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

PROJECT THE WORLD TRADE CENTER | TITLE EXTERIOR WALL - TREE - WELDING ELECTRODES & NOTES | DATE 4-7-67

REVISIONS

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 Fy of the plates joined

GENERAL NOTES

1. All welding to be done using electrodes as scheduled this sheet.
2. F.P.)— indicates full penetration weld.

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