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CK'D BY JWC OK'D BY _____

December 19, 2013

WELDING PROCEDURE SPECIFICATION RESUBMIT NO Approved
 BY J. Lacroix DATE 1/7/2014

Material Specification	<u>A36</u>		
Welding Process	<u>GMAW</u>		
Manual or Machine	<u>SEMAUTOMATIC</u>		
Position of Welding	<u>FLAT</u>		
Filler Metal Specification	<u>A5.18</u>		
Filler Metal Classification	<u>L-50 .052 LINCOLN</u>		
Flux	<u>N/A</u>		
Shielding Gas	<u>90% ARGON /10% CO2 Dew Point -40DEG F Flow Rate 50 CFM</u>		
Single or Multiple Pass	<u>SINGLE</u>		
Single or Multiple Arc	<u>SINGLE</u>		
Welding Current	<u>DC</u>		
Polarity	<u>REVERSE</u>		
Welding Progression	<u>STRINGER</u>		
Root Treatment	<u>PER D1.5</u>		
Preheat and Interpass Temperature	<u>PER D1.5</u>		
Postheat Temperature	<u>NONE</u>		
Heat Input	Min _____	Max _____	

WELDING PROCEDURE

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
Variable	LIMITS	430	32	13	
		387	29	12	
		TO	TO	TO	
		473	34	14	

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

Procedure No. 3040 Contractor Elderlee, Inc.
 Revision No. _____ Authorized By RANDY SCOTT
 Date 12/20/2011