

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: CO² 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