

VT-06215

Contract #BRF 0241 (29)

VTRANS
RECEIVED

MINIMUM PREHEAT AND INTERPASS TEMPERATURE OK'D BY _____ OK'D BY JWC

DEC 18 2006

SHIELDED METAL-ARC WELDING WITH LOW RESUBMIT _____ APPROVED
HYDROGEN ELECTRODES, OR SUBMERGED ARC BY _____ DATE 12-21-06
WELDING, OR FLUX CORED ARC WELDING

| THICKNESS OF THICKEST PART AT POINT OF WELDING - INCHES | ASTM A-36, A-572, AND A-588 M183, M223, AND M222 ASTM A709, GRADE 36 ASTM A709, GRADE 50 ASTM A709, GRADE 50W |
|---|---|
| TO 3/4, INCL. | 50° F |
| OVER 3/4 TO 1 1/2, INCL. | 70° F |
| OVER 1 1/2 TO 2 1/2, INCL. | 150° F |
| OVER 2 1/2 | 225° F |

MAXIMUM PREHEAT TEMPERATURE SHALL NOT EXCEED 450°F
MAXIMUM INTERPASS TEMPERATURE SHALL NOT EXCEED 550°F

REFER TO THE FOLLOWING CHART FOR EQUIVALENT STEEL TYPES.

ASTM A-36 AND A-709 GRADE 36 AND AASHTO M183

ASTM A-572 AND A-709 GRADE 50 AND AASHTO M223

ASTM A-588 AND A-709 GRADE 50W AND AASHTO M222

CONTACT QUALITY CONTROL FOR PREHEAT REQUIREMENTS ON ANY STEEL

NOT SPECIFICALLY NOTED ABOVE

REVISED: 12/10/02

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