

POSITION OF WELDING: Down hand (Flat)
 STUD METAL SPECIFICATION: ASTM A-108
 STUD METAL CLASSIFICATION: Type A or B
 STUD MANUFACTURE: Tru-Weld
 SHIELDING GAS: N/A DEW POINT: FLOW RATE:
 FERRULE OR FLUX DESCRIPTION: Ceramic part #F 009-694
 SINGLE OR MULTIPLE ARC: Single ELECTRODE STICKOUT: N/A
 WELDING CURRENT: DC
 POLARITY: Straight
 ROOT TREATMENT: Clean of oil, dirt, rust, rust pits, moisture and scale
 PREHEAT AND INTERPASS TEMP. 40F min
 POSTHEAT TREATMENT: None
 WELDING MACHINE: Pro-Weld model ARC 1800
 STUD WELDING GUN: Nelson model # 751-347-000 1800amp

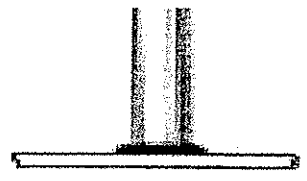
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OK'D BY JWC

MAR 27 2008

WELDING PROCEDURE

RESUBMIT _____ APPROVED ✓
 BY _____ DATE 4/22/08

Stud Diameter	Weld Current (Amps)	Lift & Plunge		Weld Time (sec.)	Joint Detail (Stud weld)
		Lift	Plunge		
3/4"	1600 ± 5%	.093"	.187"	.700 ± 5%	

THIS PROCEDURE MAY VARY DUE TO THE FABRICATION SEQUENCE, FIT-UP, ETC., WITHIN THE LIMITATIONS OF VARIABLES GIVEN IN SECTION 7 OF AWS D1.5 BRIDGE WELDING CODE.

THIS PROCEDURE IS CONSIDERED PREQUALIFIED IN ACCORDANCE WITH AWS D1.5 SECTION 7.6.1 AND IS PERFORMED WITHIN THE STUD MANUFACTURES RECOMMENDATIONS.

PROCEDURE NO: Carbon Stud weld MANUFACTURER: Niagara Bridge and Rail
 REVISION NO: 0 AUTHORIZED BY: *Thomas F. Wright*