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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 A709 TO 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 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	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. 3009  
 Revision No. \_\_\_\_\_

Contractor Elderlee, Inc.  
 Authorized By RANDY SCOTT  
 Date 3/30/2016