

PROJECT NAME _____

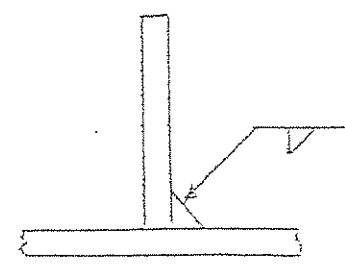
PREQUALIFIED JOINT WELDING PROCEDURE PROJECT NUMBER _____
PROCEDURE SPECIFICATION _____

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 TT 71 ULTRA (E71T-1)
Flux N/A
Shielding gas CO₂ Flow rate 35 GPH
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
Post treatment NONE
Preheat and interpass temperature 50°F to 3/8" INCL., 70°F to 1/2" INCL., 150°F to 2 3/4" INCL.
Postheat treatment NONE
Supported by WPS_007_Bnd_008

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OK'D BY _____ ON'D BY JWC

APR 13 2006

Pass no.	Electrode size	Welding current		Travel speed (T.P.M.)	Weld Size (in)	Joint detail
		Amperes	Volts			
1	.045	220-240	26-28	16-18	3/16"	
1	.045	220-240	26-28	12-13	1/4"	
All	.045	210-230	25-27	9-10	5/16"	
1	.045	220-240	26-28	16-18	3/8" (3 passes)	
2	.045	220-240	26-28	16-18		
3	.045	220-240	26-28	16-18		
1	.045	210-230	25-27	9-11	7/16" (3 passes)	
2	.045	210-230	25-27	9-11		
3	.045	210-230	25-27	9-11		

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

Procedure no. DS-16 Contractor Merrimack Sheet Metal, Inc.
Revision _____ Authorized by Scott Blanchette
Date 1/26/01 120 bi