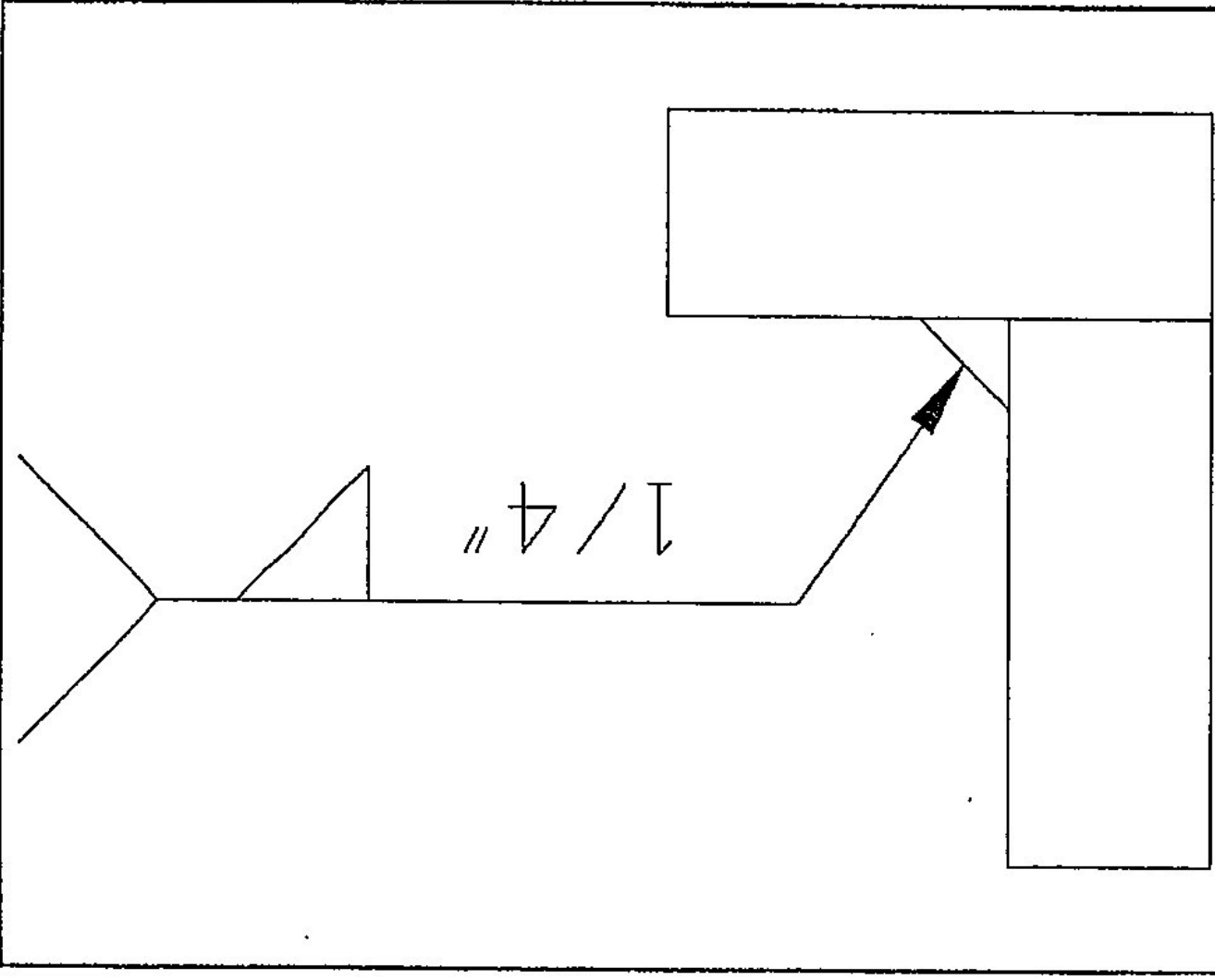


WELDING PROCEDURE SPECIFICATION
 PQR ELDERLEE #3
 A709 TO A500 GR B

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

WELDING PROCEDURE

Pass no.	Electrode size	Welding Current			Travel speed	Variable
		Amperes	Volts	Travel speed		
1	1/16	310	25	11	12	LIMITS
		269	23	10	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. 3009
 Contractor Elderlee, Inc.
 Authorized By RANDY SCOTT
 Date 3/20/2014

Vermont Agency of Transportation
RECEIVED
 ON: April 28, 2014
 and Checked for
CONFORMANCE
 BY: Rob Young DATE: 05/16/2014