

WELDING PROCEDURE SPECIFICATION

Material Specification	A36
Welding Process	GMAW
Manual or Machine	SEMAUTOMATIC
Position of Welding	FLAT
Filler Metal Specification	A5.18
Filler Metal Classification	L-50 .052 LINCOLN
Flux	N/A
Shielding Gas	90% ARGON /10% CO2 Dew Point -40DEG F Flow Rate 50 CFM
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		
	.052	430	32	13	
Variable	LIMITS	387 TO 473	29 TO 34	12 TO 14	

CK'D _____
 7/Trans Received OK'd BY Juc
 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. 3040 Contractor Elderlee, Inc.
 Revision No. _____ Authorized By RANDY SCOTT
 Date 12/20/2011