

QW-253
WELDING VARIABLES, PROCEDURE SPECIFICATIONS (
Shielded Metal-Arc Welding (SMAW)
(ASME Sec IX, 2010)

Paragraph		Brief of Variables		Essential
QW-402 Joints	.1	Φ	Groove design	
	.4	-	Backing	
	.10	Φ	Root spacing	
	.11	±	Retainers	
QW-403 Base Metals	.5	Φ	Group Number	
	.6		T Limits impact	
	.8	Φ	T Qualified	X
	.9		t Pass > 1/2 in. (13 mm)	X
QW-404 Filler Metals	.11	Φ	P-No. qualified	X
	.4	Φ	F-Number	X
	.5	Φ	A-Number	X
	.6	Φ	Diameter	
	.7	Φ	Diameter > 1/4 in. (6 mm)	
	.12	Φ	Classification	
	.30	Φ	t	X
QW-405 Positions	.33	Φ	Classification	
	.1	+	Position	
	.2	Φ	Position	
QW-406 Preheat	.3	Φ	↑ ↓ Vertical welding	
	.1		Decrease > 100°F (55°C)	X
	.2	Φ	Preheat maint.	
QW-407 PWHT	.3		Increase > 100°F (55°C) (IP)	
	.1	Φ	PWHT	X
	.2	Φ	PWHT (T & T range)	
QW-409 Electrical Characteristics	.4		T Limits	X
	.1		Heat input	
	.4	Φ	Current or polarity	
QW-410 Technique	.8	Φ	I & E range	
	.1	Φ	String/weave	
	.5	Φ	Method cleaning	
	.6	Φ	Method back gouge	
	.9	Φ	Multiple to single pass/side	
	.25	Φ	Manual or automatic	
	.26	±	Peening	
	.64		Use of thermal processes	X

Legend:

+ Addition, > Increase/greater than, ↑ Uphill, ← Forehand, Φ Ch
 - Deletion, < Decrease/less than, ↓ Downhill, → Backhand

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A red circular graphic with a gradient, appearing as a stylized arrow or a partial circle, located to the right of the author's name.

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