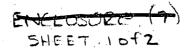
Enclosure 1 Drawing 3246-N-1585

Schedule of Field Welding Procedures



APPENDIX TO INDEX

- A. Welding Procedure Designations
 - P1, P8, etc. describes the base material "P Number" to be welded.
 - 2. Basic welding processes is/are identified by capital letters.

A	-	Shielded Metal-Arc Welding	(SMAW)
E	-	Electroslag Welding	(ESW)
F	-	Flux Cored-Arc Welding	(FCAW)
G	-	Electrogas Welding	(EGW)
M	-	Gas Metal-Arc Welding	(GMAW)
P	-	Plasma Arc Welding	(PAW)
S	_	Submerged Arc Welding	(SAW)
T	_	Gas Tungsten-Arc Welding	(GTAW)
X	-	Oxyacetylene Welding	(FGW)

- 3. Standard letter designations describe variations:
 - a Automatic welding
 - Ag Argon gas purging
 - b Backing Strips or Tape
 - c Cellulosic electrodes (EXX10)
 - Clad Cladding or overlay welding
 - CVN Charpy V-Notch impact tested.
 - d Downhill progression for vertical position welding
 - du Combination downhill root pass and uphill filler pass progression for vertical position welding
 - bf Backing, Solar-Flux
 - I Consumable Insert

 - Lh Low-hydrogen electrodes (Exxl5,16 or 18) for welding Pl and P3 materials
 - Ng Nitrogen gas purging
 - o Machine welding
 - r Horizontal roll welding of pipe
 - u Uphill progression for vertical position welding (used only when needed to separate procedures for filing)
- 4. Other designations and information often enclosed by parenthesis:
 - (F-XX) Where XX indicates an electrode F Grouping number.
- (Structural) An AWS Code or structural use only procedure.
 - (AX) Where X indicates an A analysis of the filler metal.
 - (Rebar) Rebar welding only.

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(A-Co2) - Argon and Carbon Dioxide Shielding Gas used.

(2-1/2Ni) - Filler metal information here indicating 2-1/2% Nickel.

(Seal Weld) - Special use procedure for seal welds.

(CVN) - Charpy V-Notch Tested.

(STUD) - Stud Welding.

B. Designations of various standards

GWS-DM - Dissimilar Metal combinations of carbon and low alloy steels to stainless and nickel alloys.

GWS-FM - Mild steels and low alloy steels including ferritic and martensitic stainless steels.

GWS-NF - Nonferrous alloys except nickel-base alloys.

GWS-SN - Austenitic stainless steels and nickel-base alloys.

GWS-Structural - Structural applications normally encountered under AWS (Dl.1) and AISC Codes.

GBS-FM - General brazing standard of ferrous materials.

GBS-NF - General brazing standard of nonferrous materials.

GSS-NF - General soldering standard of nonferrous materials.

PHT - Postweld heat treatment standard

WQ-F, WQ-FN - Welder qualification standard

BQ-1 - Brazer qualification standard

Enclosure 2

BPC Welding Procedure

Designations and Abbreviations

Enclosure 3
BPC Welding Procedure
P1-AT-Lh-f