

VT-06001

Contract #BRO 1448(20)

RECEIVED
 OK'D BY _____ OK'D BY *JWC*
 APR 03 2006
 RESUBMIT _____ APPROVED *✓*
 BY *JWC* DATE *4/10/06*

MINIMUM PREHEAT AND INTERPASS TEMPERATURE

SHIELDED METAL-ARC WELDING WITH LOW HYDROGEN ELECTRODES, OR SUBMERGED ARC WELDING, OR FLUX CORED ARC WELDING

THICKNESS OF THICKEST PART AT POINT OF WELDING - (mm)	ASTM A-36, A-572, AND A-588 M183, M223, AND M222 ASTM A709, GRADE 36 (250) ASTM A709, GRADE 50 (345) ASTM A709, GRADE 50W (345W)
TO 20, INCL.	10°C
OVER 20 TO 40, INCL.	20°C
OVER 40 TO 60, INCL.	65°C
OVER 60	110°C

THE MAXIMUM PREHEAT TEMPERATURE SHALL NOT EXCEED 232°C.
THE MAXIMUM INTERPASS TEMPERATURE SHALL NOT EXCEED 288°C.

REFER TO THE FOLLOWING CHART FOR EQUIVALENT STEEL TYPES.
ASTM A-36 AND A-709 GRADE 36 AND AASHTO M183
ASTM A-572 AND A-709 GRADE 50 AND AASHTO M223
ASTM A-588 AND A-709 GRADE 50W AND AASHTO M222

CONTACT QUALITY CONTROL FOR PREHEAT REQUIREMENTS ON ANY STEEL NOT SPECIFICALLY NOTED ABOVE

REVISED:
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