

**WELDING PROCEDURE SPECIFICATION**

PQR ELDERLEE #3

Material Specification ASTM A572 GR. 50 /ASTM A108  
 Welding Process FCAW-G  
 Manual or Machine SEMAUTOMATIC  
 Position of Welding FLAT/HORIZONTAL  
 Filler Metal Specification A5.29  
 Filler Metal Classification E81T1-Ni1C-JH4  
 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 CK'D BY \_\_\_\_\_ OK'D BY RF  
 Welding Progression STRINGER February 11, 2016  
 Root Treatment CLEAN PER D1.5 RESUBMIT NO \_\_\_\_\_ Approved \_\_\_\_\_  
 Preheat and Interpass Temperature PER D1.5 BY KH DATE 02/16/2016  
 Postheat Temperature NONE  
 Heat Input Min \_\_\_\_\_ Max \_\_\_\_\_

**RECEIVED**

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Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	1/16	310	25	11	
Variable	LIMITS	341	27	12	
		TO 269	TO 23	TO 10	

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

Procedure No. 3019  
 Revision No. \_\_\_\_\_

Contractor Elderlee, Inc.  
 Authorized By RANDY SCOTT  
 Date 2/11/2016