

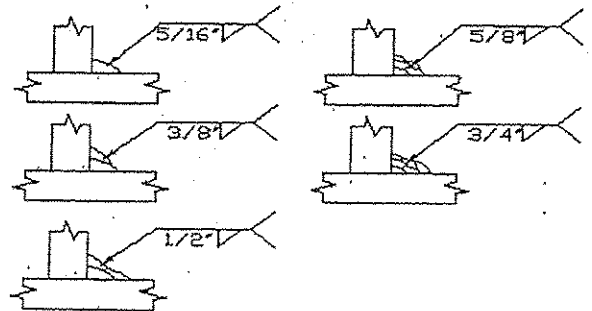
FILLER METAL SPECIFICATION: AWS 5.20  
 MANUFACTURER: LINCOLN ELECTRIC  
 FLUX: INTERNAL  
 SHIELDING GAS: CO2  
 SINGLE OR MULTIPLE PASSES: MULTIPLE  
 SINGLE OR MULTIPLE ARC: SINGLE  
 WELDING CURRENT: DC  
 POLARITY: REVERSE (EP)  
 WELDING PROGRESSION:

CLASSIFICATION: E71T  
 TRADENAME: E71T OUTERSHIELD  
 FLOW RATE: 45 CFH

ROOT TREATMENT: CLEANED & PREPARED BRIGHT METAL  
 PREHEAT AND INTERPASS TEMPERATURE: SEE BELOW  
 POSTHEAT TEMPERATURE: N/A  
 HEAT INPUT: MIN. MAX.

**WELDING PROCEDURE**

PASS NO.	ELECTRODE SIZE	WELDING CURRENT		TRAVEL SPEED	JOINT DETAIL
		AMPERES	VOLTS		
ALL	0.045	190-230	27-29	8-9	



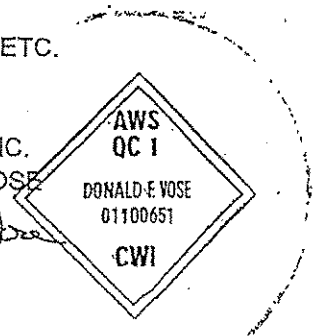
**PREHEAT TEMPS.**

THICKNESS	TEMP.
UP TO 3/4"	50 DEG. F
OVER 3/4" TO 1 1/2"	70 DEG. F
OVER 1 1/2" TO 2 1/2"	150 DEG. F
OVER 2 1/2"	225 DEG. F
<b>INTERPASS TEMP:</b>	400 DEG. F

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

PROCEDURE NO. FCAW-FILLET  
 SUPPORTING PQR: FCAW-1.0-05  
 REVISION NO.

CONTRACTOR: COSMEC INC.  
 AUTHORIZED BY: DONALD VOSE



DATE: 1/31/2005

**VTRANS RECEIVED**

OK'D BY: JWC

OCT 16 2007

RESUBMIT: APPROVED ✓

BY: DATE 11-16-07