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CK'D BY R. Foster OK'D BY G. Laroche

April 8, 2016

RESUBMIT No Approved
BY K. Higgins DATE 04/11/2016

WELDING PROCEDURE SPECIFICATION

PQR ELDERLEE #3
 Material Specification A572 GR. 50 /A500 GR. B
 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
 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	1/16	310	25	11	
Variable	LIMITS	341	27	12	
		TO 279	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. 3006
 Revision No. _____

Contractor Elderlee, Inc.
 Authorized By RANDY SCOTT
 Date 3/31/2016