

degussa.
Construction Chemicals Americas

TRANS
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OK'D BY: _____ OK'D BY: JWC

PROCEDURE SPECIFICATION
PQR 3

JUN 28 2005

RESUBMIT _____ APPROVED
BY _____ DATE 7-29-05

MATERIAL SPECIFICATION: A588 to A588
 WELDING PROCESS: GMAW
 MANUAL OR MACHINE: Semi-Automatic
 POSITION OF WELDING: Flat
 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. ≤ 3/4" = 50°F ≤ 1 1/2" = 70°F ≤ 2 1/2" = 150°F (Minimums)
 POSTHEAT TREATMENT: N/A

WELDING PROCEDURE

S	Electrode Size	Welding Current		Travel Speed "/Min	E	Joint Detail BTC=P10-GF
		Amps	Volts			
3/16	.045	205 - 245	26.5 - 28.5	9 - 11	5/64	<p>E - Effective Throat .625(S) S - Radius of Bar</p>
1/4	.045	205 - 245	26.5 - 28.5	9 - 11	3/32	
5/16	.045	205 - 245	26.5 - 28.5	9 - 11	1/8	

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 D1.5-98 BRIDGE WELDING CODE.

PROCEDURE NO: GMAW 10 MANUFACTURER: Watson Bowman Acme Corp.

REVISION NO: Rev. 3 -2/2/01 AUTHORIZED BY: *J. Meyer*

