

Brown, Mark

From: John.Adams@alliedsystems.com
Sent: Monday, October 27, 2008 10:34 AM
To: Brown, Mark
Subject: FW: Weld procedure
Follow Up Flag: Follow up
Flag Status: Red

Mark,

Please see below information from Bob Nourse. Let me know how it goes...
John Adams

From: Bob Nourse
Sent: Monday, October 27, 2008 10:13 AM
To: John Adams
Subject: RE: Weld procedure

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
Max Interpass temp 205 deg C
Use Dual Shield 11-71 All position electrodes or AWS Class E71-T1

From: John Adams
Sent: Monday, October 27, 2008 9:49 AM
To: Bob Nourse
Cc: Dan Lanxon
Subject: FW: Weld procedure

Bob,

Could you please advise on this. Thanks.

John Adams

From: Brown, Mark [mailto:mob@mbari.org]
Sent: Monday, October 27, 2008 9:35 AM
To: Dan Lanxon; John Adams
Subject: Weld procedure

Hi Dan & John-

We're finally getting around to the weld repair for the crane. Can you let me know what the base material is that we will be welding to, and the Weld procedure that you normally use?

Bottom line is I'm trying to specify filler material for the application.

Thanks-

-Mark

Mark Brown
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Support Engineering Group
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