

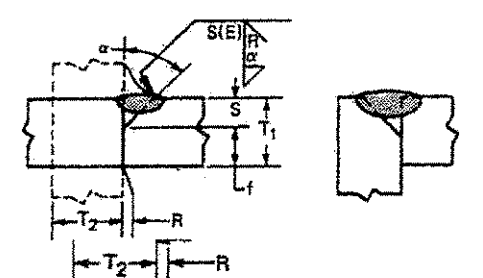
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Construction Chemicals Americas

VTRANS  
RECEIVED  
OK'D BY JWC  
JUN 28 2005  
RESUBMIT \_\_\_\_\_ APPROVED \_\_\_\_\_  
BY \_\_\_\_\_ DATE 7-29-05

**PROCEDURE SPECIFICATION**  
PQR 3 or 4

MATERIAL SPECIFICATION: A588  
WELDING PROCESS: GMAW  
MANUAL OR MACHINE: Semi Automatic  
POSITION OF WELDING: Flat  
FILLER METAL SPECIFICATION: A5.18  
FILLER METAL CLASSIFICATION: ER70S-6  
FLUX: N/A  
WELD METAL GRADE: \*  
SHIELDING GAS: AR98% 0.2% DEW POINT: -80°F FLOW RATE: 35CFH  
SINGLE OR MULTIPLE PASS: Multiple  
SINGLE OR MULTIPLE ARC: Single ELECTRODE STICKOUT: 3/4"  
WELDING CURRENT: DC  
POLARITY: Reverse  
WELDING PROGRESSION: Forward  
ROOT TREATMENT: N/A  
PREHEAT AND INTERPASS TEMP. ≤ 1/2" = 50°F ≤ 1 1/2" = 70°F ≤ 2 1/2" = 150°F (Minimums)  
POSTHEAT TREATMENT: N/A

**WELDING PROCEDURE**

# PASS	Electrode Size	Welding Current		Travel Speed "/Min	Joint Detail TC-P4-GF
		Amps	Volts		
All	.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 09 MANUFACTURER: Watson Bowman Acme Corp.  
REVISION NO: 3 - 2/2/01 AUTHORIZED BY: T. Myklebust

