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CK'D BY RSF OK'D BY WDL

January 26, 2016

RESUBMIT BY RSY YES **Rejected** DATE 02/11/2016

WELDING PROCEDURE SPECIFICATION

STOCK PQR # ELDERLEE #1

Material Specification	<u>ASTM A588</u>	SHOULD THIS BE A572 GR. 50?
Welding Process	<u>FCAW</u>	
Manual or Machine	<u>SEMAUTOMATIC</u>	
Position of Welding	<u>FLAT</u>	
Filler Metal Specification	<u>A5.20</u>	
Filler Metal Classification	<u>E70 LINCOLN OUTERSHEILD</u>	What Wire?
Flux	<u>N/A</u>	
Shielding Gas	<u>CO 2</u>	Dew Point <u>-40DEG F</u> Flow Rate <u>50 CFM</u>
Single or Multiple Pass	<u>SINGLE</u>	(45 TO 63 CFM)
Single or Multiple Arc	<u>N/A</u>	
Welding Current	<u>DC</u>	
Polarity	<u>DCEP</u>	
Welding Progression	<u>STRINGER</u>	NONE OF THESE MATCH THE PLANS.
Root Treatment	<u>CLEAN PER D1.5</u>	
Preheat and Interpass Temperature	<u>PER D1.5</u>	
Postheat Temperature	<u>NONE</u>	
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

Revision No. _____

Contractor Elderlee, Inc.

Authorized By RANDY SCOTT

Date 2/14/2014