

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                                   |  |                                     |
| Single or Multiple Pass           | SINGLE                                 |  | Dew Point -40DEG F Flow Rate 50 CFM |
| Single or Multiple Arc            | N/A                                    |  | (45 TO 63 CFM)                      |
| 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                                 |

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| 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<br>Received<br>GRD BY: |                |                 |          |              |              |
| OCT 18 2011                   |                |                 |          |              |              |
| Resubmit BY:                  |                | APPROVED:       |          |              |              |
|                               |                | DATE: 10/17/11  |          |              |              |

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

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