

VERMONT
AGENCY OF TRANSPORTATION
JUNTINGTON
PROJECT BRO 1445(29)

COSMEC INC.

WELDING PROCEDURE SPECIFICATION

SPECIFICATIONS AND CODE: D1.9
MATERIAL SPECIFICATION ASTM A240 TYPE 304 TO ASTM A709 GR 50W
WELDING PROCESS GTAW
MANUAL OR MACHINE MANUAL
POSITION OF WELDING 1F & 2F
FILLER METAL SPECIFICATION ER309L CLASSIFICATION: A5.9
MANUFACTURER: HARRIS WELCO TRADENAME:
FLUX INTERNAL FLOW RATE 45 CFH
SHIELDING GAS ARGON
SINGLE OR MULTIPLE PASSES SINGLE
SINGLE OR MULTIPLE ARC SINGLE
WELDING CURRENT DC
POLARITY: REVERSE (EN)
WELDING PROGRESSION
ROOT TREATMENT CLEANED & PREPARED BRIGHT METAL
PREHEAT AND INTERPASS TEMPERATURE SEE BELOW
POSTHEAT TEMPERATURE N/A
HEAT INPUT MIN. MAX.

WELDING PROCEDURE

PASS NO.	ELECTRODE SIZE	WELDING CURRENT AMPERES	TRAVEL SPEED	JOINT DETAIL
ALL	3/32"	130-155 14-17	6.75-8.5	LAP JOINT

PREHEAT TEMPS. ***PREHEAT UNTIL NO MOSITURE PRESENT
THICKNESS | TEMP.
UP TO 3/4" | 100 DEG.
OVER 3/4" TO 1 1/2" | 100 DEG.
OVER 1 1/2" TO 2 1/2" | 100 DEG.
OVER 2 1/2" | 100 DEG.

THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT-UP, PASS SIZE, ETC.
WITHIN THE LIMITATION OF VARIABLES GIVEN IN SECTION 5.
SUPPORTING PQR: GTAW-WF-05
PROCEDURE NO. GTAW-WF

CONTRACTOR: COSMEC INC.
AUTHORIZED BY: DONALD VOSE
CW#01100651 *Donald Vose*
REVISION NO. 1

DATE: 2/1/2005

TRANS RECEIVED
OK'D BY *JWC*
DEC 14 2006
RESUBMIT APPROVED
BY DATE 11-18-06
066 BB

