

COSMEC INC.

WELDING PROCEDURE SPECIFICATION

SPECIFICATIONS AND CODE: AASHTO-AWS D1.5  
 MATERIAL SPECIFICATION ASTM A709 GR 50W, GR 50, GR 36  
 WELDING PROCESS: FCAW-G  
 MANUAL OR MACHINE: SEMI-AUTOMATIC  
 POSITION OF WELDING: 1F & 2F  
 FILLER METAL SPECIFICATION AWS 5.20  
 MANUFACTURER: LINCOLN ELECTRIC  
 FLUX: INTERNAL  
 SHIELDING GAS: CO2  
 SINGLE OR MULTIPLE PAS: MULTIPLE  
 SINGLE OR MULTIPLE ARC: SINGLE  
 WELDING CURRENT: DC  
 POLARITY: REVERSE (EP)  
 WELDING PROGRESSION: \_\_\_\_\_  
 ROOT TREATMENT: CLEANED & PREPARED BRIGHT METAL  
 PREHEAT AND INTERPASS TEMPERATURE: SEE BELOW  
 POSTHEAT TEMPERATURE: N/A  
 HEAT INPUT MIN: \_\_\_\_\_ MAX: \_\_\_\_\_

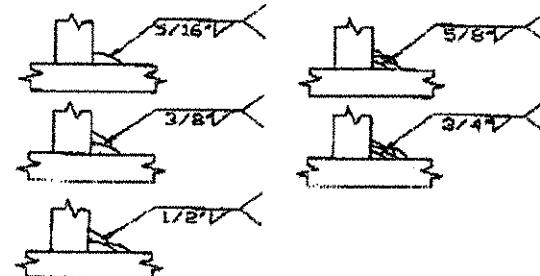
CLASSIFICATION: E71T  
 TRADENAME: E71T OUTERSHIELD  
 FLOW RATE: 45 CFH

WELDING PROCEDURE

PASS NO.	ELECTRODE SIZE	WELDING CURRENT AMPERES	TRAVEL SPEED VOLTS	JOINT DETAIL
ALL	0.045	190-230	27-29	8-9

PREHEAT TEMPS.

THICKNESS TTEMP.  
 UP TO 3/4" 50 DEG. F  
 OVER 3/4" TO 1 1/2" 70 DEG. F  
 OVER 1 1/2" TO 2 1/2" 150 DEG. F  
 OVER 2 1/2" 225 DEG. F  
 INTERPASS TEMP: 400 DEG. F



THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT-UP, PASS SIZE, ETC. WITHIN THE LIMITATION OF VARIABLES GIVEN IN SECTION 5.

PROCEDURE NO. FCAW-FILLET  
 SUPPORTING PQR: FCAW-1.0-05  
 REVISION NO.

CONTRACTOR: COSMEC INC.  
 AUTHORIZED BY: DONALD VOSE

DATE: 1/31/2005



TRANS RECEIVED

OK'D BY: JWC

APR 11 2005

RESUBMIT APPROVED BY: DATE 4-13-05