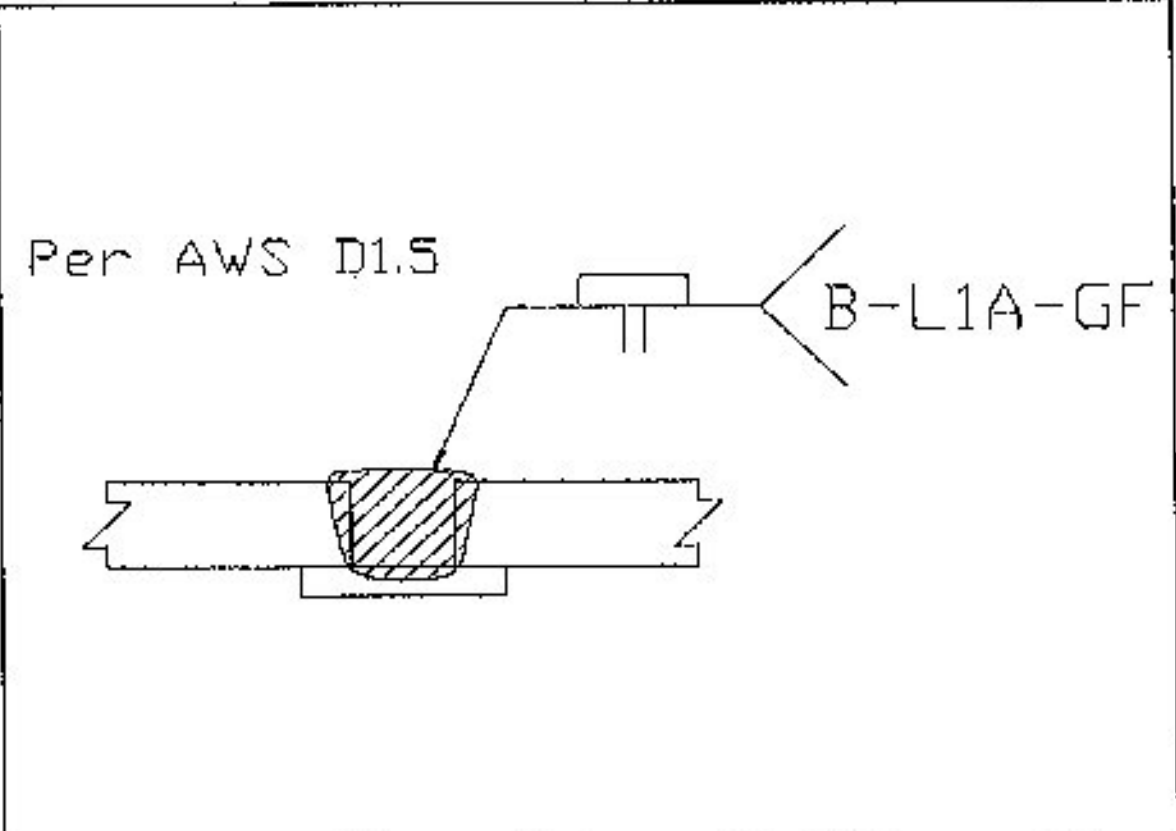


WELDING PROCEDURE SPECIFICATION
PQR ELDERLEE #3

Add Project Name and Number

Material Specification	A500 TO A36
Welding Process	FCAW-G
Manual or Machine	SEMAUTOMATIC
Position of Welding	FLAT/HORIZONTAL
Filler Metal Specification	A5.29
Filler Metal Classification	E81T1-N1C-JH4
Flux	N/A
Shielding Gas	CO 2 Dew Point -40DEG F Flow Rate 50CFH
Single or Multiple Pass	SINGLE
Single or Multiple Arc	SINGLE
Welding Current	DC
Polarity	REVERSE
Welding Progression	STRINGER
Root Treatment	CLEAN PER D1.5
Preheat and Interpass Temperature	PER D1.5
Postheat Temperature	NONE
Heat Input	Min _____ Max _____

WELDING PROCEDURE

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
	1/16	310	25	11	
Variable	LIMITS	341	27	12	
		TO 289	TO 23	TO 10	

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in Section 5.

Procedure No. 3026
Revision No. _____

Contractor Elderlee, Inc.
Authorized By RANDY SCOTT
Date 3/24/2014

Vermont Agency of Transportation

RECEIVED

CK'D BY JWC OK'D BY HIS

April 23, 2015

RESUBMIT NO Approved AsNoted
BY Carolyn Carlson DATE 4/29/2015