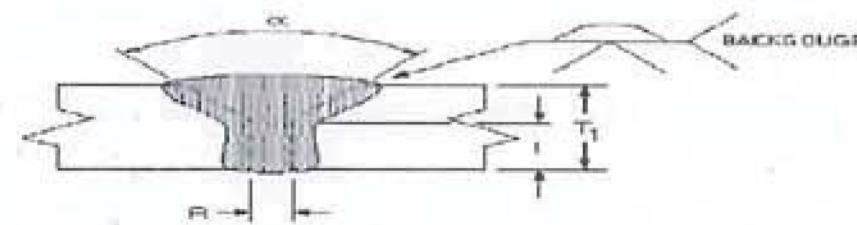




JOINTS: Typical joint(s). See actual production drawings and engineering specifications for details.



	Amps	Volts	Travel Speed
AVG	604 /	29.5 /	17.1 IPM
MIN	569 /	27.4 /	15.5 IPM
MAX	625.1 /	31.0 /	18.7 IPM

Over 1/2" to 1" (1/4 root face min)
Over 1" to 1-1/2" (3/8 root face min)
Over 1-1/2" to 2" (1/2 root face min)

*backside shall be backgouged prior to welding

Type of groove	Single-V-groove	Minimum groove angle (deg.)	55 to 70
		Minimum root opening (in.)	0 to 1/16
		Maximum root face (in.)	varies

Applicable standard

AWS D1.5 Bridge Welding Code	For thickness 1/8 to 3/4(in.): 50°F). Preheat to 70(°F) if the base metal temperature is below 32(°F). Over 3/4 thru 1-1/2(in.): 70(°F). Over 1-1/2 thru 2-1/2(in.): 150(°F). Over 2-1/2(in.): 225(°F). Refer to AWS D1.5 2010 Table 4.3 (pg 85)
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Supplementary MF control	
Peening	
Surface preparation	Grind/Blast/chemical/wirebrush clean to be free of moisture, slag, millscale, oils, dust
Initial/interpass cleaning	Brushing and Grinding
Back gouging method	Grinding or Air Carbon Arc Gouging

NOTES

RECEIVED

CK'D BY OK'D BY RSF

May 7, 2017

RESUBMIT No **Approved** _____
BY C. Carlson **DATE** 05/09/2017

Signature 1		Signature 2	
Name	Signature	Name	Signature
Matthew Cote	 Matthew J Cote CWI 08051341 QC1 EXP. 5/1/2017		
Date		Date	
6/2/14			
Signature 3		Signature 4	
Name	Signature	Name	Signature
Date		Date	