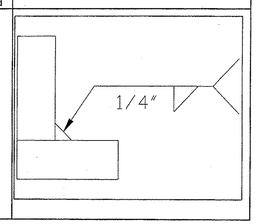
WELDING PROCEDURE SPECIFICATION

Material Specification	A709 TO A500 GR B
Welding Process	FCAW
Manual or Machine	SEMAUTOMATIC
Position of Welding	FLAT
Filler Metal Specification	A5.20 - 95
Filler Metal Classification	E71T-1H8 E71T-9H8 LINCOLN ULTRACORE
Flux	N/A
Shielding Gas	CO 2 Dew Point -40DEG F Flow Rate 50CFH
Single or Multiple Pass	SINGLE
Single or Multiple Arc	SINGLE
Welding Current	DC
Polarity	REVERSE ELECTRODE POSITIVE
Welding Progression	STRINGER
Root Treatment	CLEAN AS PER SECTION 603 OF THE NYSSCM
Preheat and Interpass Temperature	PREHEAT AS PER TABLEL 708 OF THE NYSSCM
Postheat Temperature	NONE
Heat Input	Min _____ Max _____

WELDING PROCEDURE.

Pass no.	Electrode size	Welding Current Amperes	Welding Current Volts	Travel speed	Joint detail
1	1/16	300	26	14	
Variable	LIMITS	270 TO 330	24 TO 28	12.6 TO 15.4	

VTrans Received
CK'D _____ DK'd BY JWC
OCT 18 2011
Resubmit _____ APPROVED ✓
BY _____ DATE 10/19/11

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

Procedure No. 3009
Revision No. _____

Contractor Elderlee, Inc.
Authorized By RANDY SCOTT
Date 10/18/2011

Form III-2

Form III-2-Sample Welding Procedure Specification