

VT-06215

Contract #BRF 0241 (29)

WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS

W71X-2R - AC

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-NI1-H8  
 WIRE/FLUX \_\_\_\_\_ LINCOLN LA-75/960  
 WIRE DIAMETER \_\_\_\_\_ 3/32 "  
 SINGLE OR MULTIPLE ARC \_\_\_\_\_ SINGLE ARC  
 POLARITY \_\_\_\_\_ AC (SEE RESTRICTIONS BELOW)  
 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**  
 DEC 19 2006  
 DATE 12-21-06

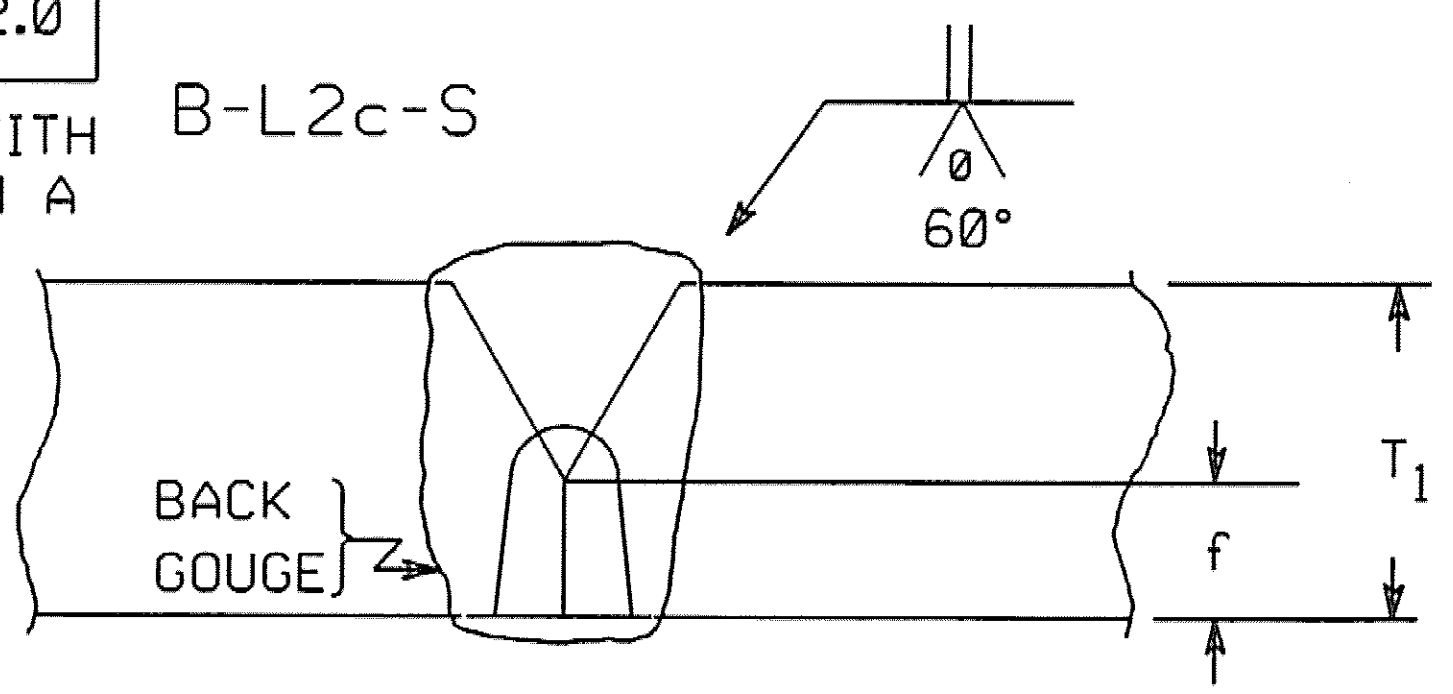
REVISED:

ORIGINAL ISSUE: 5/5/03

WELDING PROCEDURE

PASS NO.	WELDING CURRENT			TRAVEL SPEED (IPM)	JOINT DETAIL
	AMPS	WIRE FEED SPEED	VOLTS		
ALL	416-670	92-205	30.0-36.0	16.0-22.0	

NOTE: THIS PROCEDURE SHALL ONLY BE USED WITH 1000 AMP SQUAREWAVE AC POWER SOURCE WITH A FREQUENCY OF 60HZ AND A 66/34 (DC+/DC-) POLARITY BALANCE PLUG.



THE MAXIMUM WELDING CURRENT TO BE USED IN MAKING A GROOVE WELD FOR ANY PASS THAT HAS FUSION TO BOTH FACES OF THE GROOVE SHALL BE 600 AMPS / 171 WIRE FEED SPEED.

PROCEDURE QUALIFICATION RECORD AWS-03-9 (EXPIRES 4/24/08)  
 PROCEDURE QUALIFICATION RECORD AWS-03-11 (EXPIRES 7/24/08)