

WELDING PROCEDURE SPECIFICATION

PQR ELDERLEE#1

Material Specification	A572 GRD. 50 /A992-06a		
Welding Process	FCAW		
Manual or Machine	SEMAUTOMATIC		
Position of Welding	FLAT/HORIZONTAL		
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

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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.

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Contractor Elderlee, Inc.
 Authorized By RANDY SCOTT
 Date 5/29/2013