

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

Material specification A36-A572-A588
 Welding process FCM
 Manual or machine SEMI-AUTOMATIC
 Position of welding FLAT OR HORIZONTAL
 Filler metal specification AWS 5.20
 Filler metal classification ALLOY RODS DUAL SHIELD TT 71 ULTRA (E71T-1)
 Flux N/A
 Shielding gas CO₂ Flow rate 35 CFH
 Single or multiple pass SINGLE AND MULTIPLE
 Single or multiple arc SINGLE ELECTRICAL STICK-OUT 3/8" - 3/4"
 Welding current DC
 Polarity REVERSE
 Welding progression N/A
 Root treatment NONE
 Preheat and interpass temperature 50 TO 275 F (10 TO 135 C)
 Postheat treatment NONE
 Supported by WPS_007_and_008

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OK'D BY _____ OK'D BY JWC

Pass no.	Electrode size	Welding current		Travel speed (IPM)	Weld size (in)	APPROVED by _____ DATE <u>7/4/08</u>
		Amperes	Volts			
1	.045	220-240	26-28	16-18	3/16"	
1	.045	220-240	26-28	12-13	1/4"	
All	.045	210-230	25-27	9-10	5/16"	
1	.045	220-240	26-28	16-18	3/8" (3 passes)	
2	.045	220-240	26-28	16-18		
3	.045	220-240	26-28	16-18		
1	.045	210-230	25-27	9-11	7/16" (3 passes)	
2	.045	210-230	25-27	9-11		
3	.045	210-230	25-27	9-11		

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-16 Contractor Merrimack Sheet Metal, Inc.
 Authorized by [Signature]
 Revision 1/22/07