WELDING PROCEDURE SPECIFICATION

Material specification ASTM 709-Gr 36-50-50W (250-345-345W)
Welding process Shielded Metal Arc welding (SMAW)
Manual or machine Manual
Position of welding Flat (1F), Horizontal (2F) Overhead (3F)
Filler metal specification AWS/AWS A5.1 - A5.5
Filler metal classification E7018 - 8018 C1/C3 - 7028
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
Welding progression
Root treatment Meet AWS specification
Preheat and interpass temperature To 3/4 (19) 50F (10C) 3/4 (19) To 1 1/2 (38) 70F (20C) 1 1/2 (38) To 2 1/2 (63.5) 150F (65C) over 2 1/2 (63.5) 225F (110C)
Postheat temperature NA
Heat Input Min NA Max NA

Enosburg BRO 1448(40)
BR NO. 48

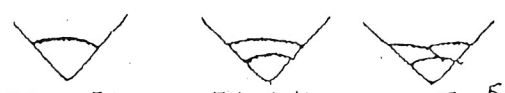
WELDING PROCEDURE

(metric)

Pass no.	Electrode size	Welding current: Amperes	Welding current: Volts	Travel speed
AS REQ.	7018			AS REQ
	1/8 (3.2)	70-170	22-26	
	5/32 (3.9)	120-225	22-26	
	3/16 (4.8)	170-300	24-27	
	8018			
	1/8 (3.2)	90-160	22-26	
	5/32 (3.9)	120-225	22-26	
	3/16 (4.8)	180-290	24-27	
	7028			
	5/32 (3.9)	170-270	22-26	
	3/16 (4.8)	210-330	24-27	

AWS D1.5 Joint detail Fillet

1F



3/16 To 3/8 (5 To 10) | 3/8 To 1/2 (10 To 13) | 1/2 To 5/8 (13 To 16)

2F

3/16 To 5/16 (5 To 8) | 3/8 (10) | 7/16 To 5/8 (11 To 16)

3F

3/16 to 5/16 | 3/8 | 7/16 to 5/8

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

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Form [illegible]

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