

# # 1 SMAW...1583...F3 {6010} + F4 {7018}

Qualified up to "T"	E6010 (F3)>>>0.188" t and E7018 (F4)>>>0.498" t
Material	P1-P1...2 " sch.160.....Carbon Steel
Joint type	Single bevel - V-groove
Position	6G
Root Face	2.8mm - 3.0mm (a liittle less than 1/8 in.).
Root gap	2.3mm - 2.5mm (approx. 3/32 in. or less)
Root pass	E6010 >>>>3.2mm (1/8 in)>>>>>75 - 85 amps.
Fill passes	E7018>>>>2.4mm (3/32 in)>>>>>90 - 100 amps.
Cap Passes	<b>Max. 3 passes</b> ..E7018>>3/32 in>> 90 - 100 amps.
Note	<i>Do not use grinder or file on cap after completion of weld.</i>
Root penetration	1- 3 mm, but must be consistent.
Type of testing	Radiography.
Tacking method	Use bridge tacks @ 9 O'clock & 1 O'clock. Tack @ 6 O'clock is <u>not</u> necessary with this procedure.
Visual inspection	<b>Please pay attention to the following.</b> Crown height; <b>Undercut</b> ; <b>Coldlap</b> ; Root side penetration Crown profile; <b>Crater cracks</b> ; <b>Surface porosity</b> ; Underfill

