

**WELDING PROCEDURE SPECIFICATION**  
PQR ELDERLEE #3

Material Specification	ASTM-A500-A53-GRADE B TO A36
Welding Process	FCAW-G
Manual or Machine	SEMAUTOMATIC
Position of Welding	FLAT/HORIZONTAL
Filler Metal Specification	A5.29
Filler Metal Classification	E81T1-Ni1C-JH4
Flux	N/A
Shielding Gas	CO 2 Dew Point -40DEG F FLOW RATE 50 CFH
Single or Multiple Pass	SINGLE
Single or Multiple Arc	SINGLE
Welding Current	DC
Polarity	REVERSE ELECTRODE POSITIVE
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	1/16	310	25	11	
Variable	LIMITS	341 TO 289	27 TO 23	12 TO 10	
CK'D _____ AUG 06 2014 Resubmit BY _____		/Trans Received OK'D BY <u>JWC</u> APPROVED DATE <u>8/12/14</u>			

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

Procedure No. 3012 Contractor Elderlee, Inc.  
 Revision No. \_\_\_\_\_ Authorized By RANDY SCOTT  
 Date 3/20/2014