

degussa.
Construction Chemicals Americas

TRANS RECEIVED
OK'D BY JWC
JUN 28 2005
RESUBMITTED APPROVED
BY DATE 7-29-05

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
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. ≤ 1/4" = 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 B-P3-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 07 MANUFACTURER: Watson Bowman Acme Corp.
REVISION NO: 2-2/2/01 AUTHORIZED BY: [Signature]

