

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	
Trans Received OK'd BY OCT 18 2011 APPROVED BY 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

Contractor

Elderlee, Inc.

Revision No.

Authorized By

RANDY SCOTT

Date

10/18/2011