

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

WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS  
W44X - METRIC

PROCEDURE SPECIFICATIONS

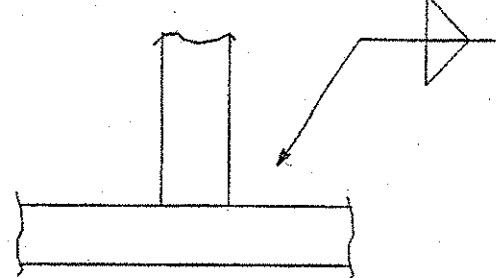
MATERIAL SPECIFICATION \_\_\_\_\_ ASTM A709 GRADES: 250, 345, 345W  
 WELDING PROCESS \_\_\_\_\_ SUBMERGED ARC WELDING  
 MANUAL OR MACHINE \_\_\_\_\_ SEMIAUTOMATIC OR MACHINE  
 POSITION OF WELDING \_\_\_\_\_ 2F  
 FILLER METAL SPECIFICATION \_\_\_\_\_ AWS A5.17  
 WELD METAL CLASSIFICATION \_\_\_\_\_ F7A2-EM12K  
 WIRE/FLUX \_\_\_\_\_ LINCOLN L61/761  
 WIRE DIAMETER \_\_\_\_\_ 2.4mm  
 SINGLE OR MULTIPLE ARC \_\_\_\_\_ SINGLE ARC  
 POLARITY \_\_\_\_\_ DC-  
 ROOT TREATMENT \_\_\_\_\_ MANUAL CLEANING  
 PREHEAT AND INTERPASS TEMPERATURE \_\_\_\_\_ SEE PREHEAT CHART  
 ELECTRICAL STICK-OUT \_\_\_\_\_ 25.4mm  
 SHIELDING GAS \_\_\_\_\_ D.N.A.

VTRAWS  
RECEIVED  
SEP 12 2006  
JWC

REVISED: 5/5/03  
ORIGINAL ISSUE: 3/4/96

| PASS NO. | WELDING CURRENT |                 |           | TRAVEL SPEED (mm/m) | JOINT DETAIL    |
|----------|-----------------|-----------------|-----------|---------------------|-----------------|
|          | AMPS            | WIRE FEED SPEED | VOLTS     |                     |                 |
| 1        | 360-440         | 2.9-3.7         | 29.0-36.0 | 279-686             | 8mm FILLET WELD |

PRIMARY USE:  
STIFFENER TO FLANGE  
(AND OTHER APPLICATIONS AS NEEDED)



AWS D1.5 FWST T-TEST-10  
 PROCEDURE QUALIFICATION RECORD AWS-FCM-02-4 (EXPIRES 6/27/07)  
 PROCEDURE QUALIFICATION RECORD AWS-FCM-02-5A (EXPIRES 7/16/07)