

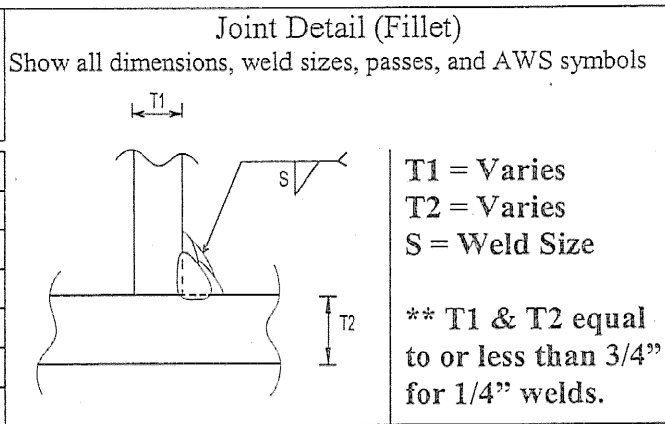
DSBROWN Production Joint Welding Procedure Specification (D1.5-02)

Procedure No: A-(MC)GP-01 Date Issued: 9-28-04 Revision No: 0 Rev. Date: _____
 Contractor (Fabricator) D. S. Brown Company Prepared by: James R. Connor, Quality Assurance Manager

- Non-Fracture Critical Fracture Critical WPS Expiration Date: _____
- Qualified in accordance with: AWS D1.5-2002 (5.12.1)
 Referenced PQR No(s): PQR-(MCGMAW-01(04))
 Referenced FWST No(s): PQR-(MCGMAW-FWST-01A(04)), PQR-(MCGMAW-FWST-01B(04))
- Material specification(s) ASTM A709 Gr. 36, 50, 50W
- Material Thickness (es) Unlimited
- Welding process GMAW
- Manual , machine , or semiautomatic
- Position(s) of welding 1F, 2F
- Filler metal specification AWS A5.18
- Filler metal class and brand name E70C-6M Corex Metal-Core Maxim
- Flux class & brand N/A, Type N/A
- Shielding gas 75% Ar / 25% CO2 Flow rate 45 CFH
- Single pass Or multiple pass
- Single arc Or multiple arc
- Welding Current DCEP
- Polarity Reverse
- Welding progression stringers
- Root treatment Clean to bright sound metal or per AWS D1.5 (3.2.1 & 3.11)
- Postheat treatment N/A
- Calculated Heat Input (KJ/in) Min 30.6 KJ/in Max 51.1 KJ/in
- Electrode extension (electrical stickout) 3/4"

For DOT Approval
RECEIVED
 JUN 03 2008
 APPROVED: _____
 DATE 6/9/08

Weld Size (in)	Pass No(s)	Electrode Size (in)	Welding Process Variables		Travel Speed (IPM)
			AMPS/WFS*	VOLTS	
**1/4"	1	.052"	265-320	31-34.5	13-16
5/16"	1	.052"	265-320	31-34.5	13-16
3/8"	1-3	.052"	265-320	31-34.5	13-16
7/16"	2-4	.052"	265-320	31-34.5	13-16
1/2"	4-6	.052"	265-320	31-34.5	13-16
5/8"	5-7	.052"	265-320	31-34.5	13-16
3/4"	6-8	.052"	265-320	31-34.5	13-16



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

Prepared By: <u>James R. Connor</u> DSB QA Manager	Preheat and Interpass Temperature Chart	
	Minimum Preheat (°F)	Max Preheat & Interpass (°F)
Project: _____	≤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 A709G50W materials, it shall be limited to 5/16" single pass or material be coated.