WORK THIS DOCUMENT WITH GEN. WELD PROCEDURE SPEC. GWPS-SMAW NO. POSITION THICKNESS RANCE POSITION THICKNESS RANCE NO. POSITION THICKNESS RANCE POSITION THICKNESS RANCE 4580 16,36 3/16" - 3" ALL 3/16" - 2 3/4 4581 16,36 3/16" - 2" 3/16" - 2 3/4 4643 56 3/16" - 1.75" 3/16" - 2 3/4 SPECIFIC CONTRACT WS REQUIREMENTS BASE METAL- A6888 Gr. A (Sim. ASME P-1 Gp 3) welded to A240 Tp 304 (ASME P-8 Gp 1) This Welding Procedure Specification i corp to A36 (ASME P-1 Gp 1) 0 or to A36 (ASME P-1 Gp 1) This Welding Procedure Specification i corp to A36 (ASME P-1 Gp 1) ASME ECADUP NO. SFA 5.4 ASME CLASSIFICATION NO. SFA 5.4 ASME ECOUP NO. F-5 No post weld heat treatment is required for removing molisture or unless the abient temperature falls below SOF- when the ambient temperature falls below SOF- when the ASSB material to the A	PR	ODUCT	r DC	WNCOMER	BRACIN	G - NUC	CIFICATI		LANT	s-E30	PAGE N	0 1		DF 3	
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her 11/29/8	REVIEW	JSV		DJS		LRS	RTF			CHE	CKED	TJL	5	5/15/78	
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		IDENTIFICATION	
CBI	WELDING PROCEDURE SPECIFICATION	WPS -E309/83670	
RODUCT	DOWNCOMER BRACING - NUCLEAR POWER PLANT COMMONWEALTH EDISON		оғ 3 те 5/19/8
LIMITAT For pla vertica root pa uphill thickne passes downhil Nonmeta metal n No supp used. Weldin shall of 5/8 Maximu than 5 approx Weldin A588 m maximu	allic retainers or nonfusing retainers are not to be used. plemental filler metal is to be g of A 36 material together be limited to a maximum thickness ". m pass thickness in welds greater 5/8" thick shall not exceed cimately 1/4". ng of the A618 material to the material shall be limited to a um thickness of 1", and the um electrode diameter to be used	CBI	
		CONTRACT 83674 DATE 7-7-80 INITIALS dla RELEASED BY CNQA SERVICES	
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DATE 5/19/80

WELDING PROCEDURE SPECIFICATION

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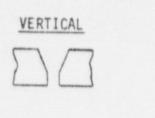
PRODUCT DOWNCOMER BRACING - NUCLEAR POWER PLANT CUSTOMERCOMMONWEALTH EDISON

GENERAL WELDING TECHNIQUE

Operation	Boads	Weld	E	ac trade	Current	Voltage	Travel	8.0.R.
Description	Lever	Proc	Size	Type	(emps)	(Volts)	(IPM)	Sec/12"
Stringer	As	SMA	3/32"0	E309-15	60-100	23-26		54-30
Beads*	Req'd		1/8"Ø		60-100	23-26		85-53
			5/32"Ø		100-145	23-26		93-59
			3/16"Ø		130-230	24-27		90-45
			3/32"Ø 1/8"Ø 5/32'Ø 3/16"Ø	E309-16	60-100 70-110 110-160 160-240	19-22 23-26 24-26 24-27	 	65-40 108-55 105-62 90-50
Vertical Up technique.	Vertical	s and o positi	verhead on: max	welds may imum diame	be deposit ter allowe	ted using	a weave	

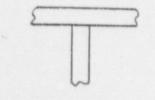
JOINT DETAIL - See contract drawings for applicable joint details and dimensions.

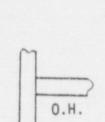
HORIZONTAL







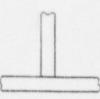












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