

AWD D1.5
WELDING PROCEDURE SPECIFICATION

MATERIAL SPECIFICATION:	ASTM: A709 Gr. 250, 345, & 345W (painted); A36, A572, A588 (painted) (ref. AWS D1.5:2002, sect. 1.2 & 5.4)
WELDING PROCESS:	GMAW
MANUAL OR MACHINE:	Semi-Automatic
POSITION OF WELDING:	Flat Horizontal
FILLER METAL SPECIFICATION:	A5.18
FILLER METAL CLASSIFICATION:	BR708-C
FILLER METAL MANUFACTURER:	HOBART BR-C
SHIELDING GAS: Ar - 98%, O ₂ - 2%	DEW POINT: -40°F min. FLOW RATE: 37 - 49 CFH
SINGLE OR MULTIPLE PASS:	Multiple
SINGLE OR MULTIPLE ARC:	Single ELECTRODE STICKOUT: 3/4" ± 1/4"
WELDING CURRENT:	DCBP
WELDING PROGRESSION:	Forward
ROOT TREATMENT:	Surfaces shall be smooth and uniform, and free of discontinuities, loose or thick scale, slag, rust, moisture, grease/oil, and other foreign material. (ref. AWS D1.5:2002, 3.2.1)
PREHEAT AND INTERPASS TEMP.:	Minimum: ≤ 3/4" = 50°F; over 3/4" to 1-1/2" = 70°F; over 1-1/2" to 2-1/2" = 150°F; over 2-1/2" = 225°F Maximum: 450°F
POSTHEAT TREATMENT:	N/A

WELDING PROCEDURE

Weld Size - # of Passes	Electrode Size	Welding Current		Travel Speed "/Min	Joint Detail B-3-Q
		Amps	Volts		
All	.045	265-280	27.5-30	10.0-11.0	
T ₁ = 1/2" min T ₂ = 1/8" min α = 60° R = 0 S ₁ + S ₂ = 1/3 T					

*** This procedure may vary within the limitations identified in AWS D1.5:2003 "Welding Code" ***

PROCEDURE NO: GMAW-07 REVISION NO: 0-2010
 QUALIFYING PQR: WBA - GMAW 2010 -A PQR REQUAL DATE: 11/09/15
 MANUFACTURER: Watson Boyman Acme Corp. AUTHORIZED BY: [Signature]
Gregory Ross - Quality Control Manager

Trans Received
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ORFORD ROSS
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