

PROJECT NAME _____
 QUALIFIED JOINT WELDING PROCEDURE PROJECT NUMBER _____
 PROCEDURE SPECIFICATION _____

Material specification A36, A572, A588
 Welding process FCM
 Manual or machine SEMI-AUTOMATIC
 Position of welding FLAT for groove welds, Horizontal for fillet welds 1G: 2F
 Filler metal specification AWS 5.20
 Filler metal classification ALLOY RODS, SHIELD TIG, ULTRA (E71T-1)
 Flux N/A
 Shielding gas CO₂ 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 3/4" INCL. 70 to 3/8" INCL. 150 to 1/2" INCL.
 Postheat treatment NONE
 Supported by PQR 007 and 008

CR'D BY: _____
 OR'D BY: Juc

WELDING PROCEDURE

NOV 24 2009

Pass no.	Electrode size	Welding current		Travel speed I P M	Weld Size (e)	RESUBMIT _____ APPROVED <input checked="" type="checkbox"/> BY (joint detail) DATE <u>12/10/09</u>
		Amperes	Volts			
GROOVE WELDS						
1	.045	220-240	26-28	16-18	3/16"	
1	.045	220-240	26-28	10-12	1/4"	
all	.045	220-240	26-28	14-16	5/16"	
FILLET WELDS						
FILLET WELDS SHALL EQUAL 1/4 OF t BUT NOT MORE THAN 3/8"						
SEE PROCEDURE DS-16 FOR PARAMETERS OF FILLET WELDS.						

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-13 Contractor Merrimack Sheet Metal, Inc.
 Revision no. _____ Authorized by Statt Blumhardt
 Form E-2 Date 1/26/01