Welding Procedure Specification

WELDING PROCEDURE

Layer/Pass	Process	Filler Metal Class	Diameter	Cur. Type	Amps or WFS	Volts	Travel Speed	Other Notes
1	FCAW-G	E71T-1	1.2mm	DCEP	220-240	26-28	406-457mm	Weld Size 5mm
1	FCAW-G	E71T-1	1.2mm	DCEP	220-240	26-28	305-330mm	Weld Size 6mm
1	FCAW-G	E71T-1	1.2mm	DCEP	210-230	25-27	229-254mm	Weld Size 8mm
1	FCAW-G	E71T-1	1.2mm	DCEP	220-240	26-28	406-457mm	Weld Size
2	FCAW-G	E71T-1	1.2mm	DCEP	220-240	26-28	406-457mm	10mm
3	FCAW-G	E71T-1	1.2mm	DCEP	220-240	26-28	406-457mm	(3 Passes)
1	FCAW-G	E71T-1	1.2mm	DCEP	200-210	25-26	203-254mm	Weld Size
2	FCAW-G	E71T-1	1.2mm	DCEP	200-210	25-26	203-254mm	11mm
3	FCAW-G	E71T-1	1.2mm	DCEP	200-210	25-26	203-254mm	(3 Passes)

CERTIFIED WELDING INSPECTOR
AWS
QC 1
GLENN A. MYRICK
95070991
CWI

RECEIVED
CK'D BY_____ OK'D BY_____
OCT 27 1998
RESUBMIT_____ APPROVED_____
BY DATE

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