

VT A.O.T.
 PROJ. NO. BHF-0188(7)
 BRIDGE No. 7
 TOWN OF WARREN

COSMEC INC.

WELDING PROCEDURE SPECIFICATION

TRANS
 RECEIVED

SPECIFICATIONS AND CODE: D1.6
 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
 MANUFACTURER: HARRIS WELCO
 FLUX INTERNAL
 SHIELDING GAS ARGON
 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.

CLASSIFICATION: A5.9
 TRADENAME:
 FLOW RATE 45 CFH

JUL 19 2007
 APPROVED
 DATE 7-17-07

WELDING PROCEDURE

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

16 GA THRU 10 GA
 BM THICKNESS

PREHEAT TEMPS. ***PREHEAT UNTIL NO MOISTURE PRESENT

THICKNESS	TEMP.
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.

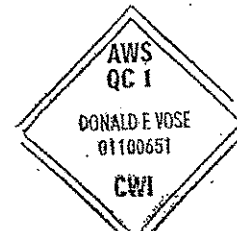
THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT-UP, PASS SIZE, ETC.
 WITHIN THE LIMITATION OF VARIABLES GIVEN IN SECTION 5.

SUPPORTING PQR: GTAW-WF-05
 PROCEDURE NO. GTAW-WF

CONTRACTOR: COSMEC INC.
 AUTHORIZED BY: DONALD VOSE
 CWI# 01100651

REVISION NO. 1

DATE: 2/1/2005



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