

**WELDING PROCEDURE SPECIFICATION**

Material Specification	ASTM-A36 A709 GR 36 CVN	
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	
Welding Progression	STRINGER	
Root Treatment	PER D1.5	
Preheat and Interpass Temperature	PER D1.5	
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 330	TO 28	TO 15.4	

RECEIVED  
 CK'D BY JWC OK'D BY JTS  
 June 5, 2013  
 RESUBMIT NO Approved  
 BY KMH DATE 6-12-2013

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

Procedure No. 3016 Contractor Elderlee, Inc.  
 Revision No. \_\_\_\_\_ Authorized By RANDY SCOTT  
 Date 1/3/2013