

QUALIFIED JOINT WELDING PROCEDURE PROJECT NUMBER  
PROCEDURE SPECIFICATION

**BERKSHIRE BHF-0287(9)S**

Material specification A36/A572-45BR  
 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 E70  
 Filler metal classification ALLOY RODS SHIELD TIG WELDS (E70T-1)  
 Flux N/A  
 Shielding gas CO<sub>2</sub> Flow rate 25 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 300°F INCL. 20" INCL. 150 to 210°F INCL.  
 Postheat treatment NONE

Supported by WPS Q07 and Q08

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Pass no.	Electrode size	Welding current		Travel speed in./min.	Weld size	Joint detail
		Amperes	Volts			
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 SHALL EQUAL 1/4 OF t BUT NOT MORE THAN 3/8"						
SEE PROCEDURE DS-16 FOR PARAMETERS OF FILLET WELDS.						

APR 01 2001  
APPROVED: [Signature] DATE: 04/06/01

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 Blanchette  
 Form E-2 Date 1/26/01