

WELDING PROCEDURE SPECIFICATION

Material Specification	A572 GR 50	
Welding Process	GMAW	
Manual or Machine	SEMI-AUTOMATIC/ROBOTIC	
Position of Welding	FLAT/HORIZONTAL	
Filler Metal Specification	A5.18	
Filler Metal Classification	L-56	LINCOLN
Flux	N/A	
Shielding Gas	90% ARGON /10% CO2	Dew Point -40DEG F Flow Rate 45CFH
Single or Multiple Pass	SINGLE	
Single or Multiple Arc	SINGLE	
Welding Current	DC	
Polarity	REVERSE	
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		
	.045	190	22	19	
Variable	LIMITS	171	20	17	
		TO 209	TO 24	TO 21	

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

Procedure No. 3022

Contractor Elderlee, Inc.

Revision No. _____

Authorized By RANDY SCOTT

Date 3/20/2014

Virans
Received
OK'D BY JWC

D/C 29 2014

Resubmit BY _____ APPROVED DATE 1/5/15