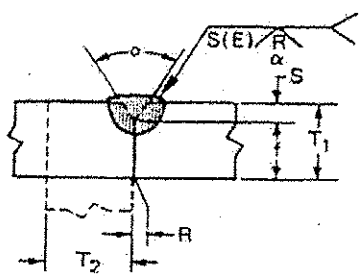


MANUAL OR MACHINE: Semi-Automatic
 POSITION OF WELDING: Horizontal
 FILLER METAL SPECIFICATION: A5.18
 FILLER METAL CLASSIFICATION: ER70S-6
 FILLER METAL MANUFACTURER: Hobart
 SHIELDING GAS: AR 92% C02 8% DEW POINT: -60°F FLOW RATE: 35 CFH
 SINGLE OR MULTIPLE PASS: Single
 SINGLE OR MULTIPLE ARC: Single ELECTRODE STICKOUT: ¾ max
 WELDING CURRENT: DC+
 POLARITY: Reverse
 WELDING PROGRESSION: Forward (Stringer Bead)
 ROOT TREATMENT: Free of dirt, rust and oil
 PREHEAT AND INTERPASS TEMP. ≤ ¾" = 50°F ≤ 1½" = 70°F ≤ 2½" = 150°F (Minimums)
 POSTHEAT TREATMENT: N/A

WELDING PROCEDURE

Weld Size	Electrode Size	Welding Current		Travel Speed "/Min	Joint Detail C-P2-GF
		Amps	Volts		
All	1/16	247-302	27-31	9-11	 <p>Bevel and weld size per approved drawings</p>
TRANS RECEIVED OK'D BY _____ OK'D BY <u>JWC</u> MAR 27 2008 RESUBMIT _____ APPROVED ✓ LY _____ DATE <u>4/22/08</u>					

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: C-P2-GF MANUFACTURER: Niagara Bridge and Rail
 REVISION NO: 0 AUTHORIZED BY: Thomas F. Wright