

**WELDING PROCEDURE SPECIFICATION**

Material Specification	ASTM A500 GRD. B A36		
Welding Process	FCAW		
Manual or Machine	SEMIAUTOMATIC		
Position of Welding	FLAT		
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

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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	
	CK'D	VTrans Received OK'd BY	JWC		
		AUG 06 2014			
	Resubmit BY	APPROVED DATE	8/12/14		

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

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Contractor Elderlee, Inc.  
Authorized By RANDY SCOTT  
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