

Seismic Energy Products, L.P.

518 Progress Way
Athens, TX 75751
Phone: (903)675-8571
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Welding Procedure Specification

Material Specification: ASTM 709, Grade A36

Welding Process: FCAW

Manual, Semiautomatic, or Automatic: SEMI-AUTO

Position of Welding: 1F

Filler Metal Specification: AWS A5.29

Filler Metal Classification: E81T1-Ni1CJ-H4

Flux: N/A

Electrode and Manufacturer: 81 NiC-H LINCOLN

Shielding Gas: 100% Co2 Dew Point: -128 °F Flow Rate: 40cfm

Single or Multiple Pass: Single

Single or Multiple Arc: Single

Welding Current: DC

Polarity: DCEP

Welding Progression: Left to Right

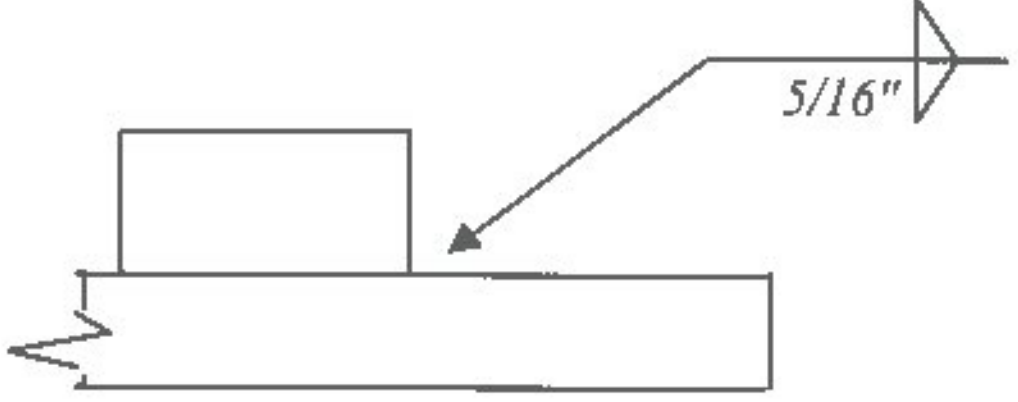
Root Treatment: Wire Brush

Preheat and Interpass Temperature: 70° and 450° MAX.

Postheat Treatment: None

Vermont Agency of Transportation
RECEIVED
CK'D BY _____ OK'D BY JC
February 13, 2015
RESUBMIT NO _____ Approved
BY KH DATE 3-5-2015

WELDING PROCEDURE

Pass No	Electrode Size	Welding Parameters		Travel Speed	Joint Detail
		Amperes	Volts		
All	0.0625	300-325	27-30	12 IPM	

Procedure File#: TP4 Contractor: Seismic Energy Products, L.P.

Revision: WPS # NY-01 Date: 2/12/2015