

WELDING PROCEDURE SPECIFICATION

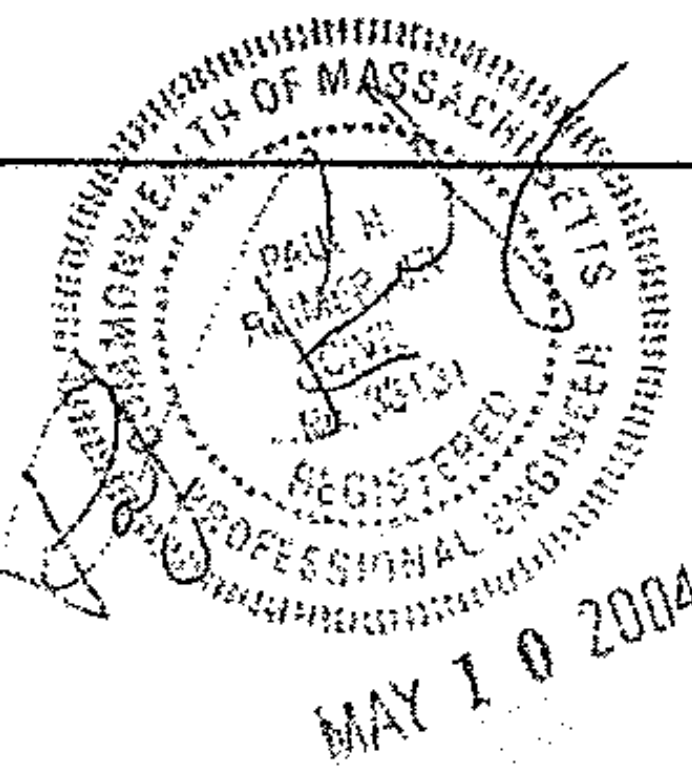
MATERIAL SPECIFICATION _____
 WELDING PROCESS SMAW
 MANUAL, SEMIAUTOMATIC OR AUTOMATIC MANUAL
 POSITION OF WELDING HORIZONTAL
 FILLER METAL SPECIFICATION AWS A5.1
 FILLER METAL CLASSIFICATION E7018
 ELECTRODE AND MANUFACTURER JETWELD LH-73 LINCOLN ELECTRIC (Conforms to AWS5.1, ASME SFA-5.1)
 FLUX AND MANUFACTURE N/A
 SHIELDING GAS N/A DEW POINT N/A FLOW RATE N/A
 SINGLE OR MULTIPLE PASS SINGLE PASS
 SINGLE OR MULTIPLE ARC SINGLE ARC
 WELDING CURRENT DC
 POLARITY REVERSED
 WELDING PROGRESSION N/A
 ROOT TREATMENT REMOVE RUST, SLAG, MOISTURE, GREASE & ANY FOREIGN MATERIAL
 PREHEAT AND INTERPASS TEMPERATURE N/A
 POSTHEAT TEMPERATURE N/A

WELDING PROCEDURE

PASS NO.	ELECTRODE SIZE	WELDING PARAMETERS		TRAVEL SPEED	JOINT DETAIL
		AMPERES	VOLTS		
1	1/8	200 <i>RECOMMENDED 90-150</i>	N/A	12" PER MINUTE	

THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT-UP, PASS SIZE, ETC., WITHIN THE LIMITATION OF VARIABLES VARIABLES GIVEN IN SECTION 8A.

PROCEDURE NO.: 711.2 FABRICATOR OR ERECTOR: J & B WELDING
 REVISION NO.: _____ AUTHORIZED BY: _____
 DATE: _____



VT RANS
RECEIVED

CK'D BY _____ OK'D BY JWC

MAR 06 2009 AS

REQUEST APPROVED NOTED

BY _____ DATE 3/10/09

Welding Procedure Qualified AC-119 091-1135