

VT-06001

Contract #BRO 1448(20)

CK'D BY: OK'D BY:

APR 03 2006

RESUBMIT: APPROVED:

DATE: 4/10/06

WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS
W44X - 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 A5.17
 WELD METAL CLASSIFICATION _____ F7A2-EM12K
 WIRE/FLUX _____ LINCOLN L61/761
 WIRE DIAMETER _____ 2.4mm
 SINGLE OR MULTIPLE ARC _____ SINGLE ARC
 POLARITY _____ DC-
 ROOT TREATMENT _____ MANUAL CLEANING
 PREHEAT AND INTERPASS TEMPERATURE _____ SEE PREHEAT CHART
 ELECTRICAL STICK-OUT _____ 25.4mm
 SHIELDING GAS _____ D.N.A.

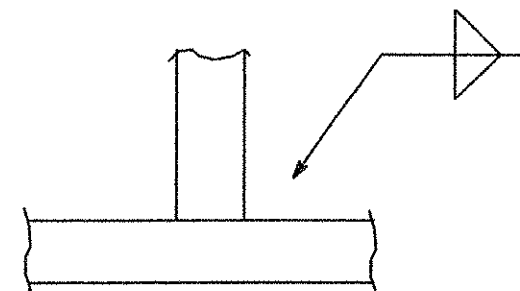
REVISED: 5/5/03

ORIGINAL ISSUE: 3/4/96

WELDING PROCEDURE

PASS NO.	WELDING CURRENT			TRAVEL SPEED (mm/m)	JOINT DETAIL
	AMPS	WIRE FEED SPEED	VOLTS		
1	360-440	2.9-3.7	29.0-36.0	279-686	8mm FILLET WELD

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



AWS D1.5 FWST T-TEST-10
 PROCEDURE QUALIFICATION RECORD AWS-FCM-02-4 (EXPIRES 6/27/07)
 PROCEDURE QUALIFICATION RECORD AWS-FCM-02-5A (EXPIRES 7/16/07)