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

April 8, 2016

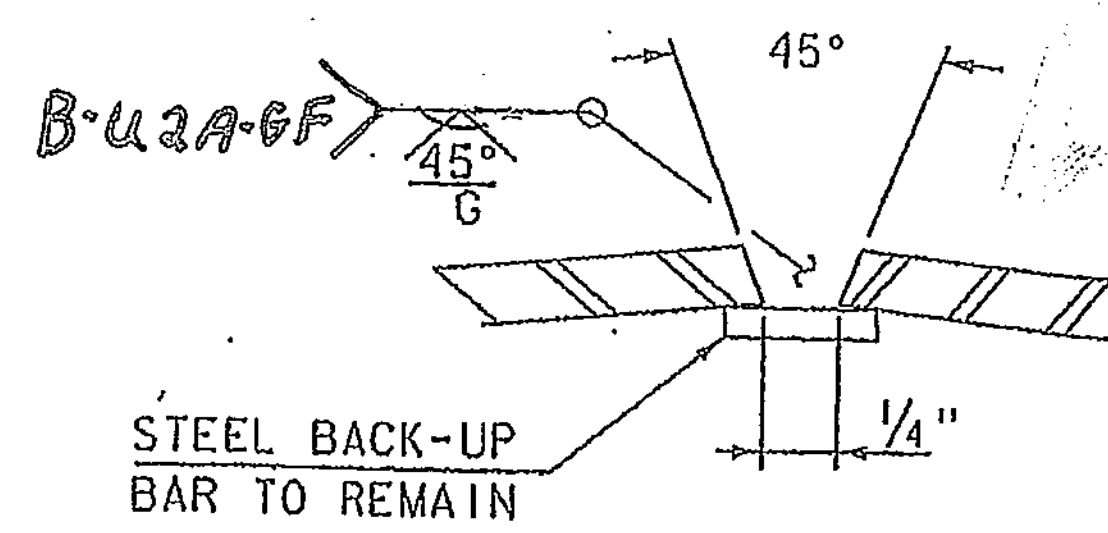
RESUBMIT No Approved
BY K. Higgins DATE 04/11/2016

WELDING PROCEDURE SPECIFICATION

PQR ELDERLEE #3

Material Specification	ASTM A500 TO A36
Welding Process	FCAW-G
Manual or Machine	SEMAUTOMATIC
Position of Welding	FLAT
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	 <p>WELD DETAIL FOR SPLICE TUBE</p>
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. 3900

Contractor Elderlee, Inc.

Revision No. _____

Authorized By RANDY SCOTT

Date 4/7/2016