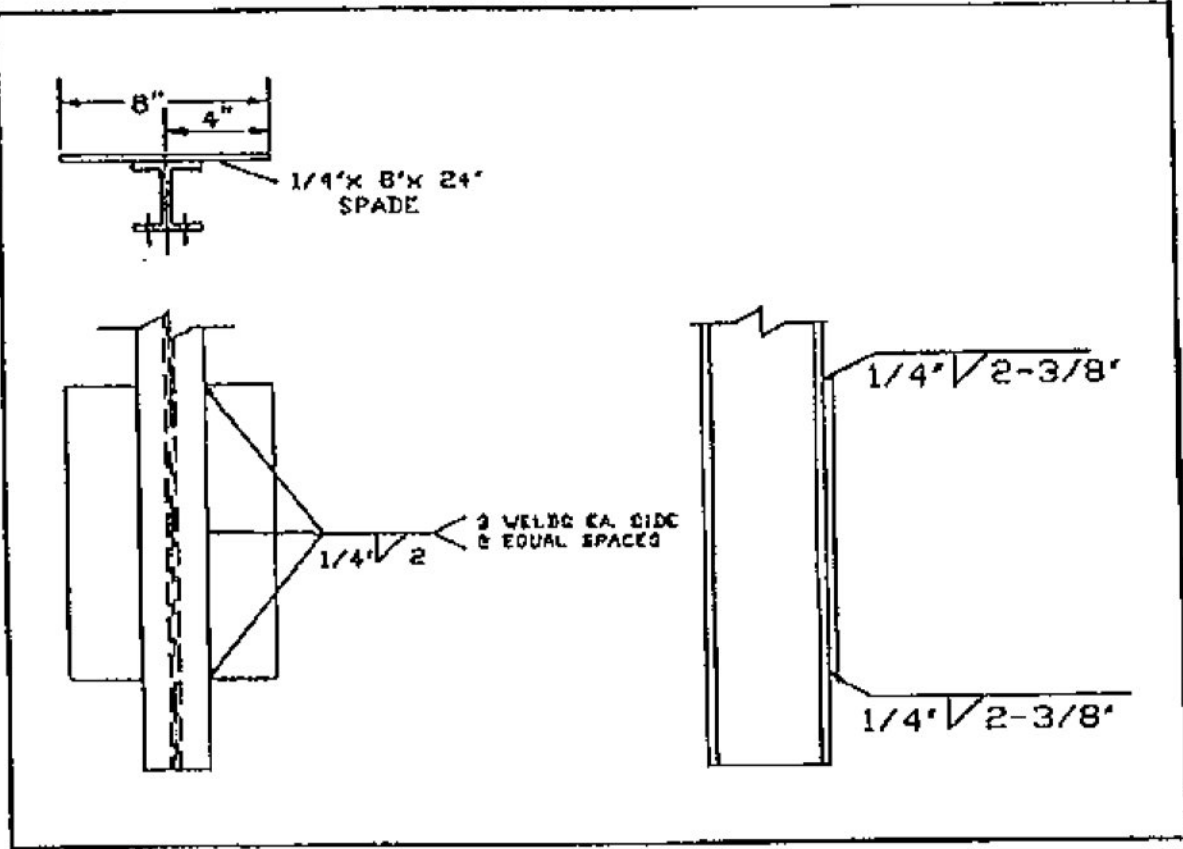


WELDING PROCEDURE SPECIFICATION

Material Specification	A572 GR 50		
Welding Process	GMAW		
Manual or Machine	SEMIAUTOMATIC/ROBOTIC		
Position of Welding	FLAT/HORIZONTAL		
Filler Metal Specification	A5.18		
Filler Metal Classification	L-56	LINCOLN	
Flux	N/A		
Shilding Gas	90% ARGON /10% CO2	Dew Point	-40DEG F Flow Rate 45CFH
Single or Multiple Pass	SINGLE		
Single or Multiple Arc	SINGLE		
Welding Current	DC		
Polarity	REVERSE		
Welding Progression	STRINGER		
Root Treatment	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		
Variable	LIMITS	190	22	19	
		171	20	17	
		TO 209	TO 24	TO 21	

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

Procedure No. 3022

Revision No.

Contractor Elderlee, Inc.

Authorized By RANDY SCOTT

Date 3/20/2014