

PROJECT NAME
 QUALIFIED JOINT WELDING PROCEDURE PROJECT NUMBER
 PROCEDURE SPECIFICATION

Material specification A36/A572-6588
 Welding process FCAW
 Manual or machine SEMI-AUTOMATIC
 Position of welding FLAT for groove welds Horizontal for fillet welds 1G, 2F
 Filler metal specification AWS 5.20
 Filler metal classification ALLOY RODS SHAL SHIELD T191 ULTRA (E71T-1)
 Flux N/A
 Shielding gas CO₂ Flow rate 35 CFH
 Single or multiple pass SINGLE AND MULTIPLE
 Single or multiple arc SINGLE ELECTRICAL STICK-OUT 3/8"-3/4"
 Welding current DC
 Polarity REVERSE
 Welding progression N/A
 Root treatment NONE
 Preheat and interpass temperature 50 to 217 INCI
 Postheat treatment NONE
 Supported by PQR 007 and 008

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	Weld size	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. TC-PR-6F						

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 **RECEIVED** Contractor Merrimack Sheet Metal, Inc.
 Revision no. CKD BY CKD BY Authorized by Scott Blanchette
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 RESUBMIT APPROVED
 BY _____ DATE 5-3-06 119 65