

degussa.
Construction Chemicals Americas

VTRANS
RECEIVED

OK'D BY _____ OK'D BY JWC

PROCEDURE SPECIFICATION
PQR 3 or 4

JUN 28 2005
RESUBMIT _____ APPROVED

BY _____ DATE 7-29-05

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. ≤ 3/4" = 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: 3-2/201 AUTHORIZED BY: [Signature]

