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 APPROVED
 DATE 11-5-07

ISI WELDING PROCEDURE SPECIFICATION

Proc. Qual. Record No. (POR#)	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	Dew Point	-40degree F Min.
Single or Multiple Pass	15% CO2	Flow Rate	40 cfm
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:
 1) Grind weld flush if required by job specification or as shown on shop drawings.
 2) Dimensions 't' (material thickness) and 'S' (bevel size) are per approved shop drawings.

WELDING PROCEDURE

Size	Pass no.	Electrode size	Welding Parameters		Travel speed	SINGLE-BEVEL-GROOVE (TC-P4-GF)
			Amperes	Volts		
SI(E) Per Shop Dwgs	1	.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 D1.5, Section 5A.

Procedure no. IDSI-6-26M Fabricator Interlocking Deck Systems International, LLC
 Revision no. 1 Authorized By Brad King CWI #02100701
 Date 05-04-2007

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