WORTHINGTON, SKILLING, HELLE & JACKSON — Civil & Structural Engineers

PROJECT: WORLD TRADE CENTER | TITLE: EXT. WALL TO ELEV. 363 - GENERAL NOTES | DATE: 2-17-67

REVISIONS

3-15-67

SCHEDULE OF WELDING ELECTRODES**

(# For Fy = 36 ksi)

1.) ASTM A233 class E70xx electrodes
2.) Grade SAW-2 Submerged Arc Welding

36 < Fy, ≤ 50

1.) ASTM A233 class E70xx electrodes
2.) Grade SAW-2 Submerged Arc Welding

50 ≤ Fy, ≤ 55

1.) ASTM A233 class E70xx electrodes
2.) Submerged Arc Welding *

55 ≤ Fy, ≤ 60

1.) ASTM A316 class E80xx electrodes
2.) Submerged Arc Welding *

60 ≤ Fy, ≤ 65

1.) ASTM A316 class E80xx electrodes
2.) Submerged Arc Welding *

65 ≤ Fy, ≤ 70

1.) ASTM A316 class E80xx electrodes
2.) Submerged Arc Welding *

70 ≤ Fy, ≤ 80

1.) ASTM A316 class E90xx electrodes
2.) Submerged Arc Welding *

80 ≤ Fy, ≤ 90

1.) ASTM A316 class E100xx electrodes
2.) Submerged Arc Welding *

90 ≤ Fy, ≤ 100

1.) ASTM A316 class E110xx electrodes
2.) Submerged Arc Welding *

* Submerged arc welding shall conform to the specifications.
** Low hydrogen electrodes shall be used for all manual arc welding.

(# Fy indicated is the lower Fu of the plates joined)

GENERAL NOTES

1. Provide ⅛"x2" or larger backing strips for all butt welds made against column plates; fillet welds to these column plates shall be increased in size in accordance with AWS specifications.
2. Where any separation between plates to be joined by fillet welds exceeds 3/16", filler plates shall be used and overlapped according to AWS specifications.
3. All welding to be done using electrodes as scheduled this sheet.
4. F.P. ⟩— indicates full penetration weld

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1-A2-44