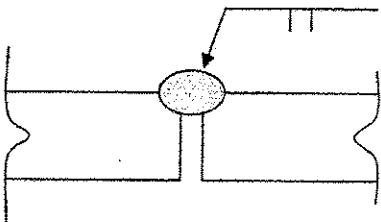


MANUAL OR MACHINE:	Semi-Automatic
POSITION OF WELDING:	Horizontal
FILLER METAL SPECIFICATION:	A5.18
FILLER METAL CLASSIFICATION:	ER70S-6
FILLER METAL MANUFACTURER:	Hobart
SHIELDING GAS: AR 92% CO2 8%	DEW POINT: -60°F FLOW RATE: 35 CFH
SINGLE OR MULTIPLE PASS:	Single
SINGLE OR MULTIPLE ARC:	Single ELECTRODE STICKOUT: 3/4 max
WELDING CURRENT:	DC+
POLARITY:	Reverse
WELDING PROGRESSION:	Forward (Stringer Bead)
ROOT TREATMENT:	Free of dirt, rust and oil
PREHEAT AND INTERPASS TEMP.	≤ 3/4" = 50°F ≤ 1 1/2" = 70°F ≤ 2 1/2" = 150°F (Minimums)
POSTHEAT TREATMENT:	N/A

WELDING PROCEDURE

Weld Size	Electrode Size	Welding Current		Travel Speed "/Min	Joint Detail Square groove seal weld
		Amps	Volts		
All	1/16	247 - 302	27 - 31	9 - 11	 <p>Material thickness and shape per approved drawings Seal weld on one side only</p>
<p align="center"> <i>TRANS RECEIVED</i> CK'D BY _____ OK'D BY <i>Juc</i> MAR 27 2008 RESUBMIT _____ APPROVED <input checked="" type="checkbox"/> BY _____ DATE <i>4/22/08</i> </p>					

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: Seal Weld MANUFACTURER: Niagara Bridge and Rail
 REVISION NO: 0 AUTHORIZED BY: *Thomas F. Wright*