

WELDING PROCEDURE SPECIFICATION

PQR ELDERLEE #3

Material Specification	A709 TO A500 GR B	
Welding Process	FCAW-G	
Manual or Machine	SEMAUTOMATIC	
Position of Welding	FLAT/HORIZONTAL	
Filler Metal Specification	A5.29	
Filler Metal Classification	E81T1-Ni1C-JH4	
Flux	N/A	
Shielding Gas	CO 2	Dew Point -40DEG F Flow Rate 50CFH
Single or Multiple Pass	SINGLE	
Single or Multiple Arc	SINGLE	
Welding Current	DC	
Polarity	REVERSE ELECTRODE POSITIVE	
Welding Progression	STRINGER	
Root Treatment	D1.5	
Preheat and Interpass Temperature	D1.5	
Postheat Temperature	NONE	
Heat Input	Min _____	Max _____

WELDING PROCEDURE

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	1/16	310	25	11	
Variable	LIMITS	341	27	12	
		TO 269	TO 23	TO 10	

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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