

PROCEDURE SPECIFICATION

Material Specification: Spec sec. 6-02.3(24) E	Welding Position: 1G
Welding Process: SMAW	Manual or Machine: Manual
Filler Metal Spec.: Conforms to AWS A5.5	Filler Classification: E 8018
Weld Metal Grade: A 706 Grade 60	Shielding Gas: NA
Single or Multiple Pass: Single	Welding Current: Direct
Single or Multiple Arc: Single	Polarity: DC +
Root Treatment: NA	Preheat & Interpass Temp: 50 °F

WELDING PROCEDURE

Pass No.	Elect. Size	Welding Current Amp.	Voltage	Joint Detail																								
1	1/8	125 To 135	21	<p style="text-align: center;">Field or Shop Weld</p> <p style="text-align: center;">S (E) L</p> <p style="text-align: center;">1 Inch Min. Length of Weld (L) 1 Inch Min.</p> <table style="width: 100%; border: none;"> <thead> <tr> <th style="text-align: left;">Deformed Bar</th> <th colspan="3" style="text-align: left;">Weld Dimensions</th> </tr> <tr> <th style="text-align: left;">A 706 Grade 60</th> <th style="text-align: left;">S</th> <th style="text-align: left;">(E)</th> <th style="text-align: left;">Length (L)</th> </tr> </thead> <tbody> <tr> <td># 7</td> <td>7/16</td> <td>(1/4)</td> <td>7"</td> </tr> <tr> <td>✓ # 6</td> <td>3/8</td> <td>(5/16)</td> <td>6"</td> </tr> <tr> <td># 5</td> <td>5/16</td> <td>(3/16)</td> <td>6"</td> </tr> <tr> <td># 4</td> <td>1/4</td> <td>(1/8)</td> <td>5"</td> </tr> </tbody> </table>	Deformed Bar	Weld Dimensions			A 706 Grade 60	S	(E)	Length (L)	# 7	7/16	(1/4)	7"	✓ # 6	3/8	(5/16)	6"	# 5	5/16	(3/16)	6"	# 4	1/4	(1/8)	5"
Deformed Bar	Weld Dimensions																											
A 706 Grade 60	S	(E)	Length (L)																									
# 7	7/16	(1/4)	7"																									
✓ # 6	3/8	(5/16)	6"																									
# 5	5/16	(3/16)	6"																									
# 4	1/4	(1/8)	5"																									
1	5/32	125 To 150	21																									

This procedure may vary due to fabrication sequence, fit-up, pass size, etc. within the limitation of variables given in 6.2.1. The lap splice **WILL** extend beyond the one inch minimum as necessary for ease of placement.



3-27-12



LAB [REDACTED]
 PO [REDACTED]
 MATL A706-60 to A706-60
 SPEC AWS D1.4/D1.4M:2011
 TEST METHOD Macro Evaluation
 DESCRIPTION Rebar Weld (2)

Test Report

Page 1 of 1

Welder Qualification

Identification of Parameters

WPS ID: NA
 Welder Name/ID: [REDACTED]
 Specification: AWS D1.4/D1.4M:2011
 Base Metal Side 1: ASTM A706-60
 Side 2: ASTM A706-60
 Filler Metal: E8018-C3
 Welding Process: SMAW
 Position: 1G

Qualification

Test Specimen: Flare-Bevel-Groove-Indirect Butt Joint
 Macroetch Test: 2 faces

Macro Examinations

2-faces were sectioned, polished, etched, and examined. Both Butt Joints were examined per section 6.3.7.3.

Note: Meets the requirements of the following applicable sections; 4.4.1, 4.4.3 4.4.2, 4.4.5 and 4.4.6 (weld size not disclosed).

Specimens pass the acceptance criteria of the specification.

Respectfully,





10-20-11



LAB [REDACTED]
 PO [REDACTED]
 MATL A706 to A706
 SPEC AWS D1.4/D1.4M:2005
 TEST METHOD Macro Evaluation
 DESCRIPTION Rebar Weld

Attn: [REDACTED]

Test Report

Page 1 of 1

Corrected Test Report-11-21-11- Removed Photo and changed acceptance results

Welder Qualification

Identification of Parameters

WPS ID: NA
 Welder Name/ID: [REDACTED]
 Specification: AWS D1.4/D1.4M:2005
 Base Metal Side 1: ASTM A706
 Side 2: ASTM A706
 Filler Metal: E8018-C3
 Welding Process: SMAW
 Position: 1G

Qualification

Test Specimen: Flare-Bevel-Groove-Indirect Butt Joint
 Macroetch Test: 2 faces

Macro Examinations

2-faces were sectioned, polished, etched, and examined. Both Butt Joints were examined per section 6.3.7.3.

Note: Meets the requirements of the following applicable sections; 4.4.1, 4.4.3 4.4.2, 4.4.5 and 4.4.6 (weld size not disclosed).

Specimens pass the acceptance criteria of the specification.

Respectfully,

[REDACTED]

Materials Engineer