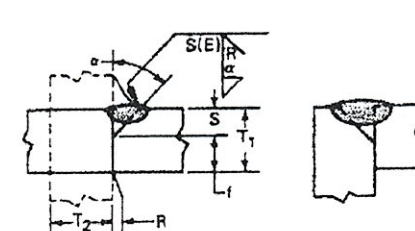




WELDROCFEDURE SPECIFICATION
Per WPQR # GMAW-01

MATERIAL SPECIFICATION: A36, A572, A709 Grade 36 & 50
 WELDING PROCESS: GMAW
 MANUAL OR MACHINE: Semi-Automatic
 POSITION OF WELDING: Flat & Horizontal
 FILLER METAL SPECIFICATION: A5.18
 FILLER METAL CLASSIFICATION: ER70S-6
 FILLER METAL MANUFACTURER: Hobart
 SHIELDING GAS: AR 92% CO2 8% DEW POINT: -40°F FLOW RATE: 32-43 CFH
 SINGLE OR MULTIPLE PASS: Single or Multiple
 SINGLE OR MULTIPLE ARC: Single ELECTRODE STICKOUT: 3/4 + 1/4"
 WELDING CURRENT: DC+
 POLARITY: Reverse
 WELDING PROGRESSION: Forward (Stringer Bead)
 ROOT TREATMENT: Free of dirt, rust and oil
 PREHEAT AND INTERPASS TEMP. ≤ 3/8" = 50°F ≤ 1/2" = 70°F ≤ 2/2" = 150°F (Minimum)
 POSTHEAT TREATMENT: N/A

WELDING PROCEDURE

Weld Size	Electrode Size	Welding Current		Travel Speed "/Min	Joint Detail TC-P4-GF
		Amps	Volts		
All	.045	247 - 302	27 - 31	9 - 11	 Dimensions per approved drawings
All	1/16	247 - 302	27 - 31	9 - 11	

THIS PROCEDURE MAY VARY DUE TO THE FABRICATION SEQUENCE, FIT-UP, PASS SIZE, ETC., WITHIN THE LIMITATIONS OF VARIABLES GIVEN IN TABLE 5.3 OF AWS D1.5-2002 BRIDGE WELDING CODE.

PROCEDURE NO: GM - TC-P4-GF MANUFACTURER: Niagara Bridge and Rail

REVISION NO: 0 AUTHORIZED BY: Thomas F. Wright

VT RANS
 RECEIVED
 JWC
 5/12/08