

VT-06062 Contract #BHF 0200 (9), Bridge #36 Improvement

WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS				
W2 - METRIC				
PROCEDURE SPECIFICATIONS				
MATERIAL SPECIFICATION	ASTM A709 GRADES: 250, 345, 345W			
WELDING PROCESS	SHIELDED METAL ARC WELDING			
MANUAL OR MACHINE	MANUAL			
POSITION OF WELDING	ALL (EXCEPT AS NOTED BELOW)			
FILLER METAL SPECIFICATION	AWS A5.1 AND A5.5			
WELD METAL CLASSIFICATION	E7018/E7028 (TACKING ONLY) AND E8018-C3			
WIRE/FLUX	D.N.A.			
POLARITY	DC+ OR AC			
ROOT TREATMENT	MANUAL CLEANING			
PREHEAT AND INTERPASS TEMPERATURE	SEE PREHEAT CHART			
ELECTRICAL STICK-OUT	D.N.A.			
SHIELDING GAS	D.N.A.			
WELDING PROCEDURE				REVISED: 7/27/98
WELDING PROCEDURE				ORIGINAL ISSUE: 4/9/96

PASS NO.	WIRE SIZE (mm)	CURRENT RANGE E7018		TRAVEL SPEED (mm/min)	JOINT DETAIL
		DC+	AC		
1	3.2	90-150	110-170	152-228	TACK WELDS
	4.0	120-190	135-225	203-330	GROOVE ROOT PASSES AND TACK WELDS
PASS NO.	WIRE SIZE (mm)	CURRENT RANGE E7028		TRAVEL SPEED (mm/min)	JOINT DETAIL (LIMITED TO FLAT AND HORIZONTAL TACK WELDS AND FLAT POSITION GROOVE ROOT PASSES)
		DC+	AC		
1	4.0	170-240	180-270	203-330	GROOVE ROOT PASSES AND TACK WELDS
PASS NO.	WIRE SIZE (mm)	CURRENT RANGE E8018-C3		TRAVEL SPEED (mm/min)	JOINT DETAIL
		DC+	AC		
1	4.0	130-190	140-225	203-330	GROOVE ROOT PASSES, REPAIR WELDS AND TACKS
ALL	4.0	130-190	140-225	203-330	FILLET WELDS
ALL	4.8	180-270	210-290	228-381	FILLET WELDS (FLAT AND HORIZONTAL WELDS ONLY)
ALL	4.8	250-330	270-370	228-406	FILLET WELDS (FLAT AND HORIZONTAL WELDS ONLY)

* WELD SIZE DETERMINED BY TRAVEL SPEED

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TRANS RECEIVED
 DATE: 9-12-06
 BY: JUC
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