



in the program.

multi-cert steel is to be used in an A36 application, the actual A36 welding procedures are applicable.

Consumers

changeable.
The weld program produced no weld cracking. Radiographic inspection revealed only isolated areas of light porosity. All bend specimens were acceptable. Tensile specimens all fractured in the

tions for both ASTM A36 and A572 Grade 50

steels. This quality grade capability was achieved by careful selection and control of steel chemistry.

The intent of this program was to demonstrate whether or not these two somewhat different steel products could be welded using identical welding procedures.

*** Another response:**

The following is in reply to the two questions regarding welding:

Vertical deflections (for the crane runway) should not exceed L/400 based on 10 percent of maximum wheel load(s) without impact. The vertical deflection should not exceed L/600 based on maximum wheel load(s) without impact. Gantry and other types of special cranes may require additional consideration.