

Proj #: BRZ-1444 (23)

COSMEC INC.

WELDING PROCEDURE SPECIFICATION

SPECIFICATIONS AND CODE: D1.6
 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 PAS S 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	VOLTS	TRAVEL SPEED	JOINT DETAIL
ALL	3/32"	130-155	14-17	6.75-8.5	LAP JOINT

16 GA THRU 10 GA
 BM THICKNESS

PREHEAT TEMPS. ***PREHEAT UNTIL NO MOSITURE PRESENT
 THICKNESS T 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
 REVISION NO. 1

CONTRACTOR: COSMEC INC.
 AUTHORIZED BY: DONALD VOSE
 CW#01100651 *Donald Vose*

DATE: 2/1/2005

TRANS RECEIVED
 OK'D BY: *JWC*



JUN 16 2008
 RESUBMIT APPROVED
 BY: DATE: *6/16/08*

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