

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

WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS					
W6-METRIC					
PROCEDURE SPECIFICATIONS					
MATERIAL SPECIFICATION	ASTM A709 GRADES: 250, 345, 345W				
WELDING PROCESS	FLUX CORE ARC WELDING				
MANUAL OR MACHINE	SEMI-AUTOMATIC OR MACHINE				
POSITION OF WELDING	1F, 2F, 3F, 4F				
FILLER METAL SPECIFICATION	AWS A5.20				
WELD METAL CLASSIFICATION	E71T-1				
WIRE/FLUX	HOBART FORMULA XL 550 (H4)				
WIRE DIAMETER	1.4 mm				
SINGLE OR MULTIPLE ARC	SINGLE ARC				
POLARITY	DC+				
ROOT TREATMENT	MANUAL CLEANING				
PREHEAT AND INTERPASS TEMPERATURE	SEE PREHEAT CHART*				
ELECTRICAL STICK-OUT	19.1 mm				
SHIELDING GAS	100% CO2				
WELDING PROCEDURE				REVISED:	
				ORIGINAL ISSUE: 5/3/06	
PASS NO.	AMPS	VOLTS	TRAVEL SPEED (mm/MIN.)	GAS FLOW (L/MIN.)	JOINT DETAIL
ALL	225-250	25.0-27.0	375-419	19-24	ALL POSITION TACK WELDS
<p>USED FOR:</p> <p>ALL POSITION TACK WELDS</p> <p>PREHEAT NOT REQUIRED FOR TACK WELDS REMELTED BY THE SAW PROCESS</p> <p>PROCEDURE QUALIFICATION RECORD AWS-06-02 (EXPIRES 4/27/11)</p>					

RECEIVED
 VTRAPS
 DATE: 9-13-06
 BY: [Signature]

04955