

degussa.
Construction Chemicals Americas

TRANS RECEIVED
CK'D BY JWC
JUN 28 2005
RESUBMIT APPROVED
BY _____ DATE 7-29-05

PROCEDURE SPECIFICATION
PQR 3 or 4

MATERIAL SPECIFICATION: A588 to A588
 WELDING PROCESS: GMAW
 MANUAL OR MACHINE: Semi-Automatic
 POSITION OF WELDING: Horizontal
 FILLER METAL SPECIFICATION: A5.18
 FILLER METAL CLASSIFICATION: ER70S-6
 FILLER METAL MANUFACTURER: Hobart
 SHIELDING GAS: AR 98% O 2% DEW POINT: -80°F FLOW RATE: 35 CFH
 SINGLE OR MULTIPLE PASS: Single
 SINGLE OR MULTIPLE ARC: Single ELECTRODE STICKOUT: 3/4
 WELDING CURRENT: DC+
 POLARITY: Reverse
 WELDING PROGRESSION: Forward (Stringer Bead)
 ROOT TREATMENT: N/A
 PREHEAT AND INTERPASS TEMP. ≤ 3/8" = 50°F ≤ 1/2" = 70°F ≤ 2/4" = 150°F (Minimums)
 POSTHEAT TREATMENT: N/A

WELDING PROCEDURE

Weld Size	Electrode Size	Welding Current		Travel Speed "/Min	Joint Detail Fillet
		Amps	Volts		
3/16	.045	225 - 245	27.5 - 29	9 - 11	
1/4	.045	225 - 245	27.5 - 29	9 - 11	
5/16	.045	225 - 245	27.5 - 29	9 - 11	
3/4	.045	225 - 245	27.5 - 29	9 - 11	

THIS PROCEDURE MAY VARY DUE TO THE FABRICATION SEQUENCE, FIT-UP, PASS SIZE, ETC., WITHIN THE LIMITATIONS OF VARIABLES GIVEN IN TABLE 5.3 OF AWS D1.5-95 BRIDGE WELDING CODE.

PROCEDURE NO: GMAW 11 MANUFACTURER: Watson Bowman Acme Corp.
 REVISION NO: Rev4 - 2/2/01 AUTHORIZED BY: [Signature]

