

RECEIVED
 OK'D BY _____ OK'D BY *JWC*
 APR 03 2006
 RESUBMIT _____ APPROVED

VT-06001 Contract #BRO 1448(20)

WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS BY *WJC* DATE *4/19/06*

W2 - METRIC

PROCEDURE SPECIFICATIONS

MATERIAL SPECIFICATION _____ ASTM A709 GRADES: 250, 345, 345W
 WELDING PROCESS _____ SHIELDED METAL ARC WELDING
 MANUAL OR MACHINE _____ MANUAL
 POSITION OF WELDING _____ ALL (EXCEPT AS NOTED BELOW)
 FILLER METAL SPECIFICATION _____ AWS A5.1 AND A5.5
 WELD METAL CLASSIFICATION _____ E7018/E7028 (TACKING ONLY) AND E8018-C3
 WIRE/FLUX _____ D.N.A.
 POLARITY _____ DC+ OR AC
 ROOT TREATMENT _____ MANUAL CLEANING
 PREHEAT AND INTERPASS TEMPERATURE _____ SEE PREHEAT CHART
 ELECTRICAL STICK-OUT _____ D.N.A.
 SHIELDING GAS _____ D.N.A.

REVISED: 7/27/98
 ORIGINAL ISSUE: 4/9/96

WELDING PROCEDURE

PASS NO.	WIRE SIZE (mm)	CURRENT RANGE E7018		TRAVEL SPEED (mm/min)	JOINT DETAIL
		DC+	AC		
1	3.2	90-150	110-170	152-228	TACK WELDS
1	4.0	120-190	135-225	203-330	GROOVE ROOT PASSES AND TACK WELDS
PASS NO.	WIRE SIZE (mm)	CURRENT RANGE E7028		TRAVEL SPEED (mm/min)	JOINT DETAIL (LIMITED TO FLAT AND HORIZONTAL TACK WELDS AND FLAT POSITION GROOVE ROOT PASSES)
		DC+	AC		
1	4.0	170-240	180-270	203-330	GROOVE ROOT PASSES AND TACK WELDS
PASS NO.	WIRE SIZE (mm)	CURRENT RANGE E8018-C3		TRAVEL SPEED (mm/min)	JOINT DETAIL
		DC+	AC		
1	4.0	130-190	140-225	203-330	GROOVE ROOT PASSES, REPAIR WELDS AND TACKS
ALL	4.0	130-190	140-225	203-330	FILLET WELDS
ALL	4.8	180-270	210-290	228-381	FILLET WELDS (FLAT AND HORIZONTAL WELDS ONLY)
ALL	4.8	250-330	270-370	228-406	FILLET WELDS (FLAT AND HORIZONTAL WELDS ONLY)

* WELD SIZE DETERMINED BY TRAVEL SPEED