

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

Material specification A36; A572; A588 SINGLE PASS ONLY
 Welding process FOAW
 Manual or machine SEMI-AUTOMATIC
 Position of welding FLAT
 Filler metal specification AWS 5.20
 Filler metal classification ALLOY RODS DUAL SHIELD IT 71 ULTRA
 Flux N/A
 Shielding gas CO₂ Flow rate .35 CFH
 Single or multiple pass MULTIPLE
 Single or multiple arc SINGLE ELECTRICAL STICK-OUT 3/8"-3/4"
 Welding current DC
 Polarity REVERSE
 Welding progression N/A
 Root treatment Back-Gouge root to sound metal before welding second side.
 Preheat and interpass temperature 50 to 3/4" INCL .70 to 1 1/4" INCL .150 to 2 1/4" INCL
 Postheat treatment NONE
 Supported by WPS 007 and 008

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed I.P.M.	Joint detail
		Amperes	Volts		
a11	.045	220-240	26-28	14-16	
<p>RECEIVED DEC 14 2006 APPROVED DATE 12-18-06</p>					

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-7 Contractor Merrimack Sheet Metal, Inc.
 Revision no. _____ Authorized by Scott Blanchette
 Form E-2 Date 1/26/01