

PROJECT NAME BELVIN
 PROJECT NUMBER 11261-102

PREQUALIFIED JOINT WELDING PROCEDURE PROJECT NUMBER 11261-102
 PROCEDURE SPECIFICATION

Material specification A36/A572, A588 SINGLE PASS ONLY TO A-635 (see note)
 Welding process FCAW
 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 NITRA (E71T-1)
 Flux N/A
 Shielding gas CO₂ Flow rate 27-37.5 CFM
 Single or multiple pass SINGLE
 Single or multiple arc ELECTRICAL STICK-OUT 3/8"-3/4"
 Welding current DC
 Polarity REVERSE
 Welding progression N/A
 Root treatment NONE
 Preheat and interpass temperature 255°F CE 65°F 65-75°F 65-75°F 50°F
 Postheat treatment NONE
 Supported by WPS

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed (IPM)	Weld size (IP)	Groove depth (IP)	Joint detail
		Amperas	Volts				
1	.045	220-240	26-28	10-12	1/8"	5/16"	

TRANS RECEIVED
 OK'D BY JUL
 SEP 04 2008
 RESUBMIT APPROVED
 BY JUL DATE 9/4/08

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-18 Contractor Merrimack Sheet Metal, Inc.
 Revision no. _____ Authorizes by Scott Beal
 Form 6-2 Date 1126101