

VT-06001

Contract #BRO 1448(20)

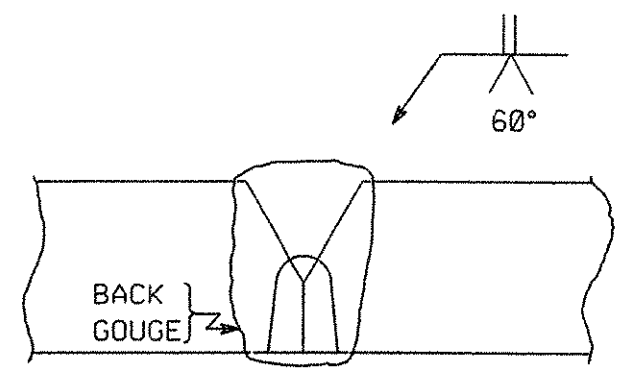
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WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS BY *one* DATE *4/10/06*
W71X-2 METRIC
 PROCEDURE SPECIFICATIONS

MATERIAL SPECIFICATION _____ ASTM A709 GRADES: 250, 345, 345W
 WELDING PROCESS _____ SUBMERGED ARC WELDING
 MANUAL OR MACHINE _____ SEMIAUTOMATIC OR MACHINE
 POSITION OF WELDING _____ 1G
 FILLER METAL SPECIFICATION _____ AWS A5.23
 WELD METAL CLASSIFICATION _____ F8A2-ENIK-N11-H8
 WIRE/FLUX _____ LINCOLN LA-75/960
 WIRE DIAMETER _____ 2.4 mm
 SINGLE OR MULTIPLE ARC _____ SINGLE ARC
 POLARITY _____ DC+
 ROOT TREATMENT _____ MANUAL CLEANING
 PREHEAT AND INTERPASS TEMPERATURE _____ SEE PREHEAT CHART
 ELECTRICAL STICK-OUT _____ 25.4 mm
 SHIELDING GAS _____ D.N.A.

REVISID: _____
 ORIGINAL ISSUE: 3/10/03

PASS NO.	AMPS	WIRE FEED SPEED (m/MIN.)	VOLTS	TRAVEL SPEED (mm/MIN.)	JOINT DETAIL
ALL	448-550	2.3-3.2	31.0-38.0	381-635	B-L2c-S



PROCEDURE QUALIFICATION RECORD AWS-04-1 (EXPIRES 4/29/09)
 PROCEDURE QUALIFICATION RECORD AWS-04-2 (EXPIRES 2/2/09)