

VT-06062 Contract #BHF 0200 (9), Bridge #36 Improvement

WELDING PROCEDURE FOR AWS PREQUALIFIED JOINTS

W34X - METRIC

PROCEDURE SPECIFICATIONS

MATERIAL SPECIFICATION

WELDING PROCESS

MANUAL OR MACHINE

POSITION OF WELDING

FILLER METAL SPECIFICATION

WELD METAL CLASSIFICATION

WIRE/FLUX

WIRE DIAMETER

SINGLE OR MULTIPLE ARC

POLARITY

ROOT TREATMENT

PREHEAT AND INTERPASS TEMPERATURE

ELECTRICAL STICK-OUT

SHIELDING GAS

ASTM A709 GRADES: 250, 345, 345W

SUBMERGED ARC WELDING

SEMI-AUTOMATIC OR MACHINE

2F

AWS A5.17

F7A2-EM12K

LINCOLN L61/761

2.4mm

SINGLE ARC

DC-

MANUAL CLEANING

SEE PREHEAT CHART

25.4mm

D.N.A.

SEP 12 2006

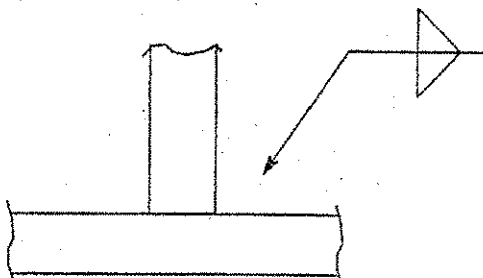
REVISED: 5/5/03

ORIGINAL ISSUE: 3/4/96

WELDING PROCEDURE

PASS NO.	WELDING CURRENT			TRAVEL SPEED (mm/m)	JOINT DETAIL
	AMPS	WIRE FEED SPEED	VOLTS		
1	360-440	2.9-3.7	29.0-36.0	279-686	8mm FILLET WELD

PRIMARY USE:
STIFFENER TO WEB
(AND OTHER APPLICATIONS AS NEEDED)



AWS D1.5 FWST T-TEST-10

PROCEDURE QUALIFICATION RECORD AWS-FCM-02-4 (EXPIRES 6/27/07)

PROCEDURE QUALIFICATION RECORD AWS-FCM-02-5A (EXPIRES 7/16/07)

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