

WELDING PROCEDURE SPECIFICATION

PQR ELDERLEE#1

Material Specification	A572 GRD. 50 /A992-06a	
Welding Process	FCAW	
Manual or Machine	SEMAUTOMATIC	
Position of Welding	FLAT/HORIZONTAL	
Filler Metal Specification	A5.20	
Filler Metal Classification	E70 LINCOLN OUTERSHEILD	
Flux	N/A	
Shielding Gas	CO 2	Dew Point -40DEG F Flow Rate 50 CFM
Single or Multiple Pass	SINGLE (45 TO 63 CFM)	
Single or Multiple Arc	N/A	
Welding Current	DC	
Polarity	DCEP	
Welding Progression	STRINGER	
Root Treatment	PER D1.5	
Preheat and Interpass Temperature	PER D1.5	
Postheat Temperature	NONE	
Heat Input	Min _____	Max _____

WELDING PROCEDURE.

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	3/32	390	27	12	
Variable	LIMITS	351	25	11	
		TO 429	TO 29	TO 13	

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

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Contractor Elderlee, Inc.
Authorized By RANDY SCOTT
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