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 APR 03 2006  
 RESUBMIT \_\_\_\_\_ APPROVED

VT-06001 Contract #BRO 1448(20)

BY JWC DATE 4/10/06

WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS  
 W14X - METRIC

PROCEDURE SPECIFICATIONS

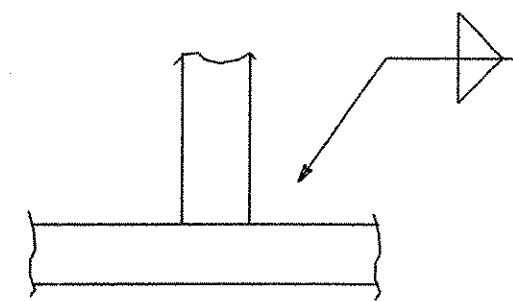
MATERIAL SPECIFICATION \_\_\_\_\_ ASTM A709 GRADES: 250, 345, 345W  
 WELDING PROCESS \_\_\_\_\_ SUBMERGED ARC WELDING  
 MANUAL OR MACHINE \_\_\_\_\_ SEMIAUTOMATIC OR MACHINE  
 POSITION OF WELDING \_\_\_\_\_ 2F  
 FILLER METAL SPECIFICATION \_\_\_\_\_ AWS A5.23  
 WELD METAL CLASSIFICATION \_\_\_\_\_ F8A2-ENI1K-N11-H8  
 WIRE/FLUX \_\_\_\_\_ LINCOLN LA-75/960  
 WIRE DIAMETER \_\_\_\_\_ 2.4mm  
 SINGLE OR MULTIPLE ARC \_\_\_\_\_ SINGLE ARC  
 POLARITY \_\_\_\_\_ DC-  
 ROOT TREATMENT \_\_\_\_\_ REMOVE ALL MILL SCALE  
 PREHEAT AND INTERPASS TEMPERATURE \_\_\_\_\_ SEE PREHEAT CHART  
 ELECTRICAL STICK-OUT \_\_\_\_\_ 25.4mm  
 SHIELDING GAS \_\_\_\_\_ D.N.A.

REVISED:

ORIGINAL ISSUE: 1/26/99

| PASS NO. | WELDING CURRENT |                 |           | TRAVEL SPEED (mm/m) | JOINT DETAIL    |
|----------|-----------------|-----------------|-----------|---------------------|-----------------|
|          | AMPS            | WIRE FEED SPEED | VOLTS     |                     |                 |
| 1        | 461-550         | 3.9-5.0         | 35.0-39.5 | 432-533             | 8mm FILLET WELD |

PRIMARY USE:  
 WEB TO FLANGE  
 (AND OTHER APPLICATIONS AS NEEDED)



AWS D1.5 FWST I-TEST-16  
 PROCEDURE QUALIFICATION RECORD AWS-05-01B (EXPIRES 6/26/10)