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V. TRAVIS

OK'D BY: JWC PROJECT NAME: MORROW
 JUN 09 2009 APPROVED: [Signature] PROJECT NUMBER: STP DECK (37)
 BY: DATE: 6/9/09 PREQUALIFIED JOINT WELDING PROCEDURE PROJECT NUMBER: STP DECK (37)
 PROCEDURE SPECIFICATION

Material specification: A36-A572-A588
 Welding process: FCAW
 Manual or machine: SEMI-AUTOMATIC
 Position of welding: FLAT OR HORIZONTAL
 Filler metal specification: E6010
 Filler metal classification: ALLOY RODS DUAL SHIELD TIG ULTRA (E71T-1)
 Flux: N/A
 Shielding gas: CO2 Flow rate: 25 CFH
 Single or multiple pass: SINGLE AND MULTIPLE
 Single or multiple arc: SINGLE ELECTRICAL STICK-OUT 3/8" - 2/8"
 Working current: DC
 Polarity: REVERSE
 Welding progression: N/A
 Root treatment: NONE
 Preheat and interpass temperature: 50° to 250° INCL. 70° to 150° INCL. 250° to 275° INCL.
 Postheat treatment: NONE
 Supported by: WPS 007 and 008

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed (IPM)	Weld size (in)	Joint detail
		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 1/3/17