

WELDING PROCESS: GMAW
 MANUAL OR MACHINE: Semi-Automatic
 POSITION OF WELDING: Horizontal
 FILLER METAL SPECIFICATION: A5.18
 FILLER METAL CLASSIFICATION: ER70S-6
 FILLER METAL MANUFACTURER: Hobart
 SHIELDING GAS: AR 92% CO2 8% DEW POINT: -60°F FLOW RATE: 35 CFH
 SINGLE OR MULTIPLE PASS: Single
 SINGLE OR MULTIPLE ARC: Single ELECTRODE STICKOUT: 3/4
 WELDING CURRENT: DC+
 POLARITY: Reverse
 WELDING PROGRESSION: Forward (Stringer Bead)
 ROOT TREATMENT: N/A
 PREHEAT AND INTERPASS TEMP. ≤ 1/2" = 50°F ≤ 1 1/2" = 70°F ≤ 2 1/2" = 150°F (Minimums)
 POSTHEAT TREATMENT: N/A

WELDING PROCEDURE

Weld Size	Electrode Size	Welding Current		Travel Speed "/Min	Joint Detail Fillet
		Amps	Volts		
ALL	1/16	247 - 302	27 - 31	9 - 11	

THIS PROCEDURE MAY VARY DUE TO THE FABRICATION SEQUENCE, FIT-UP, PASS SIZE, ETC., WITHIN THE LIMITATIONS OF VARIABLES GIVEN IN TABLE 5.3 OF AWS D1.5-2002 BRIDGE WELDING CODE.

PROCEDURE NO: GMAW 01 Fillet MANUFACTURER: Niagara Bridge and Rail

REVISION NO: 0 AUTHORIZED BY: Thomas F. Wright

TRANS RECEIVED

OK'D BY _____ OK'D BY JWC

MAR 27 2008

RESUBMIT _____ APPROVED ✓

BY _____ DATE 4/22/03