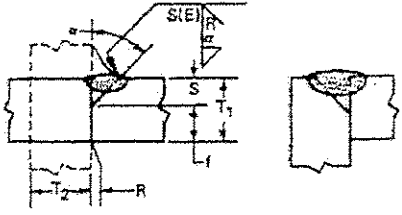


MANUAL OR MACHINE:	Semi-Automatic
POSITION OF WELDING:	Flat & Horizontal
FILLER METAL SPECIFICATION:	A5.18
FILLER METAL CLASSIFICATION:	ER70S-6
FILLER METAL MANUFACTURER:	Hobart
SHIELDING GAS: AR 92% C02 8%	DEW POINT: -40°F FLOW RATE: 32 - 43 CFH
SINGLE OR MULTIPLE PASS:	Single or Multiple
SINGLE OR MULTIPLE ARC:	Single ELECTRODE STICKOUT: 3/4 ± 1/4"
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 (Minimum)
POSTHEAT TREATMENT:	N/A

WELDING PROCEDURE

Weld Size	Electrode Size	Welding Current		Travel Speed "/Min	Joint Detail TC-P4-GF
		Amps	Volts		
All	.045	247 - 302	27 - 31	9 - 11	 <p>Dimensions per approved drawings</p>
All	1/16	247 - 302	27 - 31	9 - 11	

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: GM - TC-P4-GF MANUFACTURER: Niagara Bridge and Rail

REVISION NO: 0 AUTHORIZED BY: Thomas F. Wright

TRANS RECEIVED

OK'D BY _____ OK'D BY JWC

MAR 27 2008

RESUBMIT _____ APPROVED ✓

BY _____ DATE 4/24/08