

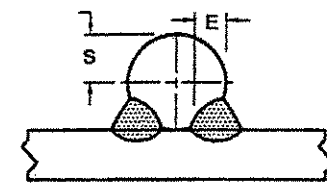
degussa.
Construction Chemicals Americas

TRANS RECEIVED
OK'D BY JWC
JUN 28 2005
RESUBMIT APPROVED
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 1/2" = 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 D1.5-95 BRIDGE WELDING CODE.

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

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

