

Brown, Mark

From: Brown, Mark
Sent: Friday, February 06, 2009 2:13 PM
To: Flores, Frank
Subject: weld stuff

Here's the info from last time I asked what they use at the crane company, it looks like we're good.
Notice their recommended preheat and interpass.

*Material is ASTM A514. This is a high strength low alloy steel 100,000 psi min Yield
Use low hydrogen welding procedure.
Preheat to 105 deg C (=221 F)
Max Interpass temp 205 deg C (=401 F)
Use Dual Shield 11-71 All position electrodes or AWS Class E71-T1*

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