

RECEIVED

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 A709 TO A500 GR B
 Welding Process FCAW
 Manual or Machine SEMAUTOMATIC
 Position of Welding FLAT
 Filler Metal Specification A5.20 - 95
 Filler Metal Classification E71T-1H8 E71T-9H8 LINCOLN ULTRACORE
 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	300	26	14	
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. 3009

Contractor Elderlee, Inc.

Revision No. _____

Authorized By RANDY SCOTT

Date 5/22/2013