

WELDING PROCEDURE SPECIFICATION

Material Specification	A572 GRD. 50 /A992-06a		
Welding Process	FCAW		
Manual or Machine	SEMAUTOMATIC		
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	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	3/32	390	27	12	
Variable	LIMITS	351 TO 429	25 TO 29	11 TO 13	
Vtrans Received GRD BY: OCT 18 2011 Re-submit BY: APPROVED:					

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

Procedure No. 3008 Contractor Elderies, Inc.
Revision No. Authorized By RANDY SCOTT
Date 10/18/2011