DSBROWN

Production Joint Welding Procedure Specification (D1.5-02)

Procedure No: A-GTF-01 Date Issued: 1-9-04 Revision No: 0 Rev. Date: _____

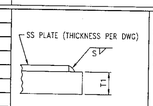
Contractor (Fabricator) D.S. Brown Company Prepared by: James R. Connor, Quality Assurance Manager

1. Non-Fracture Critical [X] Fracture Critical [ ] WPS Expiration Date: _____
2. Qualified in accordance with: AWS D1.5- 2002 , AWS D1.6-99
   Referenced PQR No(s). PQR-GTAW-01-(03) __ , __ , __
   Referenced FWST No(s). PQR-GTAW-01(03) , _____ , __ , __
3. Material specification(s) ASTM A709 Gr. 36, 50, 50W, 304SS, 316SS
4. Material Thickness (es) Unlimited
5. Welding process GTAW
6. Manual [X] , machine [ ] , or semiautomatic [ ]
7. Position(s) of welding 1F, 2F
8. Filler metal specification AWS A5.9
9. Filler metal class and brand name ER309L (Murrex)
10. Flux class & brand N/A , Type N/A
11. Shielding gas 100% Argon Flow rate 20 CFH
12. Single pass [X] Or multiple pass [ ]
13. Single arc [X] Or multiple arc [ ]
14. Welding Current DCEN
15. Polarity Straight
16. Welding progression stringers
17. Root treatment Clean to bright sound metal or per AWS D1.5 (3.2.1 & 3.11)
18. Postheat treatment N/A
19. Calculated Heat Input (KJ/In) Min 10.9 KJ Max 20.4 KJ
20. Electrode extension (electrical stickout) N/A

For DOT Approval

VTRANS
RECEIVED
OK'D BY _____ OK'D BY JLK
FEB 04 2009
R ___ APPROVED
BY DATE 02/11/09

Weld size (in)	Pass No(s)	Electrode Size (in)	Welding Process Variables AMPS/WFS*	VOLTS	Travel Speed (IPM)	Joint Detail (Flare Bevel) Show all dimensions, weld sizes, passes, and AWS symbols
20 ga.	1	1/8"	170-200	15-17	10-14	
16 ga.	1	1/8"	170-200	15-17	10-14	
14 ga.	1	1/8"	170-200	15-17	10-14	
12 ga.	1	1/8"	170-200	15-17	10-14	
11 ga.	1	1/8"	170-200	15-17	10-14	
10 ga.	1	1/8"	170-200	15-17	10-14	
8 ga.	1	1/8"	170-200	15-17	10-14	
3/16"	1	1/8"	170-200	15-17	10-14	



T_1 = Varies
S = Fillet Weld Size (Fillet weld must not exceed thickness of stainless steel)

* Wire feed speed may be used along with amperage (include chart)

Prepared By: James R. Connor DSB QA Manager

Project: _____

DSB Job: 25598-1106-VT

Preheat and Interpass Temperature Chart		
Base Metal Thickness range	Minimum Preheat (°F)	Max Preheat & Interpass (°F)
= 3/4"	50°F	450 °F
>3/4" to =1.5"	70°F	450 °F
>1.5" to =2.5"	150°F	450 °F
>2.5"	225°F	450 °F

Note: When this procedure is used for A709Gr50W materials, it shall be limited to 5/16" single pass or material be coated.