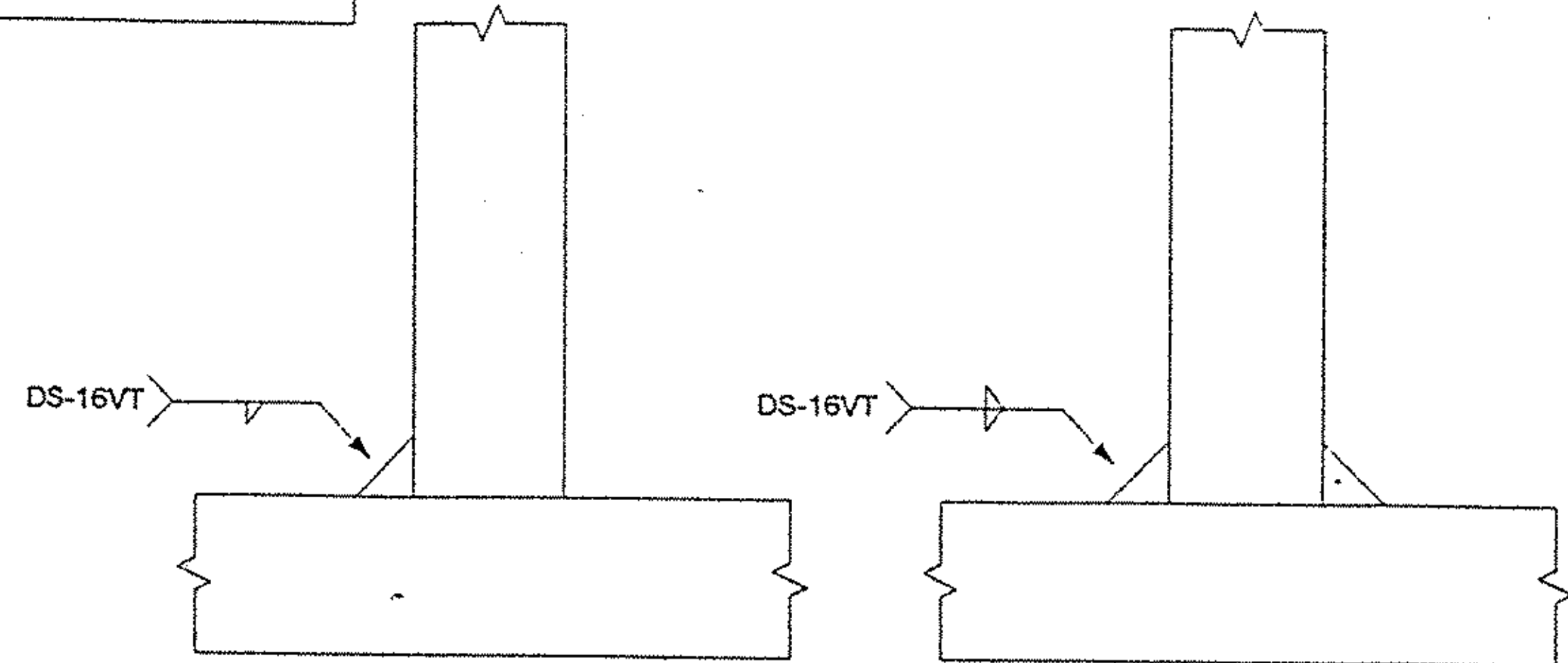


Welding Procedure Specification

Joint Detail

Single or Double Fillet Weld
T-Joint



Welding Process	Joint Designation	Base Metal Thickness (U=unlimited)		Joint Preparation			Permitted Welding Positions	Gas Shielding for FCAW-G	Notes
		T1	T2	Root Opening	Tolerances				
					As Detailed (see 2.7.1)	As Fit Up (see 3.3.1)			
FCAW-G	T	U	-	R = 0	+0mm, -0mm	+5mm, -0mm	1F, 2F	CO2	MEMO

MEMO

(3.3.1) Tolerances as Fit Up

If the root opening is greater than 2mm, the leg of the fillet weld shall be increased by the amount of the root opening or the contractor shall demonstrate that the required weld size has been obtained.

(4.1.5.4) Flux Cored Arc Welding (FCAW)

Single pass fillet welds up to 8mm maximum, may be made with a single pass or single pass each side, using an E7XT-X electrode conforming to Table 4.1 or 4.2.

Travel speed is calculated in millimeters per minute. D1.5, section 5.12.



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 CK'D BY _____ OK'D BY _____
OCT 27 1998
 RESUBMIT _____ APPROVED _____
 BY _____ DATE _____

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