

STATE OF VERMONT
AGENCY OF TRANSPORTATION
AC BRF 0160 (3)S
LEICESTER, VT.

COSMEC INC.

WELDING PROCEDURE SPECIFICATION

SPECIFICATIONS AND CODE: D1.8 (D1.3)
MATERIAL SPECIFICATION ASTM A240 TYPE 304 TO ASTM A709 GR 50W
WELDING PROCESS-----GTAW
MANUAL OR MACHINE-----MANUAL
POSITION OF WELDING-----1F & 2F
FILLER METAL SPECIFICATION ER309L CLASSIFICATION: A5.9
MANUFACTURER: HARRIS WELCO TRADENAME:
FLUX-----INTERNAL
SHIELDING GAS-----ARGON FLOW RATE 45 CFH
SINGLE OR MULTIPLE PASSES SINGLE
SINGLE OR MULTIPLE ARC SINGLE
WELDING CURRENT-----DC
POLARITY: REVERSE (EN)
WELDING PROGRESSION-----
ROOT TREATMENT-----CLEANED & PREPARED BRIGHT METAL
PREHEAT AND INTERPASS TEMPERATURE-----SEE BELOW
POSTHEAT TEMPERATURE N/A
HEAT INPUT MIN-----MAX-----

WELDING PROCEDURE

PASS NO.	ELECTRODE SIZE	WELDING CURRENT AMPERES	TRAVEL SPEED VOLTS	JOINT DETAIL
ALL	3/32"	130-155	14-17	LAP JOINT
				18 GA THRU 10 GA BM THICKNESS

PREHEAT TEMPS.
THICKNESS
UP TO 3/4" 100 DEG.
OVER 3/4" TO 1 1/2" 100 DEG.
OVER 1 1/2" TO 2 1/2" 100 DEG.
OVER 2 1/2" 100 DEG.

***PREHEAT UNTIL NO MORTURE PRESENT
OK'D BY _____ OK'D BY *Jwe*
JAN 06 2006
RESUBMIT _____ APPROVED ✓
BY *RW* DATE *02-06-06*

THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT-UP, PASS SIZE, ETC.
WITHIN THE LIMITATION OF VARIABLES GIVEN IN SECTION 5.
SUPPORTING PQR: GTAW-WF-05
PROCEDURE NO. GTAW-WF

CONTRACTOR: COSMEC INC.
AUTHORIZED BY: DONALD VOSE
CW#:01100651 *Donald Vose*

REVISION NO. 1

DATE: 2/1/2005

