

WELDING PROCEDURE SPECIFICATION

Material Specification	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	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	TO	TO	
		330	28	15.4	

CK'D	Vars Received CK'D BY	JWC
	JAN 07 2014	
Resubmit BY	APPROVED DATE	✓ 1/8/14

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

Procedure No. 3007 Contractor Elderlee, Inc.
 Revision No. _____ Authorized By RANDY SCOTT
 Date 5/29/2013