PROJECT NAME

PREQUALIFIED JOINT WELDING PROCEDURE PROJECT NUMBER
PROCEDURE SPECIFICATION

Material specification A36:A572:A588
Welding process FCAW
Manual or machine SEMI-AUTOMATIC
Position of welding FLAT OR HORIZONTAL
Filler metal specification AWS 5.20
Filler metal classification ALLOY RODS DUAL SHIELD II 71 ULTRA (E71T-1)
Flux N/A
Shielding gas CO_2 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"INCL ;70° to 13"INCL ;150° to 23" INCL
Posthest treatment NONE
Supported by WPS 007 and 008

WELDING PROCEDURE

V TRANS

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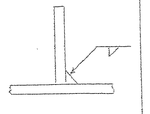
CK'D BY ____ CK'D BY JLC
RESUBMIT ____ APPROVED ✓
BY DATE 12-13-06

Pass no.	Electrode size	Welding current Amperes	Welding current Volts	Travel speed (I.P.M.)	Weld Size (e)	Joint detail
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" (3 passes)	
2	.045	220-240	26-28	16-18		
3	.045	220-240	26-28	16-18		
1	.045	210-230	25-27	9-11	7/16" (3 passes)	
2	.045	210-230	25-27	9-11		
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
Revision

Contractor Merrimack Sheet Metal, Inc.
Authorized by Scott Ranchetto
Date 1/26/07 112 EJ