

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

Material specification A36: A572-6: ER
 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 T1 T1 ULTRA (E71T-1)
 Flux N/A Flow rate 35 CFH
 Shielding gas CO₂
 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 3/4" INCL. 70° to 1 1/2" INCL. 150° to 2 1/2" INCL.
 Postheat treatment NONE
 Supported by PQR 007 and 008

WELDING PROCEDURE

DEC 14 2006

Pass no.	Electrode size	Welding current		Travel speed IPM	Weld size (S)	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 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, fill-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 Sue Blawie
 Form E-2 Date 1/26/01

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