

108 STRUCTURAL  
STEEL

WELDING PROCEDURE SPECIFICATION  BRIDGEWATER  
OR  
PROCEDURE QUALIFICATION RECORD  BRS-0149(4)

Specification No.: 55928 Miller Construction, Inc.  
Customer: Standard Fillet Weld Customer P.O.#: P.O. No. #62810  
Base Metals: A-588 P-NO.: 1 Group NO.: 1 to P-NO.: 1 Group NO.: 1  
Material Specification Type & Grade: ASTM A-588 to A-588  
Welding Process: F.C.A.W.  
Manual or Machine: Manual  
Position of Welding: Flat 1-G  
Filler Metal Specification: A 5.29  
Filler Metal Classification: E-80T1-W, Esab Dual Shield 8100-W  
Shielding Gas: CO<sup>2</sup> Rcte: 25 CFH VTRANS RECEIVED  
Single or Multiple Pass: Single CK'D BY \_\_\_\_\_ OK'D BY JUC  
Single or Multiple Arc: Single SEP 22 2010  
Welding Current: Direct RESUBMIT \_\_\_\_\_ APPROVED   
Polarity: Reverse BY \_\_\_\_\_ DATE 9/29/10  
Root Treatment: Remove all scale, grease, etc. from weld preparation face  
Preheat and Interpass Temp: 200 Deg F. to 250 Deg F.  
Post weld Heat Treatment: N/A

Pass No.	Electrode Size	Welding Current		Weld Size	Joint Detail
		Amperes	Volts		
1	.06	300-310	30-31	5/16"	<p>FILLET WELD POT PLATE MASONRY PLATE</p>

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

Manufacturer: Amscot Structural Products Authorized By: [Signature]  
Date: 8/19/10