

VT-06215

Contract #BRF 0241 (29)

WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS

W71X-2

PROCEDURE SPECIFICATIONS

MATERIAL SPECIFICATION _____ ASTM A709 Gr. 36, 50, 50W
 WELDING PROCESS _____ SUBMERGED ARC WELDING
 MANUAL OR MACHINE _____ SEMIAUTOMATIC OR MACHINE
 POSITION OF WELDING _____ 1G
 FILLER METAL SPECIFICATION _____ AWS A5.23
 WELD METAL CLASSIFICATION _____ F8A2-ENI1K-N11-H8
 WIRE/FLUX _____ LINCOLN LA-75/960
 WIRE DIAMETER _____ 3/32 "
 SINGLE OR MULTIPLE ARC _____ SINGLE ARC
 POLARITY _____ DC+
 ROOT TREATMENT _____ GRIND TO SOUND METAL AFTER BACKGOUGE
 PREHEAT AND INTERPASS TEMPERATURE _____ SEE PREHEAT CHART
 ELECTRICAL STICK-OUT _____ 1 INCH
 SHIELDING GAS _____ D.N.A.

VTRANS
RECEIVED

OK'D BY _____ OK'D BY JWC

DEC 19 2006

RESUBMIT _____ APPROVED ✓

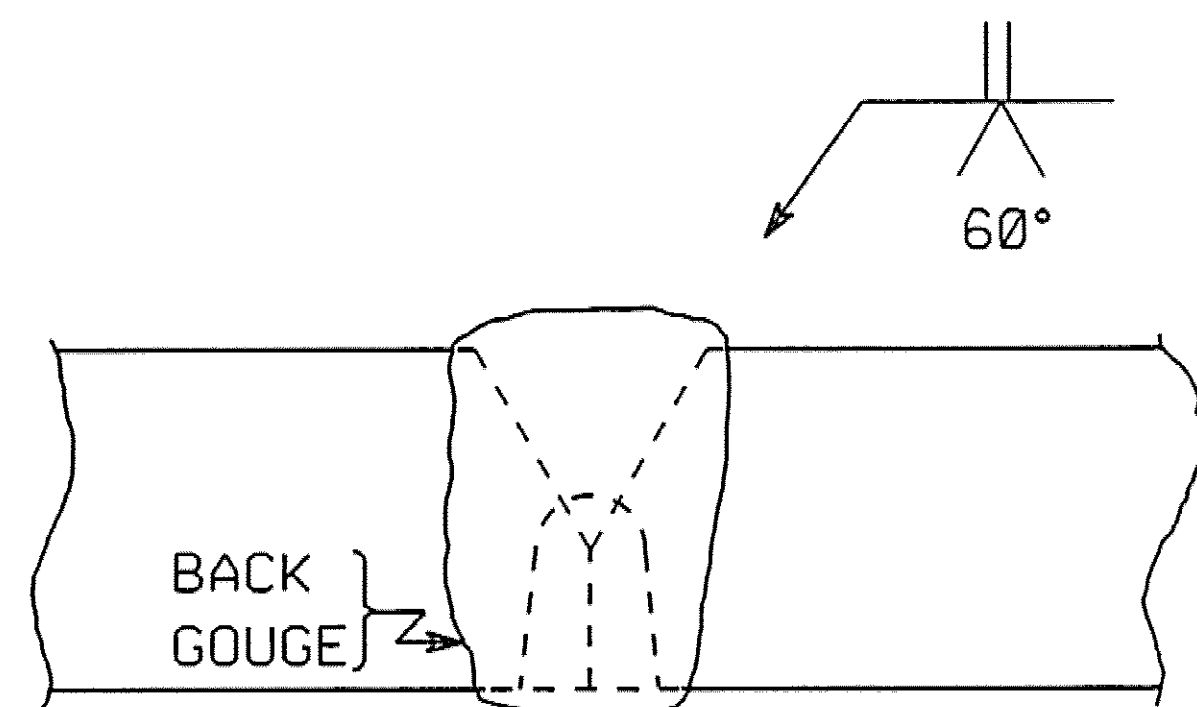
BY _____ DATE 12-21-06

REVISED:

ORIGINAL ISSUE: 3/10/03

WELDING PROCEDURE

| PASS NO. | WELDING CURRENT | | | TRAVEL SPEED (IPM) | JOINT DETAIL |
|----------|-----------------|-----------------|-----------|--------------------|--------------|
| | AMPS | WIRE FEED SPEED | VOLTS | | |
| ALL | 448-550 | 92-125 | 31.0-38.0 | 15.0-25.0 | B-L2c-S |



PROCEDURE QUALIFICATION RECORD AWS-04-1 (EXPIRES 4/29/09)
 PROCEDURE QUALIFICATION RECORD AWS-04-2 (EXPIRES 2/2/09)