

MANUFACTURER: HARRIS WELCO
 FLUX—INTERNAL
 SHIELDING GAS—ARGON
 SINGLE OR MULTIPLE PASSES SINGLE
 SINGLE OR MULTIPLE ARC SINGLE
 WELDING CURRENT—DC
 POLARITY: REVERSE (EN)
 WELDING PROGRESSION—
 ROOT TREATMENT—CLEANED & PREPARED BRIGHT METAL
 PREHEAT AND INTERPASS TEMPERATURE—SEE BELOW
 POSTHEAT TEMPERATURE N/A
 HEAT INPUT MIN.——— MAX.——

CLASSIFICATION: A5.9
 TRADENAME:
 FLOW RATE: 45 CFH
 RESUBMIT BY
 APPROVED: V
 DATE 11-16-07

WELDING PROCEDURE

PASS NO.	ELECTRODE SIZE	WELDING CURRENT AMPERES	VOLTS	TRAVEL SPEED	JOINT DETAIL
ALL	3/32"	130-155	14-17	6.75-8.5	LAP JOINT
16 GA THRU 10 GA BM THICKNESS					

PREHEAT TEMPS.

THICKNESS	TEMP.
UP TO 3/4"	100 DEG.
OVER 3/4" TO 1 1/2"	100 DEG.
OVER 1 1/2" TO 2 1/2"	100 DEG.
OVER 2 1/2"	100 DEG.

***PREHEAT UNTIL NO MOSITURE PRESENT

THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT-UP, PASS SIZE, ETC.
 WITHIN THE LIMITATION OF VARIABLES GIVEN IN SECTION 5.

SUPPORTING PQR: GTAW-WF-05
 PROCEDURE NO. GTAW-WF

CONTRACTOR: COSMEC INC.
 AUTHORIZED BY: DONALD VOSE
 CWI#:01100651 *Donald Vose*

REVISION NO. 1

DATE:— 2/1/2005

