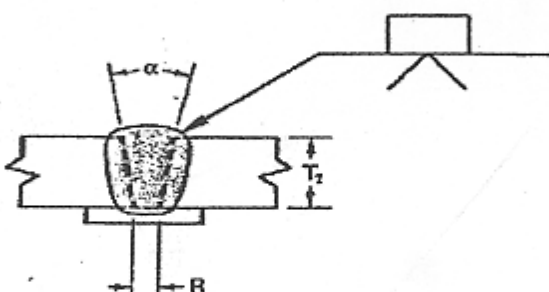


Material specification	A36, A572-50, A500, A53		
Welding process	GMAW		
Manual or machine	MANUAL		
Position Welding	1G		
Filler metal specification	A5.18		
Filler metal classification	E70C-6M H4		
Flux	N/A		
Weld metal grade*	N/A		
Shielding gas	75%Ar-25%CO2	Flow rate	40 CHF
Single or multiple pass	MULTIPLE	Range	32 - 60 CFH
Single or multiple arc	SINGLE		
Welding current	DC		
Polarity	DCEP		
Welding progression	HORIZ		
Root treatment	NONE		
Preheat and interpass temperature	3/4 AND UNDER NONE(IF UNDER 32 THEN 70F), OVER 3/4 THRU 1 1/2 50F OVER 1 1/2 THRU 2 1/2 150F		
Postheat treatment	NONE		

* Applicable only when filler metal has no AWS classification

WELDING PROCEDURE

Pass No.	Electrode Size	Welding Current		Travel Speed	Joint Detail
		Amperes	Volts		
1-n range	.045"	300 270-330	31 28.8 - 33.1	12 imp 9-15imp	<p style="text-align: center;">B-U2a-GF</p>  <p style="text-align: center;">R= 3/16@30, or, R=3/8@30, or R=1/4@45 tolerance Root = +1/4", -1/16" tolerance angle = +10 , -5</p>
1-n range	.052"	350 315-385	32 29.7 - 34.2	12 imp 9-15imp	