

VT A.O.T., BETHEL  
VT RTE 12 BRIDGE  
PROJ. NO. BRK 0241 (33) C/2  
COSMEC INC.

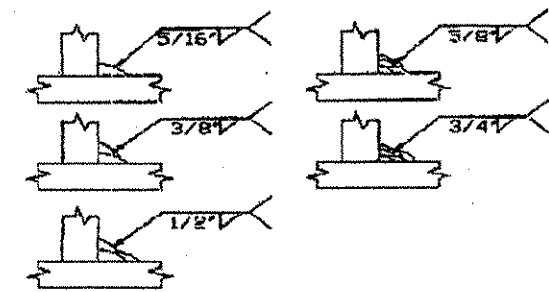
WELDING PROCEDURE SPECIFICATION

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 F & T  
FILLER METAL SPECIFICATION AWS 5.20 CLASSIFICATION: E71T  
TRADE NAME: E71T OUTERSHIELD  
MANUFACTURER: LINCOLN ELECTRIC  
FLUX INTERNAL  
SHIELDING GAS CO2 FLOW RATE 45 CFH  
SINGLE OR MULTIPLE PASSES MULTIPLE  
SINGLE OR MULTIPLE ARC SINGLE  
WELDING CURRENT DC  
POLARITY REVERSE (RP)  
WELDING PROGRESSION  
ROOT TREATMENT CLEANED & PREPARED BRIGHT METAL  
PREHEAT AND INTERPASS TEMPERATURE SEE BELOW  
POSTHEAT TEMPERATURE N/A  
HEAT INPUT MIN MIX

WELDING PROCEDURE

PASS NO.	ELECTRODE SIZE	WELDING CURRENT AMPERES	VOLTS	TRAVEL SPEED	JOINT DETAIL
ALL	0.045	190-230	27-29	8-9	

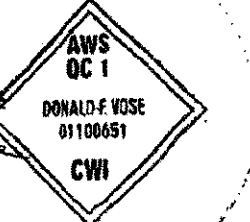
PREHEAT TEMPS.  
THICKNESS  
UP TO 3/4" 30 DEG. F  
OVER 3/4" TO 1 1/2" 70 DEG. F  
OVER 1 1/2" TO 2 1/2" 150 DEG. F  
OVER 2 1/2" 225 DEG. F  
INTERPASS TEMP: 400 DEG. F



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-FILLET  
SUPPORTING PQR: FCAW-1 0-05  
REVISION NO.

CONTRACTOR: COSMEC INC.  
AUTHORIZED BY: DONALD VOSE  
DATE: 1/31/2005



VTRAUS  
JWC  
11-7-05  
13266