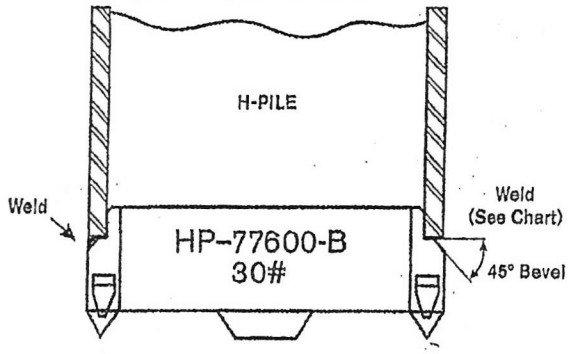
Fairfield BRF 0231(25) & BRO 1448(41)

Welding Procedure Specification

Material specification: Grade 50
Welding process: SMAW
Manual or machine: manual
Position of welding: all positions
Filler metal specification: NR311 A5.1
Filler metal classification: E-7018
Flux: N/A
Shielding gas: N/A Flow rate: N/A
Single or multiple pass: as required
Single or multiple arc: N/A.
Welding current: D.C
Polarity: regular
Welding progression: as required
Root treatment: none
Preheat and interpass temperature: 50-175
Postheat treatment: N/A

WELDING PROCEDURE

Pass no.	Electrode size	Welding current: Amperes	Welding current: Volts	Travel speed	Joint detail
As req	5/32	120-240	22-27	As req.	3/8 Groove Weld HP 12 x 84 

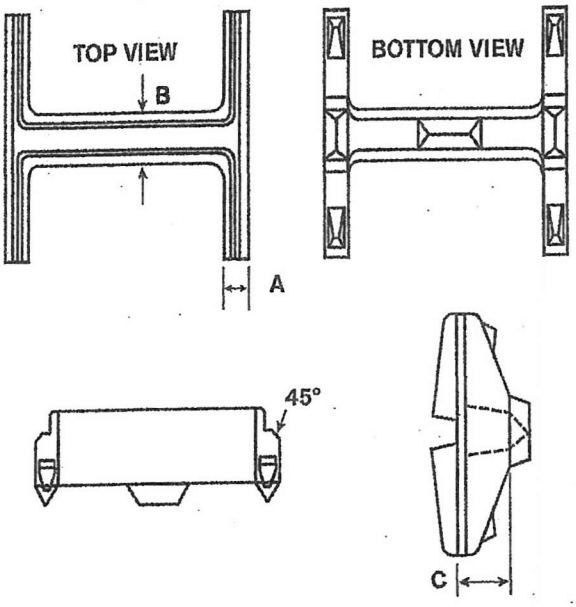
This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in Section 5. **(of the AASHTO/AWS D1.5 Bridge Welding Code and latest revision)**

Procedure no. _____
Revision no. _____
Welder _____

Contractor: ALStrong Contractor Inc
Authorized by: Randy Strong
Date: 5/29/15

HARD-BITE™ – HP-77600-B 30#

Dimensions



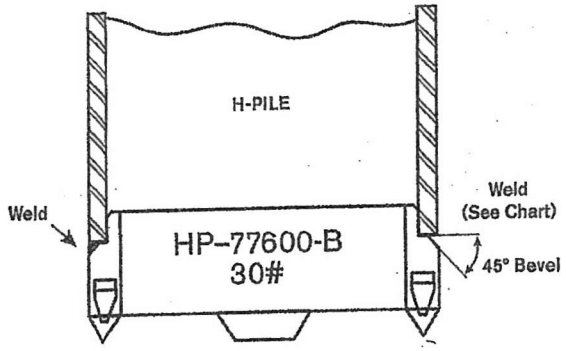
MATERIAL: CAST STEEL

ASTM A148 90/60

	12"
A	1"
B	1-5/16"
C	3"
Wt.	31#

Installation Instructions

1. Fit point onto the end of the square cut pile end.
2. Weld point to the pile in either flat or vertical position using E7018 electrodes.
3. Weld across full width of flange following chart below for minimum size weld.



Pile Size	Flange Thickness	Groove Weld
HP 12 x 84	.685	3/8
x 74	.610	3/8
x 63	.515	5/16
x 53	.435	5/16

ASSOCIATED PILE & FITTING

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(12/11)