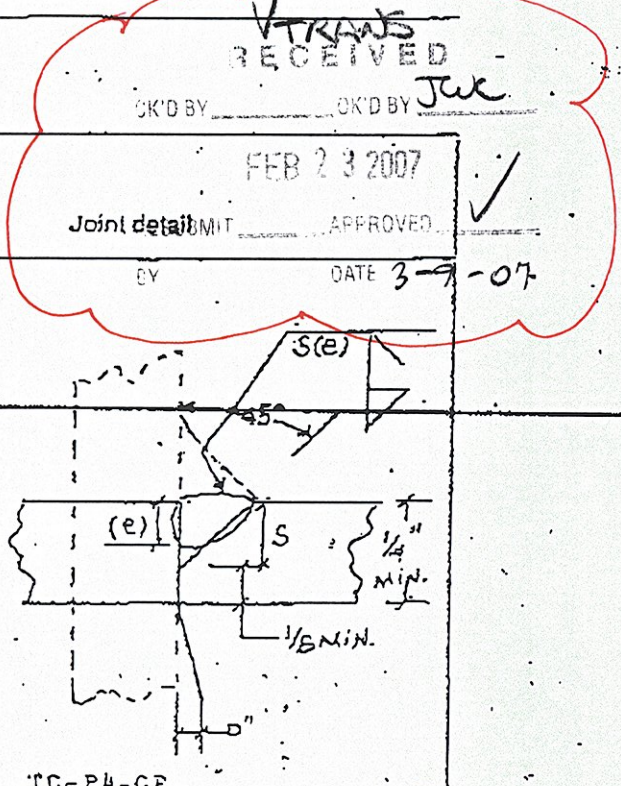


PROJECT NAME _____
 QUALIFIED JOINT WELDING PROCEDURE PROJECT NUMBER _____
 PROCEDURE SPECIFICATION _____

Material specification B36.1572.65R2
 Welding process FCM
 Manual or machine SEMI-AUTOMATIC
 Position of welding FLAT for groove welds Horizontal for fillet welds 1G 2F
 Filler metal specification AWS 5.20
 Filler metal classification ALLOY RODS DUAL METAL T1 T1 H1TR (E71T-1)
 Flux N/A
 Shielding gas CO2 Flow rate 35 CFH
 Single or multiple pass SINGLE AND MULTIPLE
 Single or multiple arc SINGLE ELECTRICAL STICK-OUT 3/8"-3/8"
 Welding current DC
 Polarity REVERSE
 Welding progression N/A
 Root treatment NONE
 Preheat and interpass temperature ED on 3/4" TNCI TO 100-200 TNCI
 Postheat treatment NONE
 Supported by WPS 007 and 008

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed I.P.M.	Weld size
		Amperes	Volts		
GROOVE WELDS					
1	.045	220-240	26-28	16-18	3/16"
1	.045	220-240	26-28	10-12	1/4"
all	.045	220-240	26-28	14-16	5/16"
FILLET WELDS					
FILLET WELDS SHALL EQUAL 1/4 OF t BUT NOT MORE THAN 3/8"					
SEE PROCEDURE DS-16 FOR PARAMETERS OF FILLET WELDS					



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

Procedure no. DS-13 Contractor Merrimack Sheet Metal, Inc.
 Revision no. _____ Authorized by Scott Blundette
 Form E-2 Date 1/26/07

APPROVED BY _____ DATE 3-2-07
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