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 OCT 29 2007
 RESUBMIT _____ APPROVED _____
 BY _____ DATE 11-5-07

ISI WELDING PROCEDURE SPECIFICATION

Proc. Qual. Record No. (PQR#)	IDSI-6		
Material Specification	ASTM A36, A588, A709 Gr 36, A709 Gr 50, A709 Gr 50W, A572 Gr50 or A992 - as per approved shop drawings.		
Welding Process	GMAW		
Manual or Semi-auto	Semi-automatic		
Position of Welding	1G - Flat		
Filler Metal Specification	AWS A5.18		
Filler Metal Classification	AWS ER70S-6		
Electrode and Manufacturer	ESAB Spoolarc 86		
Shielding Gas	85% Argon 15% CO2	Dew Point	-40degreeF Min.
Single or Multiple Pass	Single	Flow Rate	40 cfh
Single or Multiple Arc	Single		
Welding Current	DC		
Polarity	Reverse		
Welding Progression	NA		
Root Treatment	Wire brush as necessary to remove foreign material		
Preheat and Interpass Temp.	50 degree F min to 400 degree F Max		
Postheat Temperature	None		
Heat Input	25.5 kJ/in Min. to 36 kJ/in Max.		

NOTES: ✓

WELDING PROCEDURE

Pass no.	Electrode size	Welding Parameters		Travel speed	CROSS-BAR PUDDLE WELD JOINT DETAIL
		Amperes	Volts		
All	.045	257-300	26.5-29	14.5 - 16 IPM	

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in AWS D1.3, Section 5A.

Procedure no. IDSI-6-2A Fabricator Interlocking Deck Systems International, LLC
 Revision no. 1 Authorized By Brad King CWI #02100701
 Date 08-07-2006

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