

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 70 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
 Post treatment NONE
 Preheat and interpass temperature 50° to 3/4" INCL 70° to 1 1/4" INCL 150° to 2 1/2" INCL
 Postheat treatment NONE
 Supported by WPS 007 and 008

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed (IPM)	Weld Size (E)	Joint detail
		Amperes	Volts			
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 _____
 CK'D BY _____
 APR 04 2007
 RESUBMIT _____ APPROVED _____
 BY _____ DATE 4-9-07

Contractor Merrimack Sheet Metal, Inc.
 Authorized by [Signature]
 Date 11/2/07