

WELDING PROCEDURE SPECIFICATION

PQR ELDERLEE#1

Material Specification	A572 GRD. 50 /A992-06a		
Welding Process	FCAW		
Manual or Machine	SEMAUTOMATIC		
Position of Welding	FLAT/HORIZONTAL		
Filler Metal Specification	A5.20		
Filler Metal Classification	E70 LINCOLN OUTERSHEILD		
Flux	N/A		
Shielding Gas	CO 2	Dew Point	-40DEG F Flow Rate 50 CFM
Single or Multiple Pass	SINGLE		(45 TO 63 CFM)
Single or Multiple Arc	N/A		
Welding Current	DC		
Polarity	DCEP		
Welding Progression	STRINGER		
Root Treatment	PER D1.5		
Preheat and Interpass Temperature	PER D1.5		
Postheat Temperature	NONE		
Heat Input	Min		Max

WELDING PROCEDURE.

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	3/32	390	27	12	
Variable	LIMITS	351 TO 429	25 TO 29	11 TO 13	
<p>Trans Received <i>JWC</i></p> <p>CK'D _____ CK'D BY _____</p> <p>AUG 06 2014</p> <p>Resubmit BY _____ APPROVED DATE <i>8/12/14</i></p>					

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in Section 5.

Procedure No. 3027

Contractor Elderlee, Inc.

Revision No. _____

Authorized By RANDY SCOTT

Date 4/4/2014