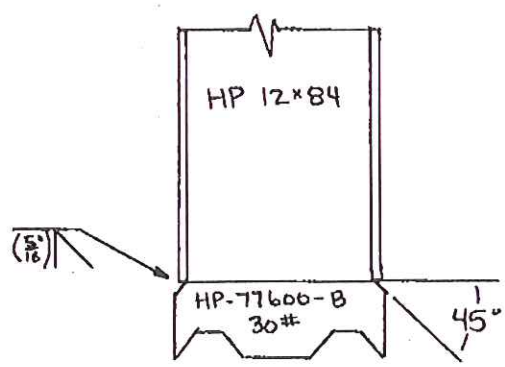
BD 190 (4/81) WELDING PROCEDURE SPECIFICATION

VTrans Received DEC 17 2014
CKD _____ OK'd BY JWC
Resubmit _____ APPROVED ✓
BY _____ DATE 12/17/14

Material specification A572 Gr. 50 to Cast Steel Tip
Welding process SMAW
Manual, semi-automatic or automatic Manual
Position of welding Flat
Filler metal specification AWS A5.1
Filler metal classification F-4 Low Hydrogen
Electrode and manufacturer Lincoln E7018 FCM Lot # _____
Flux and manufacturer N/A FCM Lot # _____
Shielding gas N/A Dew point N/A Flow rate N/A
Single or multiple pass Multiple
Single or multiple arc Single
Welding current DC
Polarity Positive
Welding progression Stringer
Root treatment Bright, Clean to Remove Contaminates
Preheat and interpass temperature 250° F
Postheat treatment Natural air Cooling
PQR# _____

WELDING PROCEDURE

Pass No.	Electrode Size	Welding parameters Amperes	Volts	Travel Speed	Joint Detail
ALL	5/32"	120-190			 Sequence of weld passes shall be shown diagramatically

Procedure no. JW-TM11 Fabricator or Erector Jimmy's Welding
Revision no. _____ Authorized by _____
Date _____

FIGURE 704 – SAMPLE WELDING PROCEDURE SPECIFICATION

BD 190 (4/81) WELDING PROCEDURE SPECIFICATION

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Material specification A572 Gr. 50 to Cast Steel Tip
Welding process SMAW
Manual, semi-automatic or automatic Manual
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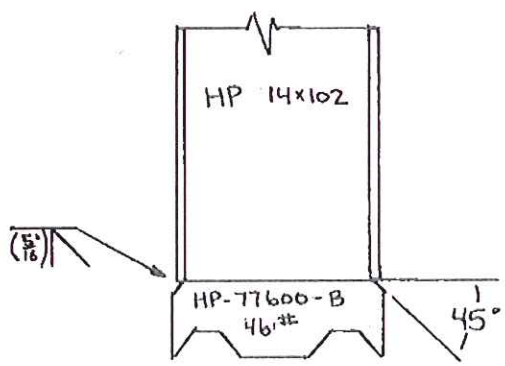
Filler metal specification AWS A 5.1
Filler metal classification F-4 Low Hydrogen
Electrode and manufacturer Lincoln E7018 FCM Lot # _____
Flux and manufacturer N/A FCM Lot # _____
Shielding gas N/A Dew point N/A Flow rate N/A
Single or multiple pass Multiple
Single or multiple arc Single
Welding current DC
Polarity Positive
Welding progression Stringer
Root treatment Bright, Clean to Remove Contaminates
Preheat and interpass temperature 250° F
Postheat treatment Natural air Cooling
PQR# _____

WELDING PROCEDURE

Pass No.	Electrode Size	Welding parameters Amperes	Volts	Travel Speed	Joint Detail
ALL	5/32"	120-190			 Sequence of weld passes shall be shown diagramatically

Procedure no. JW-TM12 Fabricator or Erector Jimmy's Welding
Revision no. _____ Authorized by _____
Date _____

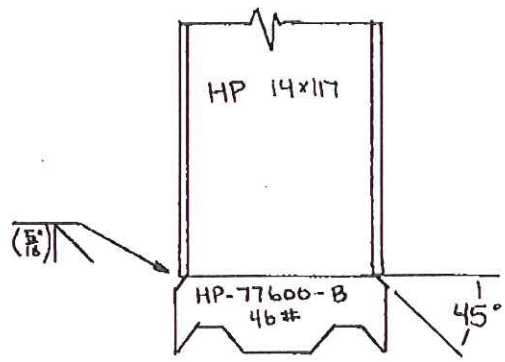
FIGURE 704 – SAMPLE WELDING PROCEDURE SPECIFICATION

BD 190 (4/81) WELDING PROCEDURE SPECIFICATION

VTrans Received DEC 17 2014
CK'D ____ OK'd BY JWC
Resubmit ____ BY ____ APPROVED ✓ DATE 12/17/14

Material specification A572 Gr. 50 to Cast Steel Tip
Welding process SMAW
Manual, semi-automatic or automatic Manual
Position of welding Flat
Filler metal specification AWS A 5.1
Filler metal classification F-4 Low Hydrogen
Electrode and manufacturer Lincoln E7018 FCM Lot # ____
Flux and manufacturer N/A FCM Lot # ____
Shielding gas N/A Dew point N/A Flow rate N/A
Single or multiple pass Multiple
Single or multiple arc Single
Welding current DC
Polarity Positive
Welding progression Stringer
Root treatment Bright, Clean to Remove Contaminates
Preheat and interpass temperature 250° F
Postheat treatment Natural air Cooling
PQR# ____

WELDING PROCEDURE

Pass No.	Electrode Size	Welding parameters Amperes	Volts	Travel Speed	Joint Detail
ALL	5/32"	120-190			 Sequence of weld passes shall be shown diagramatically

Procedure no. JW-TM13 Fabricator or Erector Jimmy's Welding
Revision no. ____ Authorized by ____
Date ____

FIGURE 704 – SAMPLE WELDING PROCEDURE SPECIFICATION