

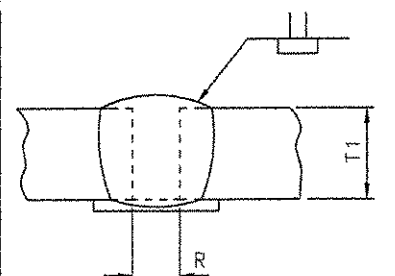
DSBROWN Production Joint Welding Procedure Specification (D1.5-02)

Procedure No: A-(MC)GB-122 Date Issued: 11-30-04 Revision No: 0 Rev. Date: _____
 Contractor (Fabricator) D. S. Brown Company Prepared by: James R. Connor, Quality Assurance Manager

2. Qualified in accordance with: AWS D1.5:2002 (5.12.1)
 Referenced PQR No(s): PQR-(MC)GMAW-01(04)
 Referenced FWST No(s): N/A

3. Material specification(s) ASTM A709 Gr. 36, 50, 50W, A500B Tube For DOT Approval
 4. Material Thickness (es) Unlimited
 5. Welding process GMAW
 6. Manual , machine , or semiautomatic
 7. Position(s) of welding 1G
 8. Filler metal specification AWS A5.18
 9. Filler metal class and brand name E70C-6M Corex Metal-Core Maxim
 10. Flux class & brand N/A, Type N/A
 11. Shielding gas 75% Ar / 25% CO2 Flow rate 45 CFH
 12. Single pass Or multiple pass
 13. Single arc Or multiple arc
 14. Welding Current DCEP
 15. Polarity Reverse
 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 30.6 KJ/in Max 51.1 KJ/in
 20. Electrode extension (electrical stickout) 3/4"

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 APPROVED
 DATE 7-23-07

Weld size (in)	Pass (No(s))	Electrode Size (in)	Welding Process Variables		Travel Speed (in)	Joint Detail (Groove) Show all dimensions, weld sizes, passes, and AWS symbols
			AMPS/WFS*	VOLTS		
CJP	ALL	.052"	265-320	31-34.5	13-16	 <p>Notes: T1 = 3/8" (10mm) MAX R = 1/8" (3mm) MIN T1 MAX</p>
DO NOT REMOVE BACKING FROM TUBE SPLICES CCS Constructors LLC 138 Munson Avenue Morrisville, VT 05661 Ph: 802-888-7701 f: 802-888-4746						

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

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

Prepared By: James R. Connor DSB QA Manager
 Project: Route No. TH 7/11, CL3
 DSB Job: 20388-1206

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

074-BRWP