

**SHOP DRAWING REVIEW**

REVIEWED AS REQUIRED BY THE CONSTRUCTION CONTRACT DOCUMENTS AND APPROVED, BUT ONLY FOR CONFORMANCE TO THE DESIGN CONCEPT OF THE WORK, AND SUBJECT TO FURTHER LIMITATIONS AND REQUIREMENTS CONTAINED IN THE CONSTRUCTION CONTRACT DOCUMENTS.

REJECTED     REVISE AND RESUBMIT     APPROVED AS NOTED

CORRECTIONS OR COMMENTS MADE ON THE SHOP DRAWINGS DURING THIS REVIEW DID NOT RELIEVE CONTRACTOR FROM COMPLIANCE WITH REQUIREMENTS OF THE DRAWINGS AND SPECIFICATIONS. THIS CHECK IS ONLY FOR REVIEW OF GENERAL CONFORMANCE WITH THE DESIGN CONCEPT OF THE PROJECT AND GENERAL COMPLIANCE WITH THE INFORMATION GIVEN IN THE CONTRACT DOCUMENTS. THE CONTRACTOR IS RESPONSIBLE FOR CONFIRMING AND CORRELATING ALL QUANTITIES AND DIMENSIONS; SELECTING FABRICATION PROCESSES AND TECHNIQUES OF CONSTRUCTION; COORDINATING THEIR WORK WITH ALL OTHER TRADES; AND PERFORMING THEIR WORK IN A SAFE AND SATISFACTORY MANNER.

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Job Number: 120712-1  
Reviewed by: SRB  
Date: 3/23/2015

**WELDING PROCEDURE SPECIFICATION**

PQR ELDERLEE #3

Material Specification ASTM A572 GR. 50 TO A325

Welding Process FCAW-G

Manual or Machine SEMAUTOMATIC

Position of Welding FLAT/HORIZONTAL

Filler Metal Specification A5.29

Filler Metal Classification E81T1-Ni1C-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 ELECTRODE POSITIVE

Welding Progression STRINGER

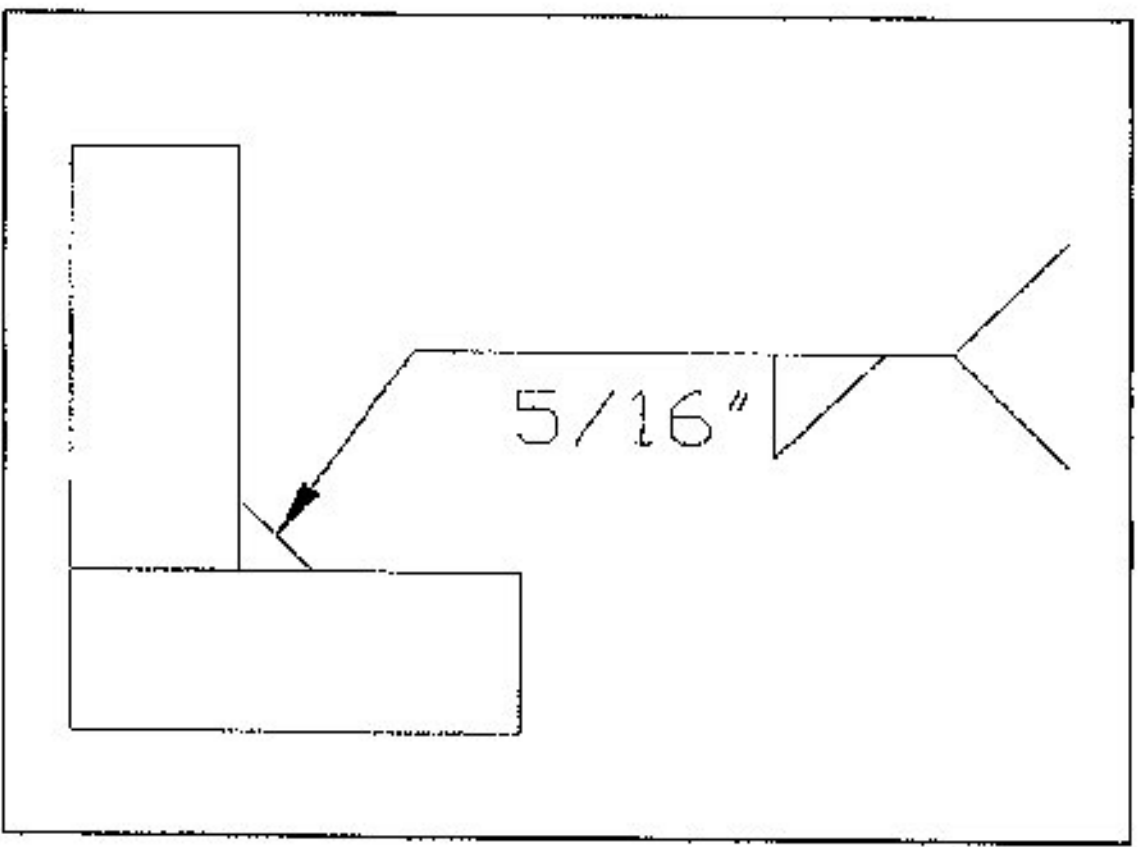
Root Treatment CLEAN PER D1.5

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	1/16	310	25	11	
Variable	LIMITS	341	27	12	
		TO 269	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. 3019 Contractor Elderlee, Inc.

Revision No. \_\_\_\_\_ Authorized By RANDY SCOTT

Date 7/28/2014

Vermont Agency of Transportation  
**RECEIVED**  
 ON: February 25, 2015  
 and Checked for  
**CONFORMANCE**  
 BY: Rob Young DATE: 03/23/2015