


GIBBONS ERECTORS, INC.

WELDING PROCEDURE QUALIFICATION TEST RECORD (PQR)

Company name: GIBBONS ERECTORS, INC.
 Procedure Qualification Record No.: GE-AWS-D1.3-1
 Welding Procedure Specification No.: GE-AWS-D1.3-1A
 Welding Process(es): SMAW
 Mode of Transfer for GMAW: N/A
(Short Circuiting, Spray, Etc.)

By: CHRIS MOHRBACH 
 Date: 9/28/2013
 Revision No.: N/A Date: -
 Type(s): MANUAL
(Automatic, Manual, Machine, or semi-Auto.)

JOINTS (Table 4.1)
 Type of Welded Joint(s): ARC SPOT WELD "SINGLE SHEET"
 Backing: YES
 Backing Material Type: STRUCTURAL / AWS D1.1 GRP II
 Groove Welded From: ONE SIDE

POSITION (Table 1.3)
 Position of weld: Flat
 Position of Fillet: N/A
 Progression: N/A

BASE METAL (1.2)
 Material Specification Type and Grade:
 Sheet Steel: ASTM A653
 Support Steel: A992 STRUCT. MEMBER (< 8 MLS. SHOP PRIMER)
 Thickness Range:
 Sheet Steel: 18 GAGE
 Support Steel: AWS GRP II
 Thickness: .500"
 Base Material Preparation: WIRE BRUSH

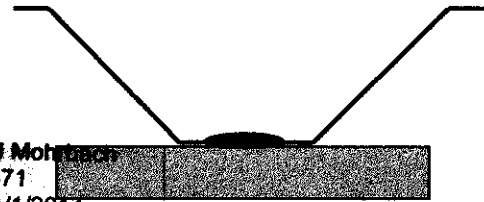
GAS (1.4.6.2)
 Shielding Gas: N/A Flow Rate: NA
 Percent of Mixture: N/A

FLUX (1.4.5.2)
 Filler Metal (Table 1.2)
 Specification: AWS A5.1
 Classification: E7018

COATING(S)
 Type: Galvanized
 Thickness: < .005"

VISUAL EXAMINATION RESULTS (4.6)
 Specimen 1: SATISFACTORY
 Specimen 2: SATISFACTORY
 Diameter of Arc Spot Nugget: 3/4"

Sketch of joint details



TEST CONDUCTED BY: WESTERN STATES INSPECTION COMPANY
 PER: CHRIS MOHRBACH (AWS-CWI)
 LAB TEST NO.: 414-13
 DATE OF TEST: 9/28/2013



Christopher J Mohrbach
 CWI 02110871
 QC1 EXP. 11/1/2014

TECHNIQUE

Pass No.	Electrode Size	Welding Current		Travel Speed (or Weld Time for Arc Spot Welds)	Melting Rate	Wire Feed Speed
		Amperes	Volts			
1	1/8"	132	24	6 Sec.	M=12	N/A

Welder or Welding Operator Name: MIKE DOUTE Date of Qualification: 9/28/2013
 Welder Identification No.: MD
 Welder's Social Security No.: -

The undersigned certifies that the statements in this record are correct and that the test welds were prepared, welded, and tested in accordance with the requirements of 4.6 of ANS/AWS D1.3 (2008), Structural Welding Code-Sheet Steel.

Authorized by: MIKE DOUTE Date: SEPTEMBER 28, 2013

GIBBONS ERECTORS, INC.

WELDING PROCEDURE SPECIFICATION (WPS)

Company name: GIBBONS ERECTORS, INC.
 Welding Procedure Specification No.: GE-AWS-D1.3-1A
 Supporting Procedure Qual. Record No.: GE-AWS-D1.3-1
 Welding Process(es): SMAW
 Mode of Transfer for GMAW: N/A
(Short Circuiting, Spray, Etc.)

By: CHRIS MOHRBACH
 Date: 9/28/2013
 Revision No.: N/A Date: N/A
 Type(s): MANUAL
(Automatic, Manual, Machine, or semi-Auto.)

JOINTS (Table 4.1)

Type of Welded Joint(s): ARC SPOT WELD "SINGLE SHEET"
& ARC SEAM WELD
 Backing: YES
 Backing Material Type: STRUCTURAL / AWS D1.1 GRP I OR II
 Groove Welded From: ONE SIDE

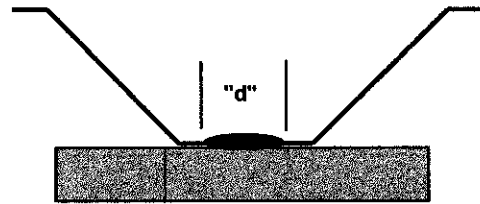
COATING(S)

Type: Galvanized or Bare
 Thickness: < .005"

BASE METAL (1.2)

Material Specification Type and Grade:
 Sheet Steel: ANY AWS D1.3 GRP I or II MATERIAL
 Support Steel: ANY AWS D1.1 GRP I or II MAT. (< 8 MLS SHOP PRIMER)
 Thickness Range:
 Sheet Steel: 18 GAGE + 10%
 Support Steel: 1/8" & UP AWS D1.1 GRP I or II MATERIAL
 Thickness: 1/8" TO UNLIMITED
 Base Material Preparation: WIRE BRUSH AS REQUIRED

SKETCH OF JOINT DETAILS



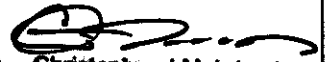

"d" = 3/4"

FILLER METAL (Table 1.2)

Specification: AWS A5.1
 Classification: E7018

POSITION (Table 1.3)

Position of Groove: Flat
 Position of Fillet: N/A
 Progression: N/A


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PREHEAT (1.1.1 AND 5.1)

Preheat Temperature Min: N/A
 Preheat Temperature Max: N/A

GAS (1.4.6.2)

Shielding Gas: N/A Flow rate: N/A
 Percent of Mixture: N/A

FLUX (1.4.5.2):

TECHNIQUE

Pass No.	Electrode Size	Welding Current		Travel Speed (or Weld Time for Arc Spot Welds)	Melting Rate	Wire Feed Speed
		Amperes	Volts			
1	1/8"	125-132	23-24	6 Sec.	M=11-12	N/A

This procedure may vary due to fabrication sequence, fit-up, pass size, etc. within the limitation of variables given in ANSI / AWS D1.3 (2008), Structural Welding Code-Sheet Steel.

Authorized by: MIKE DOUTE

Date: SEPTEMBER 28, 2013