

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

WELDING PROCEDURE SPECIFICATION

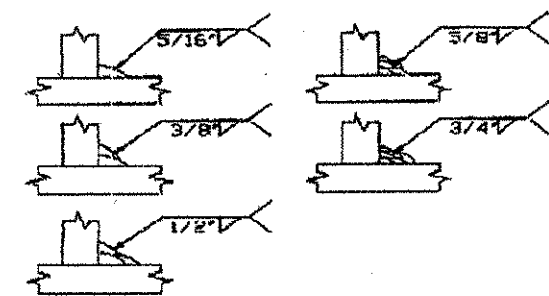
SPECIFICATIONS AND CODE: AASHTO-AWS D1.3
MATERIAL SPECIFICATION ASTM A709 GR 50W, GR 50, GR 35
WELDING PROCESS FCAW-G
MANUAL OR MACHINE SEMI-AUTOMATIC
POSITION OF WELDING F & 2F CLASSIFICATION: E71T
FILLER METAL SPECIFICATION AWS 5.20 TRADENAME: E71T OUTERSHIELD
MANUFACTURER: LINCOLN ELECTRIC
FLUX INTERNAL FLOW RATE 45 CFH
SHIELDING GAS CO2
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 MAX

WELDING PROCEDURE

PASS NO.	ELECTRODE SIZE	WELDING CURRENT AMPERES	TRAVEL SPEED VOLTS	JOINT DETAIL
ALL	0.045	180-230	27-23	8-9

PREHEAT TEMPS.

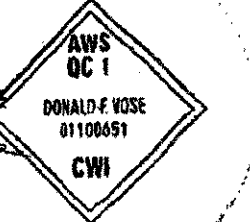
THICKNESS	TEMP.
UP TO 3/4"	30 DEG. F
OVER 3/4" TO 1 1/2"	70 DEG. F
OVER 1 1/2" TO 2 1/2"	150 DEG. F
OVER 2 1/2"	225 DEG. F
INTERPASS TEMP:	100 DEG. F



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-FI-LET
SUPPORTING PQR: FCAW-1 0-05
REVISION NO.

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



✓ TRANS
11-9-05