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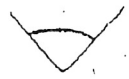
# WELDING PROCEDURE SPECIFICATION

Material specification: ASTM 709-Gr 36-50-50W (250-345-345W)
Welding process: Shielded Metal Arc welding (SMAW)
Manual or machine: Manual
Position of welding: Flat (1F), Horizontal (2F)
Filler metal specification: AWS I/AWS A5.1 - A5.5
Filler metal classification: E7018 - 8018 C1/C2 - 7028
Flux: N/A
Shielding gas: N/A Flow rate: N/A
Single or multiple pass: Single and multiple
Single or multiple arc: Single
Welding current: AC / DC
Polarity: Straight / Reverse
Welding progression:
Root treatment: Meet AWS SPECIFICATION
Preheat and Interpass temperature: To 3/4 (19) 50°F (10°C) 3/4 (19) To 1 1/2 (38) 70°F (20°C) 1 1/2 (38) To 2 1/2 (63.5) 150°F (65°C) over 2 1/2 (63.5) 225°F (110°C)
Postheat temperature: N/A
Heat Input Min: N/A Max: N/A

Colchester STP 5600 (12)

## WELDING PROCEDURE

(metric)

| Pass no. | Electrode size | Welding current: Amperes | Welding current: Volts | Travel speed | AWS D1.5 Joint detail: Fillet |
|---|---|---|---|---|---|
| AS REQ. | 7018 | | | AS REQ. | 1F |
| | 1/8 (3.2) | 70-170 | 22-26 | | |
| | 5/32 (3.9) | 120-225 | 22-26 | |  3/16 To 3/8 (5 To 10) |
| | 3/16 (4.8) | 170-300 | 24-27 | | 3/8 To 1/2 (10 To 13) |
| | 8018 | | | | 1/2 To 5/8 (13 To 16) |
| | 1/8 (3.2) | 90-160 | 22-26 | | 2F |
| | 5/32 (3.9) | 120-225 | 22-26 | | |
| | 3/16 (4.8) | 180-290 | 24-27 | | 3/16 To 5/16 (5 To 8) |
| | 7028 | | | | 3/8 (10) |
| | 5/32 (3.9) | 170-270 | 22-26 | | 7/16 To 5/8 (11 To 16) |
| | 3/16 (4.8) | 210-330 | 24-27 | | |

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in applicable A.W.S. codes or contract specifications

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Revision no.:
Form II-2

Contractor: A.L. St. Onge Contractor, Inc
Authorized By: Randy St. Onge
Date: 8/10/15