

EASTERN BRIDGE, LLC
WELDING PROCEDURE SPECIFICATION

WPS NUMBER: 2005-3-1				ISSUE DATE: 5/16/06	
PROJECT: VT AOT BR 1443(35)				EB JOB NO.: 6085	
BASE METAL: ASTM A709 GR50W					
WELDING PROCESS: SUBMERGED ARC WELDING					
FILLER METAL SPEC.: AWS A5.23 LINCOLN LA75					
FLUX / SHIELDING GAS: LINCOLN 960					
CURRENT AND POLARITY: DCEP				ELEC STICKOUT: 1" +/- 1/4"	
WELDING POSITION: 1G					
PREHEAT AND INTERPASS TEMP: AWS TABLE 4.4				WPS QUALIFICATION: AWS D1.5 / 5.13	
HEAT INPUT: 50.68 - 73.92 KILOJOULES				SUPPORTING PQR#: 2005-3	
ELECTRODE SIZE	WELDING AMPS	CURRENT VOLTS	TRAVEL SPEED	JOINT DETAIL AND AWS NUMBER: BL2c-S	
3/32"	398 - 440	28.8 - 31.5	11.25 - 13.5		
NOTES: GROOVE WELDING					
RECEIVED MAY 13 2006 DATE 6-2-06					
MINIMUM PREHEAT AND INTERPASS TEMPERATURES SHALL BE AS FOLLOWS: MAXIMUM INTERPASS TEMPERATURE SHALL BE 450F					
THICKNESS OF THICKEST PART AT POINT OF WELDING			TEMPERATURE, F ASTM A709 GR 345W STEEL		
UP TO 3/4"			50F		
3/4" TO 1 1/2"			70F		
1 1/2" TO 2 1/2"			150F		
OVER 2 1/2"			225F		
THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT UP, PASS SIZE, ETC. WITHIN THE LIMITS PROVIDED IN THE CONTRACT DOCUMENTS AND THE AWS D1.5 BRIDGE WELDING CODE					