

**WELDING PROCEDURE SPECIFICATION**

Material Specification	A36 TO A500
Welding Process	FCAW
Manual or Machine	SEMAUTOMATIC
Position of Welding	FLAT / HORIZONTAL
Filler Metal Specification	A5.20 - 95
Filler Metal Classification	E81T1-Ni1C-JH4
Flux	N/A
Shielding Gas	CO 2 Dew Point -40DEG F Flow Rate 50CFH
Single or Multiple Pass	SINGLE
Single or Multiple Arc	SINGLE
Welding Current	DC
Polarity	REVERSE ELECTRODE POSITIVE
Welding Progression	STRINGER
Root Treatment	PER D1.5
Preheat and Interpass Temperature	PER D1.5
Postheat Temperature	NONE
Heat Input	Min _____ Max _____

**WELDING PROCEDURE**

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	1/16	300	26	14	<p>1/8~1/4"</p>
Variable	LIMITS	270	24	12.6	
		TO 330	TO 28	TO 15.4	

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in Section 5.

Procedure No. 3006  
 Revision No. \_\_\_\_\_

Contractor Elderlee, Inc.  
 Authorized By RANDY SCOTT  
 Date 8/4/2014

Form III-2

**APPROVED**  
 By Jeff Clark at 11:25 am, Mar 13, 2015