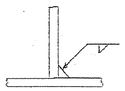
PROJECT NAME_____

PREQUALIFIED JOINT WELDING PROCEDURE PROJECT NUMBER_____
PROCEDURE SPECIFICATION

Material specification A36;A572-A588
Welding process FCAW
Manual or machine SEMI-AUTOMATIC
Position of welding FLAT OR HORIZONTAL
Filler metal specification AWS 5.20
Filler metal classification ALLOY RODS DUAL SHIELD II 71 ULTRA (E71T-1)
Flux N/A
Shielding gas CO_2 Flow rate 35 CFH
Single or multiple pass SINGLE AND MULTIPLE
Single or multiple arc SINGLE ELECTRICAL STICK-OUT 3/8"-3/8"
Welding current DC
Polarity REVERSE
Welding progression N/A
Root treatment NONE
Preheat and interpass temperature 50° to 3/8"THCK, 70° to 1"THCK, 150° to 2½" THCK
Postheat treatment NONE
Supported by WPS 007 and 008

WELDING PROCEDURE

Pass no.	Electrode size	Welding current: Amperes	Welding current: Volts	Travel speed (IPM)	Weld Size (S)	Joint detail
1	.045	220-240	26-28	16-18	3/16"	
1	.045	220-240	26-28	12-13	1/2"	
All	.045	210-230	25-27	9-10	5/16"	
1	.045	220-240	26-28	16-18		
2	.045	220-240	26-28	16-18	3/8 (3 passes)	
3	.045	220-240	26-28	16-18		
1	.045	210-230	25-27	9-11		
2	.045	210-230	25-27	9-11	7/16 (3 passes)	
3	.045	210-230	25-27	9-11		



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-16 V-TRANS
Revision
Form E-2

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MAR 30 2007

OK'D BY_____ OK'D BY TCVC
RESUBMIT_____ APPROVED_____
BY DATE 4-3-07

Contractor Merrimack Sheet Metal, Inc.
Authorized by Scott Blanchette
Date 11/26/07

071-BJ