



PREHEAT AND INTERPASS TEMPERATURES FOR ASTM A709 GRADE 36, 50, 50W STRUCTURAL STEEL IN ACCORDANCE WITH AASHTO/AWS D1.5-2010

Table with 2 columns: THICKNESS OF THICKEST PART AT POINT OF WELDING, MINIMUM PREHEAT/INTERPASS AT POINT OF WELDING. Rows include thicknesses from 3/4" to over 2-1/2" with corresponding temperatures.

MAXIMUM PREHEAT TEMPERATURE 450°F
MAXIMUM INTERPASS TEMPERATURE 550°F

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WELDING PROCEDURE FOR AWS PREGUALIFIED JOINTS GMAW-P 2F TACKS. Includes material specifications, parameters table, joint details, and diagrams.

WELDING PROCEDURE FOR AWS PREGUALIFIED JOINTS W13X-2. Includes material specifications, parameters table, joint details, and diagrams.

WELDING PROCEDURE FOR AWS PREGUALIFIED JOINTS W44X-2. Includes material specifications, parameters table, joint details, and diagrams.

WELDING PROCEDURE FOR AWS PREGUALIFIED JOINTS W2. Includes material specifications, parameters table, joint details, and diagrams.

WELDING PROCEDURE FOR AWS PREGUALIFIED JOINTS GMAW-P 4F TACKS. Includes material specifications, parameters table, joint details, and diagrams.

WELDING PROCEDURE FOR AWS PREGUALIFIED JOINTS W13X-2 GB. Includes material specifications, parameters table, joint details, and diagrams.

WELDING PROCEDURE FOR AWS PREGUALIFIED JOINTS W33. Includes material specifications, parameters table, joint details, and diagrams.

WELDING PROCEDURE FOR AWS PREGUALIFIED JOINTS W6. Includes material specifications, parameters table, joint details, and diagrams.

WELDING PROCEDURE FOR AWS PREGUALIFIED JOINTS GMAW-P FILLETS. Includes material specifications, parameters table, joint details, and diagrams.

WELDING PROCEDURE FOR AWS PREGUALIFIED JOINTS W33. Includes material specifications, parameters table, joint details, and diagrams.

WELDING PROCEDURE FOR AWS PREGUALIFIED JOINTS W33. Includes material specifications, parameters table, joint details, and diagrams.



WELDING PROCEDURE QUESTIONS MAY BE REFERRED TO: PAUL MUFFULETTO, HIGH STEEL STRUCTURES LLC PMUFFULETTO@HIGH.NET PHONE: (717)390-4253

Revision table with columns: NO., REVISION, BY, CHK'D, DATE. Includes project information for High Steel Structures LLC, drawing number S-1140166A-1, and date 12/09/14.