**PROCEDURE SPECIFICATION**

<table>
<thead>
<tr>
<th>Material Specification: Spec sec. 6-02.3(24) E</th>
<th>Welding Position: 1G</th>
</tr>
</thead>
<tbody>
<tr>
<td>Filler Metal Spec.: Conforms to AWS A5.5</td>
<td>Filler Classification: E 8018</td>
</tr>
<tr>
<td>Weld Metal Grade: A 706 Grade 60</td>
<td>Shielding Gas: NA</td>
</tr>
<tr>
<td>Single or Multiple Pass: Single</td>
<td>Welding Current: Direct</td>
</tr>
<tr>
<td>Single or Multiple Arc: Single</td>
<td>Polarity: DC +</td>
</tr>
<tr>
<td>Root Treatment: NA</td>
<td>Preheat &amp; Interpass Temp: 50 °F</td>
</tr>
</tbody>
</table>

**WELDING PROCEDURE**

<table>
<thead>
<tr>
<th>Pass No.</th>
<th>Elect. Size</th>
<th>Welding Current Amp.</th>
<th>Voltage</th>
<th>Joint Detail</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1/8</td>
<td>125 To 135</td>
<td>21</td>
<td>Field or Shop Weld</td>
</tr>
<tr>
<td>1</td>
<td>5/32</td>
<td>125 To 150</td>
<td>21</td>
<td></td>
</tr>
</tbody>
</table>

![Diagram of welding process](image)

Deformed Bar
A 706 Grade 60

<table>
<thead>
<tr>
<th>Weld Dimensions</th>
<th>Length (L)</th>
</tr>
</thead>
<tbody>
<tr>
<td>S (E)</td>
<td></td>
</tr>
<tr>
<td># 7</td>
<td>7/16 (1/4)</td>
</tr>
<tr>
<td># 6</td>
<td>3/8 (5/16)</td>
</tr>
<tr>
<td># 5</td>
<td>5/16 (3/16)</td>
</tr>
<tr>
<td># 4</td>
<td>1/4 (1/8)</td>
</tr>
</tbody>
</table>

This procedure may vary due to fabrication sequence, fit-up, pass size, etc. within the limitation of variables given in 6.2.1. The lap splice WILL extend beyond the one inch minimum as necessary for ease of placement.
Test Report

Identification of Parameters

WPS ID: NA

Welder Name/ID: NA


Base Metal Side 1: ASTM A706-60

Side 2: ASTM A706-60

Filler Metal: E8018-C3

Welding Process: SMAW

Position: 1G

Qualification

Test Specimen: Flare-Bevel-Groove-Indirect Butt Joint

Macroetch Test: 2 faces

Macro Examinations

2-faces were sectioned, polished, etched, and examined. Both Butt Joints were examined per section 6.3.7.3.

Note: Meets the requirements of the following applicable sections: 4.4.1, 4.4.3, 4.4.2, 4.4.5 and 4.4.6 (weld size not disclosed).

Specimens pass the acceptance criteria of the specification.

Respectfully,
**Corrected Test Report-11-21-11- Removed Photo and changed acceptance results**

Welder Qualification

Identification of Parameters

WPS ID: NA
Welder Name/ID: [Redacted]
Base Metal Side 1: ASTM A706
Side 2: ASTM A706
Filler Metal: E8018-C3
Welding Process: SMAW
Position: IG

Qualification

Test Specimen: Flare-Bevel-Groove-Indirect Butt Joint
Macroetch Test: 2 faces

Macro Examinations

2-faces were sectioned, polished, etched, and examined. Both Butt Joints were examined per section 6.3.7.3.

Note: Meets the requirements of the following applicable sections; 4.4.1, 4.4.3 4.4.2, 4.4.5 and 4.4.6 (weld size not disclosed).

Specimens pass the acceptance criteria of the specification.

Respectfully,

[Signature]
Materials Engineer