



PREQUALIFIED JOINT WELDING PROCEDURE
PROCEDURE SPECIFICATION

Material specification: ASTM-A709/A709M - GRADE-36(250), 50(345), 50W(345W)
Welding process: SHIELDED METAL ARC WELDING (SMAW)
Manual or machine: MANUAL
Position of welding: FLAT-VERTICAL-HORIZONTAL-OVERHEAD
Filler metal specification: AWS A5-1 & A5-5
Filler metal classification: 7018
Flux: N/A
Shielding gas: N/A Flow rate: N/A
Single or multiple pass: SINGLE & MULTIPLE
Single or multiple arc: SINGLE
Welding current: AC/DC
Polarity: STRAIGHT OR REVERSE
Welding progression: SEE JOINT DETAIL
Root treatment: WIRE BRUSH AREA TO BE FREE OF LOOSE SCALE, RUST, MOISTURE
Preheat and interpass temperature: TO 3/4"(19) 50°F (10°C), 3/4"(19) TO 1 1/2"(38) - 70°F (20°C)
Postheat treatment: N/A 1 1/2"(38) TO 2 1/2"(63.5) 150°F (65°C)

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
As Req'd	1/8	90-170	22-26	As Req'd	1F 2F 3F 4F SINGLE FLARED BEVEL GROOVE
	5/32	120-200	22-26		
	3/16	170-250	24-27		
NOTE-VERTICAL UP					

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in Section 5.

Procedure no. 401-A - FIELD WELD

Contractor WINTERSET, INC.

Revision no. _____

Authorized by GLENN A. LAVOIE, P.E.

Location: MISC FIELD WELDS

Date 8-14-09

SILENCE TO BEAM
EXP DAM STUDS

PROJECT: MORETOWN - MIDDLESEX

B7S 02.84(14)