

WELDING PROCEDURE SPECIFICATION

Material specification ASTM A109 Gr. B 50-50W (250-345-345W)
 Welding process Shielded Metal Arc Welding (SMAW)
 Manual or machine Manual
 Position of welding Flat (1F), Horizontal (2F)
 Filler metal specification AWS/A51-A5.5
 Filler metal classification E7018-R01A 5/64-7/64
 Flux NA
 Shielding gas NA Flow rate NA
 Single or multiple pass Single and multiple
 Single or multiple arc Single
 Welding current AC/DC
 Polarity STRAIGHT/REVERSE
 Preheat and interpass temperature over AWS SPECIFICATION
 Postheat temperature NA
 Heat Input: Min NA Max NA

VTADT
 Brownrig Ten
 8118-Prj BR044902-R
 CB35-396

(Metric)

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
AS	<u>7018</u> 1/8 (3-2)	70-170	22-26	AS	
	<u>5/32</u> 3/8	120-225	22-26		
	<u>3/16</u> 4.0	170-300	24-27		
RFQ	<u>7018</u> 1/8 (3-2)	90-160	22-26	RFQ	
	<u>5/32</u> 3/8	120-225	22-26		
	<u>3/16</u> 4.0	170-290	24-27		
RFQ	<u>7018</u> 1/8 (3-2)	90-160	22-26	RFQ	
	<u>5/32</u> 3/8	170-270	22-26		
	<u>3/16</u> 4.0	210-330	24-27		

This procedure may vary due to production sequence, fit-up, pass size, etc., within the limitation of variables given in applicable codes or contract specifications.

Procedure no. 401 Contractor Casco Bay Steel
 Revision no. TRANS Authorized By Paul E. Hoodale
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 CTD BY JWC OK'D BY JWC