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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

Material Specification A572 GR 50
 Welding Process GMAW
 Manual or Machine SEMI-AUTOMATIC/ROBOTIC
 Position of Welding FLAT/HORIZONTAL
 Filler Metal Specification A5.18
 Filler Metal Classification L-56 LINCOLN
 Flux N/A
 Shielding Gas 90% ARGON /10% CO2 Dew Point -40DEG F Flow Rate 45CFH
 Single or Multiple Pass SINGLE
 Single or Multiple Arc SINGLE
 Welding Current DC
 Polarity REVERSE
 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		
	.045	190	22	19	
Variable	LIMITS	171	20	17	
		TO 209	TO 24	TO 21	

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

Procedure No. 3022
 Revision No. _____

Contractor Elderlee, Inc.
 Authorized By RANDY SCOTT
 Date 3/2/2016