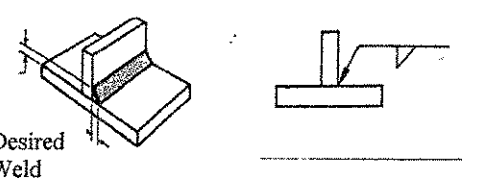

 Construction Chemicals Americas  
 TRANS RECEIVED  
 JUN 23 2005  
 PROCEDURE SPECIFICATION  
 PQR 3 or 4  
 RESUBMIT APPROVED  
 BY DATE 7-29-05

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. ≤ 3/4" = 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	 Desired Weld
1/4	.045	225 - 245	27.5 - 29	9 - 11	
5/16	.045	225 - 245	27.5 - 29	9 - 11	
3/8	.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: 