PROJECT NAME_____

PREQUALIFIED JOINT WELDING PROCEDURE PROJECT NUMBER_____
PROCEDURE SPECIFICATION

Material specification A36:A572:A588
Welding process FCAW
Manual or machine SEMI-AUTOMATIC
Position of welding FLAT OR HORIZONTAL
Filler metal specification AWS 5.20
Filler metal classification ALLOY RODS DUAL SHIELD II 71 ULTRA (E71T-1)
Flux N/A
Shielding gas CO_2 Flow rate 35 CFH
Single or multiple pass SINGLE AND MULTIPLE
Single or multiple arc SINGLE ELECTRICAL STICK-OUT 3/8"-3/4"
Welding current DC
Polarity REVERSE
Welding progression N/A
Root treatment NONE
Preheat and interpass temperature 50°to 3/8"INCL.;70°to1"INCL.;150°to 2"INCL
Postheat treatment NONE
Supported by WPS 007 and 008

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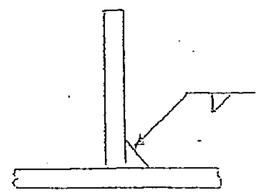
WELDING PROCEDURE CK'D BY_____ OK'D BY Jwe

RESUBMIT_____ APPROVED ✓
BY Joint detail DATE 12/10/09

Pass no.	Electrode size	Welding current: Amperes	Welding current: Volts	Travel speed (I.P.M.)	Weld Size (e)
1	.045	220-240	26-28	16-18	3/16"
1	.045	220-240	26-28	12-13	1/4"
All	.045	210-230	25-27	9-10	5/16"
1	.045	220-240	26-28	16-18	3/8" (3 passes)
2	.045	220-240	26-28	16-18	
3	.045	220-240	26-28	16-18	
1	.045	210-230	25-27	9-11	7/16" (3 passes)
2	.045	210-230	25-27	9-11	
3	.045	210-230	25-27	9-11	



This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in Section 5.

Procedure no. DS-16

Revision

Contractor Merrimack Sheet Metal, Inc.

Authorized by Scott Blanchette

11/24/09