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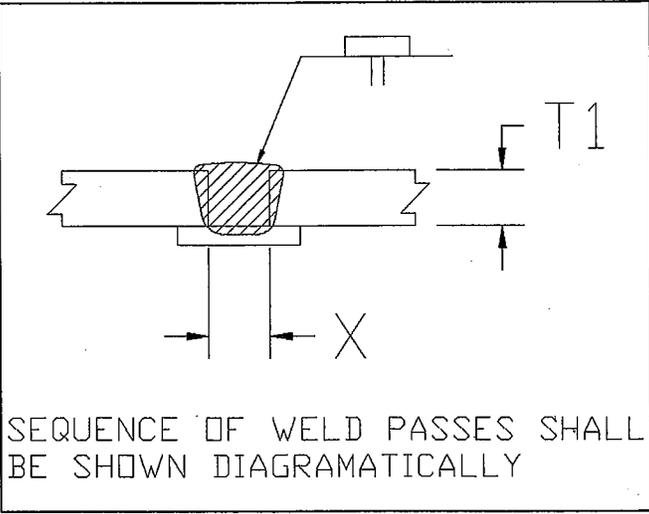
CONFORMANCE

BY: Jennifer Fitch DATE: 06/30/2014

WELDING PROCEDURE SPECIFICATION

Material Specification	PQR ELDERLEE#3	
Welding Process	A500 GR B	
Manual or Machine	FCAW	
Position of Welding	SEMAUTOMATIC	
Filler Metal Specification	FLAT / HORIZONTAL	
Filler Metal Classification	A5.20 - 95	
Flux	E81T-Ni1C-JH4	
Shielding Gas	N/A	
Single or Multiple Pass	CO 2	Dew Point -40DEG F Flow Rate 50CFH
Single or Multiple Arc	SINGLE	
Welding Current	SINGLE	
Polarity	DC	
Welding Progression	REVERSE ELECTRODE POSITIVE	
Root Treatment	STRINGER	
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		
Variable	1/16	310	25	11	
	LIMITS	341	27	12	
		TO	TO	TO	
		269	23	10	

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

Procedure No. 3003

Contractor Elderlee, Inc.

Revision No. _____

Authorized By RANDY SCOTT

Date 5/8/2014