

WELDING PROCEDURE SPECIFICATION
ASME SEC. IX Ed. 2004

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Weld Layer (s)	Process	Filler Metal		Current		Volt Range	Travel Speed (mm/sec)	
		Class	Dia. (mm)	Type Polarity	Amp. Range			
Root	SMAW	E6010	2.5	DCEN	60 - 90	19-24	1.33	
H.P. & Fill	SMAW	E7018	2.5/3.2	DCEP	70 - 100	19 - 34	1.83	
Capping	SMAW	E7018	2.5/3.2	DCEP	90 - 140	19 - 34	1.83	

REMARKS:

Low Hydrogen Electrode (E7018): Baking/Redrying to 300 to 350 deg. C for 2 hrs.
:Holding Temperature - 120 to 150 deg. C; holding time to be indefinite