

**AWS D1.5**  
**WELDING PROCEDURE SPECIFICATION**

MATERIAL SPECIFICATION:	ASTM: A709 Gr. 250, 345 & 345W (painted); A36, A572, A588(painted) (ref. AWS D1.5:2002 sect. 3.2 & 3.4)
WELDING PROCESS:	GMAW
MANUAL OR MACHINE:	Semi-Automatic
POSITION OF WELDING:	Flat & Horizontal
FILLER METAL SPECIFICATION:	A5.18
FILLER METAL CLASSIFICATION:	ER70S-6
FILLER METAL MANUFACTURER:	HOBART ER-6
SHIELDING GAS: Ar - 98% O <sub>2</sub> - 2%	DRY POINT: -40°F min. FLOW RATE: 37-49 GPH
SINGLE OR MULTIPLE PASS:	Single (S) or Multiple (S)
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	Electrode Size	Welding Current		Travel Speed, in/min	Joint Detail Fillet
		Amps	Volts		
≤ 5/16 (S)	.045	265-280	27.5-30	10.0 - 11.0	
≥ 5/16 (S)	.045	265-280	27.5-30	10.0 - 11.0	

\*\*\* This procedure may vary within the limitations identified in AWS D1.5:2008 "Bridge Welding Code", \*\*\*

PROCEDURE NO: GMAW-11 REVISION NO: 0-2010

QUALIFYING PQR: WBA - GMAW-2010 & GMAW-CS-2007 Fillet PQR REQ'AL DATE: 11/09/13

MANUFACTURER: Watson Bowman Acme Corp. AUTHORIZED BY: [Signature]  
Gregory V. Ross - Quality Control Manager

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OR'D BY: [Signature]



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Resubmit APPROVED BY: [Signature] DATE: 4/25/12