

154/Appendix IV

JOINT WELDING
PROCEDURE SPECIFICATION

Material specification A-36
 Welding process SMAW
 Manual or machine Manual
 Position of welding all
 Filler metal specification AWS A5.5-A5.1
 Filler metal classification E-7018
 Flux n/a
 Shielding gas n/a Flow rate n/a
 Single or multiple pass as required
 Single or multiple arc n/a
 Welding current DC
 Polarity R-P
 Welding progression as required
 Root treatment none
 Preheat and interpass temperature 50-175
 Postheat treatment n/a

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	SEE ATTACHED SHEET #2 Joint detail BU4a
		Amperes	Volts.		
AS Req.	1/8	90-130	22-24	As Req.	
	5/32	120-240	22-27		

VTRANS RECEIVED
 OK'D BY _____ OK'D BY Juc
 MAY 18 2010
 RESUBMIT APPROVED AS NOTED
 BY JEL DATE 5/20/10

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

Procedure no. _____ Contractor S. D. Ireland, Inc.
 Revision no. _____ Authorized by _____
 Form E-2 Date _____