

WELDING PROCEDURE SPECIFICATION

STOCK PQR # ELDERLEE #1

Material Specification	ASTM A588		
Welding Process	FCAW		
Manual or Machine	SEMAUTOMATIC		
Position of Welding	FLAT		
Filler Metal Specification	A5.20		
Filler Metal Classification	E70 LINCOLN OUTERSHEILD		
Flux	N/A		
Shielding Gas	CO 2	Dew Point	-40DEG F Flow Rate 50 CFM
Single or Multiple Pass	SINGLE	(45 TO 63 CFM)	
Single or Multiple Arc	N/A		
Welding Current	DC		
Polarity	DCEP		
Welding Progression	STRINGER		
Root Treatment	CLEAN PER D1.5		
Preheat and Interpass Temperature	PER D1.5		
Postheat Temperature	NONE		
Heat Input	Min	_____	Max _____

WELDING PROCEDURE

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	3/32	390	27	12	
Variable	LIMITS	351	25	11	
		TO 429	TO 29	TO 13	

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

Procedure No. 3035

Contractor Elderlee, Inc.

Revision No. _____

Authorized By RANDY SCOTT

Date 2/14/2014