

**degussa.**  
Construction Chemicals Americas

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

**PROCEDURE SPECIFICATION**  
PQR 3

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 1/4" = 70°F ≤ 2 1/4" = 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 D1.5-95 BRIDGE WELDING CODE.

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

REVISION NO: Rev. 3 -2/2/01 AUTHORIZED BY: [Signature]

