

WELDING PROCEDURE SPECIFICATION
PQR ELDERLEE #3

Material Specification	A709 TO A500 GR B
Welding Process	FCAW-G
Manual or Machine	SEMAUTOMATIC
Position of Welding	FLAT/HORIZONTAL
Filler Metal Specification	A5.29
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	D1.5
Preheat and Interpass Temperature	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	310	25	11	
Variable	LIMITS	341	27	12	
		TO 269	TO 23	TO 10	

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

Procedure No. <u>3009</u>	Contractor <u>Elderlee, Inc.</u>
Revision No. _____	Authorized By <u>RANDY SCOTT</u>
	Date <u>3/20/2014</u>

VTrans
Received
OK'd BY JWC

DEC 29 2014

Resubmit _____ APPROVED
BY _____ DATE 1/5/15