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December 19, 2013

**WELDING PROCEDURE SPECIFICATION**

RESUBMIT NO Approved

BY J. Lacroix DATE 1/7/2014

Material Specification	A572 GRD. 50 /A992-06a
Welding Process	FCAW
Manual or Machine	SEMAUTOMATIC
Position of Welding	FLAT
Filler Metal Specification	A5.20
Filler Metal Classification	E70 LINCOLN OUTERSHEILD
Flux	N/A
Shielding Gas	CO 2 Dew Point -40DEG F Flow Rate 50 CFM
Single or Multiple Pass	SINGLE (45 TO 63 CFM)
Single or Multiple Arc	N/A
Welding Current	DC
Polarity	DCEP
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	3/32	390	27	12	
Variable	LIMITS	351	25	11	
		TO 429	TO 29	TO 13	

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

Procedure No. 3008

Contractor Elderlee, Inc.

Revision No. \_\_\_\_\_

Authorized By RANDY SCOTT

Date 5/29/2013