

PROJECT NAME _____
 PREQUALIFIED JOINT WELDING PROCEDURE PROJECT NUMBER _____
 PROCEDURE SPECIFICATION BERKSHIRE
BHF 0283(9)S

Material specification A36-A572-A588
 Welding process FCM
 Manual or machine SEMI-AUTOMATIC
 Position of welding FLAT OR HORIZONTAL
 Filler metal specification ANS 5.20
 Filler metal classification ALLOY RODS QUAL SHIELD IT 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" - 3/4"
 Welding current DC
 Polarity REVERSE
 Welding progression N/A
 Root treatment NONE
 Preheat and interpass temperature 50° to 325° F (10° to 163° C)
 Postheat treatment NONE
 Supported by WPS_007_and_008 CDR BY OKUBV JCO

WELDING PROCEDURE APR 01 2010
 RESUBMIT APPROVED [Signature]
 BY DATE 01/06/10

Pass no.	Electrode size	Welding current		Travel speed (I.P.M.)	Weld size (in)	Joint detail
		Amperes	Volts			
1	.045	220-240	26-28	16-18	3/16"	
1	.045	220-240	26-28	12-13	1/4"	
All	.045	210-230	25-27	9-10	5/16"	
1	.045	220-240	26-28	16-18	3/8"	
2	.045	220-240	26-28	16-18	(3 passes)	
3	.045	220-240	26-28	16-18		
1	.045	210-230	25-27	9-11	7/16"	
2	.045	210-230	25-27	9-11	(3 passes)	
3	.045	210-230	25-27	9-11		

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-16 Contact Merrimack Sheet Metal, Inc.
 Revision _____ Authorized by [Signature]
 Date 11/2/10