

Enclosure 1

Drawing 3246-N-1585

Schedule of Field Welding Procedures

APPENDIX TO INDEX

A. Welding Procedure Designations

1. 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 - Electrode Gas 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
ITP - Impact Tested Procedure (CVN and Dropweight tests)
Lh - Low-hydrogen electrodes (Exx15,16 or 18) for welding P1 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 (D1.1) 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