

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

Procedure No: A-(MC)GFB-01 Date Issued: 8-14-06 Revision No: 0 Rev. Date: _____
 Contractor (Fabricator) D. S. Brown Company Prepared by: James R. Connor, Quality Assurance Manager
 1. Non-Fracture Critical Fracture Critical WPS Expiration Date: _____
 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): PQR-(MC)GMAW-FWST-01A(04), PQR-(MC)GMAW-FWST-01B(04)
 3. Material specification(s) ASTM A709 Gr. 36, 50, 50W, CF1018, CF1040, A615 For DOT Approval
 4. Material Thickness (es) Unlimited
 5. Welding process GMAW
 6. Manual , machine , or semiautomatic
 7. Position(s) of welding 1G, 2G
 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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Weld Size (in)	Pass No(s)	Eutectic Shield (in)	Welding Process Variables		Travel Speed (IPM)	Tapered Bevel
			AMPS/WFS*	VOLTS		
**1/4"	1	.052"	265-320	31-34.5	13-16	<p>Joint Detail (Flare Bevel) Show all dimensions, weld sizes, passes, and AWS symbols</p> <p>T₁ = UNLIMITED T₂ = RB (Type and Dia. per dwg.) R = 0 Bevel = NATURAL S = WELD SIZE</p>
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		
	Base Metal Thickness range	Minimum Preheat (°F)	Max Preheat & Interpass (°F)
Project: <u>Route No. TH 7/11, CL3</u> DSB Job: <u>20388-1206</u>	≤ 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.

075-RLWP