

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

VTTRANS
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BY JWC

MINIMUM PREHEAT AND INTERPASS TEMPERATURE

SHIELDED METAL-ARC WELDING WITH LOW
HYDROGEN ELECTRODES, OR SUBMERGED ARC
WELDING, OR FLUX CORED ARC WELDING

THICKNESS OF THICKEST PART AT POINT OF WELDING - (mm)	ASTM A-36, A-572, AND A-588 M183, M223, AND M222 ASTM A709, GRADE 36 (250) ASTM A709, GRADE 50 (345) ASTM A709, GRADE 50W (345W)
TO 19.1, INCL.	10°C
OVER 19.1 TO 38.1, INCL.	20°C
OVER 38.1 TO 63.5, INCL.	65°C
OVER 63.5	110°C

THE MAXIMUM PREHEAT TEMPERATURE SHALL NOT EXCEED 232°C.
THE MAXIMUM INTERPASS TEMPERATURE SHALL NOT EXCEED 280°C.

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

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