



JOINT WELDING PROCEDURE

Material Specification: A709Gr36(Gr250); A709Gr50(Gr345); A709Gr50W(Gr345W)
304 SS; 316SS

Welding process: GTAW Position of welding: 2F Manual or Machine: MANUAL

Filler metal specification: A5.9 Filler metal classification: ER309L (Lincoln)

Flux: N/A Shielding gas: 100% Argon Flow rate: 20 CFH

Single or multiple pass: SINGLE Single or multiple arc: SINGLE ESO: N/A

Welding current: DC Polarity: STRAIGHT Welding progression: STRINGER

Preheat and interpass temperature: SEE NOTE BELOW (NO PREHEAT OF STAINLESS STEEL)
A709Gr36(Gr250); A709Gr50(Gr345); A709Gr50W(Gr345W):
To 3/4" Include. (19 mm) = 50°F ; Over 3/4" to 1.5" Include. (19 to 38mm) = 70°F
Over 1.5" to 2.5" Incl. (38 to 63.5mm) = 150°F; Over 2.5" (63.5mm) = 225°F.
Root Treatment: Clean to bright sound metal.

Pass No.	Electrode Size	Welding Current Amps	Voltage	Travel Speed in.(mm)/min.	Weld Size "S" (Material thickness)
1	1/8(3 MM)	130 - 160	10 - 12	4(102) - 7(177)	20 GA. (SEAL)
1	1/8(3 MM)	130 - 160	10 - 12	4(102) - 7(177)	16GA. (1.5MM)
1	1/8(3 MM)	130 - 160	10 - 12	4(102) - 7(177)	14GA. (1.9MM)
1	1/8(3 MM)	130 - 160	10 - 12	4(102) - 7(177)	12GA. (2.7MM)
1	1/8(3 MM)	130 - 160	10 - 12	4(102) - 7(177)	11GA. (3.0MM)
1	1/8(3 MM)	130 - 160	10 - 12	4(102) - 7(177)	10GA. (3.4MM)

Notes:
T1 = VARIES

"S" FILLET WELD LEG SIZE SHALL NOT EXCEED THICKNESS OF STAINLESS STEEL.

NO PREHEAT REQUIRED ON THE STAINLESS STEEL MATERIAL.

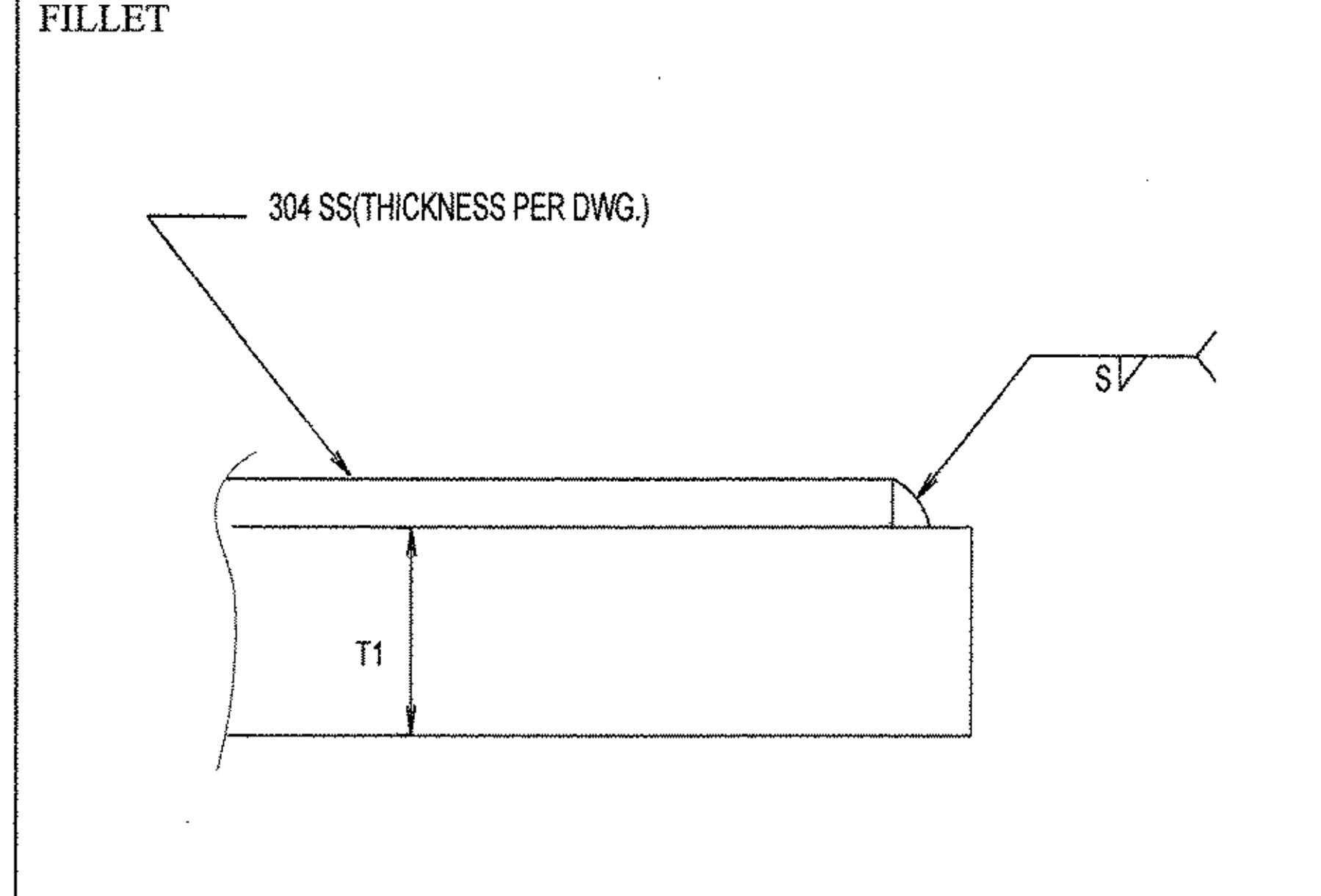
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CK'D BY _____ OK'D BY JWC

FEB 22 2007

RESUBMIT _____ APPROVED

BY _____ DATE 2-23-07



This procedure may vary due to fabrication sequence, fit-up, pass size, etc. within limitation of variables given in the AWS/AASHTO/ D1.1 Structural Welding Code and/or the D1.5 Bridge Welding Code (as applicable).

Procedure No.: (NB)GTF-01 Revision No.: 02 Date: March 21, 2003

Project: _____ DSB Job No.: _____

Prepared By: James R. Connor DSB QA Manager

Authorized by: _____

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