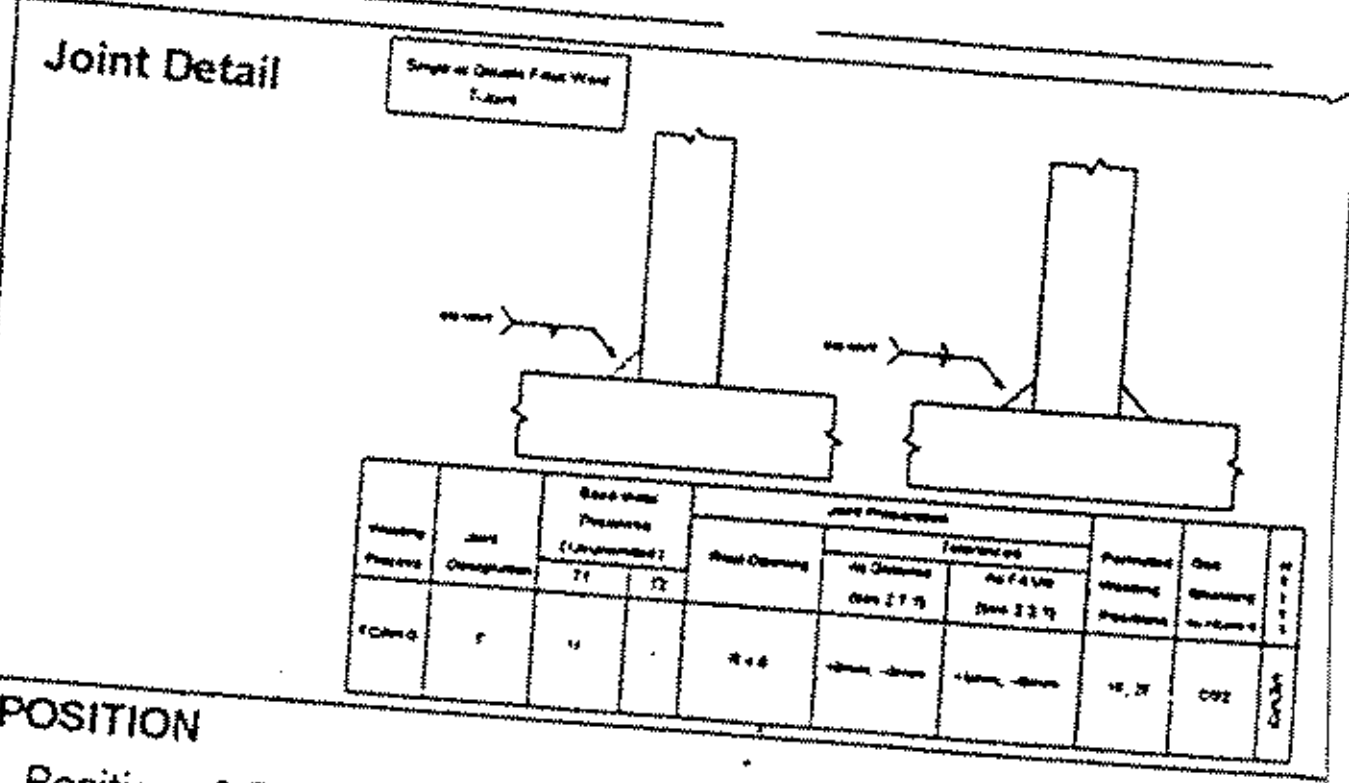


Welding Procedure Specification

WPS No. DS-16VT Date 8/28/97 By Glenn A. Myrick, CWI, CWE, CW Type Manual Machine
 Authorized By James Dussault Date 12/30/94 Revision m1 Semi-Auto Auto
 Welding Process(es) FCAW-G N/A Prequalified
 Supporting PQR(s) 007 008

JOINT
 Type T-Joint
 Backing Yes No Single Weld Double Weld
 Backing Material N/A
 Root Opening None Root Face Dimension N/A
 Groove Angle N/A Radius (J-U) N/A
 Back Gouge Yes No
 Method N/A



BASE METALS
 Material Spec. A709M to A709M
 Type or Grade 250,345,345W to 250,345,345W
 Thickness: Groove (mm) _____
 Fillet (mm All) _____ - Unlimited
 Diameter (Pipe, mm) _____

POSITION
 Position of Groove N/A Fillet 1F, 2F
 Vertical Progression: Up Down

FILLER METALS
 AWS Specification A5.20 N/A
 AWS Classification E71T-1 N/A
N/A N/A

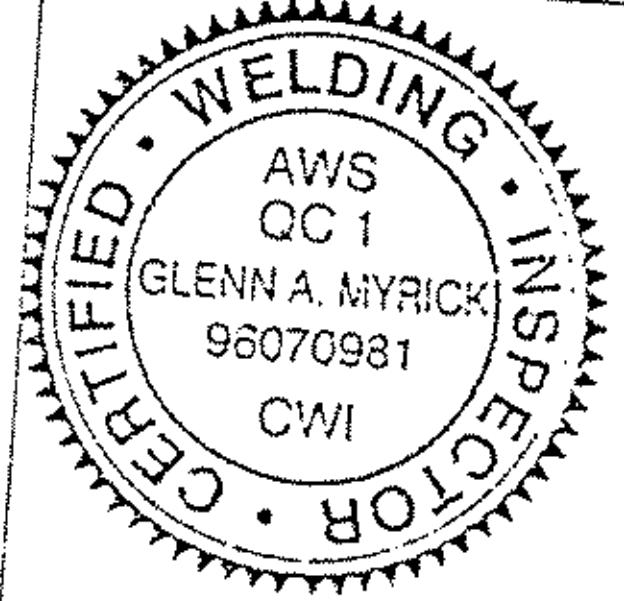
ELECTRICAL CHARACTERISTICS
 Transfer Mode (GMAW):
 Short-Circuiting Globular Spray
 Current: AC DCEP DCEN Pulsed
 Other N/A
 Tungsten Electrode (GTAW):
 Size N/A Type N/A

SHIELDING
 Flux N/A Gas CO2
 Composition 100%
 Electrode-Flux (Class) E71T-1 Flow Rate 14-16L/min
 Gas Cup Size 13MM

TECHNIQUE
 Stringer or Weave Bead Both
 Multi-pass or Single Pass (per side) Both
 Number of Electrodes 1
 Electrode Spacing: Longitudinal N/A
 Lateral N/A
 Angle N/A
 Contact Tube to Work Distance 10mm-20mm
 Peening NOT ALLOWED
 Interpass Cleaning Mechanical Only

PREHEAT
 Preheat Temp., Min. 10C
 Thickness Up to 3/4" Temperature 10c} <20mm
 Over 3/4" to 1-1/2" 20c} <40mm
 Over 1-1/2" to 2-1/2" 65c} <60mm
 Over 2-1/2" 110c} >60mm
 Interpass Temp., Min. 10C Max. 210C

POSTWELD HEAT TREATMENT PWHT Required
 Temp. NOT QUALIFIED Time N/A



STRUCTURES
COPY

V.A.O.T.
RECEIVED
CK'D BY _____ OK'D BY JWC

OCT 27 1998

RESUBMIT _____ APPROVED
BY _____ DATE 10-28-98

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