



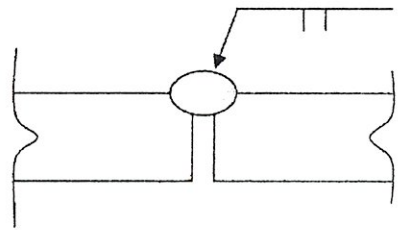
Parts and Service to meet your specific project needs

MAR 27 2008

WELD PROCEDURE SPECIFICATION
Per WPQR # GMAW-01

MATERIAL SPECIFICATION: A709, A36, A572 Grade 36 & 50
 WELDING PROCESS: GMAW
 MANUAL OR MACHINE: Semi-Automatic
 POSITION OF WELDING: Horizontal
 FILLER METAL SPECIFICATION: A5.18
 FILLER METAL CLASSIFICATION: ER70S-6
 FILLER METAL MANUFACTURER: Hobart
 SHIELDING GAS: AR 92% CO2 8% DEW POINT: -60°F FLOW RATE: 35 CFH
 SINGLE OR MULTIPLE PASS: Single
 SINGLE OR MULTIPLE ARC: Single ELECTRODE STICKOUT: 3/4 max
 WELDING CURRENT: DC+
 POLARITY: Reverse
 WELDING PROGRESSION: Forward (Stringer Bend)
 ROOT TREATMENT: Free of dirt, rust and oil
 PREHEAT AND INTERPASS TEMP. ≤ 3/4" = 50°F ≤ 1 1/2" = 70°F ≤ 2 1/2" = 150°F (Minimums)
 POSTHEAT TREATMENT: N/A

WELDING PROCEDURE

Weld Size	Electrode Size	Welding Current		Travel Speed ^{"/Min}	Joint Detail Square groove seal weld
		Amps	Volts		
All	1/16	247 - 302	27 - 31	9 - 11	 <p>Material thickness and shape per approved drawings Seal weld on one side only</p>

THIS PROCEDURE MAY VARY DUE TO THE FABRICATION SEQUENCE, FIT-UP, PASS SIZE, ETC., WITHIN THE LIMITATIONS OF VARIABLES GIVEN IN TABLE 5.3 OF AWS D1.5-2002 BRIDGE WELDING CODE.

PROCEDURE NO: Seal Weld MANUFACTURER: Niagara Bridge and Rail

REVISION NO: 0 AUTHORIZED BY: *Thomas F. Wright*

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DATE: MAR 27 2008

REVISION: 0

BY: *JWC*

DATE: 5/12/08