

COSMEC INC.

WELDING PROCEDURE SPECIFICATION

SPECIFICATIONS AND CODE: AASHTO-AWS D1.5
 MATERIAL SPECIFICATION: ASTM A709 GR 50W, GR 50, GR 38
 WELDING PROCESS: FCAW-G
 MANUAL OR MACHINE: SEMI-AUTOMATIC
 POSITION OF WELDING: 1F & 2F
 FILLER METAL SPECIFICATION: AWS 5.20 CLASSIFICATION: E71T
 MANUFACTURER: LINCOLN ELECTRIC TRADENAME: E71T OUTERSHIELD
 FLUX: INTERNAL
 SHIELDING GAS: CO2 FLOW RATE: 45 CFH
 SINGLE OR MULTIPLE PASSES: MULTIPLE
 SINGLE OR MULTIPLE ARC: SINGLE
 WELDING CURRENT: DC
 POLARITY: REVERSE (EP)
 WELDING PROGRESSION:
 ROOT TREATMENT: CLEANED & PREPARED BRIGHT METAL
 PREHEAT AND INTERPASS TEMPERATURE: SEE BELOW
 POSTHEAT TEMPERATURE: N/A
 HEAT INPUT MIN. MAX.

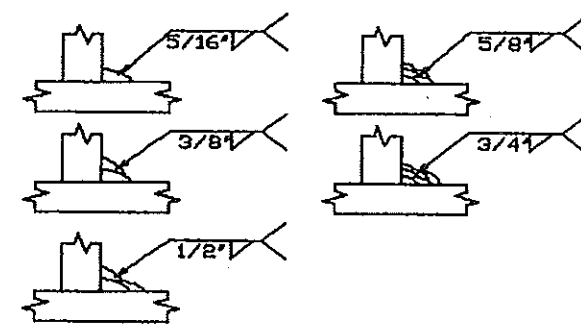
WELDING PROCEDURE

PASS NO.	ELECTRODE SIZE	WELDING CURRENT AMPERES	TRAVEL SPEED VOLTS	JOINT DETAIL
ALL	0.045	190-230	27-29	8-9

PREHEAT TEMPS.

THICKNESS	TEMP.
UP TO 3/4"	50 DEG. F
OVER 3/4" TO 1 1/2"	70 DEG. F
OVER 1 1/2" TO 2 1/2"	150 DEG. F
OVER 2 1/2"	225 DEG. F

INTERPASS TEMP: 400 DEG. F



THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT-UP, PASS SIZE, ETC. WITHIN THE LIMITATION OF VARIABLES GIVEN IN SECTION 5.

PROCEDURE NO. FCAW-FILLET
 SUPPORTING PQR: FCAW-1.0-05
 REVISION NO.

CONTRACTOR: COSMEC INC.
 AUTHORIZED BY: DONALD VOS
 CWI 91100651
 QC1 12/28/2009

DATE: 12/28/2009



RECEIVED
 BY: [Signature]
 DATE: 12/28/09