

degussa.
 Construction Chemicals Americas
 VTRANS RECEIVED
 JUN 28 2005
 OK'D BY: JWC
 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. ≤ 1/2" = 50°F ≤ 1 1/2" = 70°F ≤ 2 1/2" = 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]*