

VT A.O.T.  
 PROJECT: IM-089-2(29)  
 TOWN OF BOLTON

COSMEC INC.  
**WELDING PROCEDURE SPECIFICATION**

SPECIFICATIONS AND CODE: AASHTO-AWS D1.5  
 MATERIAL SPECIFICATION ASTM A709 GR 50W, GR 50, GR 38  
 WELDING PROCESS----- FCAW-G  
 MANUAL OR MACHINE----- SEMI-AUTOMATIC  
 POSITION OF WELDING----- 1F & 2F  
 FILLER METAL SPECIFICATION AWS 5.20 CLASSIFICATION: E71M  
 MANUFACTURER: LINCOLN ELECTRIC TRADENAME: E71M OUTERSHIELD  
 FLUX----- INTERNAL  
 SHIELDING GAS----- CO2 FLOW RATE 45 CFH  
 SINGLE OR MULTIPLE PAS S MULTIPLE  
 SINGLE OR MULTIPLE ARC SINGLE  
 WELDING CURRENT----- DC  
 POLARITY: REVERSE (EP)  
 WELDING PROGRESSION-----  
 ROOT TREATMENT----- CLEANED & PREPARED BRIGHT METAL  
 PREHEAT AND INTERPASS TEMPERATURE----- SEE BELOW  
 POSTHEAT TEMPERATURE N/A  
 HEAT INPUT MIN----- MAX-----

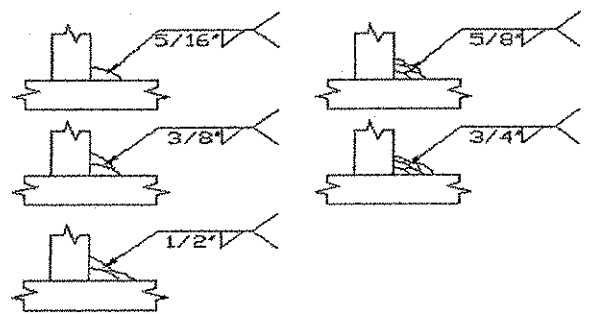
**WELDING PROCEDURE**

PASS NO.	ELECTRODE SIZE	WELDING CURRENT AMPERES	TRAVEL SPEED VOLTS	JOINT DETAIL
ALL	0.045	193.5-236.5	29.76-34.24	9.45-11.55

**PREHEAT TEMPS.**

THICKNESS	TEMP.
UP TO 3/4"	50 DEG. F
OVER 3/4" TO 1 1/2"	70 DEG. F
OVER 1 1/2" TO 2 1/2"	150 DEG. F
OVER 2 1/2"	225 DEG. F

**INTERPASS TEMP:** 400 DEG. F

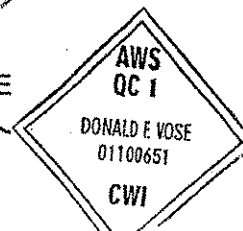


THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT-UP, PASS SIZE, ETC. WITHIN THE LIMITATION OF VARIABLES GIVEN IN SECTION 5.

PROCEDURE NO. FCAW-F-MN-VT.  
 SUPPORTING PQR: DONALD VOSE  
 REVISION NO.

CONTRACTOR: COSMEC INC.  
 AUTHORIZED BY: DONALD VOSE

DATE: 1/31/2005



TRANS RECEIVED  
 OK'D BY \_\_\_\_\_ OK'D BY JWC  
 MAR 09 2005  
 RESUBMIT \_\_\_\_\_ APPROVED ✓  
 BY \_\_\_\_\_ DATE 3-16-05

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