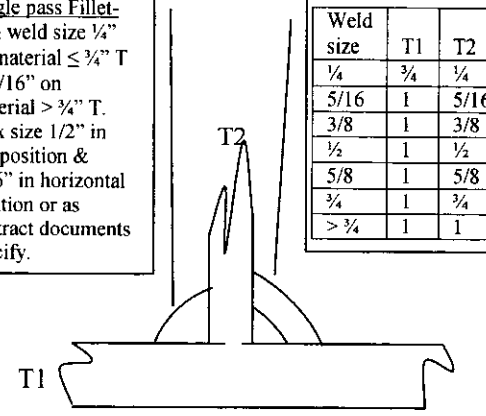


V.T.
June

WELDING PROCEDURE SPECIFICATION

MATERIAL SPECIFICATION A36, A572 Gr50, A53GR B, A252 GR 2, OR 3, 5LX52, A500 GR B
 WELDING PROCESS FCAW
 MANUAL, SEMIAUTOMATIC, AUTOMATIC SEMI-AUTOMATIC
 POSITION OF WELDING 1F & 2F (FLAT & HORIZONTAL)
 FILLER METAL SPECIFICATIONS AWS 5.20
 FILLER METAL CLASSIFICATION E71T-1
 ELECTRODE & MANUFACTURE Ultracore 71C (LINCOLN)
 FLUX & MANUFACTURE N/A
 SHIELDING GAS 100% CO2 DEW POINT -40°F FLOW RATE MIN 41 CFH MAX 56 CFH
 SINGLE OR MULTIPLE PASS SINGLE or MULTIPLE
 SINGLE OR MULTIPLE ARC SINGLE
 WELDING CURRENT DC POLARITY DCEP (REVERSE)
 WELDING PROGRESSION N/A
 ROOT TREATMENT CLEAN TO REMOVE ALL CONTAMINANT
 PREHEAT AND INTERPASS <3/4"=50°F, 3/4 TO 1 1/4"= 70°F, 1 1/4 TO 2 1/2"= 150°F >2 1/2"= 225°F
300°F MAX INTERPASS TEMP.
 POSTHEAT TREATMENT NONE

WELDING PROCEDURE

PASS NO.	ELECTRODE SIZE	AMPS	VOLTS	TRAVEL SPEED IN/MIN	JOINT DETAIL	
					Miscellaneous Fillet Welds	
ALL	1/16"	300	27	11.6		
		Max 330	Max 29	Max 12.7		
		Min 270	Min 25	Min 10.5		
		Single pass Fillet: Min weld size 1/4" on material ≤ 1/4" T & 5/16" on material > 1/4" T. Max size 1/2" in flat position & 5/16" in horizontal position or as contract documents specify.				

PROCEDURE NO: DI-03 FABRICATOR DI-HIGHWAY SIGN & STRUCTURE

OUR JOB NO. Stock fillet weld AUTHORIZED BY 

PQR REF NO. DI-01-09a DATE 11/28/10



JOEL W. SIMS
 CMI 94030071
 OCI EXP. 03/01/11