

PROJECT NAME _____
 QUALIFIED JOINT WELDING PROCEDURE PROJECT NUMBER _____
 PROCEDURE SPECIFICATION _____

Material specification A36/A572-65RR
 Welding process FCAW
 Manual or machine SEMI-AUTOMATIC
 Position of welding FLAT for groove welds Horizontal for fillet welds 1G, 2F
 Filler metal specification AWS 5.20
 Filler metal classification ALLOY RODS SHAL SHIELD T1 T1 MILTR (E71T-1)
 Flux N/A
 Shielding gas CO₂ Flow rate 25 CFH
 Single or multiple pass SINGLE AND MULTIPLE
 Single or multiple arc SINGLE ELECTRICAL STICK-OUT 3/8"-5/8"
 Welding current DC
 Polarity REVERSE
 Welding progression N/A
 Root treatment NONE
 Preheat and interpass temperature 50° to 250° F (10° to 150° C) MIN
 Postheat treatment NONE
 Supported by PQR 007 and 008

WELDING PROCEDURE _____
 DATE _____
 JWC

Pass no.	Electrode size	Welding current		Travel speed (IPM)	Weld size (in)	RESUBMIT Joint detail BY DATE	APPROVED DATE
		Amperes	Volts				
GROOVE WELDS							
1	.045	220-240	26-28	16-18	3/16"		AUG 19 2008 9/1/08
1	.045	220-240	26-28	10-12	1/4"		
all	.045	220-240	26-28	14-16	5/16"		
FILLET WELDS							
FILLET WELDS SHALL EQUAL 1/4 OF t							
BUT NOT MORE THAN 3/8"							
SEE PROCEDURE DS-16 FOR PARAMETERS OF FILLET WELDS							

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in Section 5.

Procedure no. DS-13 Contractor Merrimack Sheet Metal, Inc.
 Revision no. _____ Authorized by Scott Blundetto
 Form E-2 Date 1/26/01