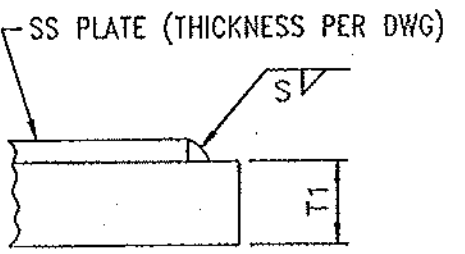


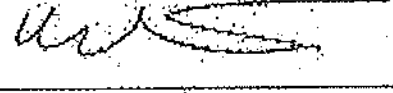
DSBROWN Production Joint Welding Procedure Specification (D1.5-08)

Procedure No: A-GTF-01 Date Issued: 1-9-04 Revision No: 01 Rev. Date: 5-15-09
Contractor (Fabricator) D.S. Brown Company Prepared by: Brad Streeter, Quality Assurance Manager

1. Non-Fracture Critical ☒ Fracture Critical ☐ WPS Expiration Date: _____
2. Qualified in accordance with: AWS D1.5- 2008 , AWS D1.6-07
Referenced PQR No(s). PQR-GTAW-01-(07)NY
Referenced FWST No(s). PQR-GTAW-01(03)
3. Material specification(s) ASTM A709 Gr. 36, 50, 50W, 304SS, 316SS For DOT Approval
4. Material Thickness (es) Unlimited
5. Welding process GTAW
6. Manual ☒ , machine ☐ , or semiautomatic ☐
7. Position(s) of welding 1F, 2F
8. Filler metal specification AWS A5.9
9. Filler metal class and brand name EK309L (Murrex)
10. Flux class & brand N/A , Type N/A
11. Shielding gas 100% Argon Flow rate 20 CFH
12. Single pass ☒ Or multiple pass ☐
13. Single arc ☒ Or multiple arc ☐
14. Welding Current DCEN
15. Polarity Straight
16. Welding progression stringers
17. Root treatment Clean to bright sound metal or per AWS D1.5 (3.2.1 & 3.11)
18. Postheat treatment N/A
19. Calculated Heat Input (KJ/In) Min 10.9 KJ Max 20.4 KJ
20. Electrode extension (electrical stickout) N/A

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Weld size (in)	Pass No(s)	Electrode Size (in)	Welding Process Variables		Travel Speed (IPM)	Travel Distance (in)	Joint Detail (Fillet Weld) Show all dimensions, weld sizes, passes, and AWS symbols
			AMPS/WFS*	VOLTS			
20 ga.	1	1/8"	170-200	15-17	12.6-15.4		 T₁ = Varies S = Fillet Weld Size (Fillet weld must not exceed thickness of stainless steel)
16 ga.	1	1/8"	170-200	15-17	12.6-15.4		
14 ga.	1	1/8"	170-200	15-17	12.6-15.4		
12 ga.	1	1/8"	170-200	15-17	12.6-15.4		
11 ga.	1	1/8"	170-200	15-17	12.6-15.4		
10 ga.	1	1/8"	170-200	15-17	12.6-15.4		
8 ga.	1	1/8"	170-200	15-17	12.6-15.4		
3/16"	1	1/8"	170-200	15-17	12.6-15.4		

* Wire feed speed may be used along with amperage (include chart) Prepared By:  DSB QA Manager Project: _____ DSB Job: 35029-1112	Preheat and Interpass Temperature Chart		
	Base Metal Thickness range	Minimum Preheat (°F)	Max Preheat & Interpass (°F)
	≤ 3/4"	50°F	450°F
	>3/4" to ≤1.5"	70°F	450°F
	>1.5" to ≤2.5"	150°F	450°F
	>2.5"	225°F	450°F

Note: When this procedure is used for A709Gr50W materials, it shall be limited to 5/16" single pass or material be coated.