degussa.

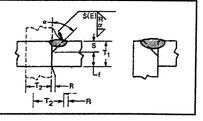
Construction Chemicals Americas

RECEIVED
CK'D BY _____ OK'D BY _____
JUN 2 8 2005
RESUBMIT _____ APPROVED _____
BY DATE

PROCEDURE SPECIFICATION
PQR 3 or 4

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.	≤ ¾" = 50°F ≤ 1½" = 70°F ≤ 2½" = 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 – 2/2/01 **AUTHORIZED BY:** T Migliozzi

AWS QC 1 THOMAS A. MIGLIOZZI 01080463 CWI

Building Tomorrow Together

Watson Bowman Acme

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