

WELDING PROCEDURE SPECIFICATION

PQR ELDERLEE#3

| | |
|-----------------------------------|---|
| Material Specification | A500 GR B to A572 GR 50 |
| 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 | 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 | 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.

Procedure No. 3007

Contractor Elderlee, Inc.

Revision No. _____

Authorized By RANDY SCOTT

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