

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 TABLE 708 OF THE NYSSCM

Postheat Temperature

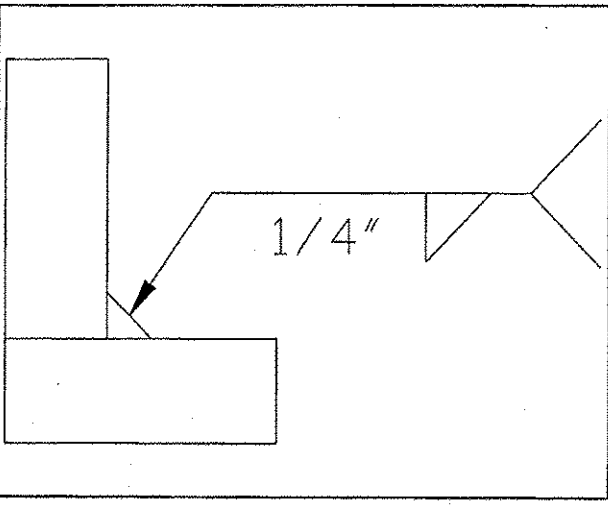
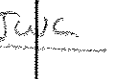
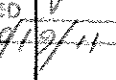
NONE

Heat Input

Min

Max

WELDING PROCEDURE.

| Pass no.                                                                                                         | Electrode size | Welding Current           |       | Travel speed | Joint detail                                                                        |
|------------------------------------------------------------------------------------------------------------------|----------------|---------------------------|-------|--------------|-------------------------------------------------------------------------------------|
|                                                                                                                  |                | Amperes                   | Volts |              |                                                                                     |
| 1                                                                                                                | 1/16           | 300                       | 26    | 14           |  |
| Variable                                                                                                         | LIMITS         | 270                       | 24    | 12.6         |                                                                                     |
|                                                                                                                  |                | TO                        | TO    | TO           |                                                                                     |
|                                                                                                                  |                | 330                       | 28    | 15.4         |                                                                                     |
| VTrans<br>Revised<br>OK'd BY  |                |                           |       |              |                                                                                     |
| OCT 18 2011                                                                                                      |                |                           |       |              |                                                                                     |
| Resubmit<br>BY                |                | APPROVED<br>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