WELD METAL CLASSIFICATION \_\_\_\_\_ F7A2-EM12K  
 WIRE/FLUX \_\_\_\_\_ LINCOLN L61/761  
 WIRE DIAMETER \_\_\_\_\_ 3/32 "  
 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 \_\_\_\_\_ 1 INCH  
 SHIELDING GAS \_\_\_\_\_ D.N.A.

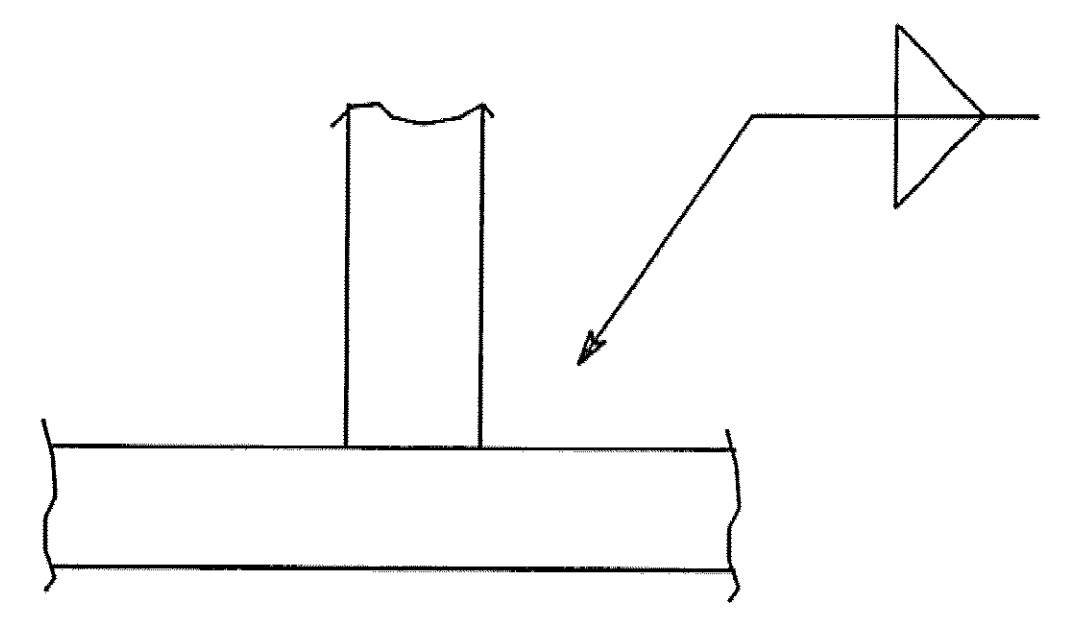
OK'D BY \_\_\_\_\_ (APPROVED) **JWC**  
 DEC 13 2006  
 RESUBMIT \_\_\_\_\_ (APPROVED) ✓  
 BY \_\_\_\_\_ DATE **12-21-06**

REVISED: 12/10/02  
 ORIGINAL ISSUE: 2/1/00

WELDING PROCEDURE

PASS NO.	WELDING CURRENT			TRAVEL SPEED (IPM)	JOINT DETAIL
	AMPS	WIRE FEED SPEED	VOLTS		
1	360-440	114-146	29.0-36.0	11.0-27.0	5/16" FILLET WELD

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



PROCEDURE QUALIFICATION RECORD AWS-FCM-02-4 (EXPIRES 6/27/07)  
 PROCEDURE QUALIFICATION RECORD AWS-FCM-02-5A (EXPIRES 7/16/07)