PROJECT NAME

QUALIFIED JOINT WELDING PROCEDURE PROJECT NUMBER
PROCEDURE SPECIFICATION

Material specification A36;A572;A588
Welding process FCAW
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 SHIELD 71 71 ULTRA (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 50 to 3/8"THCK; 70 to 1"THCK; 150 to 2" THCK
Posheat treatment NONE
Supported by WPQR 007 and 008

VARIOUS
RECEIVED
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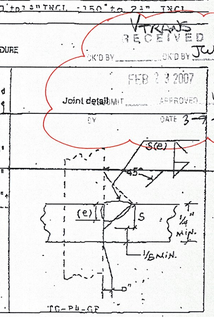
BY DATE 3-7-07

WELDING PROCEDURE

OK'D BY JCK OK'D BY
Joint detail(s) MT APPROVED

Pass no.	Electrode size	Welding current Amperes	Volts	Travel speed (I.P.M.)	Weld Size (S)
		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
Revision no.
Form E-2

Contractor Merrimack Sheet Metal, Inc.
Authorized by Scott Blanchette
Date 1/26/01