

PROJECT NAME
 QUALIFIED JOINT WELDING PROCEDURE PROJECT NUMBER
 PROCEDURE SPECIFICATION

Material specification A36/A572-50-SSA
 Welding process FCM
 Manual or machine SEMI-AUTOMATIC
 Position of welding FLAT for groove welds, Horizontal for fillet welds 1G, 2P
 Filler metal specification A55 1.20
 Filler metal classification ALLOY ROBE DIAL SHIELD TIG WELDS (E71T-1)
 Flux N/A
 Shielding gas CO₂ Flow rate 35 CFH
 Single or multiple pass SINGLE AND MULTIPLE
 Single or multiple etc SINGLE ELECTRODE STICK-OUT 3/8"± 1/8"
 Welding current DC
 Polarity REVERSE
 Welding progression N/A
 Root treatment NONE
 Preheat and interpass temperature 50 to 250 F MAX. 20 to 250 F MIN. 150 to 250 F MIN.
 Postheat treatment NONE
 Supported by WQK-007 and 008

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed I P M O	Weld Size (in)	Joint detail
		Amperes	Volts			
GROOVE WELDS						
1	.045	220-240	26-28	16-18	3/16"	
1	.045	220-240	26-28	10-12	1/4"	
All	.045	220-240	26-28	14-16	5/16"	
FILLET WELDS						
FILLET WELDS SHALL EQUAL 1/4 OF t BUT NOT MORE THAN 3/8"						
SEE PROCEDURE DS-16 FOR PARAMETERS OF FILLET WELDS						

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

Procedure no. DS-13 Contractor Merrimack Sheet Metal, Inc.
 Revision no. _____ Authorized by Scott Blanchette
 Form E-2 Date 1/26/07

RECEIVED
 OK'D BY JWC
 MAR 30 2007
 RESUBMIT APPROVED ✓
 BY _____ DATE 4-3-07

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